



MODEL G0540
SINGLE SPINDLE HORIZONTAL
BORING MACHINE
OWNER'S MANUAL
(For models manufactured since 1/12)



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#BL7175 PRINTED IN CHINA



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Machine Description

The Model G0540 horizontal boring machine is designed to drill accurate holes into the edges of lumber using drill bits or end mills—for doweling, hardware alignment, and basic mortising.

Two hand levers control table movement, and a front-mounted handwheel enables precise workpiece height adjustment. Adjustable table stops can be used to set the maximum side-to-side or front-to-back movement of the table. A hold-down clamp is used to secure the workpiece.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
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


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 contained inside. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive will be slightly different than what is shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused about a procedure, 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, please write down the **Manufacture Date** and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		WARNING!	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure machine is properly adjusted/setup and	
Weight:		4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.	
		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9.	
		10. Maintain machine carefully to prevent accidents.	

Manufactured for Grizzly in Taiwan

Manufacture Date []

Serial Number []



Identification

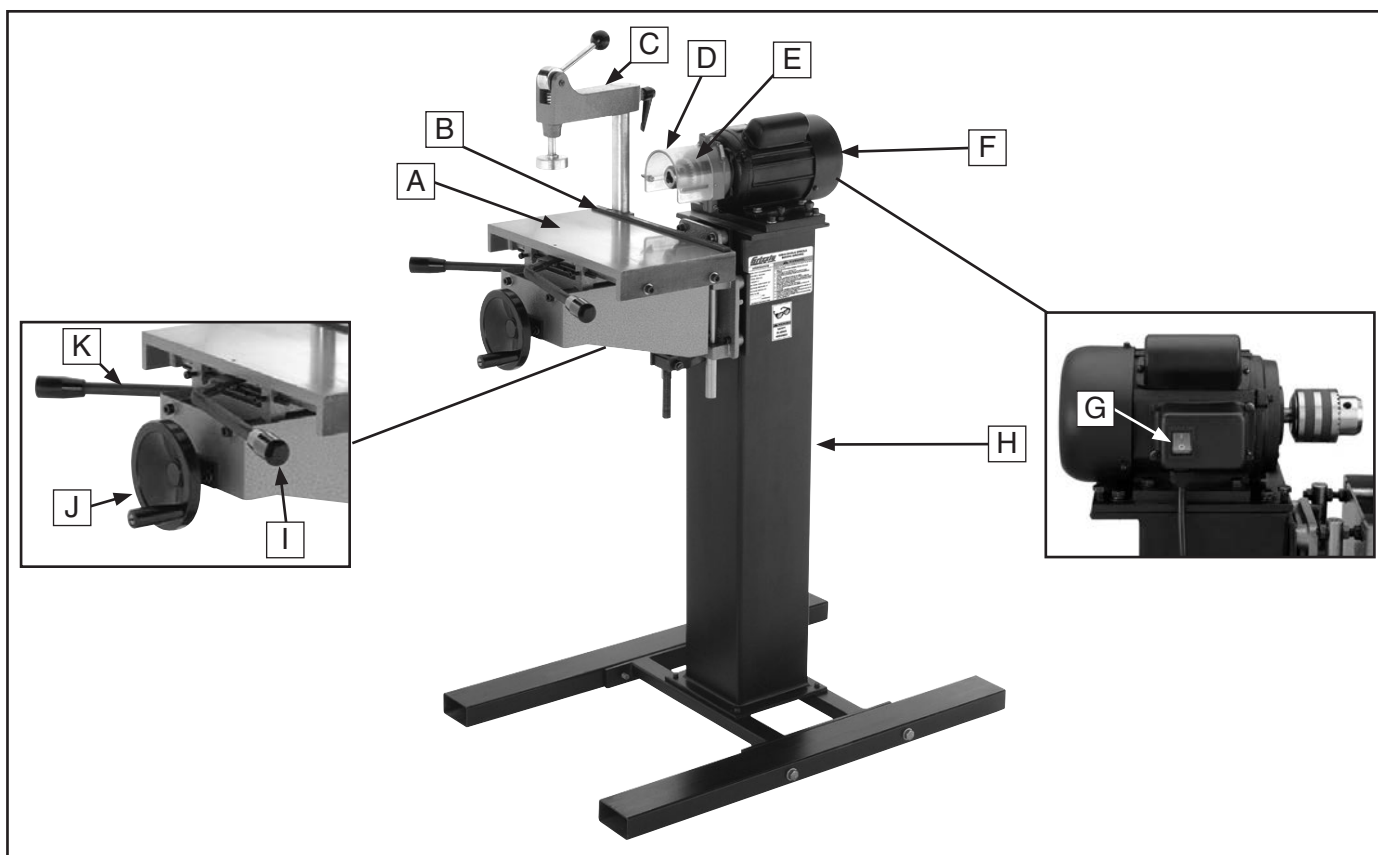


Figure 1. G0540 controls and features.

- | | |
|---------------------------|--|
| A. Work Table | G. ON/OFF Switch |
| B. Fence | H. Stand |
| C. Hold-Down Clamp | I. Horizontal Adjustment Handle |
| D. Chuck Guard | J. Elevation Handwheel |
| E. Chuck | K. Table Feed Handle |
| F. Motor | |





MACHINE DATA SHEET

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

MODEL G0540 SINGLE SPINDLE HORIZONTAL BORING MACHINE

Product Dimensions:

Weight..... 189 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 40-1/2 x 22 x 43 in.
Footprint (Length x Width)..... 22-1/4 x 31-1/2 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 201 lbs.
Length x Width x Height..... 22 x 37 x 20 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 12A
Minimum Circuit Size..... 15A
Switch..... Rocker Switch
Cord Length..... 10 ft.
Cord Gauge..... 16 AWG
Plug Included..... Yes

Motors:

Main

Type..... TEFC Capacitor-Start Induction
Horsepower..... 3/4 HP
Phase..... Single-Phase
Amps..... 12A
Speed..... 3450 RPM
Power Transfer Direct Drive
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Spindle RPM..... 3450
Drill Bit Type..... Chuck Type
Bit Cap..... 5/8 in.

Table Information

Table Travel Vertical..... 2-1/8 in.
Table Travel Front To Back..... 4-1/8 in.
Table Travel Side To Side..... 6 in.
Floor To Table Height..... 33-7/8 - 36-7/8 in.
Table Size Length..... 14-1/4 in.
Table Size Width..... 8-1/4 in.



Construction

Table.....	Cast Iron
Table Vertical Slide.....	Cast Iron
Base.....	Heavy Duty Welded Steel
Body.....	Steel/Cast Iron
Paint.....	Epoxy

Other Specifications:

Country Of Origin	China
Warranty	1 Year
Serial Number Location	ID Label
Approximate Assembly & Setup Time	1 Hour

Features:

Cam Action Hold Down Clamp
Table Moves on Ground Columns
See-Through Safety Guard
Adjustable Table Stops
Heavy Duty Stand



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.



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



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



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

This symbol is used to alert the user to useful information about proper operation of the machine.

Safety Instructions for Machinery



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 workshop kid proof!

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

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

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

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

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



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and 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!

INTENDED USAGE. Only use machine for its intended purpose and never make modifications not approved by Grizzly. Modifying machine or using it differently than intended may result in malfunction or mechanical failure that can lead to serious 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.

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.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

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 Boring Machines

WARNING

EYE/FACE/HAND PROTECTION. Debris from the drilling operation can be thrown at the operator. Always wear safety glasses or a face shield to protect your eyes and face during boring operations. The spinning bit is sharp and can cause serious injury. Always keep hands and fingers away from the moving bit and the chuck. To reduce the risk of entanglement, DO NOT wear gloves when operating this machine.

GUARDS. The chuck guard reduces the risk of debris being thrown at the operator. DO NOT operate this machine with the guard removed.

BORING OPERATION. Boring bits rotate with tremendous torque, especially at start up. To avoid a bit grabbing the workpiece and unexpectedly moving it, never start the machine with a bit pressed against the workpiece.

BORING BITS. A rapidly spinning boring bit can be thrown at the operator if it comes loose from the chuck. Only use bits with a $\frac{5}{8}$ " shank. Properly secure the bits in the chuck before beginning operations.

DULL OR WORN BITS. Dull or damaged bits may break apart during operation, be thrown at the operator, or reduce the performance of the operation. Inspect the bit before each use. DO NOT operate with a dull or damaged bit.

SECURING WORKPIECE. To keep the workpiece from moving during boring operations, make sure it is placed in a stable position on the table and is secured by the hold-down clamp or additional support fixtures.

SURFACE/WORKPIECE PREPARATION. Never turn the machine **ON** before clearing the table of all tools, scrap wood, etc. Only drill wood products that are free of imperfections or foreign objects. Never use this machine to drill metal.

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

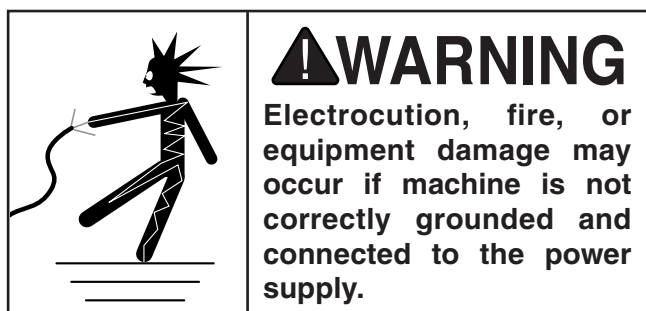
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 110V..... 12 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 requirements in the following section.

! WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

110V Circuit Requirements

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

Nominal Voltage 110V–120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps

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: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*



Grounding & Plug 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.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). 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.

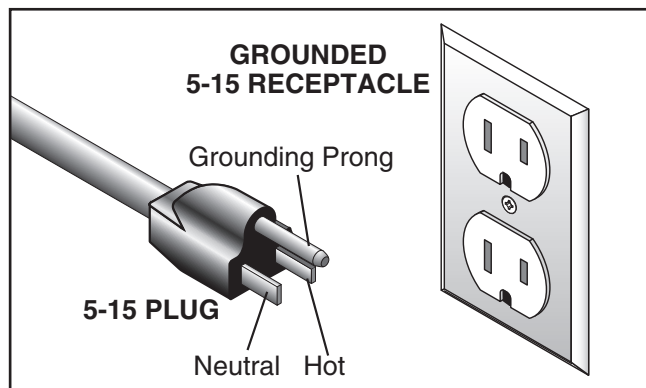
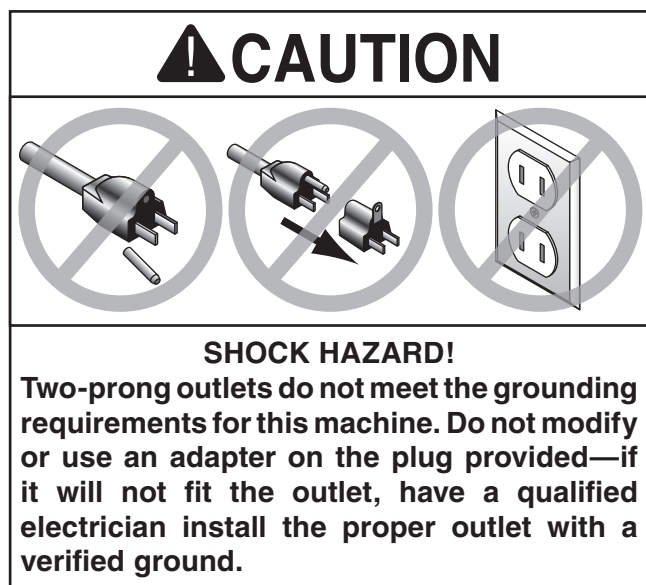


Figure 2. Typical 5-15 plug and receptacle.



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

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 may 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 contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size14 AWG
Maximum Length (Shorter is Better).....50 ft.



SECTION 3: SETUP

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Needed for Setup

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

Description	Qty
• Additional People	1
• Safety Glasses	1
• Cleaner/Degreaser (Page 14)	As Needed
• Disposable Shop Rags.....	As Needed
• Screwdriver Phillips #2	1
• Screwdriver Standard #2.....	1
• Open-End Wrench 18mm.....	1



Inventory

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

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

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Box 1: (Figure 3)	Qty
A. Cross Brace.....	1
B. Table Assembly	1
C. Motor	1
D. Stand	1
E. Legs.....	2
F. Handwheel Handle (Not Shown).....	1

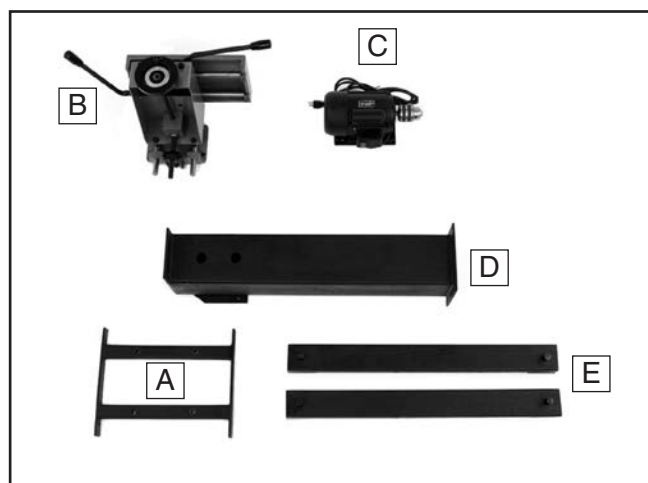


Figure 3. Box 1 inventory.

Box 2 Contents (Figure 4)	Qty
G. Chuck Guard	1
H. Lock Handle	1
I. Hold-Down Clamp	1
J. Column	1

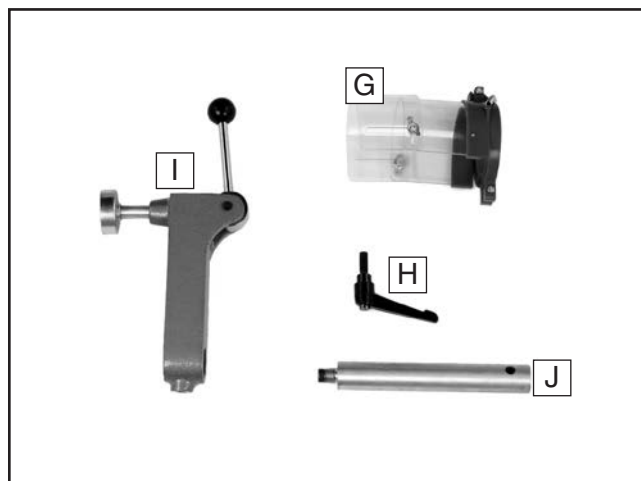


Figure 4. Box 2 inventory.

Hardware and Tools	Qty
• Hex Wrenches, 5, 6mm.....	2
• Chuck Key	1
• Wrench 13 x 16	1
• Hex Bolts M10-1.5 x 100.....	4
• Hex Bolts M10-1.5 x 40	4
• Hex Bolts M12-1.75 x 70	4
• Hex Bolts M8-1.25 x 25	4
• Hex Bolts M8-1.25 x 20	4
• Cap Screws M8-1.25 x 30	2
• Cap Screws M8-1.25 x 35	2
• Flat Washers 10mm	8
• Lock Washers 10mm.....	8
• Flat Washers 8mm	8
• Lock Washers 8mm.....	8
• Hex Nuts M12-1.75	4



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.

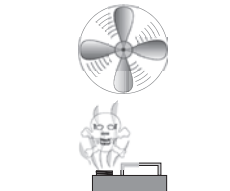
Before cleaning, gather the following:

- 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.
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	⚠ CAUTION Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.
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NOTICE Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.

<p>Call 1-800-523-4777 To Order</p>	
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Figure 5. T23692 Orange Power Degreaser.



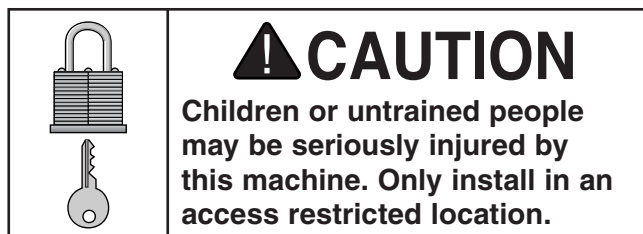
Site Considerations

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.**



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 access to a means of disconnecting the power source or engaging 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.

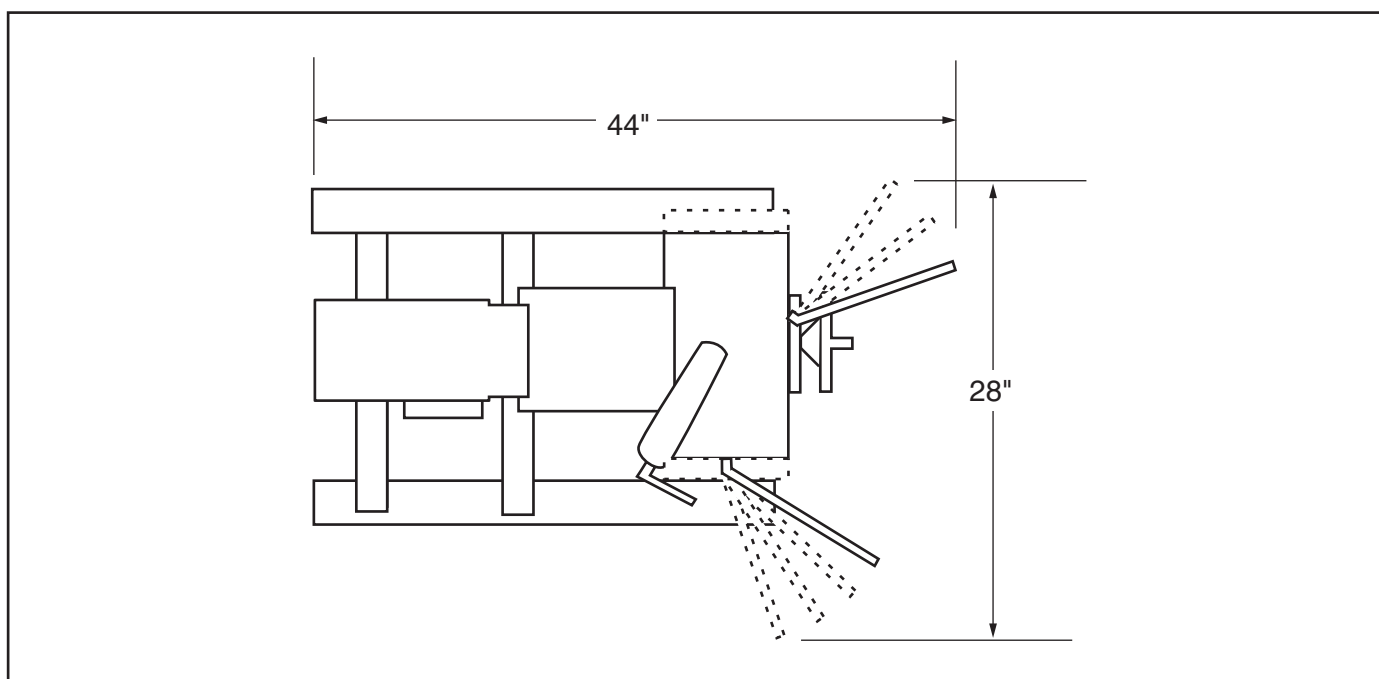


Figure 6. Minimum working clearances.



Mounting

Although not required, we recommend that you mount your new machine to the floor. Use the four holes in the legs as a guide for drilling.

Because this is an optional step and floor materials may vary, floor mounting hardware is not included. To ensure accurate operation results, make sure your mounting location is as level as possible and that you provide adequate work room all around the boring machine. Use metal shims to level the machine, if necessary.

Bolting to Concrete Floors

Lag shield anchors with lag screws and anchor studs (**Figure 7**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

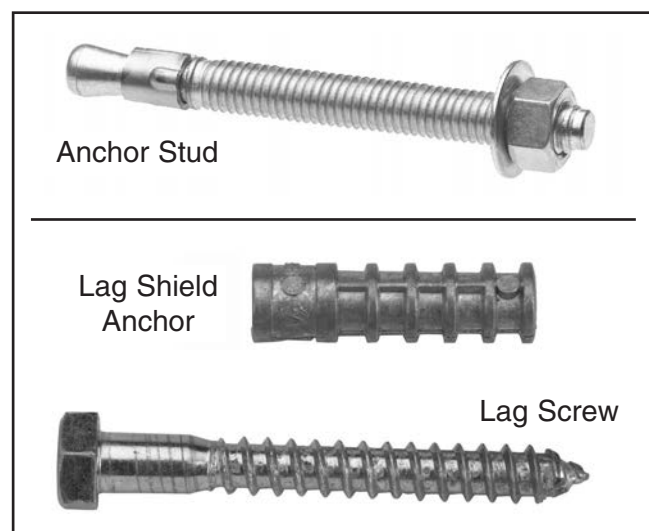


Figure 7. Typical fasteners for mounting to concrete floors.

NOTICE

Anchor studs are the strongest option, but they stick out of the floor—permanently. Before using, make sure you have enough clearance to lift the machine over the studs if it must be moved in the future.

Stand, Cross Brace & Legs

To install the stand onto the cross brace:

1. Place the cross brace on a flat surface.
2. Position the two legs perpendicular to the cross brace, making sure the mounting holes are aligned.
3. Fasten the legs to the cross brace with four M10-1.5 x 100 hex bolts, 10mm lock washers, and 10mm flat washers, as shown in **Figure 8**.

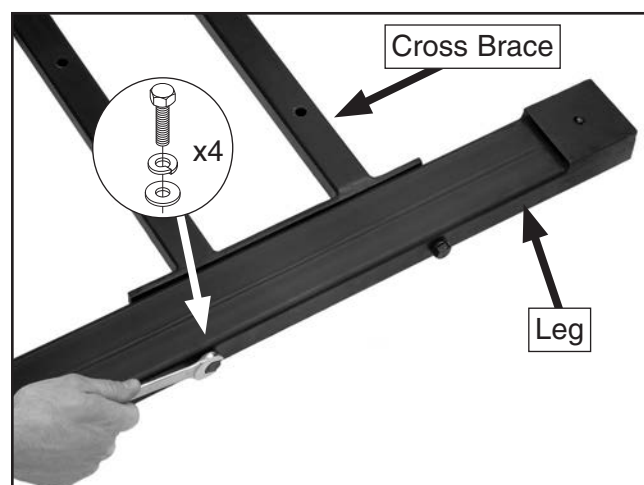


Figure 8. Fastening legs to cross brace.



⚠ WARNING
BACK INJURY HAZARD!
DO NOT over-exert yourself moving your machine—get assistance during the next step.



- Turn the stand upside down and place the cross brace on the stand bottom, as shown in **Figure 9**.

Note: The leg pads should face up and the longer length of the legs should be on the same side as the table mounting plate.

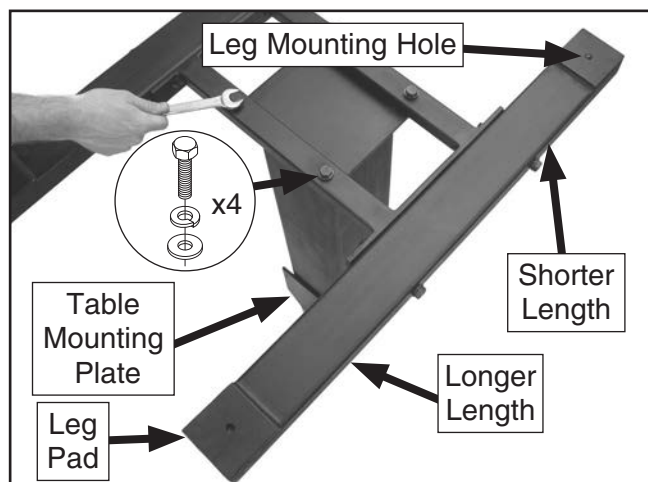


Figure 9. Installing cross brace onto stand.

- Align the mounting holes and secure with four M10-1.5 x 40 hex bolts, 10mm lock washers, and 10mm flat washers, as shown in **Figure 9**.

Note: Do not install the hex bolts from the top of the cross brace. The stand will be unstable and may tip over. The bolts must be installed through the bottom of the cross brace.

- Inspect the leg mounting holes (see **Figure 9**) and remove any extra paint or metal debris from the threads.



Table Assembly

To install the table assembly:

- With another person's help, place the stand on its back, place the table assembly on the table plate, and align the mounting holes (see **Figure 10**).

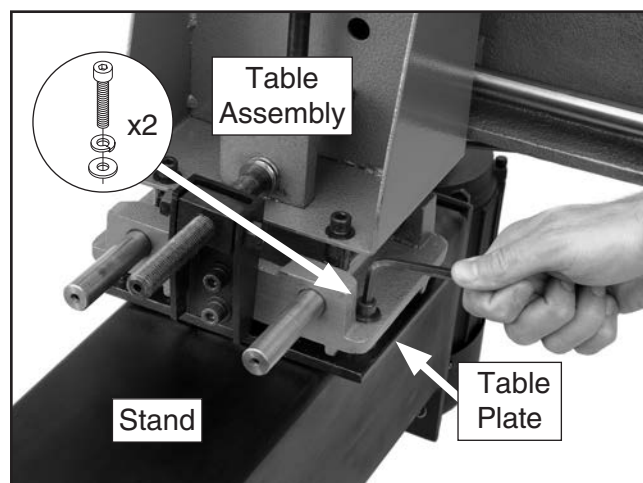


Figure 10. Mounting bottom of table assembly to stand.

- Fasten the bottom of the table assembly to the stand with two M8-1.25 x 35 cap screws, 8mm lock washers, and 8mm flat washers, as shown in **Figure 10**.
- Fasten the top of the table assembly to the stand with two M8-1.25 x 30 cap screws, 8mm lock washers, and 8mm flat washers, as shown in **Figure 11**.

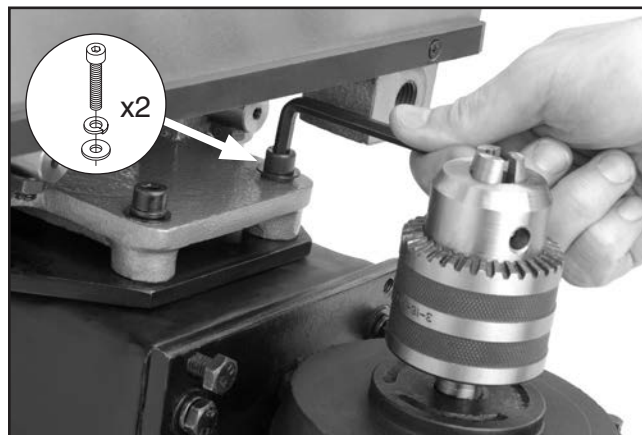


Figure 11. Mounting top of table assembly to stand.

4. Mount the machine to the floor (refer to **Mounting** on **Page 16**), or insert the four M12-1.75 x 70 hex bolts through the leg mounting holes, as shown in **Figure 12**.

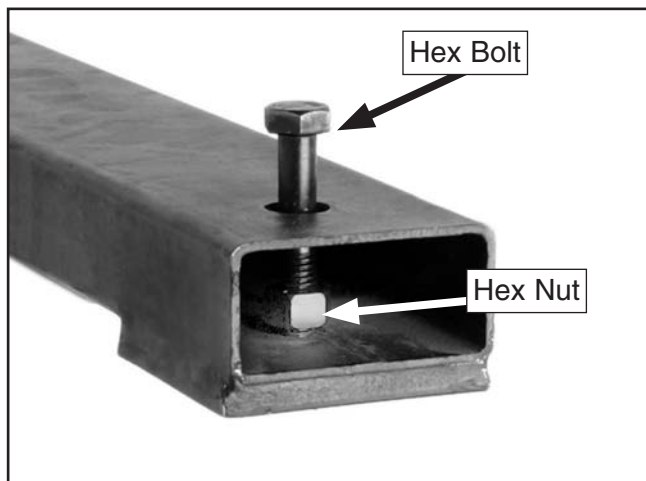


Figure 12. Leveling leg with hex bolts.

5. Thread an M12-1.75 hex nut onto each hex bolt (see **Figure 12**) and continue threading the bolts through the bottom mounting holes until they touch the floor.
6. Adjust the hex bolts up or down to level the legs, as necessary.
7. Thread the handwheel handle onto the handwheel.
8. With another person's help, place the machine upright.

Motor

To install the motor onto the stand:

1. Place the motor mounting plate over the stand and align the mounting holes.
2. Secure the motor mounting plate and stand with four M8-1.25 x 25 hex bolts, 8mm lock washers and 8mm flat washers, as shown in **Figure 13**.

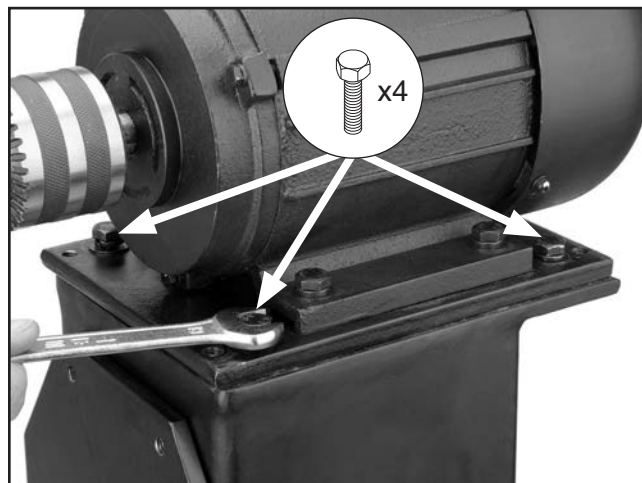


Figure 13. Mounting motor plate to stand.

3. Thread four M8-1.25 x 20 hex bolts several turns into the outer holes of the motor mounting plate (see **14**).

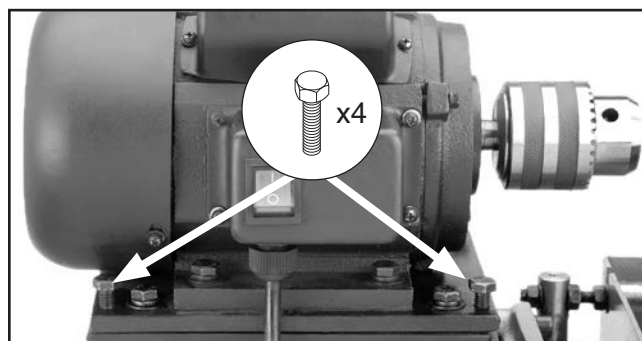


Figure 14. Hex bolts threaded into mounting plate (only one side shown).



Chuck Guard

To install the chuck guard:

1. Loosen the Phillips head screw and hex nut on the chuck guard clamp.
2. Install the chuck guard over the motor spindle with the springs up, and tighten the Phillips head screw and hex nut (see **Figure 15**).

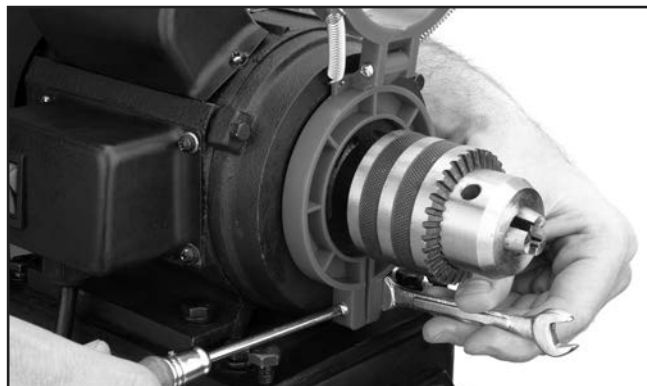


Figure 15. Installing chuck guard.

Hold-Down Clamp

To install the hold-down clamp:

1. Thread the column onto the work table (see **Figure 16**).

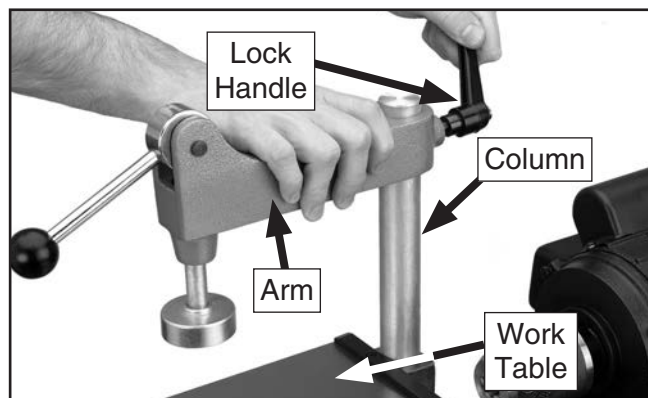


Figure 16. Installing hold-down clamp.

2. Thread the lock handle onto the arm (see **Figure 16**), slide the arm onto the column, then tighten the lock handle.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 27**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Connect the machine to the power source.
4. Turn the machine **ON**.
5. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

6. Turn the machine **OFF**.

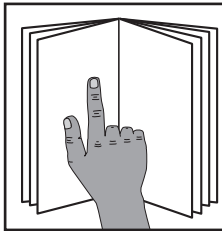


SECTION 4: OPERATIONS

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 and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

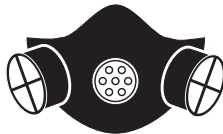


WARNING

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

WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.

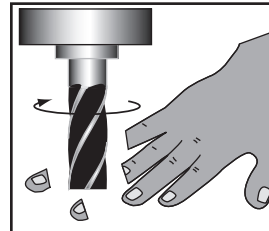


NOTICE

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

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

1. Installs the appropriate bit for the boring operation.
2. Places the workpiece flush against the table and the fence.
3. Uses the handles and handwheel to align the desired drilling location on the workpiece with the bit.
4. Secures the workpiece with the hold-down clamp.
5. Puts on safety glasses and a respirator.
6. Turns the machine **ON**.



CAUTION

AMPUTATION HAZARD
Keep hands and body away from the spinning boring bits!

7. Uses the table feed handle to move the workpiece into the bit, drills the hole, then moves the workpiece out of the bit.
8. Uses the horizontal adjustment handle to move the workpiece left-to-right for additional boring operations.
9. Turns the machine **OFF** when boring operations are complete.
10. Unclamps the workpiece.



Basic Controls

Refer to **Figures 17–18** and the following descriptions to become familiar with the basic controls of this machine.

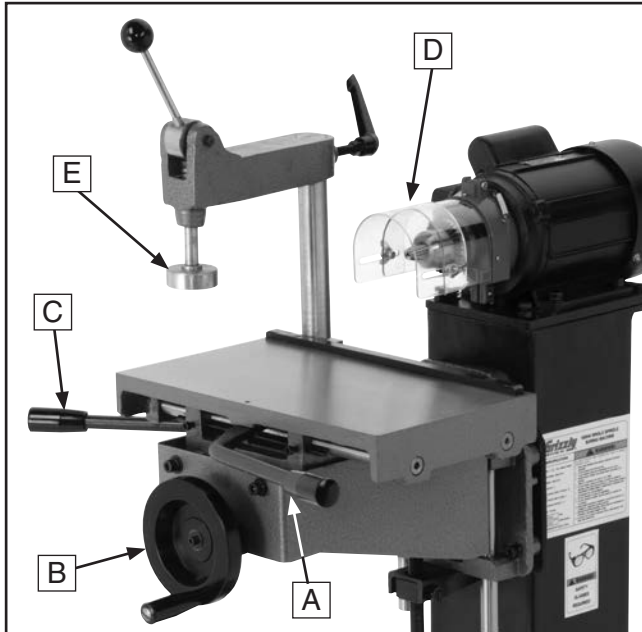


Figure 17. Main controls.

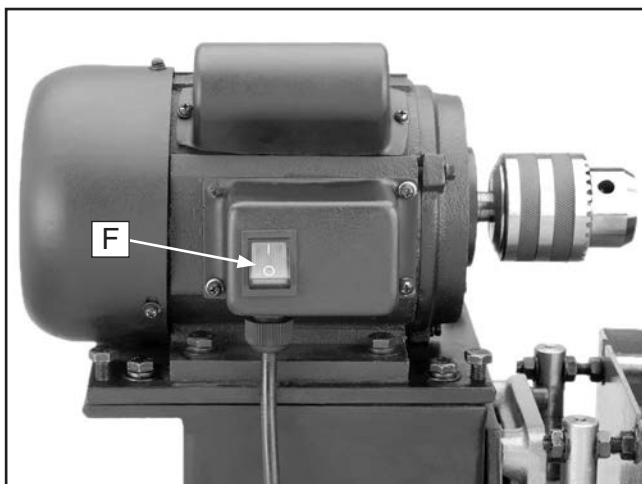


Figure 18. ON/OFF switch

- A. Horizontal Adjustment Handle:** Moves the work table left-to-right.
- B. Elevation Handwheel:** Moves the work table up or down.
- C. Table Feed Handle:** Moves the work table front-to-back.
- D. Chuck Guard:** Adjustable plastic shield covering the chuck that minimizes exposure to sharp drill bits.
- E. Hold-Down Clamp:** Secures the workpiece firmly against the table. Adjusts to accommodate different workpiece thicknesses, and is secured with the lock handle.
- F. ON/OFF Switch:** Starts and stops motor.

Operating Tips

Here are a few things you can do to ensure easy operation and excellent workpiece results:

- Use the right bit for the job.
- Never rush a drilling procedure. Extra care during set up will ensure satisfactory results.
- Maintain your horizontal boring machine in top condition. See **Section 6: Maintenance** beginning on see **Page 25** for maintenance procedures.
- Always use a test piece of wood to check your setup. Only when desired results are achieved, should you use your expensive lumber.
- Always clamp your workpiece.



Drill Bit Changes

The Model G0540 chuck can hold up to $\frac{5}{8}$ " bits. To insert a bit, care must be taken to secure the bit firmly in place. When changing bits follow the instructions below.

To install a drill bit:

1. DISCONNECT MACHINE FROM POWER!
2. Open the chuck guard.
3. Using the chuck key, adjust the chuck jaws as needed to accommodate the drill bit shaft.
4. Install the bit into the chuck, but do not allow it to grab the flutes of the drill bit. Also, ensure small drill bits do not get trapped between the jaw edges.
5. Tighten the chuck, remove the chuck key, then close the chuck guard.
6. Re-connect the machine to power.

To remove a drill bit:

1. DISCONNECT MACHINE FROM POWER!
2. Open the chuck guard, loosen the chuck, grasp the bit with your hand, then remove it.

Table Adjustments

Adjust table stop rods to set the maximum distance the table can move left-to-right and back and forth.

To adjust the front stop rods:

1. Loosen the cap screws that secure the front stop rods (see **Figure 19**), and move the rods left or right to set the maximum horizontal movement.

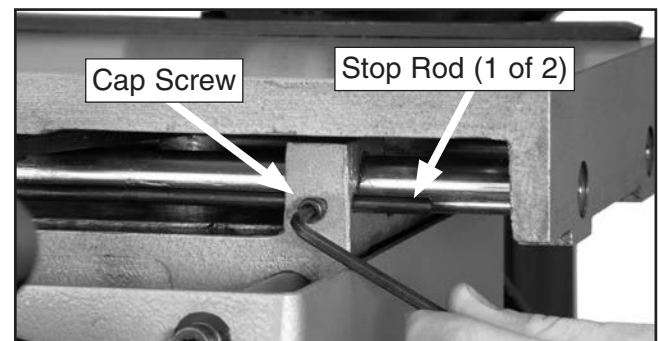


Figure 19. Front stop rod adjustments.

2. Tighten the cap screws and move the horizontal handle to test the stop rod positions.
3. Repeat **Steps 1–2** as necessary.

To adjust the center stop rod:

1. Loosen the cap screw shown in **Figure 20** and adjust the center stop rod.

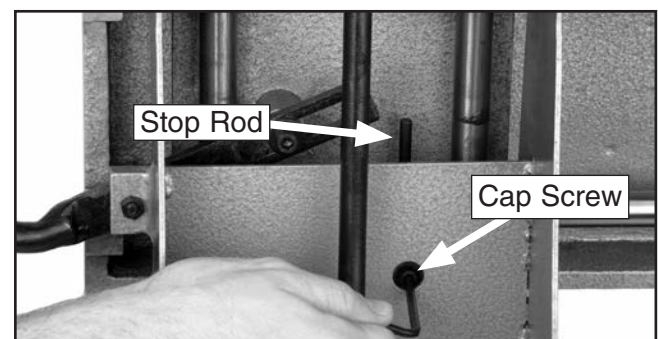


Figure 20. Adjusting center stop rod.

2. Tighten the cap screw, and move the table feed handle back and forth to test the center stop rod position.
3. Repeat **Steps 1–2** as necessary.



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.

G9753—TiN Coated Drill Set 50-Pc. Metric

G9754—TiN Coated Drill Bits 60-Pc. Set

G9755—TiN Coated Drill Bits 26-Pc. Set

These long lasting HSS, TiN coated bits are available in either a 60 piece numbered bit set or 26 piece lettered bit set. Numbered bits range from 1 to 60. Lettered bits range from A to Z. Sets include steel drill indexes. 50 piece set includes 1mm through 6mm inch 0.1mm increments plus steel index.



Figure 21. Model G9753 50-Pc. TiN Coated Bit Set.

G3656—Titanium Drill Bits 29-Pc. Set

G3658—Titanium Drill Bits 115-Pc. Set

Titanium nitride coated bits last up to six times as long as uncoated bits. 29-piece set includes bits ranging from $\frac{1}{16}$ " to $\frac{1}{2}$ " inch increments of $\frac{1}{64}$ ". 115-piece set features 29 fractional bits from $\frac{1}{16}$ " to $\frac{1}{2}$ " inch increments of $\frac{1}{64}$ ", letter bits from A to Z and 60 number bits. Housed in rugged steel case.

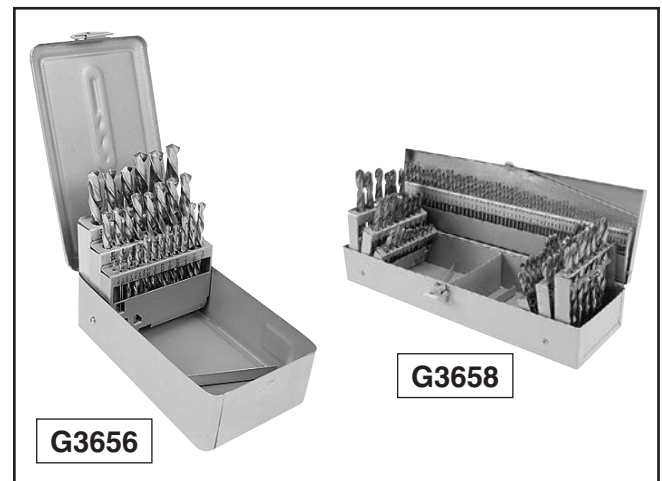


Figure 22. Models G3656 & G3658 Titanium Drill Bit Sets.

D1032—Steelex Carbide-Tipped Brad Point Bit 7-Pc. Set

This is the best set of brad point bits on the market. Set includes: $\frac{1}{8}$ ", $\frac{3}{16}$ ", $\frac{1}{4}$ ", $\frac{5}{16}$ ", $\frac{3}{8}$ ", $\frac{7}{16}$ " and $\frac{1}{2}$ ". Comes in a wooden case.



Figure 23. Model D1032 Brad Point Bit 7-Pc. set.

order online at www.grizzly.com or call 1-800-523-4777



G9756—End Mill Set 20-Pc.

This High Speed Steel set features 2 flute and 4 flute end cutting end mills in the following sizes: $\frac{3}{16}$ ", $\frac{1}{4}$ ", $\frac{5}{16}$ ", $\frac{3}{8}$ ", $\frac{7}{16}$ ", $\frac{1}{2}$ ", $\frac{9}{16}$ ", $\frac{5}{8}$ ", $\frac{11}{16}$ " and $\frac{3}{4}$ ". Sizes are marked in a durable molded case.



Figure 24. Model G9756 20-Pc. HSS End Mill Set.

G3875— $\frac{3}{8}$ " x $1\frac{1}{2}$ " Dowel Pins—500

These computer-inspected dowel pins meet the demanding standards of high-speed drilling and dowel-driving equipment. Pins are chamfered for easy insertion and grooved for even glue distribution. Straight flutes are superior over spiral grooves as they virtually eliminate hydraulic pressure build up that can split joints. Made in the U.S.A.



Figure 25. Model G3875 Dowel Pins.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz. Spray



Figure 26. Recommended products for protecting unpainted cast iron/steel parts on machinery.

G4682—Dry Coating Lube 9.5 oz.

Spray on saw blades, router bits, shaper cutters - even table tops - to form a low friction coating that works great, even under high temperature and pressure. Contains no silicone or oil, so it won't stain or damage paint or wood finishes. 9.5 oz.

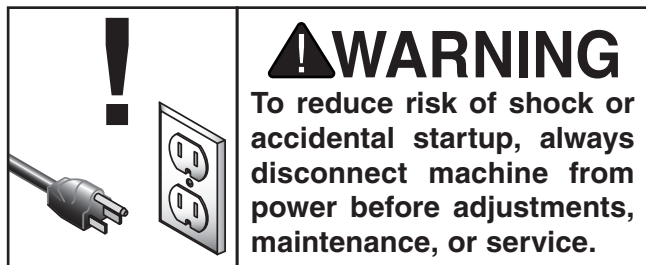


Figure 27. G4682 Dry Coating Lube.

order online at www.grizzly.com or call 1-800-523-4777



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Maintenance:

- Check for loose mounting bolts.
- Check for worn or damaged bits.
- Check for worn or damaged wires.
- Check for any other unsafe condition.

Weekly/Monthly Maintenance:

- Clean/vacuum wood chips and sawdust off of motor.
- Lubricate travel rods, table leadscrew, and hold-down clamp (see **Page 26**).

Cleaning

Cleaning the Model G0540 is relatively easy. Vacuum 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. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

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 tables rust-free with regular applications of products like SLIPIT® (see **Section 5: Accessories** on see **Page 24** for more details).

Bit Care

A horizontal boring machine bit requires proper care.

- Store the bits so their sharp points and flutes are protected. A wooden or plastic box that keeps bits from touching one another works best.
- Keep bits clean and rust free.
- Have bits sharpened as soon as they show any signs of dulling.



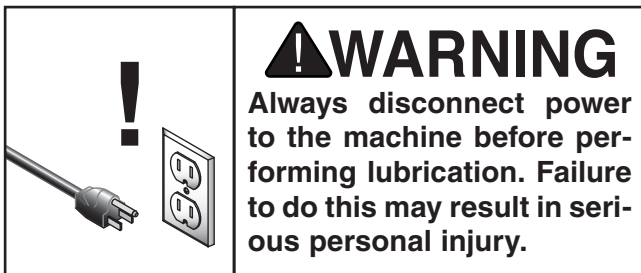
Lubrication

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more lubricant to dirty components will not yield smooth movement.

Clean the components in this section with mineral spirits, a rag, or a bristle brush as directed.

The following are the main components that need to be lubricated:

- Travel rods
- Table leadscrew
- Hold-down clamp



Travel Rods

Perform monthly. Clean sawdust and debris from the table feed rods and vertical travel rods, and horizontal travel rod (see **Figures 28–30**) with mineral spirits and a rag. Apply a thin coat of dry spray lubricant, such as Model G4682 (refer to **Page 24**) to the slides. Move the table through the entire range of motion to evenly distribute the lubricant.

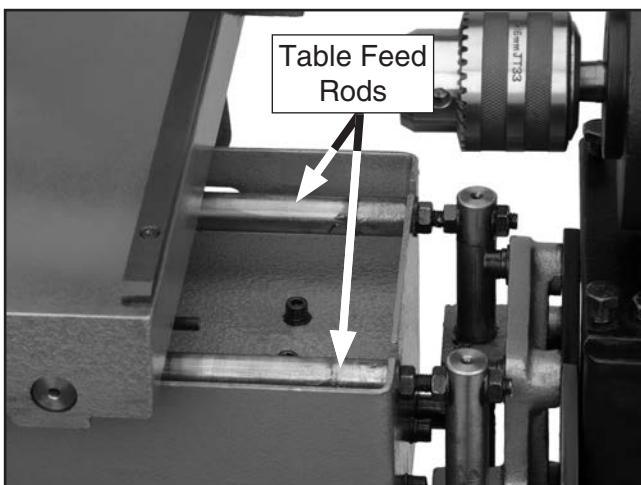


Figure 28. Table feed travel rods.

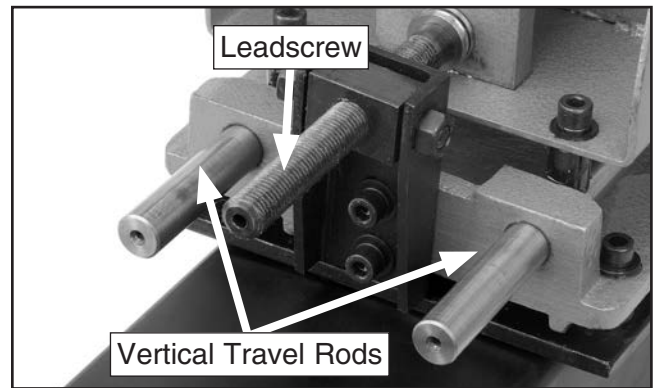


Figure 29. Vertical travel rods and leadscrew.

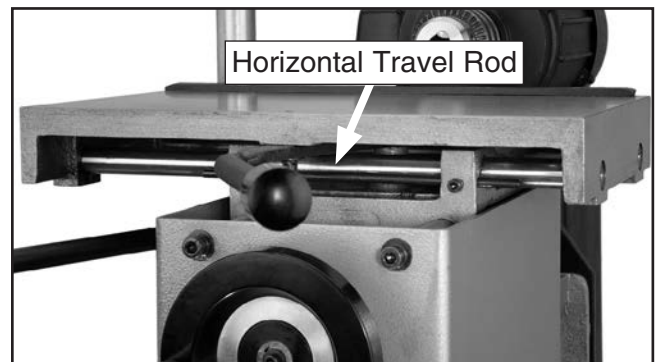


Figure 30. Horizontal travel rod.

Table Leadscrew

Perform monthly. Use a stiff bristle brush and mineral spirits to clean grime and debris from the leadscrew (see **Figures 29**). Apply a thin coat of dry spray lubricant to the leadscrew. Turn the elevation handwheel to move the table assembly through its entire vertical range of motion to evenly distribute the lubricant.

Hold-Down Clamp

Perform monthly. Apply a drop of light machine oil to the cam (see **Figure 31**).

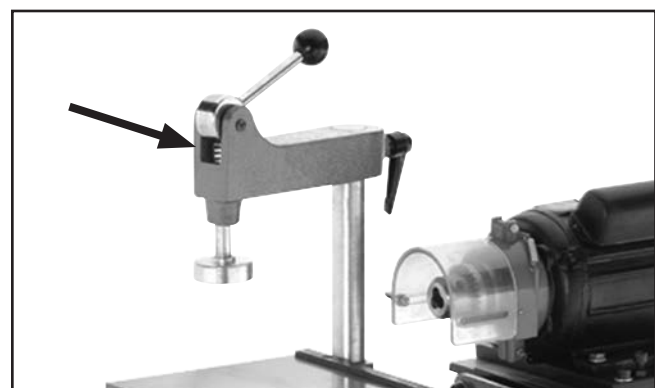


Figure 31. Location to oil hold-down clamp cam.

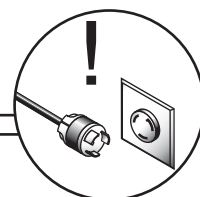


SECTION 7: SERVICE

Review the troubleshooting and 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 at (570) 546-9663.

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.	<ol style="list-style-type: none"> 1. Plug/receptacle is at fault or wired incorrectly. 2. Motor connection wired incorrectly. 3. Power supply switched OFF or is at fault. 4. Start capacitor is at fault. 5. Wall fuse/circuit breaker is blown/tripped. 6. Wiring is open/has high resistance. 7. Power ON/OFF switch is at fault. 8. Centrifugal switch is at fault. 9. Motor is at fault. 	<ol style="list-style-type: none"> 1. Test for good contacts; correct the wiring. 2. Correct motor wiring connections. 3. Ensure power supply is switched ON; ensure power supply has the correct voltage. 4. Test/replace if faulty. 5. Ensure circuit size is suitable for this machine; replace weak breaker. 6. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 7. Replace faulty ON/OFF switch. 8. Adjust/replace the centrifugal switch if available. 9. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Bit or chuck not mounted correctly. 2. Machine is incorrectly mounted or sits unevenly on floor. 3. Motor mount loose. 4. Motor or component is loose. 5. Motor fan is rubbing on fan cover. 6. Centrifugal switch is at fault. 	<ol style="list-style-type: none"> 1. Remove and re-install bit or chuck (Page 22). 2. Tighten/replace fasteners; relocate/shim machine. 3. Tighten. 4. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 5. Replace dented fan cover; replace loose/damaged fan. 6. Replace centrifugal switch.
Machine slows or stalls.	<ol style="list-style-type: none"> 1. Workpiece material is not suitable for this machine, or machine undersized for the task. 2. Motor connection is wired incorrectly. 3. Plug/receptacle is at fault. 4. Motor or boring head bearings are at fault. 5. Centrifugal switch is at fault. 6. Motor has overheated. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Only drill wood products; make sure moisture content is below 20% and use sharp bits/reduce downfeed rate. 2. Correct motor wiring connections. 3. Test for good contacts; correct the wiring. 4. Replace bearings. 5. Adjust/replace centrifugal switch. 6. Clean off motor, let cool, and reduce workload. 7. Test/repair/replace.

Operation

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"> 1. Applying too much pressure to workpiece. 2. Bits are dull. 	<ol style="list-style-type: none"> 1. Feed workpiece slower; use less pressure. 2. Replace bits.
Holes not drilled straight into workpiece.	<ol style="list-style-type: none"> 1. Motor is not parallel to the table. 	<ol style="list-style-type: none"> 1. Adjust motor-table parallelism (Page 28).



Adjusting Motor-Table Parallelism

The motor and chuck axis are adjusted parallel to the table by the factory. However, if these components are not parallel, perform the following procedure.

Tools Needed	Qty
Straightedge	1
Drill Rod.....	1
Open-End Wrench 13mm.....	1

To verify motor-table parallelism:

1. Mount a piece of drill rod (round, straight metal) in the chuck.
2. Raise the table just under the drill rod (**Figure 32**), and use a metal straightedge as a visual reference for checking the front-to-back distance between the drill rod and the table.

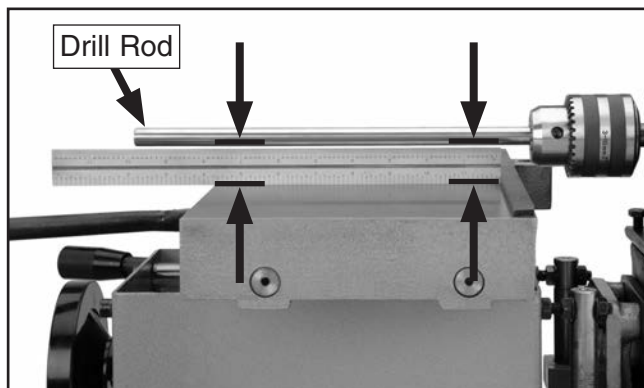


Figure 32. Checking table-motor parallelism.

—If a gap is not visible between the ruler and the drill rod along its length, no adjustments are necessary. The motor is parallel to the table.

—If a gap is visible between the ruler and the drill rod, the motor is not parallel to the table. Proceed to the next step.

3. Loosen the four mounting bolts that secure the motor to the stand (see **Figure 33**).

4. Tighten or loosen the front and rear adjusting bolts (see **Figure 33**) in pairs as needed to raise or lower the front or back of the motor.

Note: Before performing this step, make sure the adjusting bolts barely touch the top of the stand.

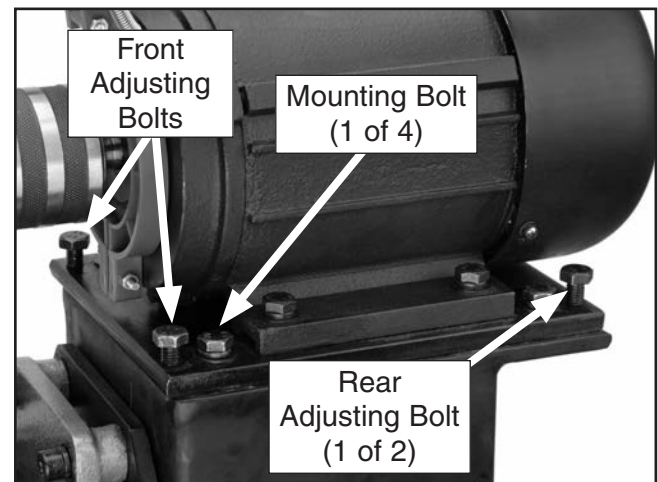


Figure 33. Bolts for adjusting motor angle.

5. Repeat **Step 2**, and adjust the motor as needed until it is parallel to the table.
6. Re-tighten the mounting bolts.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

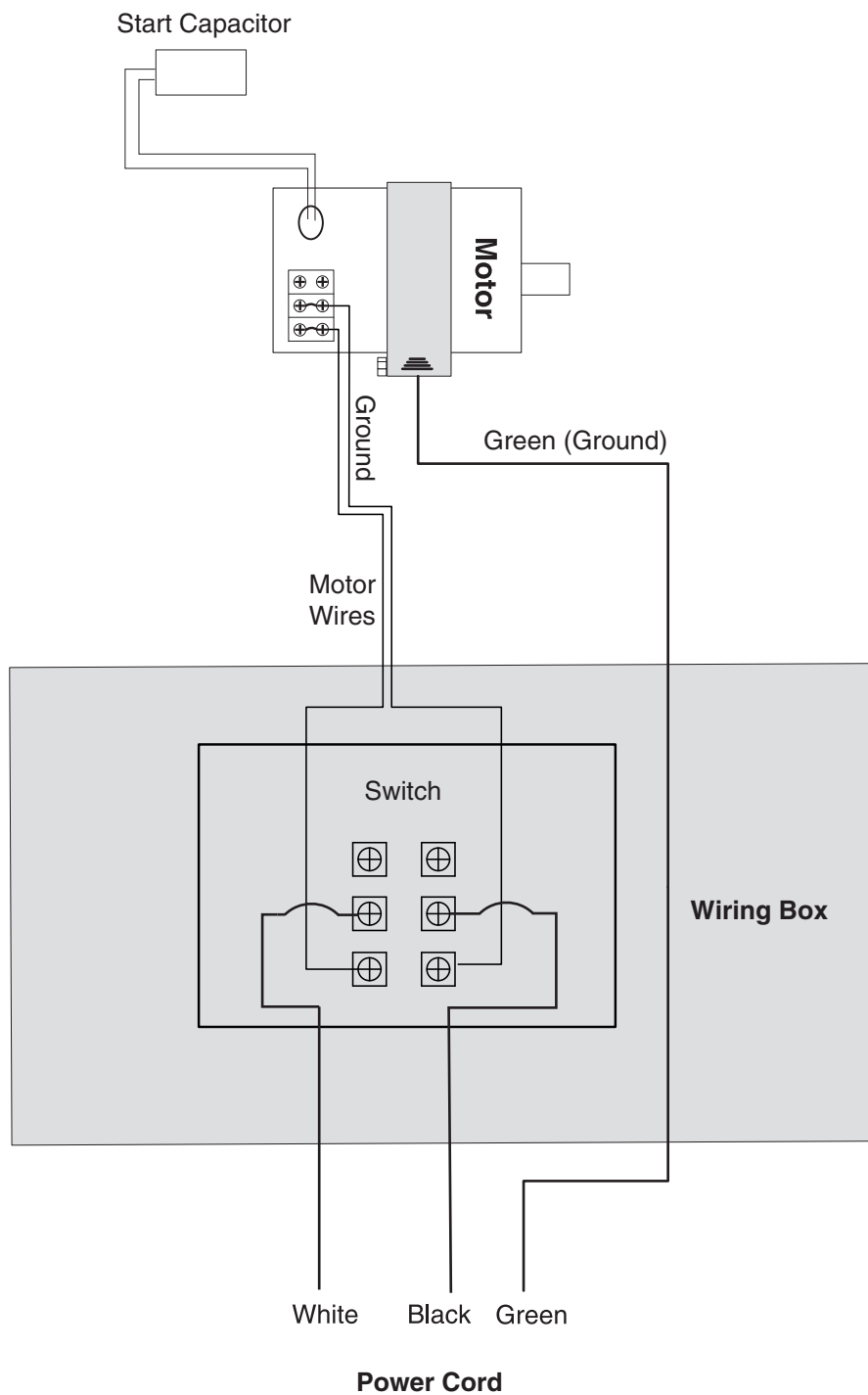
MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

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

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



Wiring Diagram



Electrical Components

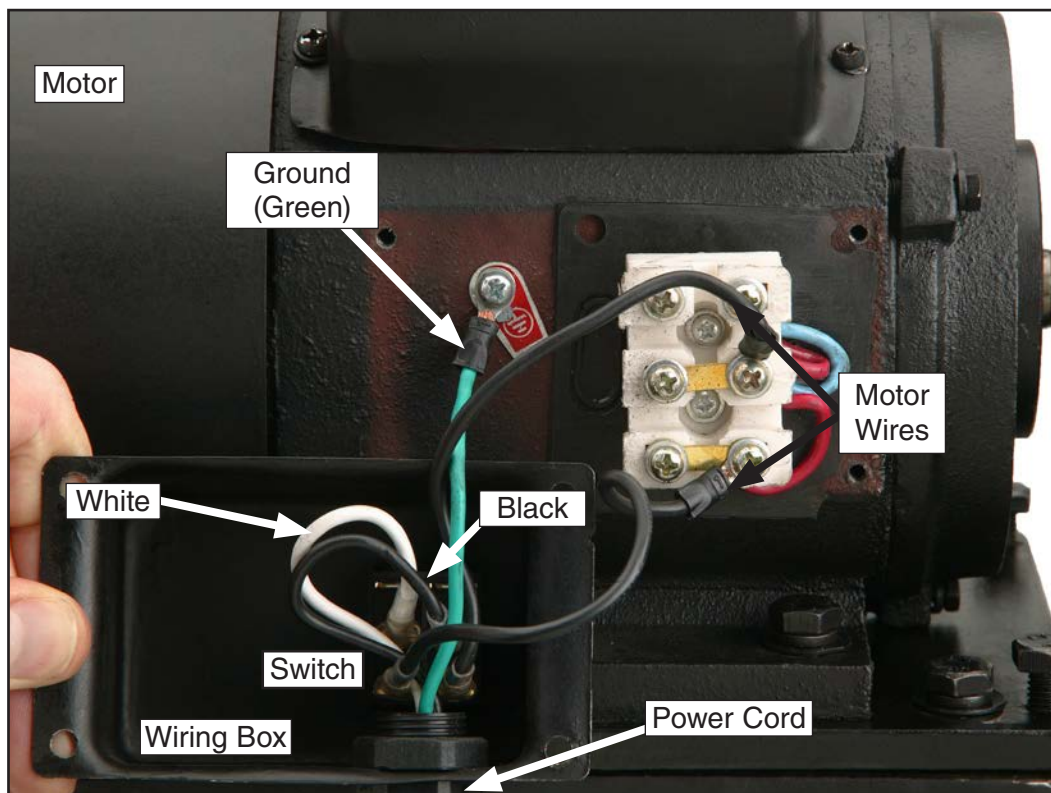


Figure 34. Switch and motor wiring.

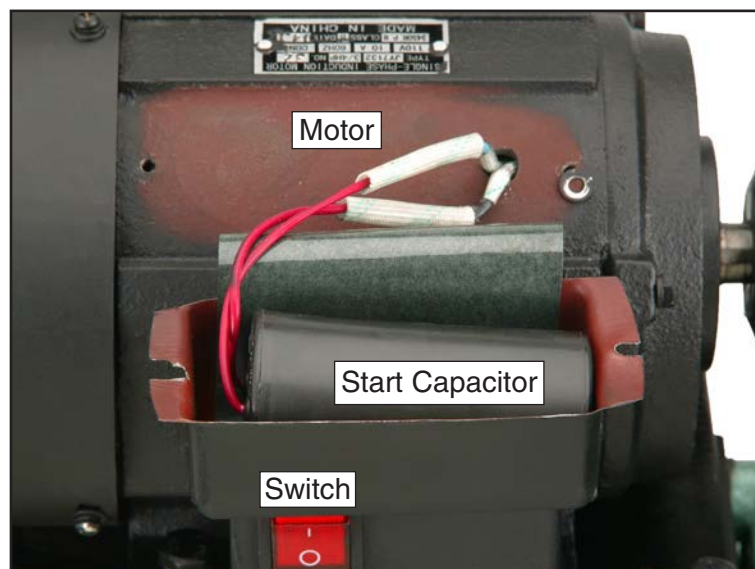
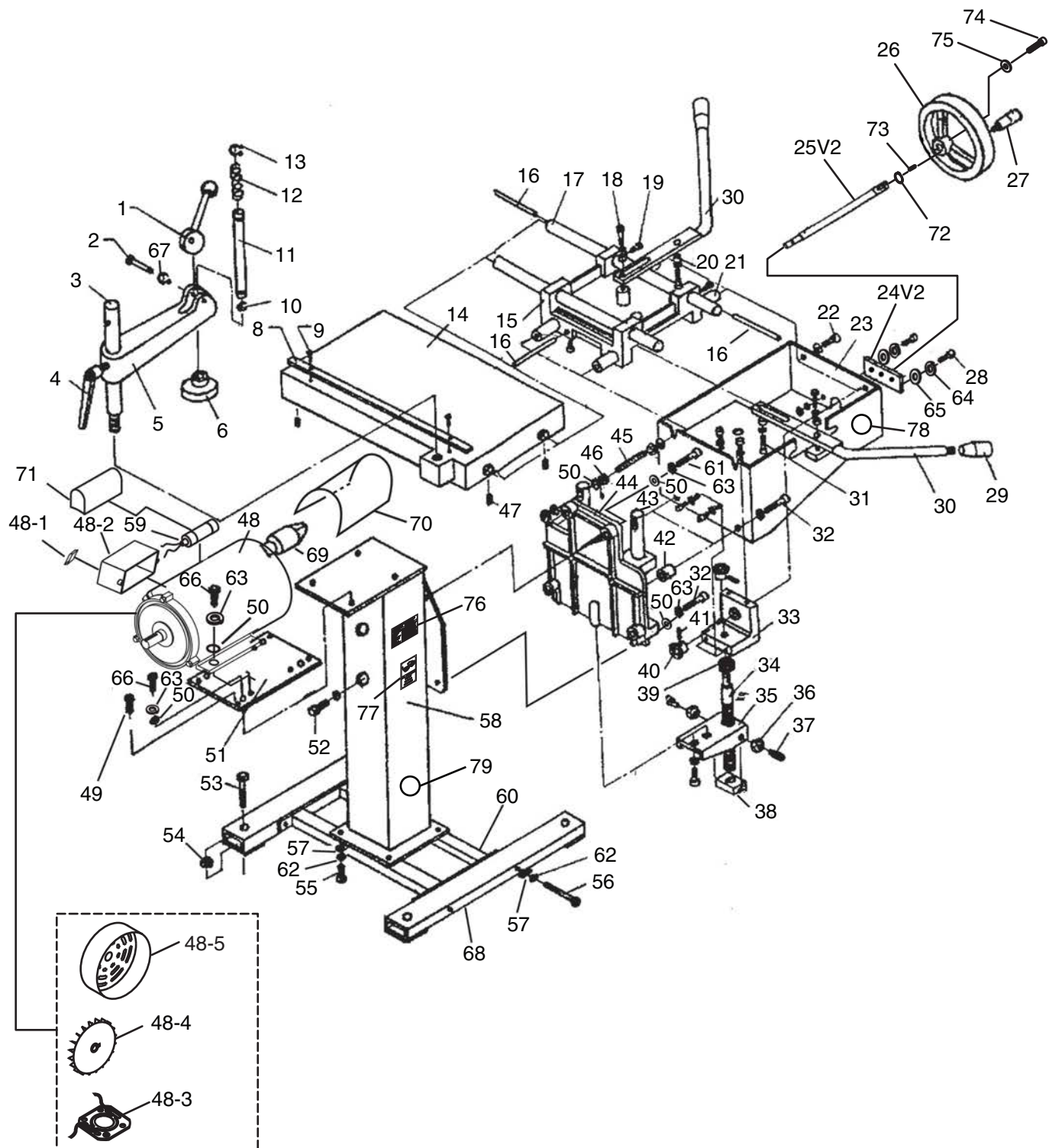


Figure 35. Capacitor wiring.

SECTION 9: PARTS

Main Parts Breakdown



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.



Main Parts List

REF	PART #	DESCRIPTION
1	P0540001	ECCENTRIC HAND LEVER
2	P0540002	ALIGNMENT PIN 8 X 43
3	P0540003	COLUMN M16-2 X 20
4	P0540004	LOCK HANDLE M10-1.5 X 25
5	P0540005	HOLD-DOWN CLAMP ARM
6	P0540006	PRESS PLATE
8	P0540008	FENCE
9	PS03M	PHLP HD SCR M6-1 X 8
10	P0540010	BLOCK RING 14MM
11	P0540011	PRESS ROD
12	P0540012	COMPRESSION SPRING .5 X 18 X 55
13	PR02M	EXT RETAINING RING 14MM
14	P0540014	WORK TABLE
15	P0540015	CONNECTING SEAT
16	P0540016	STOP ROD
17	P0540017	X-AXIS SHAFT
18	PB08M	HEX BOLT M6-1 X 20
19	PCAP50M	CAP SCREW M5-.8 X 10
20	P0540020	COVER
21	P0540021	Y-AXIS SHAFT
22	PCAP14M	CAP SCREW M8-1.25 X 20
23	P0540023	TABLE SUPPORT
24V2	P0540024V2	PLATE 12.3MM HOLE V2.01.12
25V2	P0540025V2	ELEVATION HANDWHEEL SHAFT V2.01.12
26	P0540026	ELEVATION HANDWHEEL 125 X 12MM
27	P0540027	HANDWHEEL HANDLE M8-1.25 X 63
28	PCAP01M	CAP SCREW M6-1 X 16
29	P0540029	KNOB M12- 1.75
30	P0540030	HANDLE M12-1.75 X 25
31	PCAP06M	CAP SCREW M6-1 X 25
32	PCAP40M	CAP SCREW M8-1.25 X 35
33	P0540033	L-BRACKET
34	P0540034	VERTICAL LEADSCREW
35	P0540035	LEADSCREW PLATE
36	PN02M	HEX NUT M10-1.5
37	PSS10M	SET SCREW M10-1.5 X 20
38	P0540038	LEADSCREW BLOCK
39	P51100	THRUST BEARING 51100
40	P0540040	GEAR
41	PRP39M	ROLL PIN 4 X 20
42	P0540042	COVER
43	P0540043	Z-AXIS SHAFT

REF	PART #	DESCRIPTION
44	P0540044	TABLE MOUNTING PLATE
45	P0540045	STUD-UDE M12-1.75 X 19, M10-1.5 X 12, 137
46	PN03M	HEX NUT M8-1.25
47	PSS03M	SET SCREW M6-1 X 8
48	P0540A12	MOTOR 3/4HP 110V 1-PH
48-1	P0540048-1	SWITCH
48-2	P0540048-2	WIRING BOX COVER
48-3	P0540048-3	CENTRIFUGAL SWITCH
48-4	P0540048-4	FAN
48-5	P0540048-5	FAN COVER
49	PB07M	HEX BOLT M8-1.25 X 25
50	PW01M	FLAT WASHER 8MM
51	P0540051	MOTOR PLATE
52	PCAP61M	CAP SCREW M10-1.5 X 20
53	PB140M	HEX BOLT M12-1.75 X 70
54	PN09M	HEX NUT M12-1.75
55	PB31M	HEX BOLT M10-1.5 X 40
56	PB23M	HEX BOLT M10-1.5 X 100
57	PW04M	FLAT WASHER 10MM
58	P0540058	STAND
59	P0540059	S CAPACITOR 12M 400V 1-1/4 X 2-3/4
60	P0540060	STAND CROSSBRACE
61	PCAP13M	CAP SCREW M8-1.25 X 30
62	PLW06M	LOCK WASHER 10MM
63	PLW04M	LOCK WASHER 8MM
64	PLW03M	LOCK WASHER 6MM
65	PW03M	FLAT WASHER 6MM
66	PB07M	HEX BOLT M8-1.25 X 25
67	PR39M	EXT RETAINING RING 8MM
68	P0540068	LEG
69	P0540069	CHUCK 3-16MM JT33
70	P0540070	CHUCK GUARD
71	P0540071	CAPACITOR COVER
72	PR03M	EXT RETAINING RING 12MM
73	PK48M	KEY 4 X 4 X 20
74	PCAP50M	CAP SCREW M5-.8 X 10
75	PW02M	FLAT WASHER 5MM
76	P0540076	MACHINE ID LABEL
77	PLABEL-11A	SAFETY GLASSES LABEL
78	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
79	P0540075	BLACK TOUCH-UP PAINT







WARRANTY CARD

Name _____
Street _____
City _____ State _____ Zip _____
Phone # _____ Email _____
Model # _____ Order # _____ Serial # _____

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.**

1. How did you learn about us?

_____ Advertisement _____ Friend _____ Catalog
_____ Card Deck _____ Website _____ Other:

2. Which of the following magazines do you subscribe to?

_____ Cabinetmaker & FDM	_____ Popular Science	_____ Wooden Boat
_____ Family Handyman	_____ Popular Woodworking	_____ Woodshop News
_____ Hand Loader	_____ Precision Shooter	_____ Woodsmith
_____ Handy	_____ Projects in Metal	_____ Woodwork
_____ Home Shop Machinist	_____ RC Modeler	_____ Woodworker West
_____ Journal of Light Cont.	_____ Rifle	_____ Woodworker's Journal
_____ Live Steam	_____ Shop Notes	_____ Other:
_____ Model Airplane News	_____ Shotgun News	
_____ Old House Journal	_____ Today's Homeowner	
_____ Popular Mechanics	_____ Wood	

3. What is your annual household income?

_____ \$20,000-\$29,000 _____ \$30,000-\$39,000 _____ \$40,000-\$49,000
_____ \$50,000-\$59,000 _____ \$60,000-\$69,000 _____ \$70,000+

4. What is your age group?

_____ 20-29 _____ 30-39 _____ 40-49
_____ 50-59 _____ 60-69 _____ 70+

5. How long have you been a woodworker/metalworker?

_____ 0-2 Years _____ 2-8 Years _____ 8-20 Years _____ 20+ Years

6. How many of your machines or tools are Grizzly?

_____ 0-2 _____ 3-5 _____ 6-9 _____ 10+

7. Do you think your machine represents a good value?

_____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend?

_____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times.

_____ Yes _____ No

10. Comments: _____

FOLD ALONG DOTTED LINE



Place
Stamp
Here



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



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____
Street_____
City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

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.

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.

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