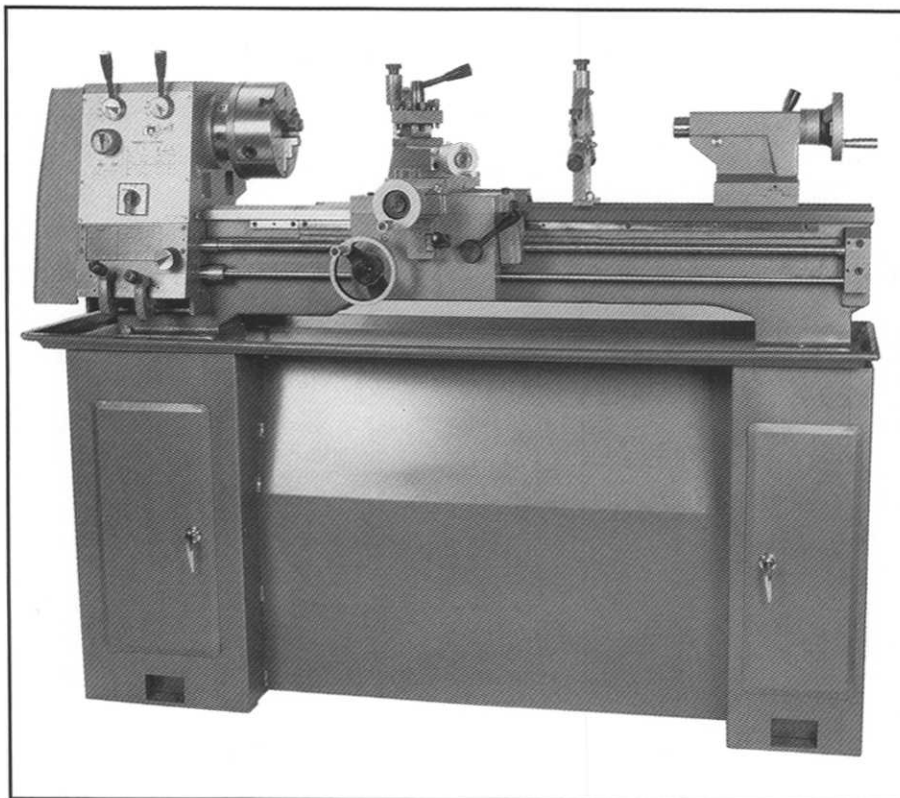




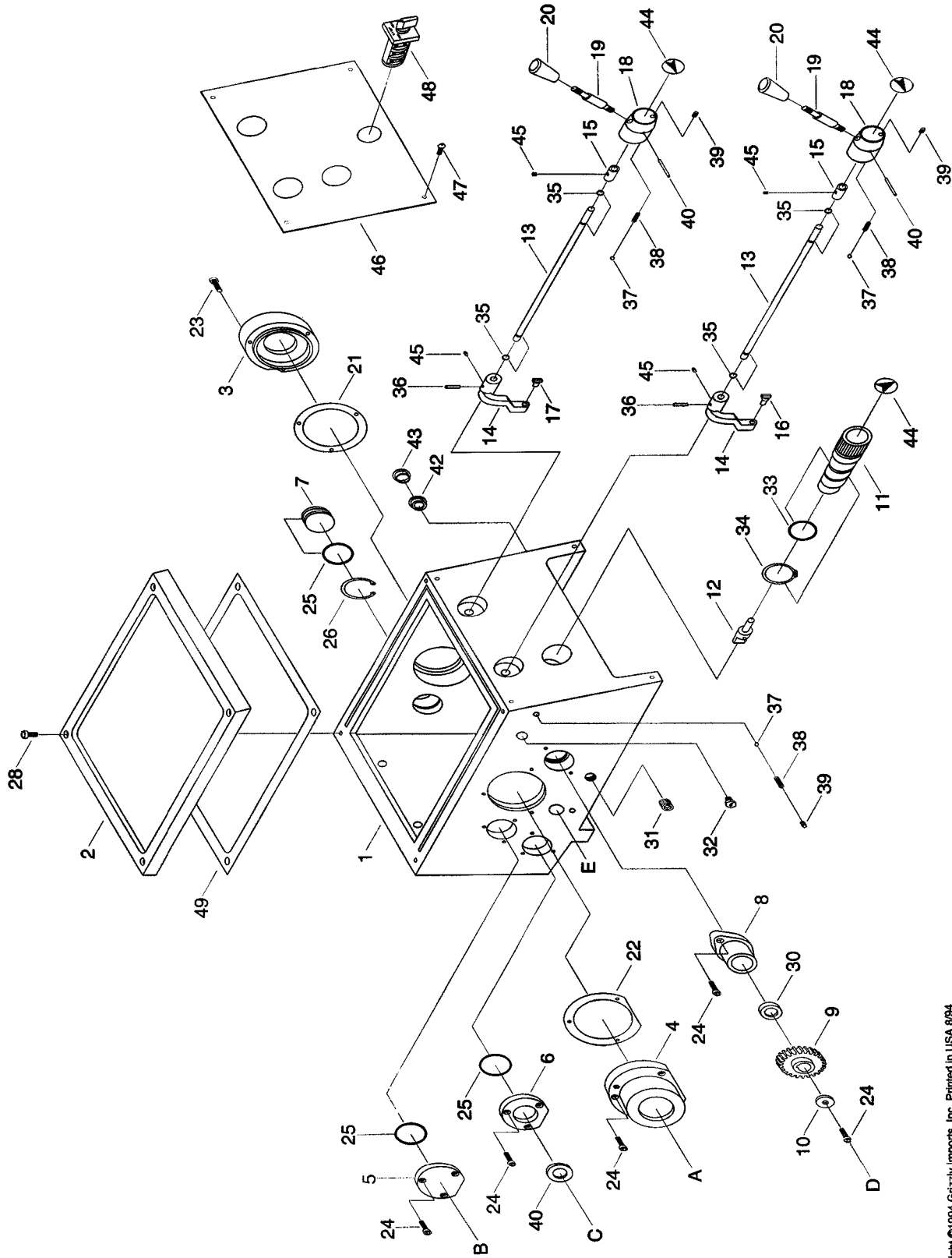
**GEAR HEAD METAL LATHE
MODEL G1001
INSTRUCTION MANUAL**



COPYRIGHT © 1994 BY GRIZZLY IMPORTS, INC.
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY IMPORTS, INC.**
REVISED OCTOBER, 1994. PRINTED IN USA

XVIII. PARTS LISTS AND DIAGRAMS

A. HEADSTOCK DIAGRAM #1



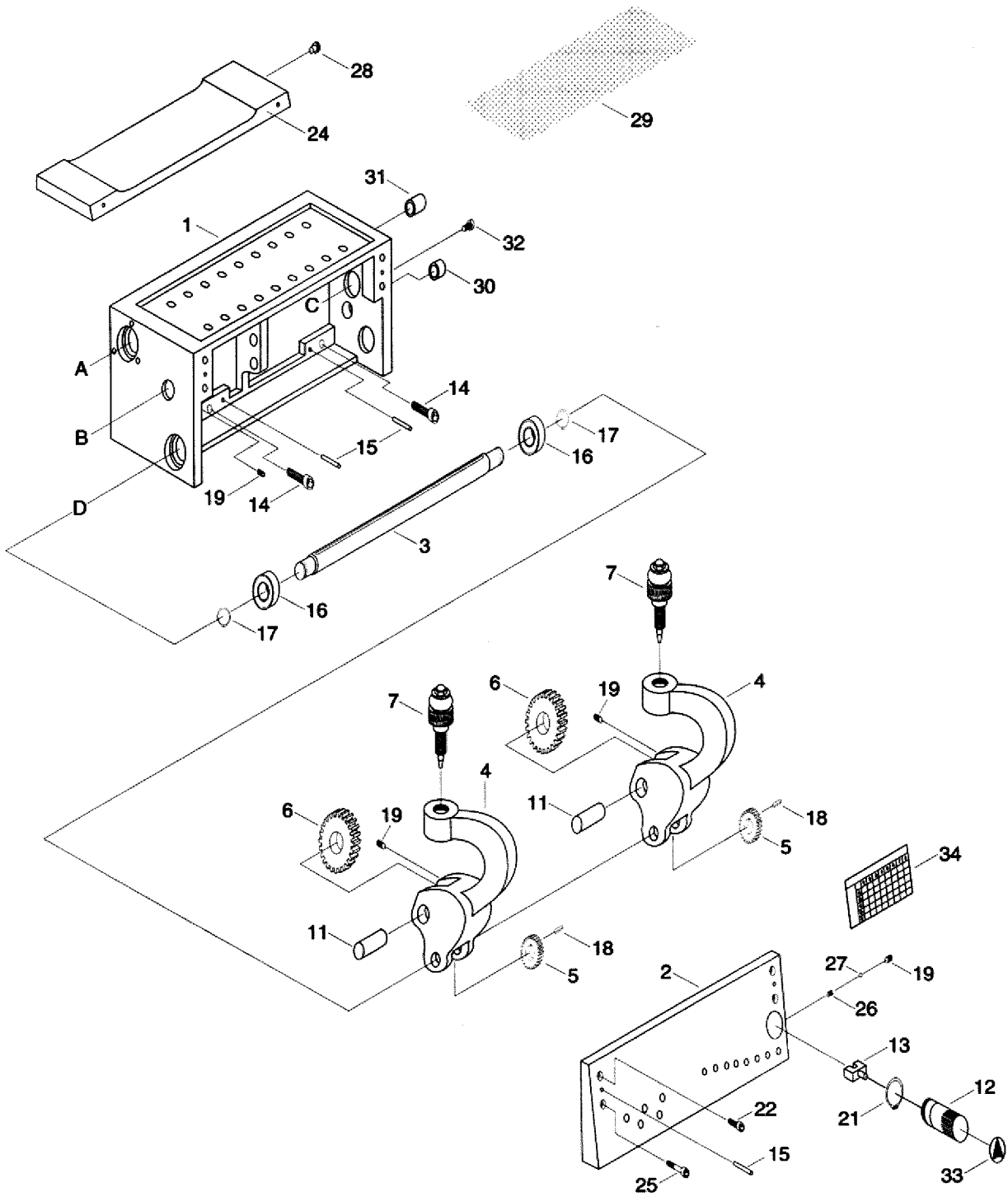
B. PARTS LIST – HEADSTOCK DIAGRAM #1

Ref. #	Part #	Description	Ref. #	Part #	Description
001	P1001001	Headcasting	025	P1001025	O-Ring
002	P1001002	Headstock Cover	026	PR25M	Snap Ring 47mm
003	P1001003	Front Bearing Cap	028	PSB06M	Cap Screw M6-1.0x25
004	P1001004	Rear Bearing Cap	030	P1001030	Oil Seal 22-35-7
005	P1001005	Bearing Cap	031	P1001031	Oil Plug
006	P1001006	Bearing Cap	032	P1001032	Oil Plug
007	P1001007	Bearing Cap	033	P1001033	O-Ring
008	P1001008	Bearing Cap	034	PR32M	Snap Ring 48mm
009	P1003605	Gear 40T	035	P1001035	O-Ring
010	P1003610	Special Washer	036	PRP26M	Roll Pin 5x26
011	P1001011	Knob	037	P1001037	Steel Ball
012	P1001012	Gear Shifter	038	P1001038	Spring
013	P1001013	Shaft	039	PSS17M	Setscrew M8-1.25x6
014	P1001014	Shifting Crank	040	PRP28M	Roll Pin 5x40
015	P1001015	Collar	041	P1001041	Oil Seal 20-35-7
016	P1001016	Gear Shifter, Long	042	P1003049A	Oilsite
017	P1001017	Gear Shifter, Short	043	P1003049B	Gasket
018	P1001018	Hub	044	P1001044	Indicator
019	P1001019	Lever / Stud	045	PSS02M	Setscrew M6-1.0x6
020	P1003050	Knob	046	P1001046	Front Cover
021	P1001021	Gasket, Front	047	PB20M	Hex Bolt M8-1.25x35
022	P1001022	Gasket, Rear	048	PSW03	F / R Switch
023	PSB02M	Cap Screw M6-1.0x20	049	P1001049	Gasket
024	PSB01M	Cap Screw M6-1.0x16			

D. PARTS LIST – HEADSTOCK DIAGRAM #2

Ref. #	Part #	Description	Ref. #	Part #	Description
101	P1001101	Main Spindle	127	P1003610	Special Washer
102	P1001102	Gear 60T	128	PK43M	Key 8x8x45
103	P1001103	Gear 46T	129	PK11M	Key 6x6x40
104	P1001104	Gear 39T	130	P1001130	Bearing 30212
105	P1001105	Spanner Nut	131	PR33M	Ext. Retaining Ring 57mm
106	P1001106	Shaft	132	P1001132	Bearing 30211
107	P1001107	Gear 60T	133	PR11M	Ext. Retaining Ring 25mm
108	P1001108	Gear 51T	134	PR34M	Ext. Retaining Ring 40mm
109	P1001109	Gear 34T	135	P6204	Bearing
110	P1001110	Gear 47T	138	PK45M	Key 6x6x24
111	P1001111	Gear 41T	139	PK07M	Key 6x6x20
112	P1001112	Shaft	140	PK44M	Key 6x6x50
113	P1001113	Gear 32T	142	PK19M	Key 5x5x14
114	P1001114	Gear Spacer	144	P6203	Bearing
115	P1001115	Gear 19T	145	PK46M	Key 6x6x8
116	P1001116	Gear 25T	146	PR35M	Ext. Retaining Ring 17mm
117	P1001117	Pulley	147	P1001147	O-Ring
118	PN13M	Hex Nut M16-2.0	148	PR09M	Ext. Retaining Ring 20mm
119	P1001119	Shaft	149	PSB26M	Cap Screw M6-1.0x12
120	P1001120	Spacer 25-17-14	150	P1001150	Camlock
121	P1001121	Gear 39T	151	P1001151	Camlock Stud
122	P1001122	Gear 28T	152	PSB52M	Cap Screw M8-1.25x10
123	P1001123	Shaft	154	P1001154	Spring
124	P1001124	Gear 28T	155	P1001155	#3 to #5 MT Adaptor
126	P1001126	Spacer 25-20-4	156	P1001156	#3 MT Dead Center

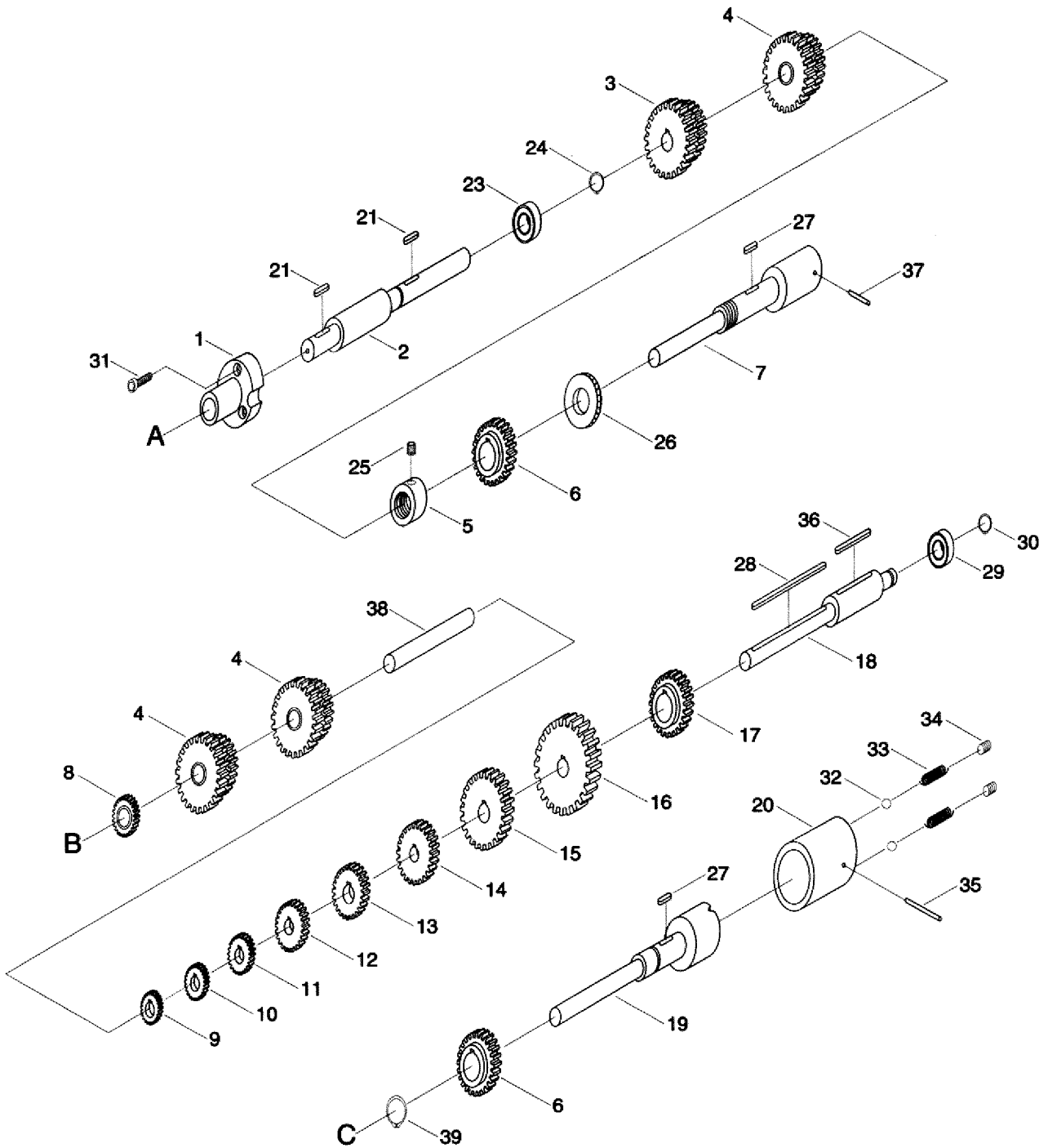
E. GEARBOX DIAGRAM #1



F. PARTS LIST – GEARBOX DIAGRAM #1

Ref. #	Part #	Description	Ref. #	Part #	Description
201	P1003701	Gearbox Casting	219	PSS02M	Setscrew M6-1.0x6
202	P1001201	Front Cover	221	PR31M	Ext. Retaining Ring 38mm
203	P1003705	Shifting Shaft	222	PSB02M	Cap Screw M6-1.0x20
204	P1003718	Change Gear Handle	224	P1003042	Cover
205	P1003715	Gear 16T	225	PSB07M	Cap Screw M6-1.0x30
206	P1003717	Gear 36T	226	P1001226	Spring
207	P1003719	Locating Device	227	P1001227	Ball 5mm
211	P1003716	Shaft	228	P1003115	Oil Cap
212	P1001212	Shift Knob	229	P1001229	Cheese Cloth
213	P1001213	Gear Shifter	230	P1001230	Brass Bush 18x25x15
214	PSB13M	Cap Screw M8-1.25x30	231	P1001231	Brass Bush 18x25x20
215	PRP27M	Roll Pin 5x28	232	P1001232	Special Screw
216	P6201	Bearing	233	P1001044	Indicator
217	PR05M	Ext. Retaining Ring 15mm	234	P1001234	Chart
218	PK19M	Key 5x5x14			

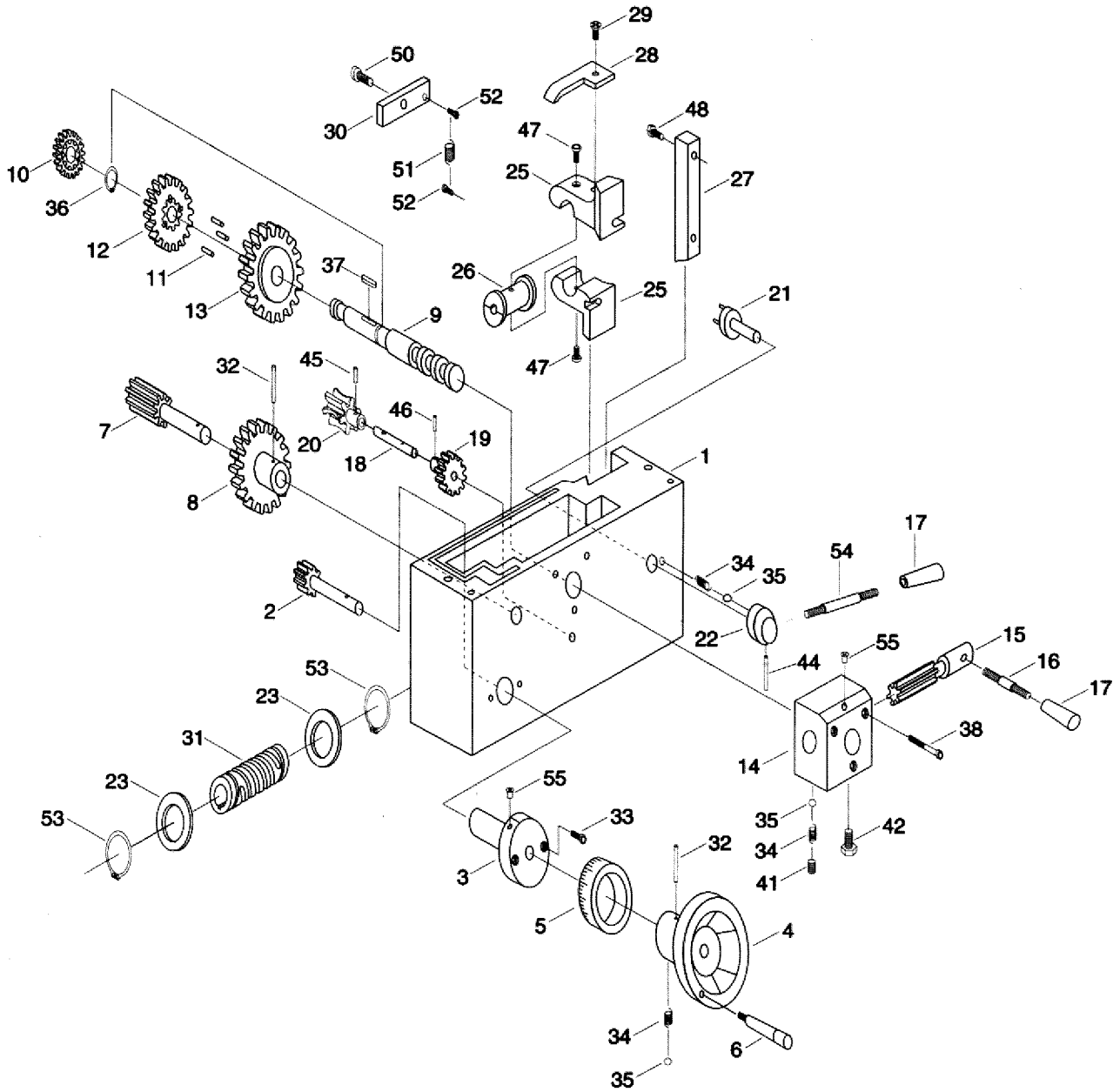
G. GEARBOX DIAGRAM #2



H. PARTS LIST – GEARBOX DIAGRAM #2

Ref. #	Part #	Description	Ref. #	Part #	Description
301	P1003709	Bearing Cap	320	P1001320	Feed Shaft Collar
302	P1003703	Spindle Shaft	321	PK19M	Key 5x5x14
303	P1003710	Gear 16T/ 32T	323	P6003	Bearing
304	P1003711	Gear 16T/ 32T	324	PR06M	Ext. Retaining Ring 16mm
305	P1003729	Thrust Nut	325	PSS02M	Setscrew M6-1.0x6
306	P1003730	Gear 24T	326	P1003757	Thrust Bearing
307	P1003707	Leadscrew Drive Shaft	327	PK10M	Key 5x5x12
308	P1003712	Gear 16T	328	PK13M	Key 5x5x70
309	P1003720	Gear 16T	329	P6002	Bearing
310	P1003721	Gear 18T	330	PR05M	Ext. Retaining Ring 15mm
311	P1003722	Gear 19T	331	PSB01M	Cap Screw M6-1.0x16
312	P1003723	Gear 20T	332	P1001332	Spring
313	P1003724	Gear 22T	333	P1001333	Ball
314	P1003725	Gear 24T	334	PSS17M	Setscrew M8-1.25x6
315	P1003726	Gear 26T	335	PRP28M	Roll Pin 5x40
316	P1003727	Gear 28T	336	PK15M	Key 5x5x35
317	P1003728	Shifting Gear 24T	337	PRP27M	Roll Pin 5x28
318	P1003704	Spindle Shaft	338	P1003704	Spindle Shaft
319	P1003708	Feed Drive Shaft	339	PR07M	Ext. Retaining Ring 18mm

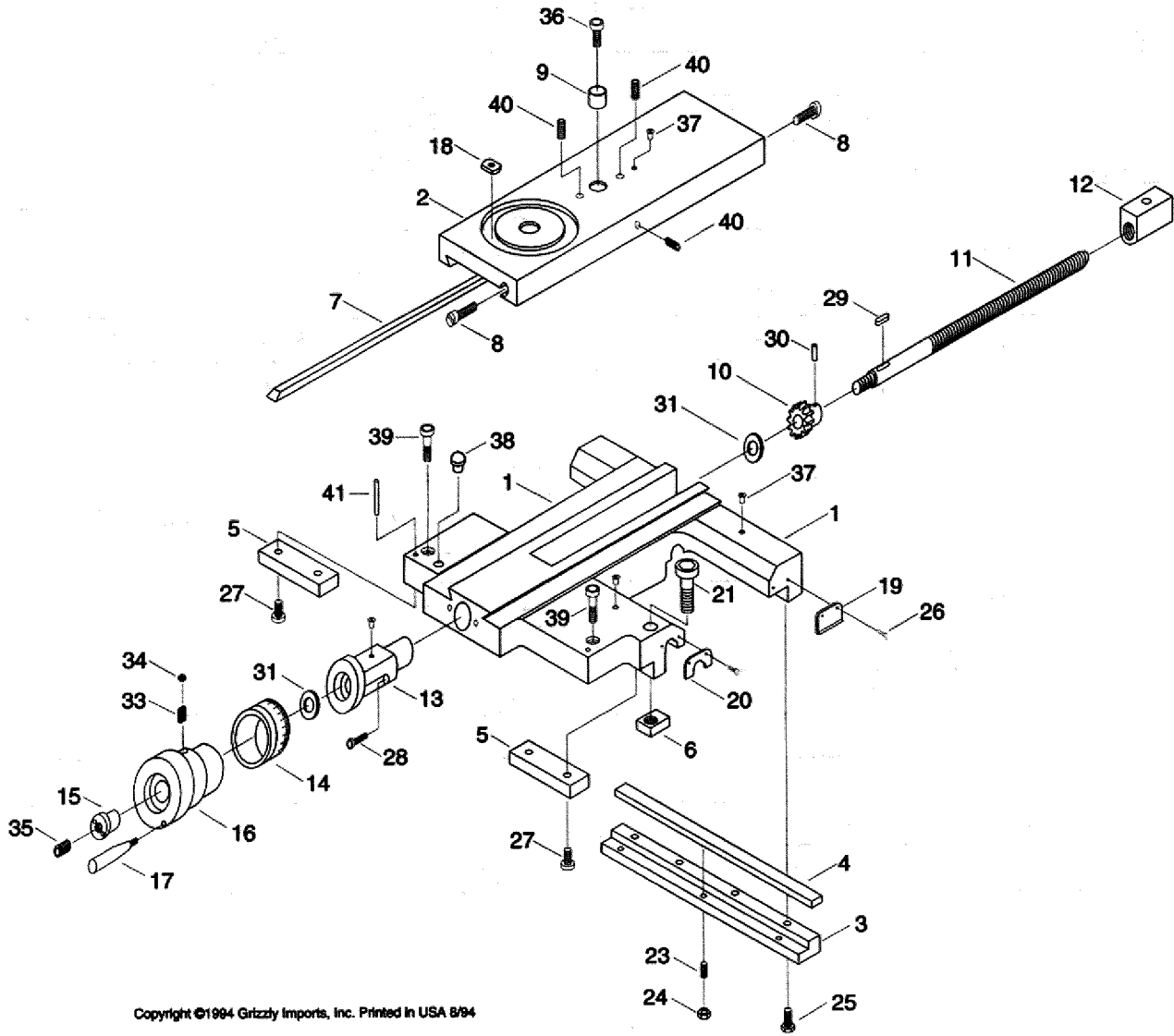
I. APRON DIAGRAM



J. PARTS LIST – APRON DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
401	P1003301	Apron Body	427	P1003326	Gib
402	P1003302	Gear Shaft	428	P1003323	Control Plate
403	P1003303	Bushing	429	PFH03	Flt. Hd Scr. 1/4"-20x1/2"
404	P1003305	Handwheel	430	P1003322	Locating Plate
405	P1003304	Handwheel Dial	431	P1003317	Worm
406	P1003109	Handle	432	PRP30M	Roll Pin 5x50
407	P1003307	Gear Shaft	433	PSB27M	Cap Screw M6-1.0x14
408	P1003308	Gear 50T	434	P1003336	Spring
409	P1003309	Shaft	435	P1003343	Ball
410	P1003310	Clutch Gear 27T	436	PR05M	Ext. Retaining Ring 15mm
411	P1003339	Pin	437	PK04M	Key 4x4x8
412	P1003311	Clutch Gear 40T	438	PSB29M	Cap Screw M6-1.0x40
413	P1003312	Clutch Gear 48T	441	PSS17M	Setscrew M8-1.25x6
414	P1003313	Bracket	442	PB20M	Hex Bolt M8-1.25x35
415	P1003314	Pinion Shaft	444	PRP29M	Roll Pin 5x45
416	P1003365	Lever Stud	445	PRP27M	Roll Pin 5x28
417	P1003050	Knob	446	PRP22M	Roll Pin 4x32
418	P1003320	Shaft	447	PSB26M	Cap Screw M6-1.0x12
419	P1003321	Gear 24T	448	PB08M	Hex Bolt M6-1.0x20
420	P1003319	Worm Gear	450	P1003348	Special Screw
421	P1003327	Cam	451	P1003350	Spring
422	P1003328	Hub	452	PS01	Phlp Hd Scr. 10-24x1/2"
423	P1001423	Spacer	453	P1003367	Snap Ring 1 1/4"
425	P1003324	Half Nut Clutch	454	P1003329	Handle Lever
426	P1003325	Half Nut Set	455	P1003117	Oil Cap

K. CARRIAGE DIAGRAM

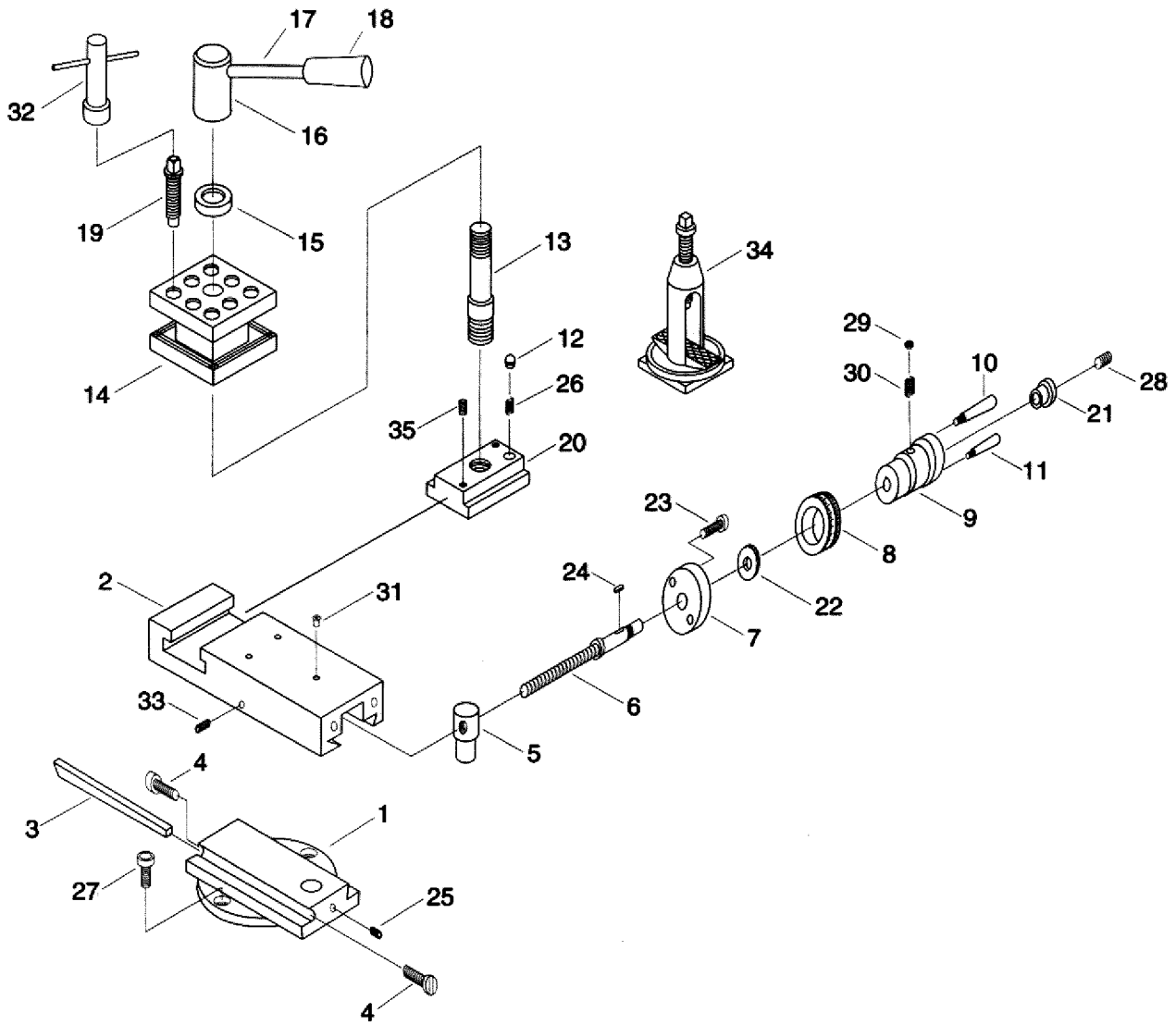


Copyright ©1994 Grizzly Imports, Inc. Printed in USA 8/94

L. PARTS LIST – CARRIAGE DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
501	P1003101	Carriage Casting	521	PSB21	Cap Screw $7/16$ "-14x2 $1/2$ "
502	P1003201	Cross Slide	523	PSS11M	Setscrew M6-1.0x16
503	P1003111	Rear Clamp	524	PN01M	Hex Nut M6-1.0
504	P1003114	Gib	525	PB20M	Hex Bolt M8-1.25x35
505	P1003110	Front Clamp	526	PS01	Phlp Hd Scr. 10-24x $3/8$ "
506	P1003119	Carriage Lock Nut	527	PSB11M	Cap Screw M8-1.25x16
507	P1003202	Cross Slide Gib	528	PSB06M	Cap Screw M6-1.0x25
508	P1003203	Gib Adj. Screw	529	PK10M	Key 5x5x12
509	P1003204	Screw Set Bushing	530	PRP03M	Roll Pin 5x30
510	P1003104	Cross Feed Pinion	531	P1003122	Thrust Bearing
511	P1003102	Cross Feed Screw	533	P1003124	Spring
512	P1003103	Cross Feed Nut	534	P1003125	Ball
513	P1003105	Cross Feed Bushing	535	PSS15M	Setscrew M12-1.75x12
514	P1003107	Cross Feed Dial	536	PSB14M	Cap Screw M8-1.25x20
515	P1003106	Spanner Nut	537	P1003117	Oil Cap
516	P1003108	Cross Feed Handle	538	P1003115	Oil Plug
517	P1003109	Hand Knob	539	PSB40M	Cap Screw M8-1.25x35
518	P1003209	Swivel Lock Nut	540	PSS11M	Setscrew M8-1.25x20
519	P1003112A	Wiper	541	PRP30M	Roll Pin 5x50
520	P1003112	V-Wiper			

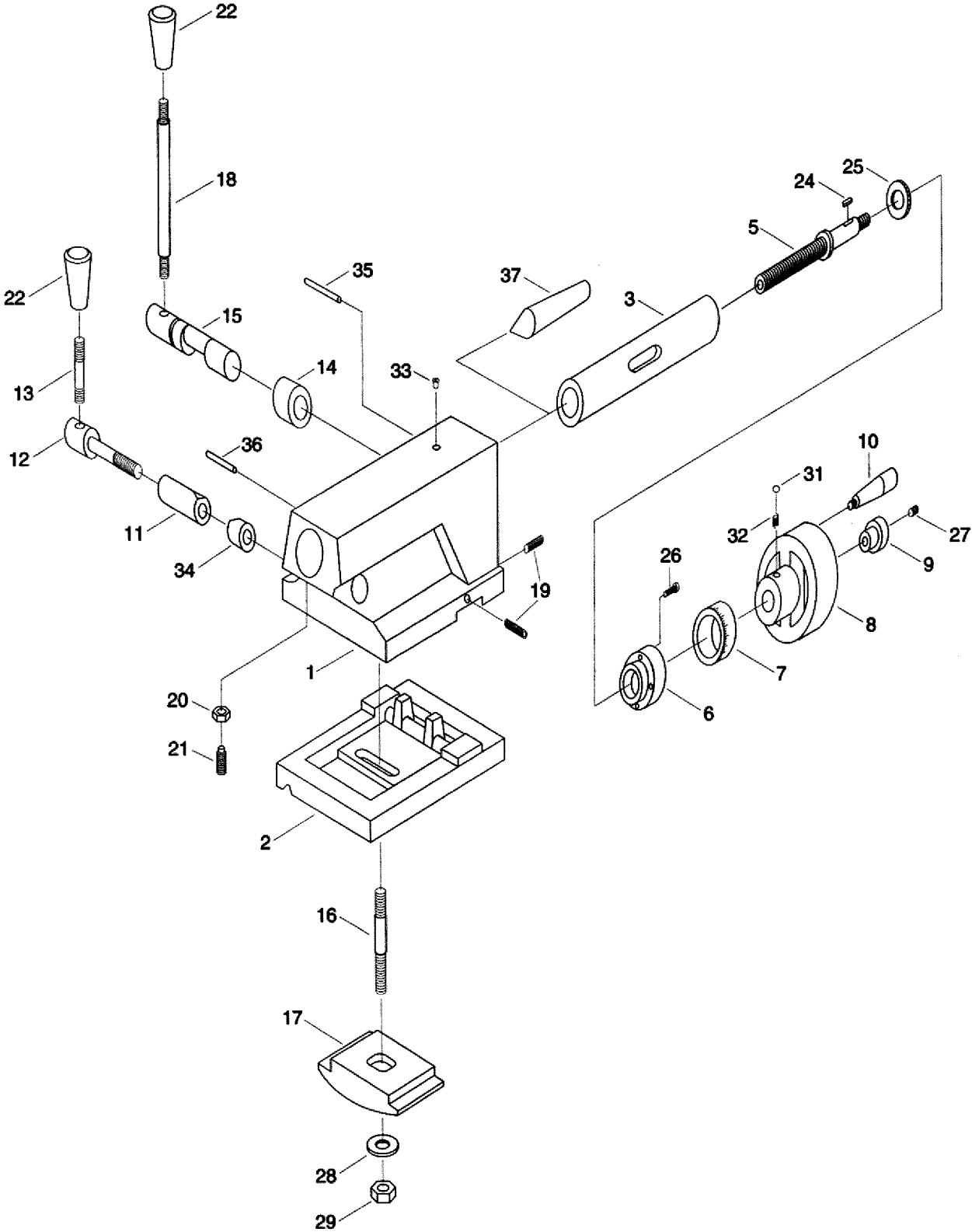
M. COMPOUND SLIDE DIAGRAM



N. PARTS LIST – COMPOUND SLIDE DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
601	P1003205	Swivel	619	P1003221	Set Bolt
602	P1003206	Compound Slide	620	P1003219	T-Slot Nut
603	P1003207	Gib	621	P1003106	Spanner Nut
604	P1003208	Gib Adjustment Screw	622	P1003231	Thrust Bearing
605	P1003210	Compound Nut	623	PSB14M	Cap Screw M8-1.25x20
606	P1003211	Compound Screw	624	PK05M	Key 4x4x10
607	P1003212	Screw Bushing	625	PSS02M	Setscrew M6-1.0x6
608	P1003213	Dial	626	P1001626	Spring
609	P1003215	Handwheel	627	PSB11M	Cap Screw M8-1.25x16
610	P1003216	Long Handle	628	PSS15M	Setscrew M12-1.75x12
611	P1003217	Short Handle	629	P1003125	Ball
612	P1001612	Pin	630	P1003124	Spring
613	P1003218	Tool Post Pin	631	P1003117	Oil Cap
614	P1003220	Tool Post	632	P1003233A	Tool Post Wrench
615	P1003222	Spacer	633	PSS01M	Setscrew M6-1.0x10
616	P1003223	Tool Post Clamp	634	P1003233B	American Rocker Tool Post
617	P1003224	Clamp Lever	635	PSS11M	Setscrew M6-1.0x16
618	P1003050	Knob			

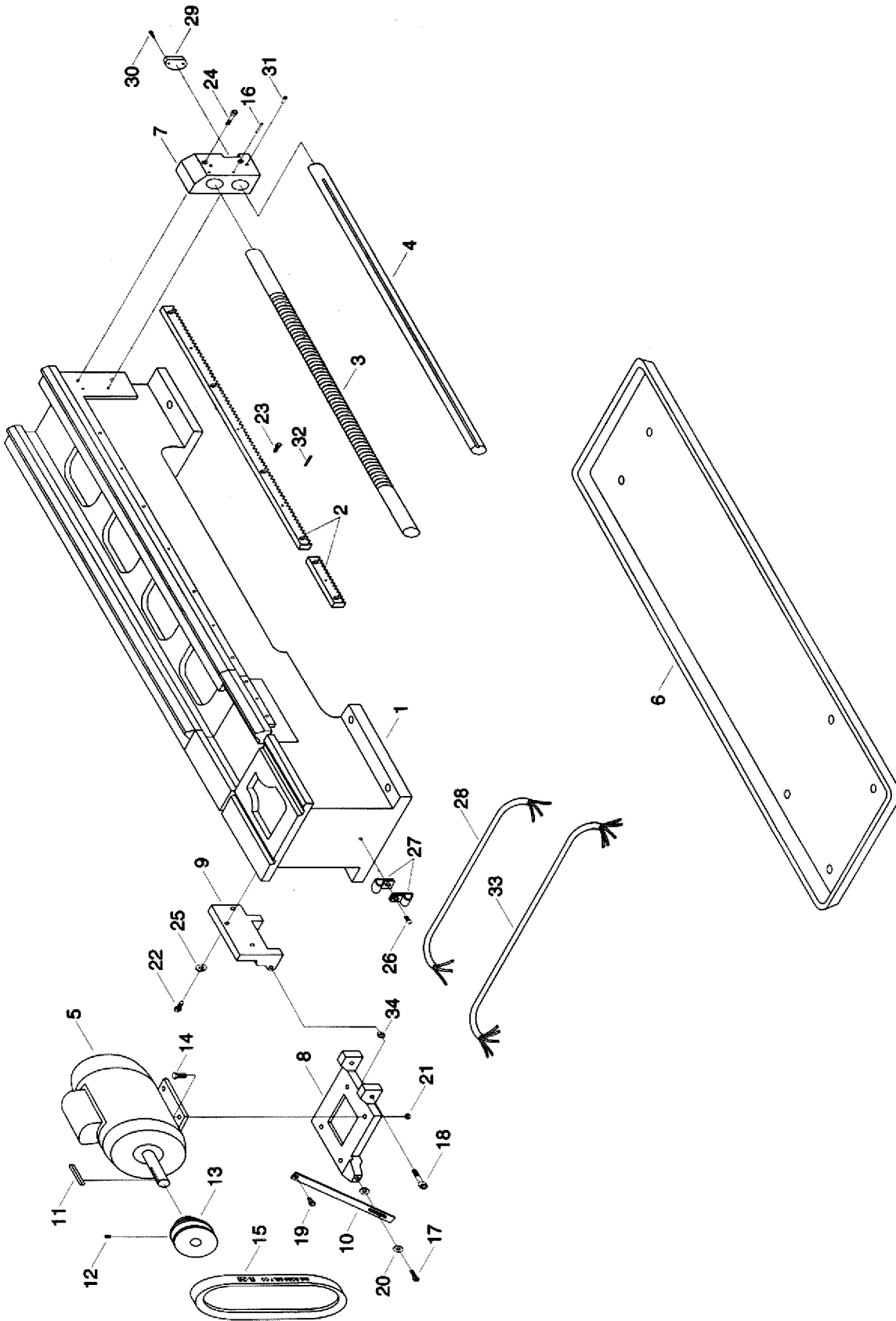
O. TAILSTOCK DIAGRAM



P. PARTS LIST – TAILSTOCK DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
701	P1003401	Tailstock Casting	719	PSS11M	Setscrew M8-1.25
702	P1003409	Tailstock Base	720	PN03M	Hex Nut M6-1.0
703	P1003402	Tailstock Barrel	721	P1003427	Special Setscrew
705	P1003403	Leadscrew	723	P1003050	Knob
706	P1003404	Leadscrew Bushing	724	PK10M	Key 5x5x12
707	P1003107	Dial	725	P1003423	Thrust Bearing
708	P1003406	Handwheel	726	PSB02M	Cap Screw M6-1.0x20
709	P1003106	Spanner Nut	727	PSS15M	Setscrew M12-1.75x12
710	P1003407	Handle	728	P1003430	Special Washer
711	P1003419	Long Clamp Bushing	729	PN09M	Hex Nut M12-1.75
712	P1003418	Clamp Hub	731	P1003125	Steel Ball
713	P1003417	Locking Lever	732	P1003124	Spring
714	P1003416	Eccentric Sleeve	733	P1003117	Oil Cap
715	P1003414	Clamp Shaft	734	P1003410	Short Clamp Bushing
716	P1003412	Clamp Stud	735	PRP30M	Roll Pin 5x50
717	P1003411	Clamp	736	PRP28M	Roll Pin 5x40
718	P1003413	Clamp Handle Lever	737	P1001156	Dead Center #3 M.T.

Q. BED DIAGRAM

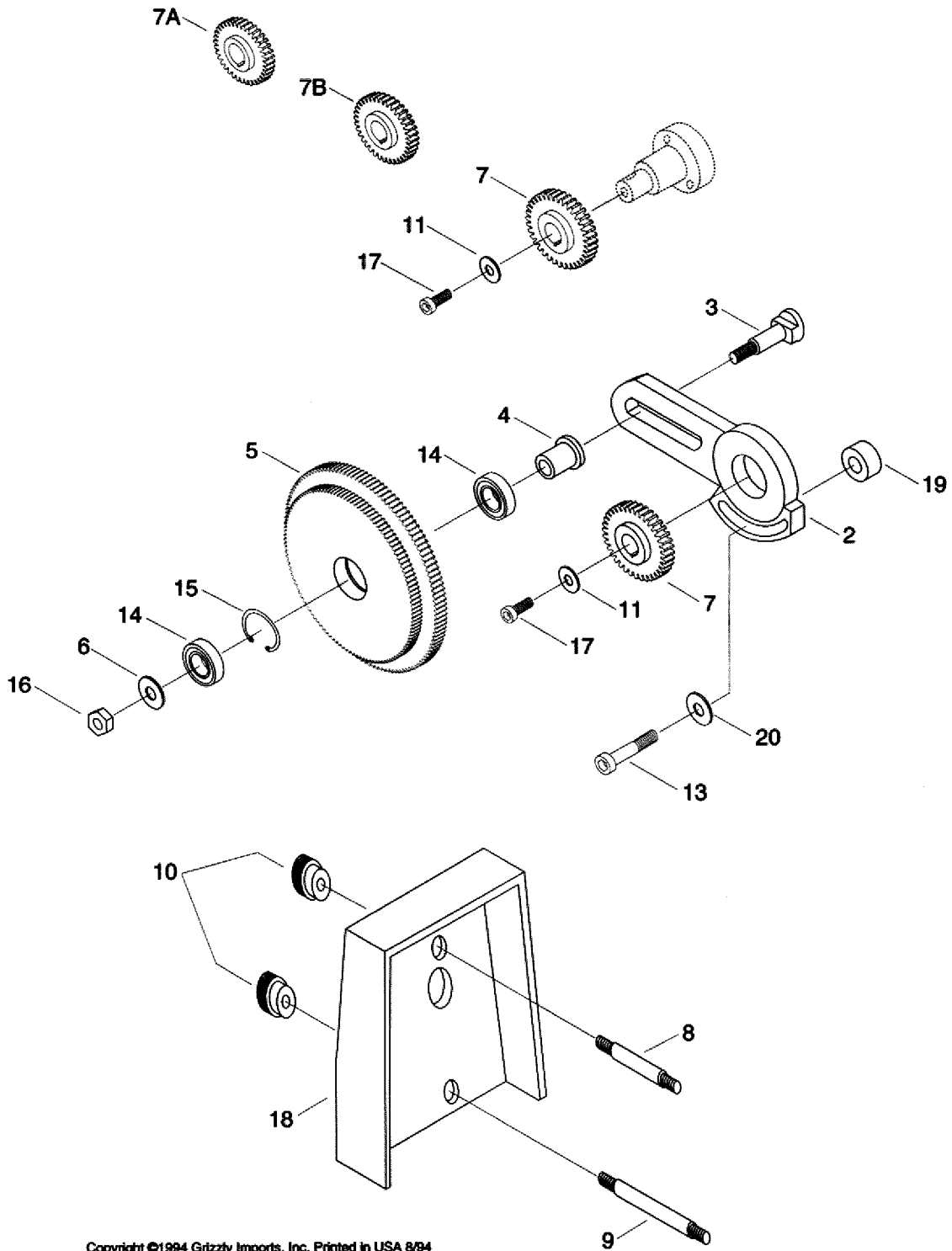


Copyright ©1994 Galzby Imports, Inc. Printed in USA 8/94

R. PARTS LIST – BED DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
801	P1001801	Bed	818	PSB47M	Cap Screw M10-1.5x40
802	P1001802	Rack	819	P1001819	Spec. Bolt M10-1.5
803	P1003503	Leadscrew	820	PW01M	Flat Washer 8mm
804	P1003504	Feed Rod	821	PN03M	Hex Nut M8-1.25
805	P1003082	Motor	822	PB07M	Hex Bolt M8-1.25x25
806	P1003506	Chip Pan	823	PSB02M	Cap Screw M6-1.0x20
807	P1003505	End Bracket	824	PSB05M	Cap Screw M8-1.25x50
808	P1001808	Motor Plate	825	PW01M	Lock Washer 8mm
809	P1001809	Hinge Bracket	826	PS01	Phlp Hd Scr. 10-24x ³ / ₈ "
810	P1001810	Bracket	827	P1001827	Wire Clamp
811	PK35M	Key 5x5x32	828	P1001828	Power Cord
812	PSS06M	Setscrew M8-1.25x16	829	P1003521	Shaft Retainer
813	P1001813	Motor Pulley	830	PSB33M	Cap Screw M5-0.8x12
814	PB26M	Hex Bolt M8-1.25x30	831	P1003117	Oil Cap
815	PVB26	V-Belt	832	PRP07M	Roll Pin 6x20
816	PRP34M	Roll Pin 6x55	833	P1001833	Switch Cord
817	PSB31M	Cap Screw M8-1.25x25	834	PN02M	Hex Nut M10-1.5

S. END GEAR TRAIN DIAGRAM

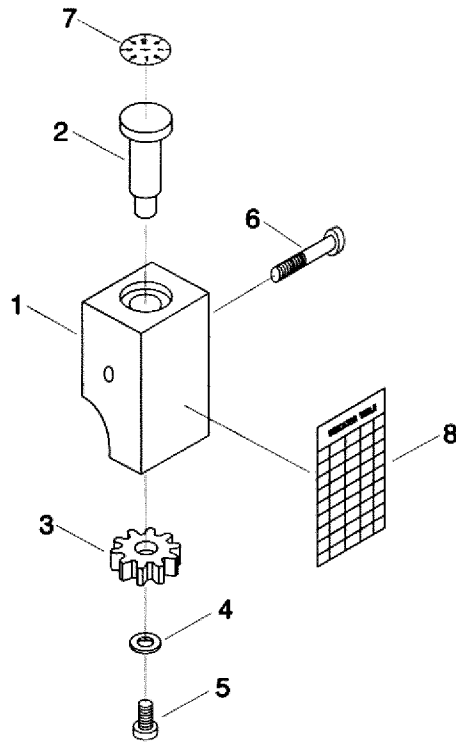


Copyright ©1994 Grizzly Imports, Inc. Printed in USA 8/94

T. PARTS LIST – END GEAR TRAIN DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
902	P1003609	Lever Quadrant	910	P1003604	Cover Set Knob
903	P1003608	Idler Axle	911	P1003610	Special Washer
904	P1003607	Bushing	913	PSB45M	Cap Screw M8-1.25x45
905	P1003606	Idler Gear	914	P6202	Bearing
906	P1003612	Special Washer	915	PR21M	Ext. Retaining Ring 35mm
907	P1003605	Change Gear 40T	916	PN08M	Hex Nut M10-1.25
907A	P1003605A	Change Gear 30T	917	PSB26M	Cap Screw M6-1.0x12
907B	P1003605B	Change Gear 32T	918	P1001918	End Gear Cover
908	P1001019	Stud	919	P1003619	Spacer
909	P1001909	Stud	920	PW01M	Flat Washer 8mm

U. THREAD INDICATOR DIAGRAM

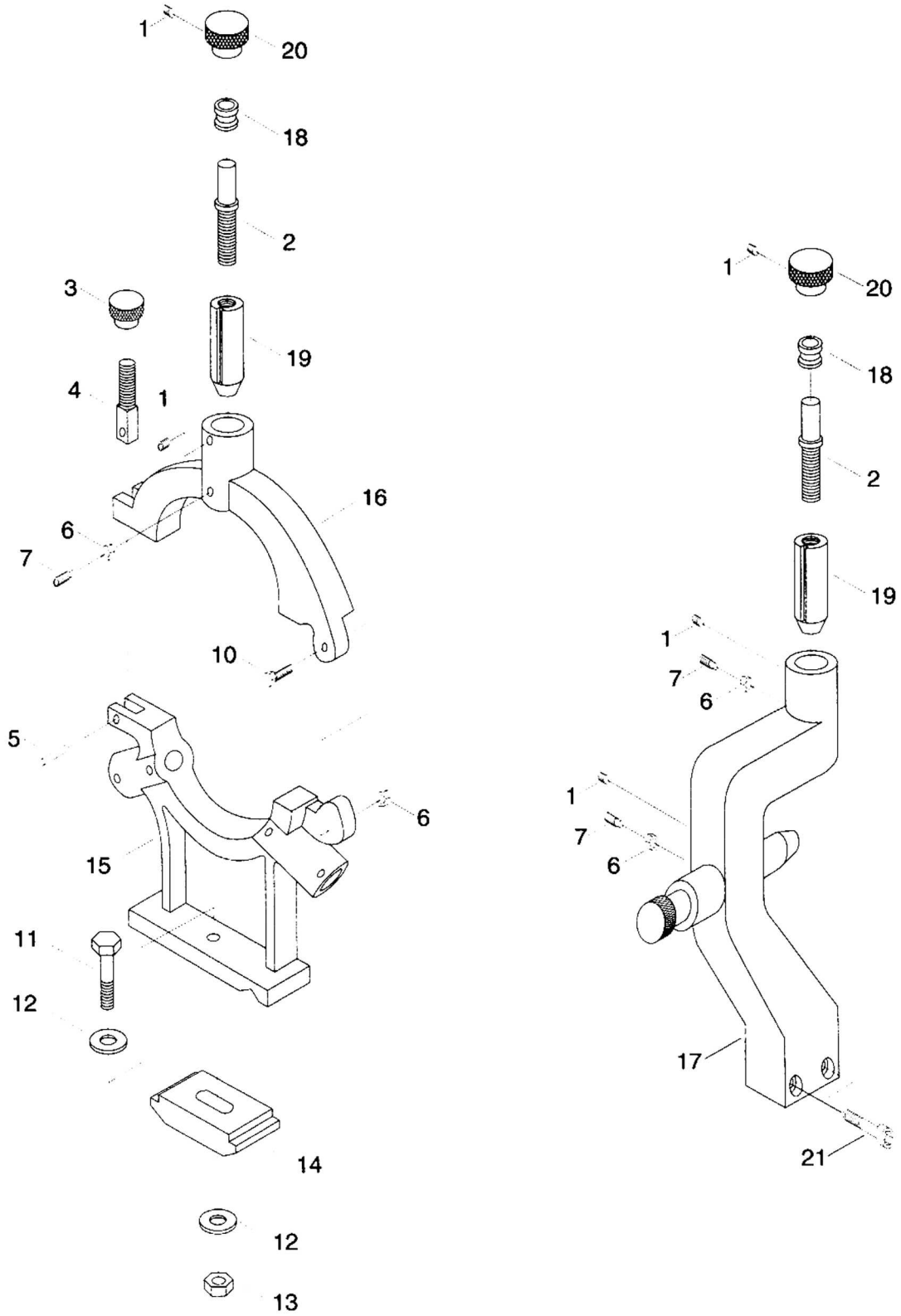


Copyright ©1994 Grizzly Imports, Inc. Printed in USA 8/94

V. PARTS LIST – THREAD INDICATOR DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
1001	P1003330	Lever Quadrant	1005	PSB26M	Cap Screw M6-1.0x12
1002	P1003331	Idler Axle	1006	PSB30M	Cap Screw M6-1.0x45
1003	P1003332	Bushing	1007	P1003804	Thread Dial
1004	PW03M	Flat Washer 6mm	1008	P1003805	Thread Chart

W. REST DIAGRAM



X. PARTS LIST – REST DIAGRAM

Ref. #	Part #	Description	Ref. #	Part #	Description
1101	PSS06M	Setscrew M8-1.25x16	1113	PN19	Hex Nut 7/16"-14
1102	P1003902	Adjusting Screw	1114	P1003411	Clamp
1103	P1003903	Knob	1115	P1003915	Lower Casting
1104	P1003904	Stud	1116	P1003916	Upper Casting
1105	PRP06M	Roll Pin 5x24	1117	P1003917	Follow Rest Casting
1106	PN01M	Hex Nut M6-1.0	1118	P1003918	Bushing
1107	P1003907	Spec. Setscrew M6-1.0x14	1119	P1003919	Mounted Brass Bushing
1110	PB29M	Hex Bolt M6-1.0x30	1120	P1003920	Knob
1111	PB59	Hex Bolt 7/16"-14x2 1/2"	1121	PSB40M	Cap Screw M8-1.25x35
1112	PW04	Flat Washer 7/16"			