



INDUSTRIAL, INC.

20" BANDSAW

MODEL G1258

INSTRUCTION MANUAL



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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 chemical are:

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

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

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SECTION 1: SAFETY

WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible dangers. This manual uses a series of symbols which are intended to convey the level of criticality of the safety message. 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.

 **NOTE** This symbol is used to alert the user to useful information about safe and proper operation of the equipment.

 **CAUTION** Failure to obey a CAUTION symbol and notation may result in minor or moderate property damage or personal injury.

 **WARNING** Failure to obey a WARNING symbol and notation can result in serious injury to yourself and others.

 **DANGER** Failure to obey a DANGER symbol and notation WILL result in serious personal injury including loss of life or body parts.

WARNING

Safety Instructions For Power Tools

- KEEP GUARDS IN PLACE** and in working order.
- REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
- KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
- KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
- MAKE WORK SHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
- DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
- USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.

WARNING

Safety Instructions For Power Tools

- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure it is rated Hard Service (grade S) or better. Conductor size must be 16 A.W.G. for cords up to 100 feet in length. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged. Minimum Gage for extension cord:
- | | |
|-----------|-------|
| 16 A.W.G. | 50ft |
| 16 A.W.G. | 100ft |
| 14 A.W.G. | 200ft |
| 12 A.W.G. | 300ft |
- 10. WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
- 13. DON'T OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- 15. DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, and the like.
- 16. REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
- 17. USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.
- 18. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- 19. DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- 20. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

WARNING

Additional Safety Instructions For Bandsaws

1. Do not operate your bandsaw with dull or badly worn blades. Dull blades require more effort to use and are difficult to control. Inspect blades before each use.
2. Never position fingers or thumbs in line with the cut. Serious personal injury could occur.
3. Always support round stock in a V-block.
4. Ensure that the machine sits firmly on the floor before use. Any “wobbles” must be corrected by shimming or blocking before operation.
5. Make sure blade has been properly tensioned.
6. Always feed stock evenly and smoothly. Do not force or twist blade while cutting, especially when sawing small radii.
7. This machine is not designed to cut metal or other material except wood.
8. When replacing blades, make sure teeth face down towards the table. The force of the cut is always down.
9. Habits – good and bad – are hard to break. Develop good habits in your shop and safety will become second-nature to you.
10. Do not manually stop or slow blade after turning the saw off. Use foot brake.

WARNING

Always wear ANSI-approved safety glasses or goggles and hearing protection when operating equipment — particularly when testing new tools or machinery. Do not allow visitors into your workshop when testing or operating equipment. 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 person injury, damage to equipment or poor work results.

SECTION 2: CIRCUIT REQUIREMENTS

220V Operation

Your Model G1258 Bandsaw is supplied with a single phase 220V only motor. Under normal use, the motor draws approximately 15 amps @ 220V. We recommend a 20 amp circuit breaker or slow-blow fuse. This should be satisfactory for normal use, while providing enough protection against motor damage caused by power surges. If frequent circuit failures occur when using the bandsaw, contact our service department or your local electrical contractor.

A plug is not supplied. We recommend using a NEMA 6-20. See **Figure 1**.



Fusing

The Model G1258 should be fused at 20 amps. Fusing at amperage ratings higher than 20 amps will not adequately protect the motor. You are cautioned that equipment that is returned to us for service that shows evidence of being over-fused will be repaired or replaced totally at the customer's expense, regardless of the present warranty status.

In preparing to connect the Model G1258 to your existing or new circuit, it will be necessary to connect a plug that matches your 220V/240V receptacle. If you will be installing a new receptacle and plug, we recommend either of the styles shown in **Figure 1**. Note that you have the choice between simple plug-in and twist-lock plug styles. Whichever style you choose, be sure that both the plug and outlet are rated at 20 amps.

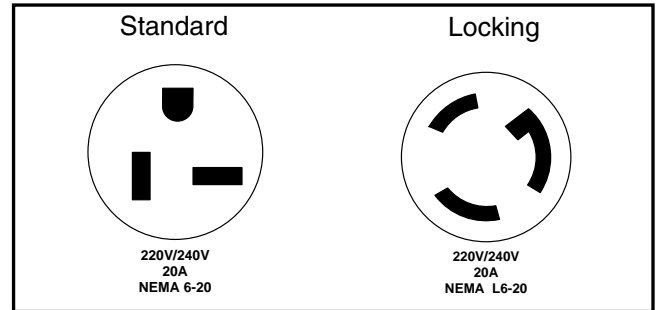


Figure 1. Two typical outlet/plug configurations.

Grounding

WARNING

This equipment must be grounded. Please ensure that this machine is continuously grounded from the motor to the machine frame and then to a known ground. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. If it is not, it will be necessary to run a separate 12 A.W.G. copper grounding wire from the outlet to a known ground. Under no circumstances should the grounding pin from any three-pronged plug be removed. **Serious personal injury may occur.**



Extension Cords

If used, extension cords must be rated hard service – grade S – or better. Conductor size must be 12 AWG for cords up to 50 feet in length. Your extension cord must also contain a ground wire and plug pin. To ensure safe and dependable machine performance, inspect cords frequently for wear or damage. Replace or repair the cord immediately if evidence of damage is apparent.



SECTION 3: INTRODUCTION

Commentary

We are proud to offer the Model G1258 20" Bandsaw. The Model G1258 is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The Model G1258 is a woodcutting bandsaw with a 3 H.P. motor, fence, foot brake and complete electrical package. It features an all steel construction frame and cast iron table. Accessories are also available for the G1258. Consult the current Grizzly catalog for prices and ordering information.

We are also pleased to provide this instructional manual with the Model G1258 20" Bandsaw. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the Model G1258 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.

WARNING

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your Model G1258 will be time well spent. **DO NOT** operate this machine until you are completely familiar with the contents of this manual. Serious personal injury may occur.



Unpacking

The bandsaw is shipped from the factory in a carefully packed carton. If you find the machine to be damaged after you've signed for delivery and the truck and driver are already gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for inspection by the carrier or their agent. Without the packing materials, filing a freight claim can be difficult. If you need advice regarding this situation, please call us immediately.

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

WARNING

The G1258 is a very heavy machine with a shipping weight of 650 lbs. **DO NOT over-exert yourself while unpacking or moving your machine – get assistance. In the event that your bandsaw must be moved up or down a flight of stairs, be sure that the stairs are capable of supporting the combined weight of people and the machine. Serious personal injury may occur.**

NOTE

Save all containers and packing materials until you are satisfied that your bandsaw has arrived in good condition. Freight company adjusters will want to inspect those materials in the event that a freight claim must be made.



Parts Inventory

Take a quick inventory of the parts and put them aside for assembly later. After all the parts have been removed from the container, you should have:

- **Bandsaw Assembly**
- **Fence Assembly**
- **Hardware**
- **Miter Gauge**

Now is a good time to inventory the fasteners required for assembly. We would like to point out that the quantities given here are the minimum needed to do the job; it is possible that there will be some extra parts. On the other hand, it is also possible that there may be one or two items missing. If so, you are welcome to call us. We will ship them to you. For the sake of expediency, you may find it more convenient, though, to replace any miscellaneous fasteners at your local hardware store. Fasteners include:

| Hardware | Qty |
|--|-----|
| Cap Screws $\frac{5}{16}$ " - 18 x 2 $\frac{1}{2}$ " | 2 |
| Fence Rail Spacers | 2 |
| Fence Rail | 1 |



Clean Up

The unpainted surfaces are coated with a waxy oil to protect it from corrosion during shipment. Remove the protective coating with common paint thinner (mineral spirits) and paper towels. Do not use gasoline or other petroleum based solvents because of their extremely low flash points. Do not use chlorine-based solvents – if you happen to splash some onto a painted surface, you'll ruin the finish.

WARNING

Follow the safety rules listed below when working with solvents.

1. Read and follow all directions and warnings on the solvent label.
2. Work only in a well ventilated area.
3. Do not work near any type of open flame (e.g., pilot lights, kerosene heaters, and so on).
4. **DO NOT smoke while working with flammable material.**
5. Paper towels from the cleaning process are extremely combustible. Dispose of waste towels so they do not create a fire hazard.

CAUTION

Some die-cut metal parts may have sharp edges (called “flashing”) on them after they are formed. Please examine the edges of all die-cut metal parts before handling them. Failure to do so could result in injury.



Site Considerations

FLOOR LOAD

Your G1258 Bandsaw represents a large weight load in a small footprint. Most commercial floors are suitable for the Model G1258. Some residential floors may require additional build up to support both machine and operator.

WORKING CLEARANCES

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

LIGHTING AND OUTLETS

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets, or circuits.

CAUTION

Make your shop “child safe”. Ensure that your workplace is inaccessible to youngsters by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting or operating equipment.



SECTION 4: ASSEMBLY

Fence

Most of your G1258 20" bandsaw has been assembled at the factory. Only the fence assembly requires installation.

To mount the fence to the bandsaw table:

1. Mount the front rail to the table using the 2 $\frac{5}{16}$ -18 x 2 $\frac{1}{2}$ " Cap Screws and the 2 Spacers provided. See **Figure 2**.
2. Loosen the fence lock knob and slide the fence onto the rail.



Figure 2. Front rail in place and fence installed.

WARNING

DO NOT attempt any step of assembly, adjustments, or maintenance while your Model G1258 is running. Ensure that the switch is off, power is disconnected and moving parts have stopped before making adjustments. Failure to comply may result in serious personal injury.



SECTION 5: ADJUSTMENTS

Tracking

To adjust the tracking:

1. Disconnect the bandsaw from the power source and open the top and bottom wheel covers. Adjust the upper and lower guide assemblies away from the blade.
2. Loosen the lock nut on the tracking knob. See **Figure 3**. Rotate the upper wheel by hand and adjust the tracking knob (turn the tracking knob clockwise to track the blade in, counterclockwise to track out) until the flat body of the blade tracks in the center of the upper wheel. Turn the wheel at least three full turns to ensure that the blade is tracking in its final position.



Figure 3. Tracking knob adjustment location.

CAUTION

Use extreme care when turning the bandsaw wheel. The upper wheel may have sharp edges and any procedures which require work in close proximity to the bandsaw blade could result in serious injury.



Tension

Final blade tension ultimately depends on the type and size of blade you use. To adjust the tension:

1. Press, with moderate pressure, on the face of the blade with your thumb.
2. Turn the tension wheel until the blade deflects about $\frac{1}{4}$ ". See **Figure 4**.
3. Make the other adjustments to the saw and test run it. If the blade is not cutting properly, the tension may need to be increased. Remember, thin blades require less tension than wide blades.
4. Reduce the blade tension when the bandsaw is not in use. This will help prevent premature wear or breakage of the blade and/or rubber tires.

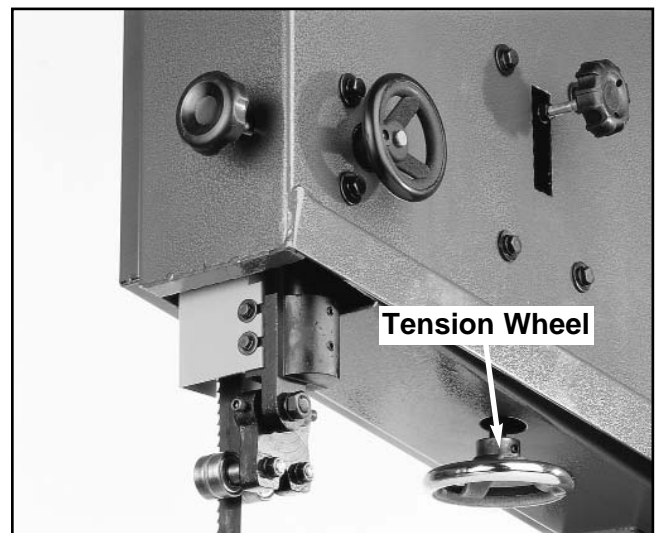


Figure 4. Tension wheel adjustment location.



Wheel Alignment

The upper wheel can be adjusted to correct for any deviation in parallelism. Although this has been set at the factory, it is a good idea to check it occasionally to assure good and proper operation of your bandsaw. To adjust the wheel parallelism:

1. Open the top and bottom covers.
2. Measure the distance the bottom wheel is from the bandsaw frame, front to back. Usually the Lower wheel will be slightly at an angle to the bandsaw frame. Make note which way the wheel is skewed and by how much.
3. Now measure the top wheel, front to back. Ideally, you want the top wheel to match the angle at which the bottom wheel is set. *For example:* if the you determine the bottom wheel is tapered to the front by $\frac{1}{16}$ ", the top wheel should be adjusted so it is tapered in the same direction by the same amount.
4. The knobs to adjust the top wheel are located at the back of the bandsaw. Refer to **Figure 5**. Loosen the check nuts and adjust as necessary.

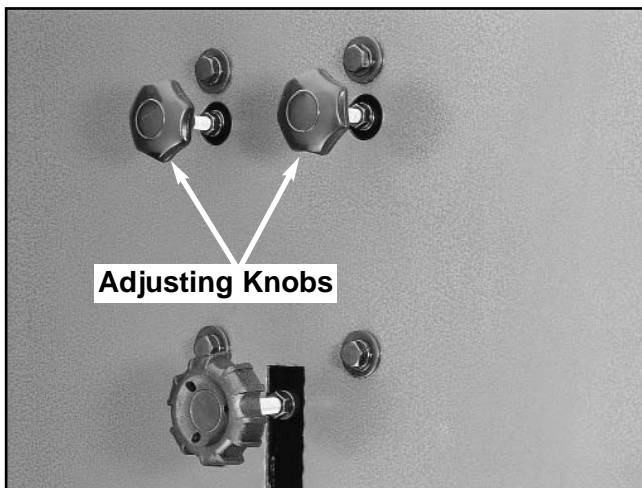


Figure 5. Wheel alignment adjusting knobs.



CAUTION

Which ever direction one knob is turned, the other knob must be turned the same amount in the opposite direction. If this step is not observed, the tracking mechanism will be put in a bind.

Upper Guides

Normally **Steps 1-4** are implemented prior to installing a new blade. To adjust the upper guides:

1. Loosen the bearing guide shaft lock nuts.
2. The bearing guides are mounted on an eccentric shaft. With a regular screwdriver, rotate the guides away from the blade.
3. Loosen the cap screw holding the bearing back-up shaft in place and slide the bearing back-up away from the blade.
4. Loosen the cap screw holding the blade assembly in place and slide it back away from the blade.
5. Install your blade of choice. Track and tension as per the instructions in this manual.
6. Move the blade guide assembly so the bearing guides are $\frac{1}{16}$ " behind blade gullets. Tighten the guide assembly.

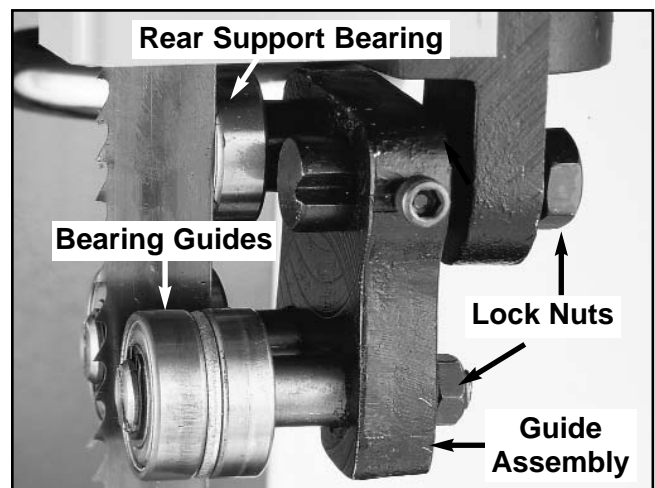


Figure 6 shows upper blade guide assembly.

7. Now rotate the bearing guide shafts until the bearings are approximately $\frac{1}{64}$ " from the blade. Hold the shafts in place with a screw driver and tighten the bearing guide lock nuts. The guide bearing, when adjusted correctly, should have a slight drag against the blade. If the guide bearings pinch the blade, it will damage the bearing guides and blade.
8. Slide the rear support bearing until it is approximately $\frac{1}{32}$ " from the blade and tighten.

NOTE

The bearing guide shaft lock nuts should only be as loose as necessary to allow the shafts to rotate. If they are too loose it will be very difficult, if not impossible, to adjust the guides accurately.



Lower Guides

Normally **Steps 1-4** are implemented prior to installing a new blade. To adjust the lower guides:

1. Loosen the lower guide lock nuts and thread the shafts out so the blade guides are away from the blade.
2. Loosen the setscrew that holds the rear support bearing in place and slide it back.
3. Loosen the bolts that hold the lower guide assembly in place and slide the lower guide back.
4. Install blade. Track and tension according to the instructions in this manual. It is recommended that you adjust the upper guides first, then the lower.
5. Slide the lower guide forward so the bearing guides are $\frac{1}{16}$ " behind blade gullets. Tighten the lower guide assembly.

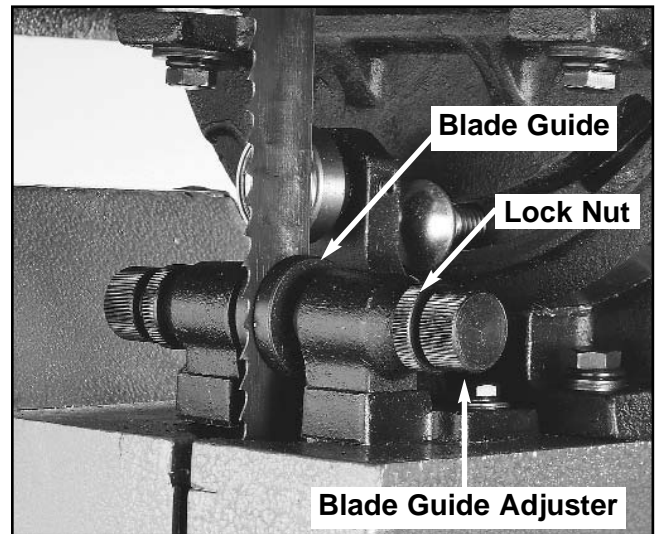


Figure 7 shows lower blade guide assembly.

6. Thread in the lower blade guide adjusters until the blade guides are approximately $\frac{1}{64}$ " from the blade. Tighten the lock nuts.
7. Slide the rear support bearing until it is approximately $\frac{1}{32}$ " from the blade and tighten.

WARNING

DO NOT make adjustments while the band-saw is running. Ensure that the switch is off, power is disconnected and moving parts have stopped before making adjustments. Failure to comply may result in serious personal injury.



Changing Blades

After changing a blade, the upper and lower blade support bearings and guide blocks must be readjusted. Always adjust the guide assemblies away from the blade before installing a new blade or making blade adjustments.

To change blades:

1. Make sure machine is off and unplugged.
2. Open upper and lower wheel covers.
3. Remove the fence assembly.
4. Release tension on the bandsaw blade.
5. Remove table insert and setscrew from the table.
6. Slip blade off wheels and guide it through the table slot.
7. To install a new blade, reverse the above procedure.

After correctly setting blade tension and tracking, readjust the upper and lower support bearings and guide block assemblies.

WARNING

Wear gloves and safety glasses when handling blades. Coiled blades will spring open as they are uncoiled. Blades are very sharp. Failure to exercise care may result in serious personal injury.



Positive Table Stop

To adjust the positive stop so the table will be perpendicular to the blade:

1. Loosen the trunnion lock handle and check nut locking the positive stop adjusting bolt. See **Figure 8**.
2. Raise the upper blade guide assembly up and stand a machinist's square or adjustable square on the table next to the side of the blade. Adjust the positive stop adjusting bolt to raise or lower the table until the table is 90° to the blade.
3. Secure the trunnion lock handle and lock the positive stop adjusting bolt by tightening the lock nut. Ensure that the bolt does not turn while tightening the lock nut.

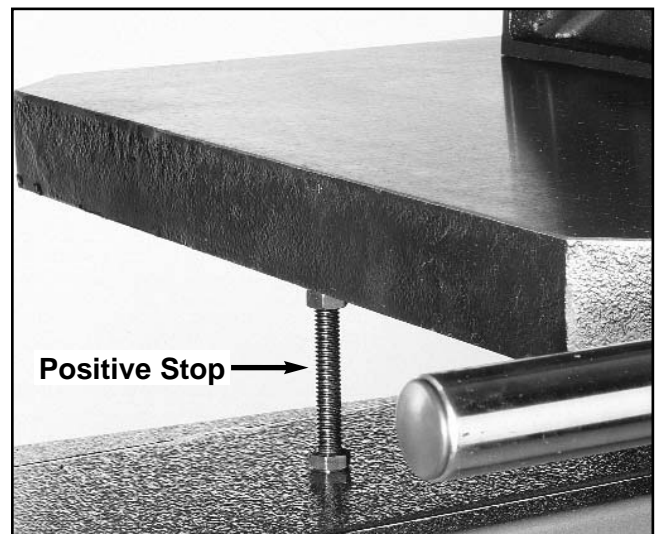


Figure 8. Location of positive stop adjustment.



SECTION 6: OPERATIONS

Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing many different cutting functions including, but not limited to:

STRAIGHT CUTS

1. Miters
2. Angles
3. Compound Angles
4. Resawing

IRREGULAR CUTS

1. Simple and Complex Curves
2. Duplicate Parts
3. Circles
4. Beveled Curves

Although you can perform many types of straight cuts such as angling and mitering on the bandsaw, they will not be as precise as on a table saw. Also, since the blade is flexible, the resulting cut is somewhat rougher than one performed on a table saw. However, just as a table saw is suited to precision straight cuts and miters, the bandsaw excels when resawing and when cutting irregular shapes. A properly adjusted and tuned up bandsaw is also safer to operate than most other saws and is capable of performing many sawing functions with ease and accuracy.

A common fault when using a bandsaw is blaming the saw for not performing up to expectations. Many factors contribute to a bandsaw's performance. Using the wrong kind of blade or a cheap blade usually results in unsatisfactory performance. Misuse of the saw or using incorrect sawing techniques can be unsafe as well as result in frustration and poor cuts. Remember, the blade does the cutting with the operator's guidance. Replace blades as necessary and make adjustments periodically to keep the saw always running in top condition.

NOTE

Set the top guide assembly so it is just above the top of the work at all times.

Do not force the material against the blade, use light even pressure. Light contact with the blade will permit easier line following and prevent undue friction, heat and work-hardening along the back edge of the blade.

Avoid twisting the blade by trying to turn sharp corners. Remember, you must saw around corners.



Test Run

Once assembly is complete and adjustments are done to your satisfaction, you are ready to test the machine.

Turn on the power supply at the main panel. Press the START button. Make sure that your finger is poised on the STOP button, just in case there is a problem. The bandsaw should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further.

If noises occur that cannot be found by visual inspection, feel free to contact our service department for help.

CAUTION

Keep your finger on the STOP button, just in case there are any problems with the machine. Turn the machine off IMMEDIATELY if you suspect there is something wrong.



Blade Information

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain long use from a bandsaw blade if you give it fair treatment. Be sure you use blades with proper width and temper for the various types of cutting operations.

Always use the widest blade possible. Use narrow blades only for sawing small, abrupt curves and fine detail work. Blades may be purchased welded, set and sharpened ready-for-use. We supply 154 $\frac{1}{2}$ " bandsaw blades in $\frac{3}{16}$ ", $\frac{1}{4}$ ", $\frac{3}{8}$ ", $\frac{1}{2}$ ", $\frac{3}{4}$ ", 1" and 1 $\frac{1}{4}$ " widths for this saw. Refer to our current catalog for prices and ordering information.

Always select and use good-quality saw blades and choose the right blade for the right job. Poor quality blades and improper use are often the cause of premature blade failure.

Many conditions may cause a bandsaw blade to break. Blade breakage is, in some cases, unavoidable, 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 support guides.

The most common causes of blade breakage are: (1) faulty alignment and adjustment of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding too fast, (4) tooth dullness or absence of sufficient set, (5) excessive tension, (6) top blade guide assembly set too high above the workpiece, (7) using a blade with a lumpy or improperly finished braze or weld and (8) continuously running the bandsaw when not in use.

When installing a new blade, inspect its weld and file smooth, when necessary, prior to operation.



Resawing

Resawing is the process of cutting a board into two or more thinner boards. 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 13".

The Model G1258 bandsaw is highly capable of resawing, provided the saw is set up properly. Use common sense when resawing. Attempting to resaw too wide or too dense a board may put excessive strain on the blade and be dangerous.

The important consideration when resawing is blade selection. Generally, the wider blade, the better your results. In most applications, a hook or skip tooth style will be sufficient. Since most resawn lumber will be planed smooth, choose blades with fewer teeth-per-inch (from 3 to 6). While blades with fewer teeth-per-inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust, less heat buildup, and yield more horsepower per tooth.

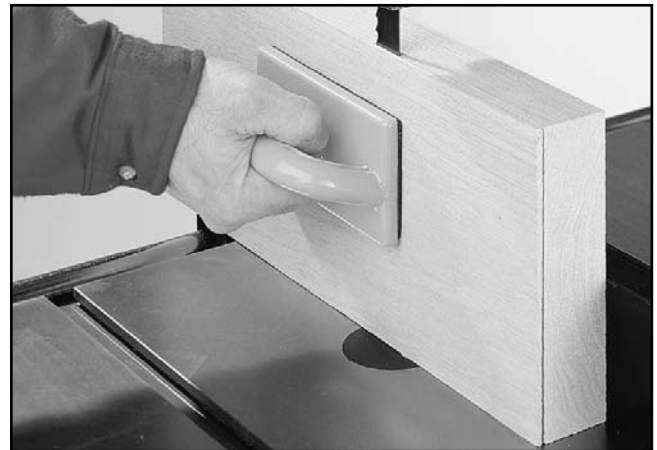


Figure 16. Proper method for resawing lumber.

1. The bandsaw must be adjusted correctly. See Blade Adjustment Section.
2. The table must be square to the blade. See Table Adjustment Section.
3. Use the widest blade available. The blade must also be in good condition.
4. Use a fence to guide work.

5. Draw a reference line on the edge of the board.
6. Support ends of the board if necessary.
7. Feed work slowly and evenly.



Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more set. A blade with more set can cut relatively tighter radii, though the cut is usually rougher than cuts produced by a blade with medium set.

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, if needed.

NOTE

The table below lists blade widths and corresponding minimum radii each blade will cut.

| Width | Radius |
|--------|--------|
| 3/8" | 1 1/2" |
| 1/2" | 2 1/2" |
| 3/4" | 5 1/2" |
| 1" | 6" |
| 1 1/2" | 8" |



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, it is essential to ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece cut from the top to the bottom of the stack.

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. Using brads in the waste portion of each piece, secure all the pieces together.
3. Lay out the shape you intend to cut on the face of the top piece.
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 kerf 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.



SECTION 7: MAINTENANCE

General

Make a habit of inspecting your Bandsaw each time you use it. Check for the following conditions and repair or replace when necessary.

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Damaged V-belt.
5. Any other condition that could hamper the safe operation of this machine.



Lubrication

Shielded and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes and replacements can be purchased from our parts department or your local 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 or towel and spray on the lubricant. Ensure that oil does not get on the pulleys or V-belts because it could cause belt deterioration and slipping.



Table

The table and other non-painted surfaces on the Model G1258 should be protected against rust and pitting. Wiping the saw clean after every use ensures that moisture from wood dust isn't allowed to trap moisture against bare metal surfaces.

Most experienced woodworkers recommend using automotive paste wax on exposed steel and cast iron surfaces. The wax provides a layer of protection, as well as reducing friction between lumber and the table, making cuts faster and smoother.

Avoid waxes that contain silicone or other synthetic ingredients. These materials can find their way into lumber that's being milled, and can make staining and finishing difficult. If you use paste wax, make sure that it's 100% Carnauba wax.

WARNING

DO NOT make adjustments or attempt maintenance procedures while the Model G1258 is running. Ensure that the switch is off, power is disconnected and moving parts have stopped before making adjustments. Failure to comply may result in serious personal injury.



SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, and Warranty/Return information for your Model G1258 20" Bandsaw.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the Introduction. The specifications, drawings, and photographs illustrated in this manual represent the Model G1258 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation*.

WARNING

Always wear ANSI-approved safety glasses or goggles when operating equipment. Do not allow visitors into your workshop when testing or operating equipment unless they also have proper safety glasses. Serious personal injury may occur.

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department listed in *Section 3: Introduction*.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.



WARNING

The Model G1258 was specifically designed for wood cutting operations. **DO NOT MODIFY AND/OR USE THIS BANDSAW FOR ANY OTHER PURPOSE.** Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, **DO NOT** use it until you have answered all your questions. Serious personal injury may occur.

WARNING

Like all power tools, there is danger associated with the Model G1258 20" Bandsaw. Use the tool with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored. Serious personal injury may occur.



MACHINE DATA SHEET

Customer Service #: (570) 326-3806 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

GRIZZLY MODEL G1258 20" BANDSAW

Design Type: Floor Model

Overall Dimensions:

Table20" W x 24"D x 1 $\frac{5}{8}$ " Thick
Overall Height.....75"
Height From Floor to Table35 $\frac{1}{2}$ "
Width38 $\frac{1}{2}$ "
Depth including Fence27 $\frac{3}{4}$ "
Shipping Weight.....650 lbs.
Weight in Place.....514 lbs.
Crate Size24" x 37" x 81"

Cutting Capacity:

Left of Blade20"
Height13"

Construction:

TablePrecision Ground Cast Iron
Upper Wheel.....Fully balanced Cast Aluminum with Rubber Tires
Lower WheelFully balanced Cast Iron with Rubber Tires
Rip FenceFormed Steel and Bar Stock
Wheel CoversPre-Formed Steel
GuidesAll Ball Bearings Guides

Motor:

TypeTEFC Capacitor Start Induction
Horsepower.....3 HP
Phase / CycleSingle Phase / 60 Hz
Voltage220V
Amps15
RPM1720
BearingsShielded & Permanently Lubricated Ball

Blades:

Sizes AvailableFrom $\frac{3}{16}$ " to $\frac{1}{4}$ "
Standard Blade Length.....154 $\frac{1}{2}$ "
Blade Speeds.....2800 FPM

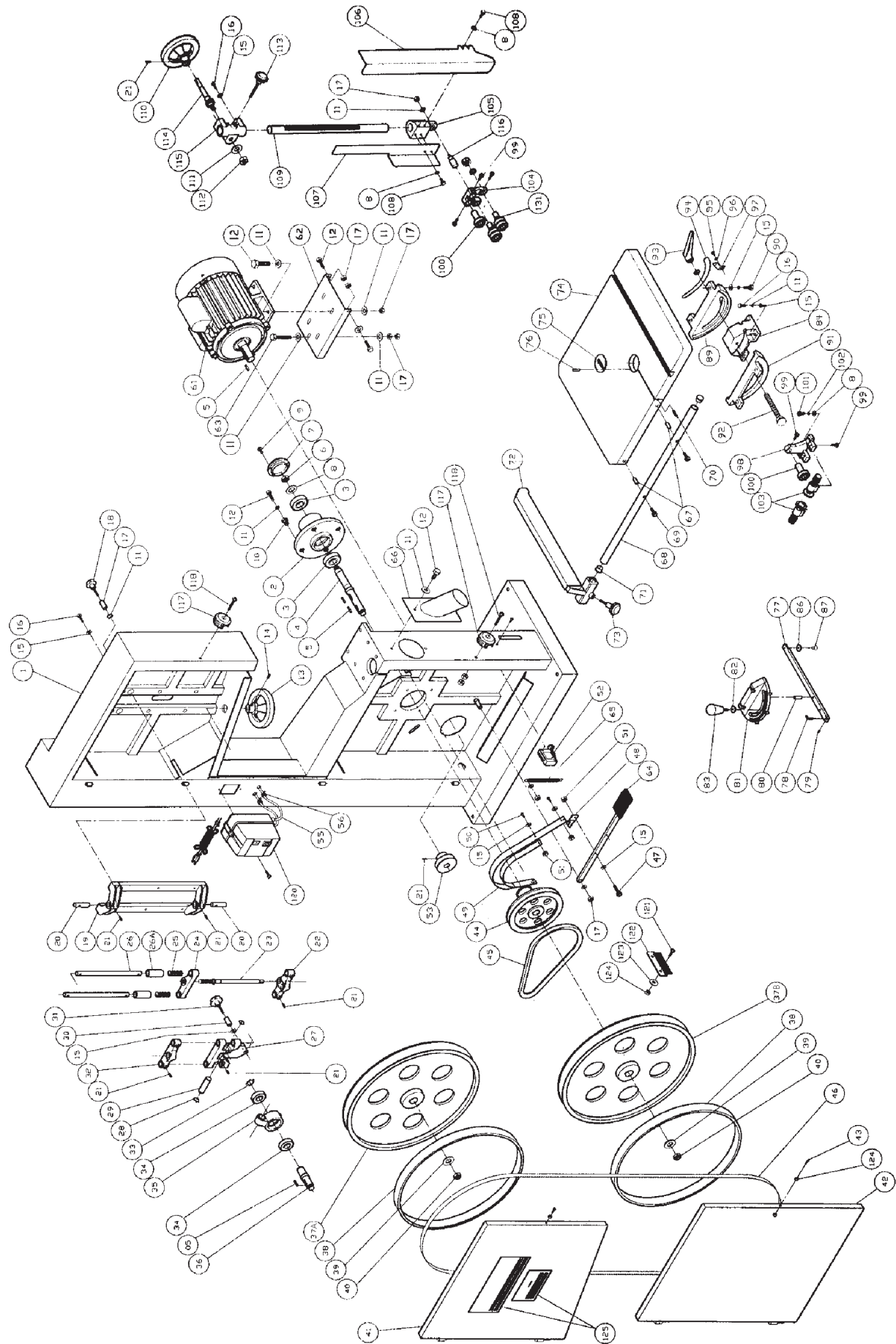
Features:

.....Micro-Adjustable Ball Bearing Blade Guides
.....Cast Iron Fence
.....Miter Gauge
.....4" Dust Port
.....Foot Brake
.....Table Tilt 45°

Specifications, while deemed accurate, are not guaranteed.

REVISED 2/99

PARTS DIAGRAM AND PARTS LIST



| REF | PART # | DESCRIPTION |
|-----|-----------|---------------------------|
| 01 | P1258001 | BODY |
| 02 | P1258002 | BEARING BASE |
| 03 | P6305 | BEARING 6305-2RS |
| 04 | P1258004 | SHAFT |
| 05 | PK28M | KEY 7 X 7 X 29 |
| 06 | PN03 | HEX NUT 3/4"-16 |
| 07 | P1258007 | BEARING COVER |
| 08 | P1258008 | WASHER |
| 09 | P1258009 | PHILLIPS HEAD SCREW |
| 10 | P1258010 | COVER |
| 11 | P1258011 | WASHER |
| 12 | PB18 | HEX BOLT 3/8"-16 X 1" |
| 13 | P1258013 | ADJUST WHEEL |
| 14 | PSS03 | SETSCREW 1/4"-20 X 3/8" |
| 15 | PW02 | FLAT WASHER 3/8" |
| 16 | PSB14 | CAP SCREW 3/8"-16 X 1" |
| 17 | PN02 | HEX NUT 5/16"-18 |
| 18 | P1258018 | KNOB 5/16"-18 |
| 19 | P1258019 | WHEEL BRACKET |
| 20 | P1258020 | BRACKET SHAFT |
| 21 | PSS02 | SET SCREW 5/16"-18 X 3/8" |
| 22 | P1258022 | ADJUST BRACKET |
| 23 | P1258023 | ADJUST SCREW |
| 24 | P1258024 | ELEVATOR BRACKET |
| 25 | P1258025 | SPRING |
| 26 | P1258026 | GUIDE SPINDLE |
| 26A | P1258026A | BUSHING |
| 27 | P1258027 | GUIDE BRACKET |
| 28 | PR09M | SNAP RING 20MM |
| 29 | P1258029 | LEVER SHAFT |
| 30 | PN08 | HEX NUT 3/8"-16 |
| 31 | P1010079 | TENSION KNOB |
| 32 | P1258032 | UPPER ADJUST BRACKET |
| 33 | PR11M | SNAP RING 25MM |
| 34 | P6205 | BEARING 6205-2RS |
| 35 | P1258035 | BEARING BASE |
| 36 | P1258036 | UPPER WHEEL SHAFT |
| 37A | P1258037A | UPPER WHEEL ALUMINUM |
| 37B | P1258037B | LOWER WHEEL CAST IRON |
| 38 | P1258038 | RUBBER TIRE |
| 39 | P1258039 | WASHER 3/4" |
| 40 | PN03 | HEX NUT 3/4"-16 |
| 41 | P1258041 | UPPER GUARD |
| 41A | P1258041A | HINGE PINS |
| 42 | P1258042 | LOWER GUARD |
| 43 | P1258043 | PHILLIPS HEAD SCREW |
| 44 | P1258044 | BRAKE WHEEL |
| 45 | PVB36 | V-BELT B-36 |
| 46 | P1258046 | SEE CATALOG |
| 47 | P1258047 | HEX BOLT |
| 48 | P1258048 | BRAKE BELT LOCKING |
| 49 | P1258049 | BRAKE BELT |
| 50 | P1258050 | RIVET |
| 51 | P1258051 | HEX NUT |
| 52 | P1258052 | MICRO SWITCH |
| 53 | P1258053 | MOTOR PULLEY |
| 55 | P1258055 | POWER CORD |
| 56 | P1258056 | MOTOR CORD |
| 61 | P1258061 | MOTOR |
| 62 | P1258062 | MOTOR PLATE |

| REF | PART # | DESCRIPTION |
|-----|----------|-----------------------------|
| 63 | P1258063 | HEX BOLT |
| 64 | P1258064 | BRAKE PEDAL |
| 65 | P1258065 | SPRING |
| 66 | P1258066 | DUST CHUTE |
| 67 | P1258067 | BUSH |
| 68 | P1258068 | FENCE GUIDE RAIL |
| 69 | PSB12 | CAP SCREW 5/16"-18 X 2 1/2" |
| 70 | P1258070 | SETSCREW |
| 71 | P1258071 | RAIL PLUG |
| 72 | P1258072 | FENCE |
| 73 | P1258073 | LOCKING KNOB |
| 74 | P1258074 | WORKING TABLE |
| 75 | P1012044 | TABLE INSERT |
| 76 | P1258076 | SPRING PIN |
| 77 | P1258077 | MITER BAR |
| 78 | P1258078 | POINTER |
| 79 | P1258079 | PAN SCREW 3/16" X 3/8" |
| 80 | P1258080 | PIN |
| 81 | P1258081 | MITER BODY |
| 82 | P1258082 | WASHER |
| 83 | P1258083 | LOCK HANDLE |
| 84 | P1258084 | TABLE BRACKET |
| 86 | P1025086 | SPECIAL WASHER |
| 87 | P1258087 | FLAT HEAD SCREW |
| 89 | P1258089 | TRUNNION |
| 90 | P1258090 | HEX BOLT |
| 91 | P1258091 | TRUNNION |
| 92 | P1258092 | HEX BOLT |
| 93 | P1258093 | LOCK HANDLE |
| 94 | P1258094 | SCALE |
| 95 | P1258095 | SCREW |
| 96 | P1258096 | WASHER |
| 97 | P1258097 | POINTER |
| 98 | P1258098 | BRACKET |
| 99 | P1258099 | CAP SCREW |
| 100 | P1258100 | ADJUST GUIDE SHAFT |
| 101 | P1258101 | HEX BOLT |
| 102 | P1258102 | WASHER |
| 103 | P1258103 | BLADE GUIDE |
| 104 | P1258104 | BRACKET |
| 105 | P1258105 | GUIDE BAR BRACKET |
| 106 | P1258106 | BLADE GUARD |
| 107 | P1258107 | INNER GUARD |
| 108 | PB02 | HEX BOLT |
| 109 | P1258109 | GUIDE BAR |
| 110 | P1025048 | HAND WHEEL |
| 111 | P1258111 | WASHER |
| 112 | P1258112 | SNAP RING 12MM |
| 113 | P1258113 | KNOB |
| 114 | P1258114 | GEAR SHAFT |
| 115 | P1258115 | GEAR BRACKET |
| 116 | P1258116 | SHAFT |
| 117 | P1258117 | KNOB WHEEL |
| 118 | P1258118 | PHILLIPS HEAD SCREW |
| 120 | P1258120 | SWITCH |
| 121 | P1258121 | PHILLIPS HEAD SCREW |
| 122 | P1258122 | BRUSH |
| 123 | P1258123 | WASHER |
| 124 | P1258124 | HEX NUT |
| 125 | P1258125 | LABEL |
| 131 | P1258131 | BEARING GUIDE |

WARRANTY AND 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.

To take advantage of 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.

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.

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.

WARRANTY CARD

Name _____
Street _____
City _____ State _____ Zip _____
Phone Number _____ E-Mail _____ FAX _____
MODEL # _____ Order # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

- How did you learn about us?
 Advertisement Friend
 Catalog Card Deck
 World Wide Web
 Other _____
- Which of the following magazines do you subscribe to.
 American Woodworker Practical Homeowner
 Cabinetmaker Shop Notes
 Family Handyman Today's Homeowner
 Fine Homebuilding WOOD
 Fine Woodworking Wooden Boat
 Home Handyman Woodshop News
 Journal of Light Construction Woodsmith
 Old House Journal Woodwork
 Popular Mechanics Woodworker
 Popular Science Woodworker's Journal
 Popular Woodworking Workbench
 Other _____
- Which of the following woodworking/remodeling shows do you watch?
 Backyard America The New Yankee Workshop
 Home Time This Old House
 The American Woodworker Woodwright's Shop
 Other _____
- What is your annual household income?
 \$20,000-\$29,999 \$60,000-\$69,999
 \$30,000-\$39,999 \$70,000-\$79,999
 \$40,000-\$49,999 \$80,000-\$89,999
 \$50,000-\$59,999 \$90,000 +
- What is your age group?
 20-29 50-59
 30-39 60-69
 40-49 70 +
- How long have you been a woodworker?
 0 - 2 Years 8 - 20 Years
 2 - 8 Years 20+ Years
- How would you rank your woodworking skills?
 Simple Advanced
 Intermediate Master Craftsman
- What stationary woodworking tools do you own? Check all that apply.
 Air Compressor Panel Saw
 Band Saw Planer
 Drill Press Power Feeder
 Drum Sander Radial Arm Saw
 Dust Collector Shaper
 Horizontal Boring Machine Spindle Sander
 Jointer Table Saw
 Lathe Vacuum Veneer Press
 Mortiser Wide Belt Sander
 Other _____
- How many of your woodworking machines are Grizzly? _____
- Which benchtop tools do you own? Check all that apply.
 1" x 42" Belt Sander 6" - 8" Grinder
 5" - 8" Drill Press Mini Lathe
 8" Table Saw 10" - 12" Thickness Planer
 8" - 10" Bandsaw Scroll Saw
 Disc/Belt Sander Spindle/Belt Sander
 Mini Jointer
 Other _____
- How many of the machines checked above are Grizzly? _____
- Which portable/hand held power tools do you own? Check all that apply.
 Belt Sander Orbital Sander
 Biscuit Joiner Palm Sander
 Circular Saw Portable Planer
 Detail Sander Saber Saw
 Drill/Driver Reciprocating Saw
 Miter Saw Router
 Other _____
- What machines/supplies would you like Grizzly Industrial to carry?
 12" Table Saw Radial Arm Saw
 12" Jointer Panel Saw
 Combination Planer/Joiner Brass Hardware
 Paint & Finishing Supplies Lumber
 Contractor's Supplies
 Other _____
- What new accessories would you like Grizzly Industrial to carry?
 Builders Hardware Hand Tools
 Fasteners Wood Components
 Other _____
- What other companies do you purchase your tools and supplies from?

- Do you think your purchase represents good value?
 Yes No
- Would you recommend Grizzly Imports to a friend?
 Yes No
- Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**
 Yes No
- Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here



**GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069**

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Send a Grizzly Catalog to a friend:

| |
|----------------------------------|
| Name _____ |
| Street _____ |
| City _____ State _____ Zip _____ |

TAPE ALONG EDGES--PLEASE DO NOT STAPLE