

READ THIS FIRST



Model G0811
*****IMPORTANT UPDATE*****

For Machines Mfd. Since 06/20
 and Owner's Manual Revised 09/17

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

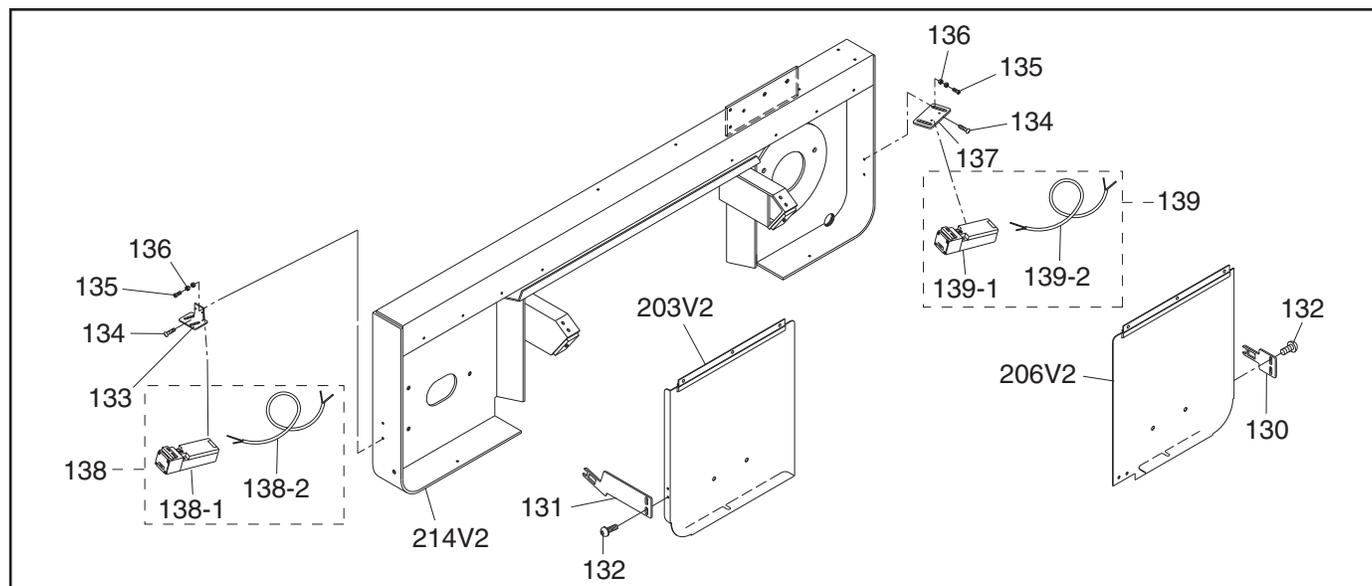
The following changes were made since the owner's manual was printed:

- The body frame and left and right blade covers changed to allow for the mounting of two limit switches.

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

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Parts Breakdown

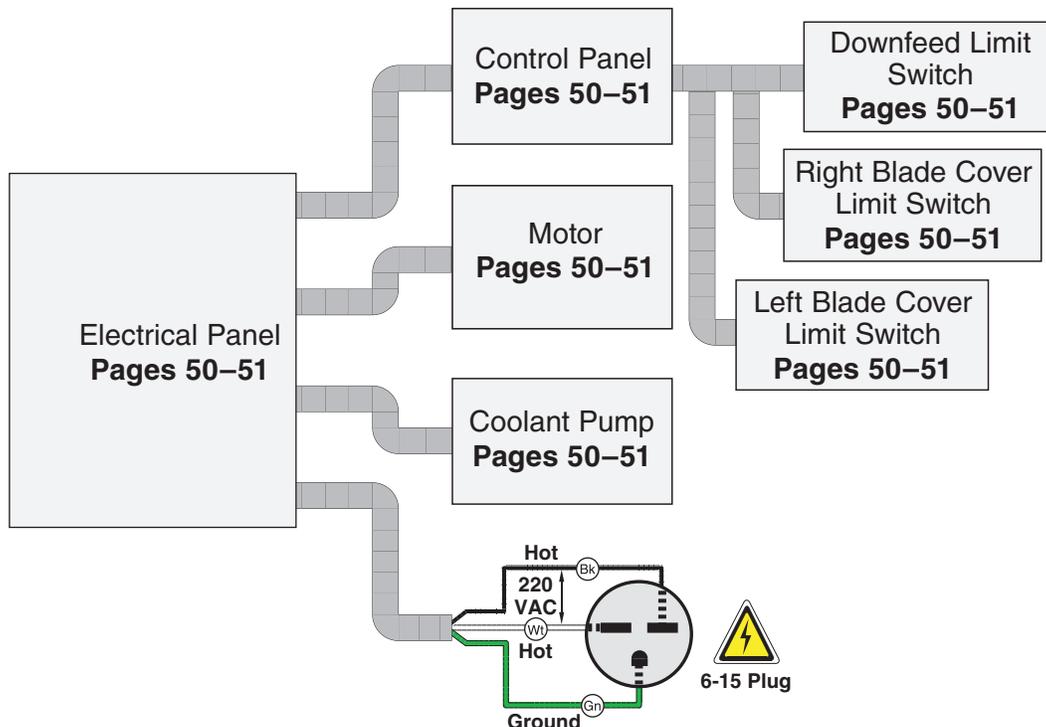


REF	PART #	DESCRIPTION
130	P0811130	LIMIT SWITCH KEY (RIGHT)
131	P0811131	LIMIT SWITCH KEY (LEFT)
132	P0811132	BUTTON HD CAP SCR M4-.5 X 12
133	P0811133	LIMIT SWITCH BRACKET (RIGHT)
134	P0811134	PHLP HD SCR M5-.8 X 10
135	P0811135	CAP SCREW M4-.7 X 12
136	P0811136	HEX NUT M4-.7
137	P0811137	LIMIT SWITCH BRACKET (RIGHT)
138	P0811138	BLADE COVER LIMIT SWITCH (LEFT)

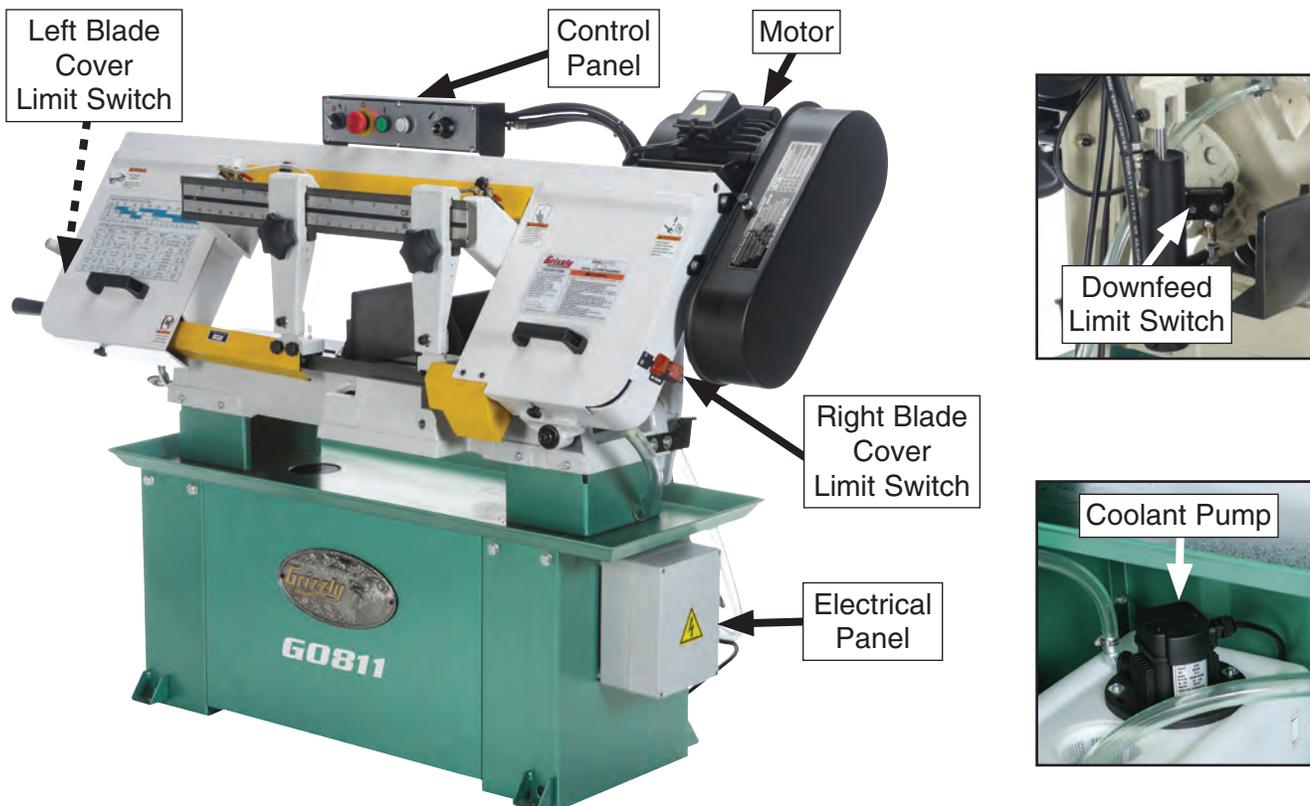
REF	PART #	DESCRIPTION
138-1	P0811138-1	LIMIT SWITCH KEDU QKS8
138-2	P0811138-2	LIMIT SWITCH CORD 18G 2W 60"
139	P0811139	BLADE COVER LIMIT SWITCH (RIGHT)
139-1	P0811139-1	LIMIT SWITCH KEDU QKS8
139-2	P0811139-2	LIMIT SWITCH CORD 18G 2W 60"
203V2	P0811203V2	BLADE COVER (LEFT) V2.06.20
206V2	P0811206V2	BLADE COVER (RIGHT) V2.06.20
214V2	P0811214V2	BODY FRAME V2.06.20

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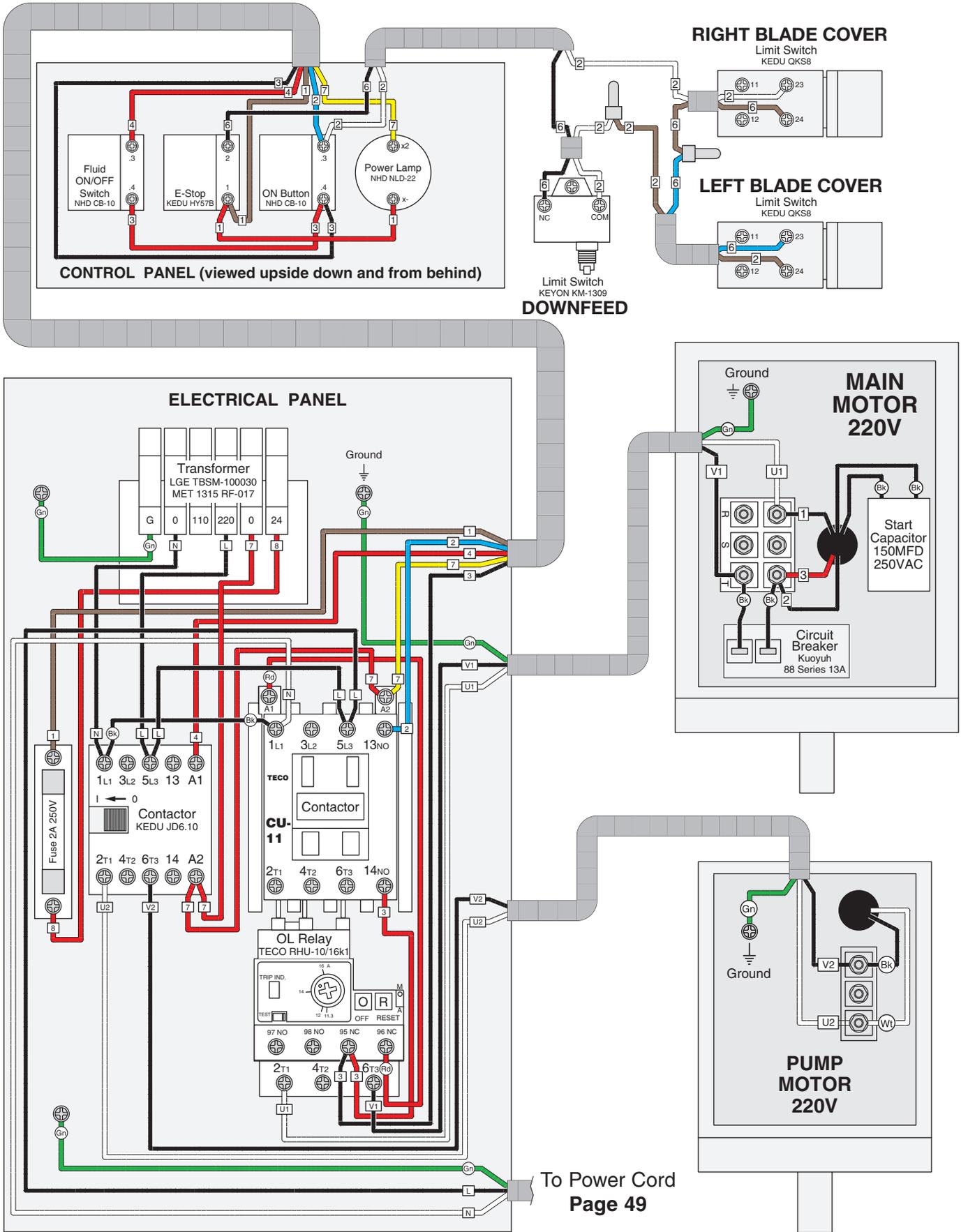
Electrical Overview



Component Locations



Wiring Diagram



Wiring Photos

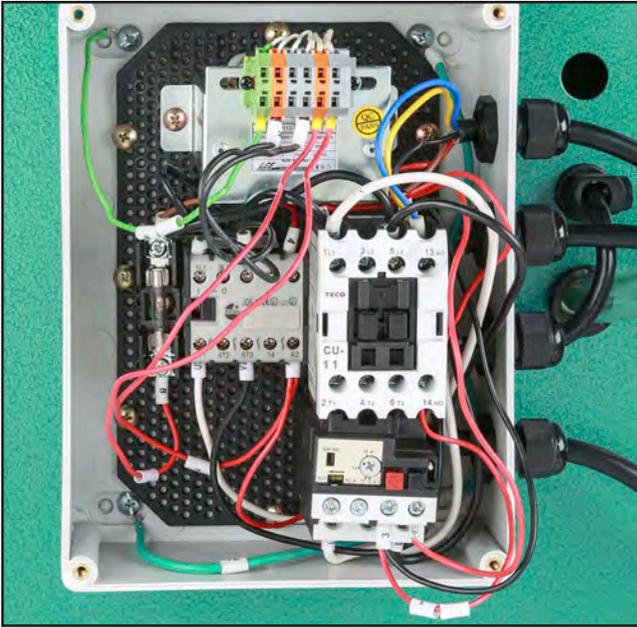


Figure 63. Electrical panel wiring.



Figure 67. Motor wiring.

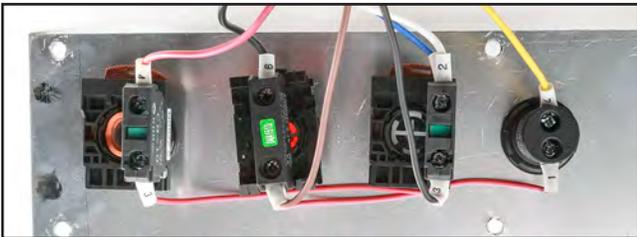


Figure 64. Control panel wiring.



Figure 68. Circuit breaker wiring.

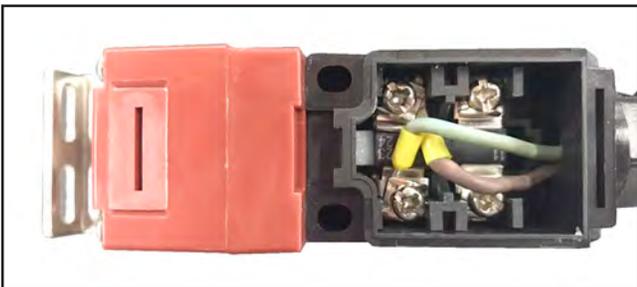


Figure 65. Right blade cover limit switch wiring.



Figure 69. Coolant pump wiring.



Figure 66. Left blade cover limit switch wiring.



Figure 70. Limit switch wiring.



Grizzly **Industrial, Inc.**®

MODEL G0811 9" X 16" METAL-CUTTING BANDSAW OWNER'S MANUAL *(For models manufactured since 02/16)*



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V1.10.17

 **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

Contact Info

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

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

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

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

Manual Accuracy

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

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

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

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

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety glasses/respirator are properly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not use while under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
Manufactured for Grizzly in Taiwan			

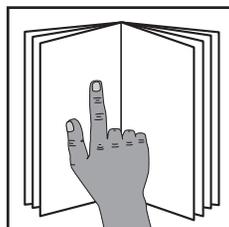
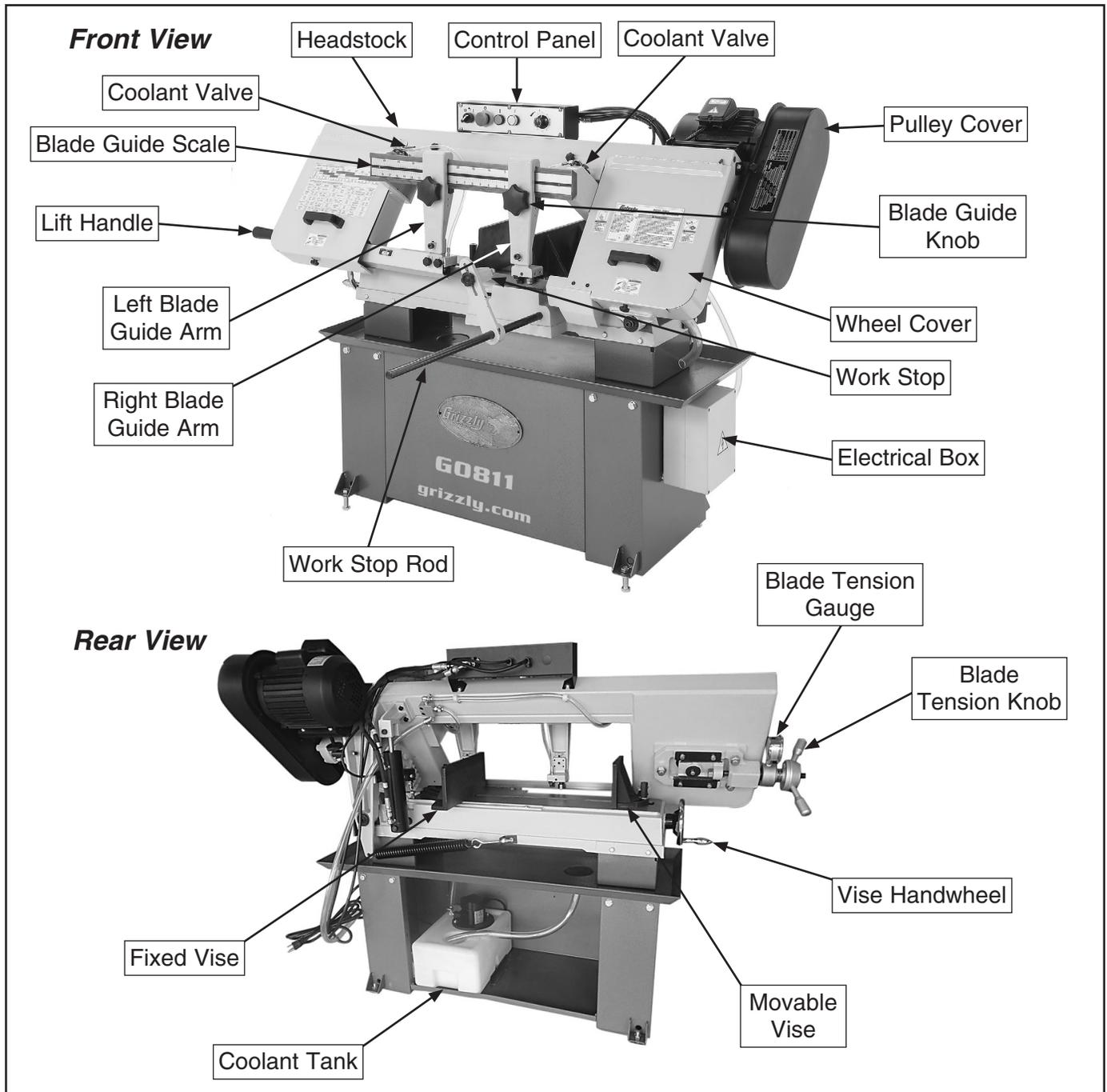
Manufacture Date

Serial Number



Identification

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

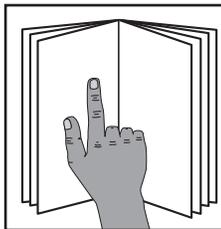


!WARNING

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



Controls & Components



!WARNING

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

Refer to **Figures 1–3** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

Control Panel

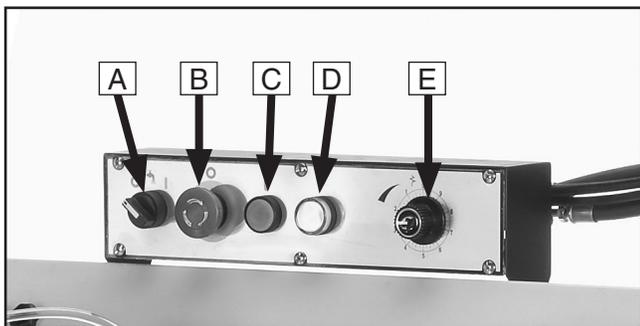


Figure 1. Model G0811 control panel.

- A. Coolant Pump Switch:** Turns coolant tank pump **ON**, enabling flow to coolant valves (see **Identification** on **Page 3**).
- B. Emergency Stop Button:** Stops all machine functions. Twist clockwise to reset.
- C. ON Button.** Turns motor **ON**.
- D. Power Lamp:** Illuminates when machine is connected to power.
- E. Feed Rate Dial:** Controls speed at which blade lowers into workpiece; range is from "0" (slowest) to "9" (fastest). Turning the dial all the way clockwise locks the headstock in position.

Headstock

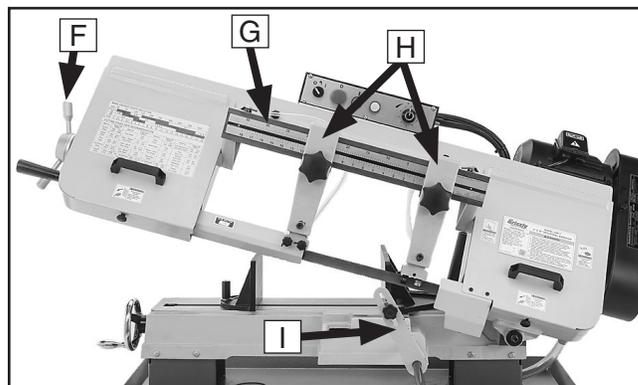


Figure 2. Headstock controls and components.

- F. Blade Tension Knob and Gauge (Not Shown):** Rotate clockwise to increase or counterclockwise to decrease blade tension. Gauge indicates proper tension setting.
- G. Blade Guide Scale:** Displays position of blade guide arms relative to fixed vise jaw.
- H. Blade Guide Arms:** Hold blade guides that support bandsaw blade. Arms are placed as close to workpiece as possible during cutting to prevent blade from twisting.
- I. Work Stop:** Quickly positions workpiece during repetitive cutting operations.

Vise Table

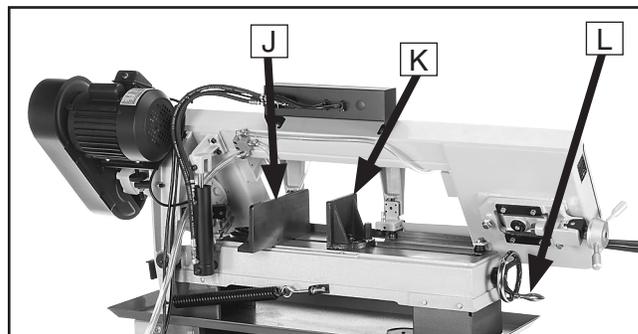


Figure 3. Vise table controls.

- J. Fixed Vise Jaw:** Can be adjusted to cut angles from 45° to 90°.
- K. Movable Vise Jaw:** Features quick-release that allows jaw width to be adjusted when changing from one workpiece size to another.
- L. Vise Handwheel:** Adjusts position of movable vise jaw relative to fixed vise jaw.





MACHINE DATA SHEET

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

MODEL G0811 9" X 16" METAL-CUTTING BANDSAW

Product Dimensions:

Weight..... 572 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 62-1/2 x 22-1/2 x 45-1/2 in.
Footprint (Length x Width)..... 38 x 17-1/2 in.

Shipping Dimensions:

Type..... Cardboard w/Wood Pallet
Content..... Machine
Weight..... 638 lbs.
Length x Width x Height..... 63 x 23 x 48 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
Full-Load Current Rating..... 11.8A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6-1/2 ft.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Recommended Plug Type..... 6-15
Switch Type..... Magnetic Switch

Motors:

Coolant Pump

Horsepower..... 53 W
Phase..... Single-Phase
Amps..... 0.3A
Speed..... 3440 RPM
Type..... Universal
Bearings..... Shielded & Permanently Lubricated

Main

Horsepower..... 1.5 HP
Phase..... Single-Phase
Amps..... 11.5A
Speed..... 1720 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Belt Drive
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Info

Blade Speeds..... 114 – 377 FPM
Std. Blade Length..... 114-1/2 in.
Blade Size Range..... 1 in.



Cutting Capacities

Cutting Height.....	9 in.
Angle Cuts.....	45 deg.
Vise Jaw Depth.....	16 in.
Vise Jaw Height.....	5-1/8 in.
Max. Capacity Rectangular Height at 90 Deg.....	5 in.
Max. Capacity Rectangular Width at 90 Deg.....	16 in.
Max. Capacity Round at 90 Deg.....	9 in.
Max. Capacity Rectangular Height at 30 Deg.....	9 in.
Max. Capacity Rectangular Width at 30 Deg.....	14 in.
Max. Capacity Round at 30 Deg.....	9 in.
Max. Capacity Rectangular Height at 45 Deg.....	8 in.
Max. Capacity Rectangular Width at 45 Deg.....	9-1/2 in.
Max. Capacity Round at 45 Deg.....	9 in.

Construction

Table.....	Precision-Ground Cast Iron
Trunnions.....	Cast Iron
Upper Wheel.....	Cast Iron
Lower Wheel.....	Cast Iron
Body.....	Steel
Stand.....	Steel
Wheel Cover.....	Steel
Paint Type/Finish.....	Epoxy

Other

Wheel Size.....	11-3/4 in.
Blade Guides Upper.....	Carbide Steel
Blade Guides Lower.....	Carbide Steel

Table Info

Table Size Length.....	31 in.
Table Size Width.....	6-1/2 in.
Table Size Thickness.....	4-1/2 in.
Floor To Cutting Area Height.....	26-1/8 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

Features:

- Coolant System with 10-Liter Coolant Capacity
- Heavy-Duty, Precision-Ground Cast-Iron Table
- Blade Speeds from 114 – 377 FPM
- Large 31" x 6-1/2" Table
- Quick-Positioning Vise
- Hydraulic Feed Control
- Top-Mounted Control Panel
- Sliding Cutter Depth Gauge
- Handwheel Blade Tensioner



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 your workshop kid proof!

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

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

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Horizontal Metal Bandsaws

WARNING

Serious injury or death can occur from getting fingers, hair, or clothing entangled in rotating or moving parts or making direct contact with the moving blade. To minimize risk of injury, anyone operating this machine MUST completely heed hazards and warnings below.

BLADE CONDITION. Do not operate with dull, cracked, or badly worn blade. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position hands or fingers in line with the cut or under bandsaw headstock while lowering or operating. Hands could be cut or crushed.

ENTANGLEMENT HAZARDS. Do not operate this saw without blade guard in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.

BLADE REPLACEMENT. When replacing blades, disconnect the machine from power, wear gloves to protect hands and safety glasses to protect eyes.

WORKPIECE HANDLING. Always properly support workpiece with table, vise, or some type of support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.

UNSTABLE WORKPIECES. Avoid cutting workpieces that cannot be properly supported or clamped in a vise or jig, because they can unexpectedly move while cutting and draw the operator's hands into the blade causing serious personal injury. Examples are chains, cables, round or oblong-shaped workpieces, and those with internal or built-in moving or rotating parts, etc.

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

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

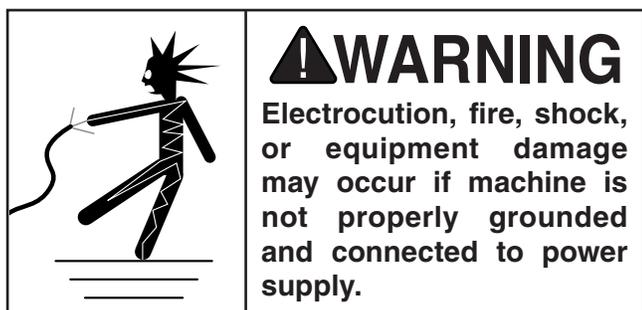
HOT SURFACES. Contact with hot surfaces from machine components, ejections of hot chips, swarf, and the workpiece itself can cause burns.



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 220V .. 11.8 Amps

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

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

Circuit Information

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

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

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

Circuit Requirements

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

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



Grounding Requirements

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

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

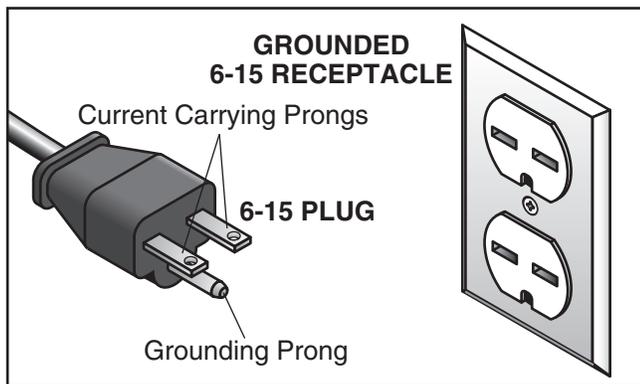
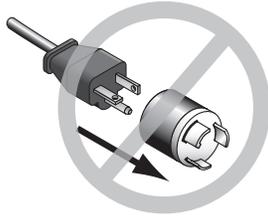


Figure 4. Typical 6-15 plug and receptacle.

CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

WARNING

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

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.

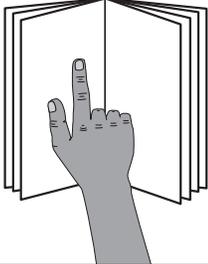
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

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



SECTION 3: SETUP



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



!WARNING
Wear safety glasses during the entire setup process!



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

Needed for Setup

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

Description	Qty
• Safety Glasses (For Each Person).....	1
• Cleaner/Degreaser (Page 15)	1
• Disposable Shop Rags.....	1
• Lifting Slings (Minimum Rating 1000 lbs.)..	2
• Lifting Equipment (Minimum Rating 1000 lbs.).....	1
• Open-End Wrench 19mm.....	1
• Hex Wrench 3mm.....	1
• Round Steel Bar Stock 1/2" x 3'	2
• Additional Person	1

Unpacking

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

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



!WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

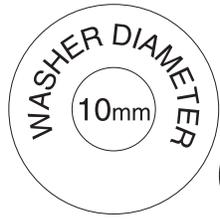
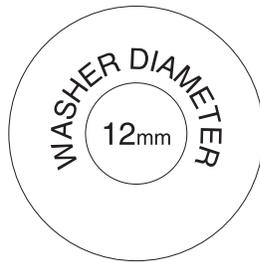
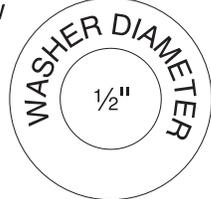
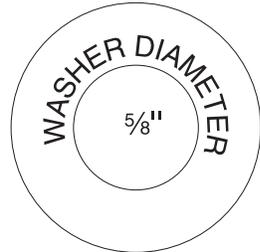
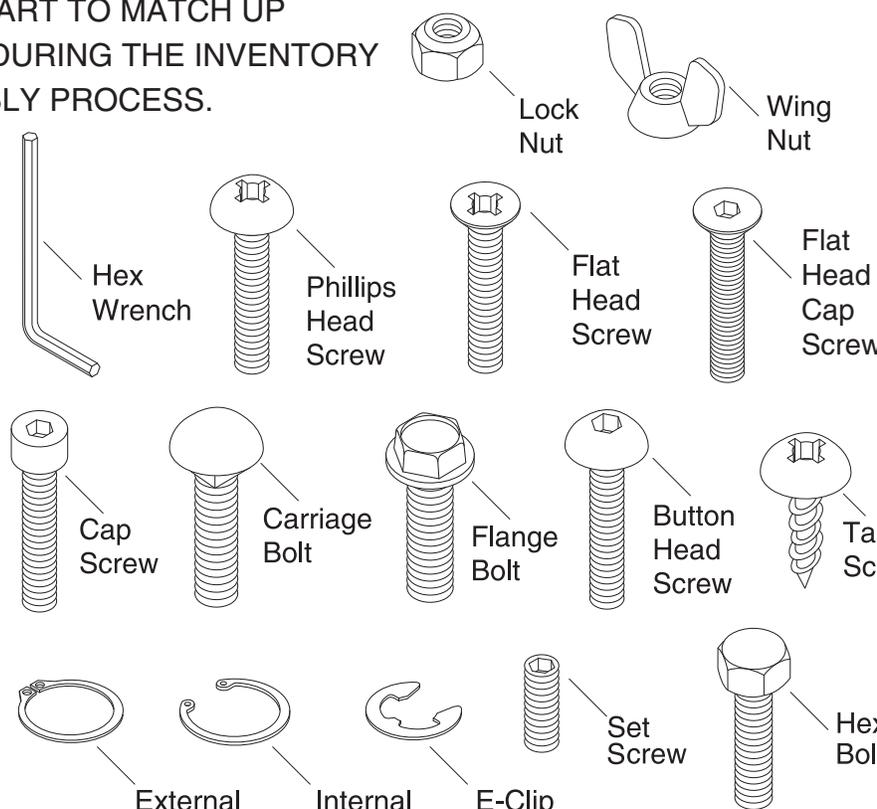


Hardware Recognition Chart

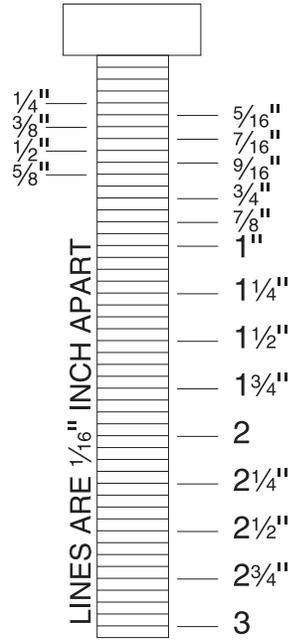
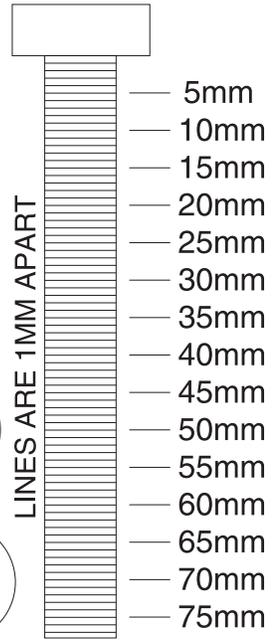
USE THIS CHART TO MATCH UP
HARDWARE DURING THE INVENTORY
AND ASSEMBLY PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"



- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



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.

Component Inventory (Figure 5)		Qty
A.	Work Stop Rod.....	1
B.	Work Stop.....	1

Fasteners (see Hardware Recognition Chart)		
•	Hex Bolts M12-1.75 x 50 (Frame)	4
•	Hex Nuts M12-1.75 (Frame)	8

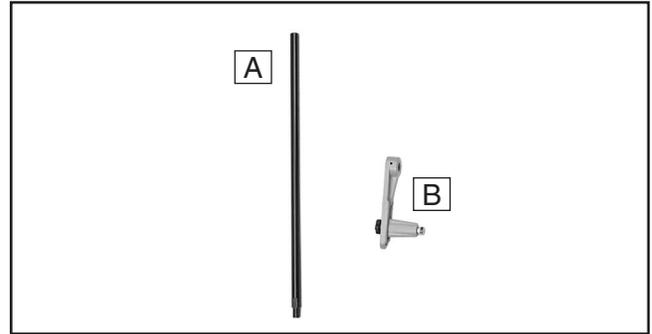


Figure 5. Component inventory.

NOTICE

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



Cleanup

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

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

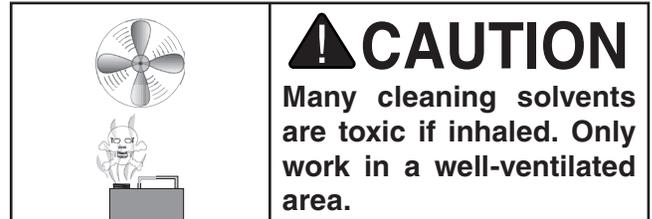
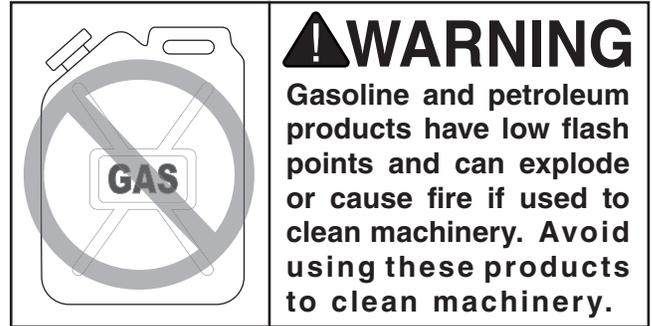
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



T23692—Orange Power Degreaser

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



Figure 6. T23692 Orange Power Degreaser.



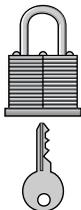
Site Considerations

Weight Load

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

Space Allocation

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

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

Physical Environment

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

Electrical Installation

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

Lighting

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

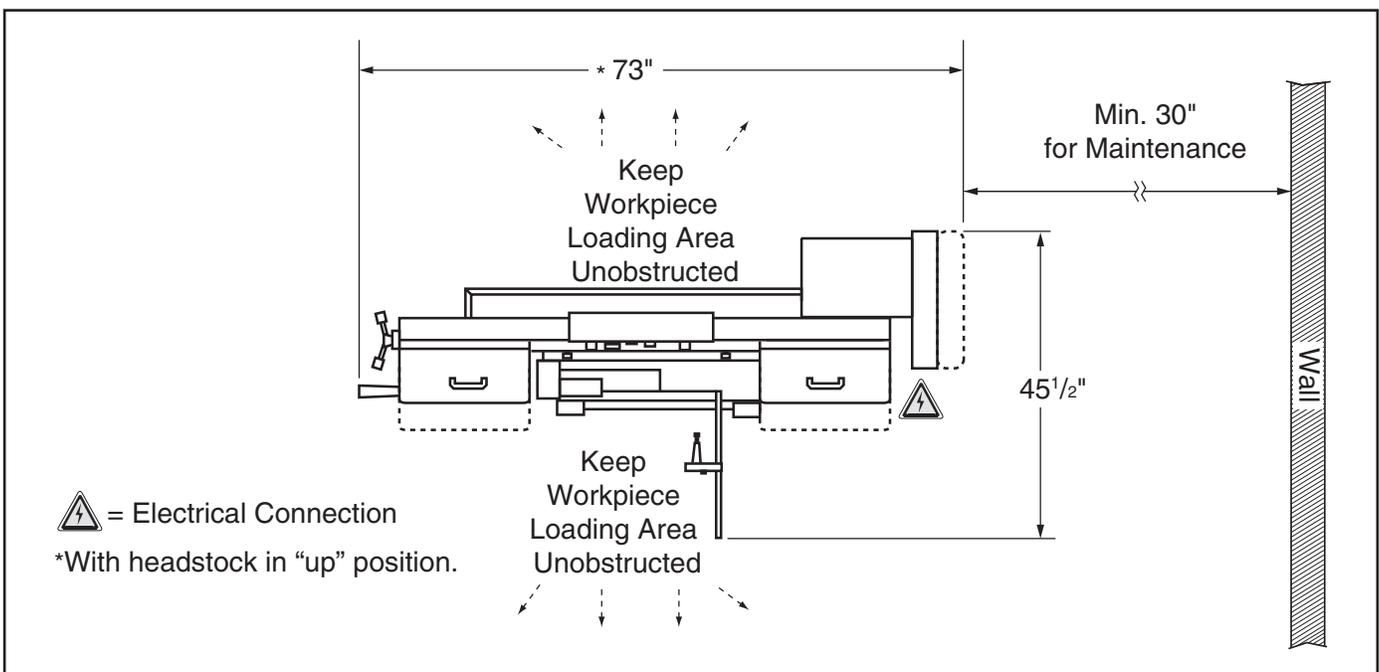
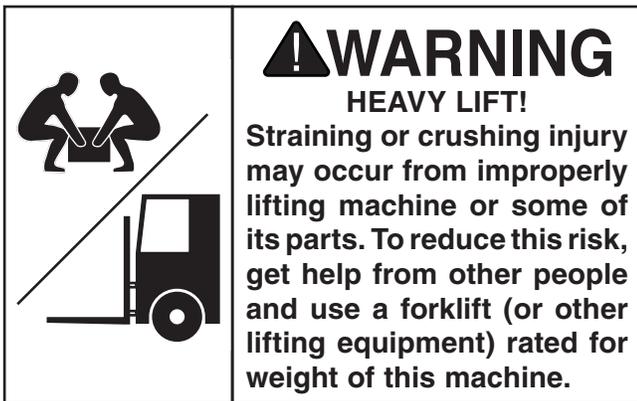


Figure 7. Minimum working clearances.



Lifting & Placing



To lift and place machine:

1. Position crate as close as possible to installation location, then remove top.
2. Unbolt machine from pallet.
3. Insert round steel bar stock through (4) lifting holes in machine base (see **Figure 8**).

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

4. Attach lifting slings to steel bar stock and power lifting equipment (see **Figure 8**).

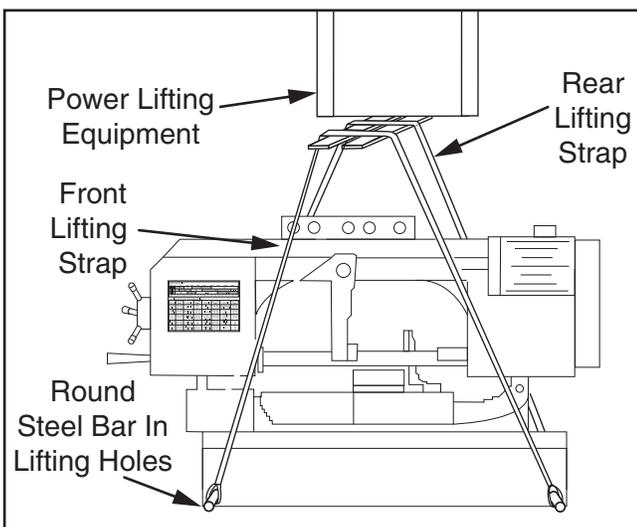


Figure 8. Lifting machine with forklift and lifting slings.

5. With an assistant helping to stabilize the load, lift machine just high enough to clear pallet and any floor obstacles, then place machine in final position on shop floor.
6. Thread (1) M12-1.75 hex nut onto each of (4) M12-1.75 x 50 leveling hex bolts, then thread these into each of the (4) mounting holes in frame (see **Figure 9**).

Note: Refer to **Anchoring to Floor** for additional options if you choose not to install included leveling bolts.

7. Thread an additional hex nut onto each leveling hex bolt (see **Figure 9**).

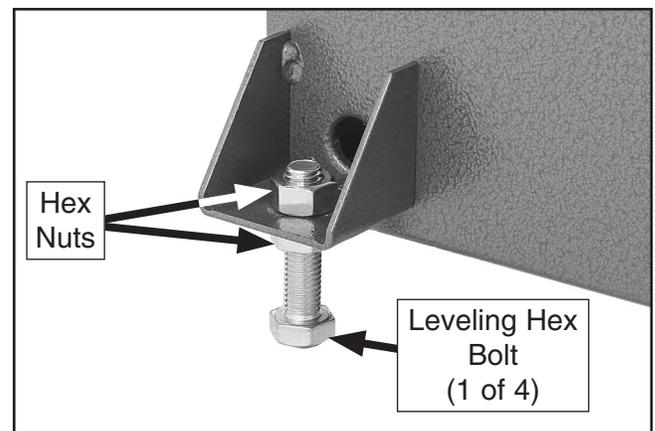


Figure 9. Leveling bolt threaded into frame.

8. Carefully lower machine onto floor, and then back forklift away.
9. Adjust leveling hex bolts as needed to stabilize saw.
10. Tighten hex nuts against frame to secure leveling hex bolts.



Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 3/8"

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you **MUST** follow the anchoring methodology specified by the code.

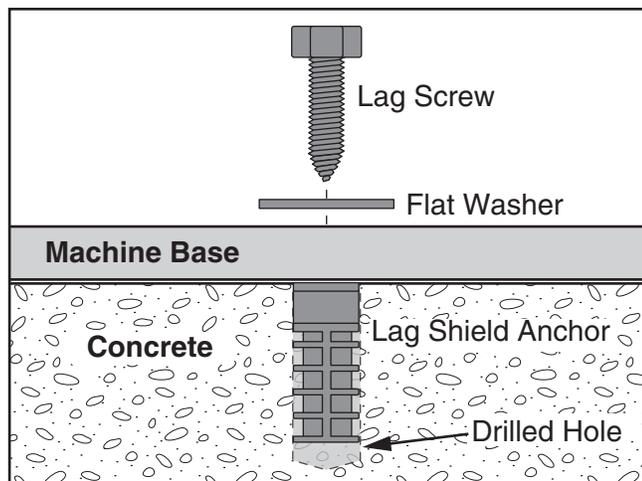


Figure 10. Popular method for anchoring machinery to a concrete floor.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

To assemble machine:

1. Thread work stop rod onto base (see **Figure 11**).
2. Slide work stop onto the rod, position it as necessary, then tighten set screw shown in **Figure 11**.

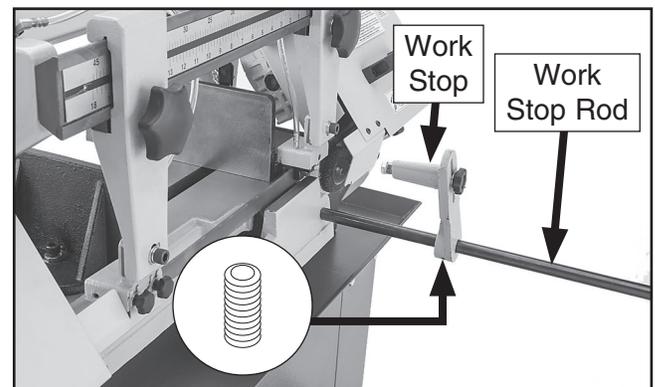


Figure 11. Work stop rod and work stop installed.



Test Run

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

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

The test run consists of verifying the following: 1) the main motor runs correctly, 2) the Emergency Stop button safety feature works correctly, 3) the coolant pump motor runs correctly, and 4) the downfeed limit switch and stop bolt work correctly.

WARNING

Serious injury or death can result from using this machine **BEFORE** understanding its controls and related safety information. **DO NOT** operate, or allow others to operate, machine until the information is understood.

WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.
2. Raise headstock all the way up, and turn feed rate dial (see **Figure 12**) clockwise to "0".
3. Press Emergency Stop button (see **Figure 12**).

4. Connect machine to power by inserting power cord plug into matching receptacle; power lamp (see **Figure 12**) will illuminate.

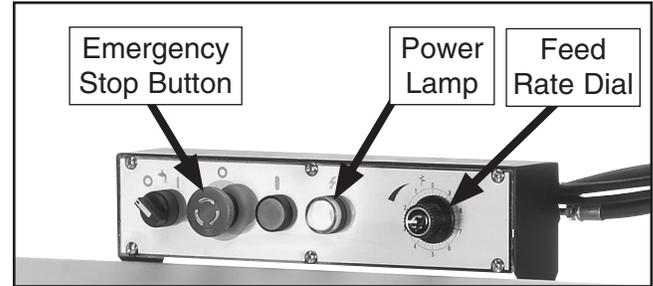


Figure 12. Emergency stop button location.

5. Twist Emergency Stop button clockwise until it springs out. This resets switch so machine can start.
6. Press **ON** button (see **Figure 12**) to turn machine **ON**.

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

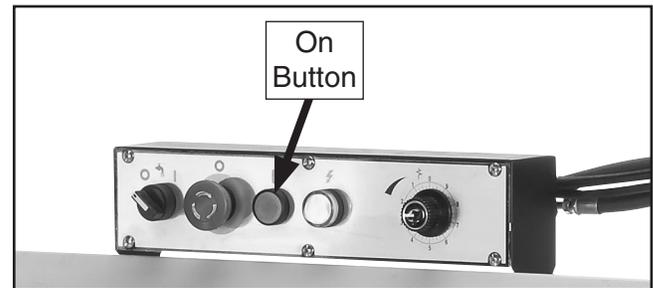


Figure 13. Feed rate dial location.

7. Press Emergency Stop button to turn machine **OFF**.
8. **WITHOUT** resetting Emergency Stop button, try to start machine by pressing **ON** button. The machine should not start.

— If machine *does not* start, safety feature of Emergency Stop button is working correctly.

— If machine *does* start, immediately turn it **OFF** and disconnect power. Safety feature of Emergency Stop button is **NOT** working properly and must be replaced before further using machine.



9. Reset Emergency Stop button and start machine. Rotate feed rate dial counterclockwise. The machine should move to bottom of its travel and then shut off.

— If machine does not stop at bottom of its travel, immediately press Emergency Stop button and disconnect power. The limit switch stop bolt is not adjusted properly and must be adjusted. Refer to **Limit Switch Stop Bolt** on **Page 44** and adjust stop bolt.

10. DISCONNECT MACHINE FROM POWER!
11. Add coolant to coolant system (refer to instructions on **Page 33**).

NOTICE

Running coolant pump without adequate coolant can significantly damage pump, which will not be covered under warranty.

12. Raise headstock several inches.
13. Open both coolant valves by turning handles so they are parallel with valve (see **Figure 14**).

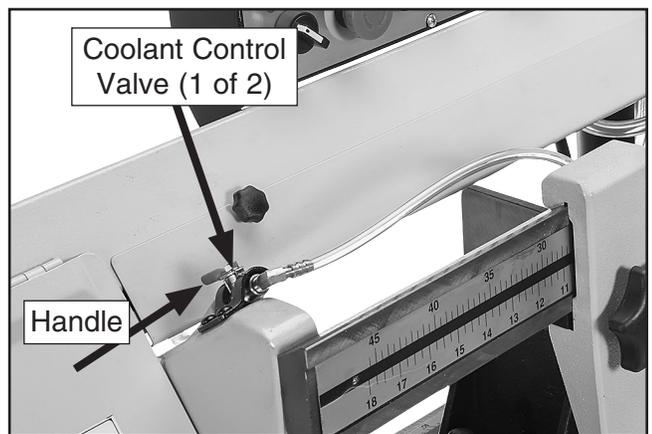


Figure 14. Coolant control valve open.

14. Start machine, then turn coolant pump switch to ON position (see **Figure 15**). Verify that coolant flows through nozzles into tubing and blade guides, then turn pump **OFF** and press Emergency Stop button.

Congratulations! The Test Run is now complete.

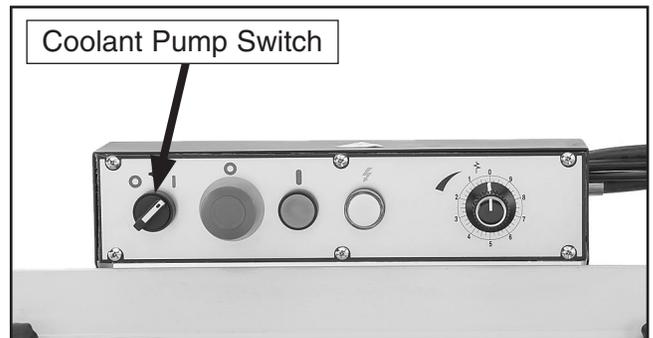


Figure 15. Coolant pump switch location.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure accurate cutting results.

Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE**.

Factory adjustments that should be verified:

1. Blade Tracking (**Page 45**).
2. Blade Guide Bearings (**Page 46**).
3. Squaring Blade to Table (**Page 47**).

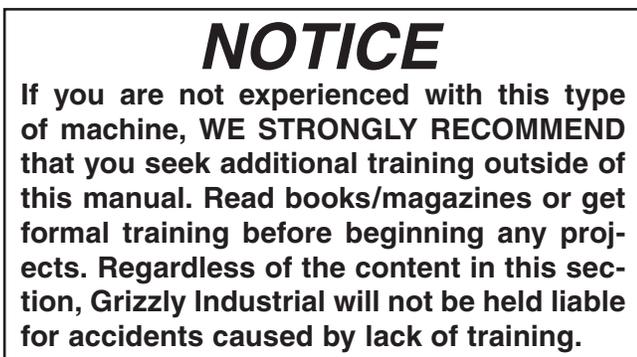
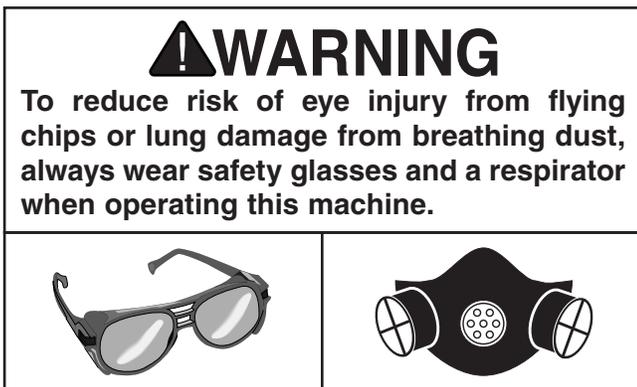


SECTION 4: OPERATIONS

Operation Overview

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

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



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

1. Examines workpiece to make sure it is suitable for cutting.
2. Raises headstock, then rotates feed rate dial all the way clockwise to secure headstock position.
3. Adjusts vise angle, then securely clamps workpiece in vise.
4. Adjusts left blade guide arm as close to workpiece as possible, and verifies blade is properly tensioned.
5. Makes sure workpiece and machine are stable and that there are no obstructions in the way of cut.
6. Puts on safety glasses and respirator.
7. Starts machine and waits for blade to reach full speed, then turns on coolant pump and valves.
8. Turns feed rate dial counterclockwise to lower headstock and blade into workpiece, then allows machine to complete cut.
9. Once machine has stopped, raises headstock, and removes workpiece.
10. When finished, turns machine **OFF**.



Blade Selection

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

Blade Terminology

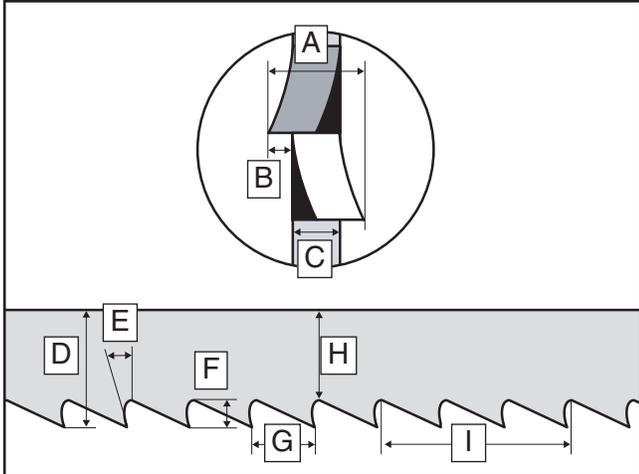


Figure 16. Bandsaw blade terminology.

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

Blade Length

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

Model	Blade Length Range
G0811	114 ¹ / ₄ "–114 ³ / ₄ "

Blade Width

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

Model	Blade Width
G0811	1"

Tooth Type

The most common tooth types are described as follows, and illustrated in Figure 17.

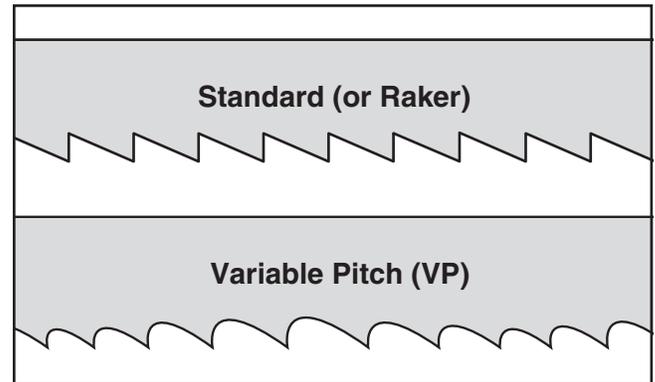


Figure 17. Bandsaw blade tooth types.

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

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



Blade Pitch (TPI)

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

To select correct blade pitch:

1. Measure material thickness. This measurement is distance from where each tooth enters workpiece to where it exits workpiece.
2. Refer to "Material Width/Diameter" row of blade selection chart in **Figure 18**, and read across to find workpiece thickness you need to cut.

3. Refer to "Material Shapes" row and find shape of material to be cut.
4. In applicable row, read across to right and find box where row and column intersect. Listed in the box is minimum TPI recommended for variable tooth pitch blades.

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

The "Cutting Speed Rate Recommendation" chart, which is located on the machine just below the Blade Pitch Chart, offers guidelines for various metals, given in feet per minute (FPM). Refer to **Blade Speed Chart** section on **Page 28** for further details.

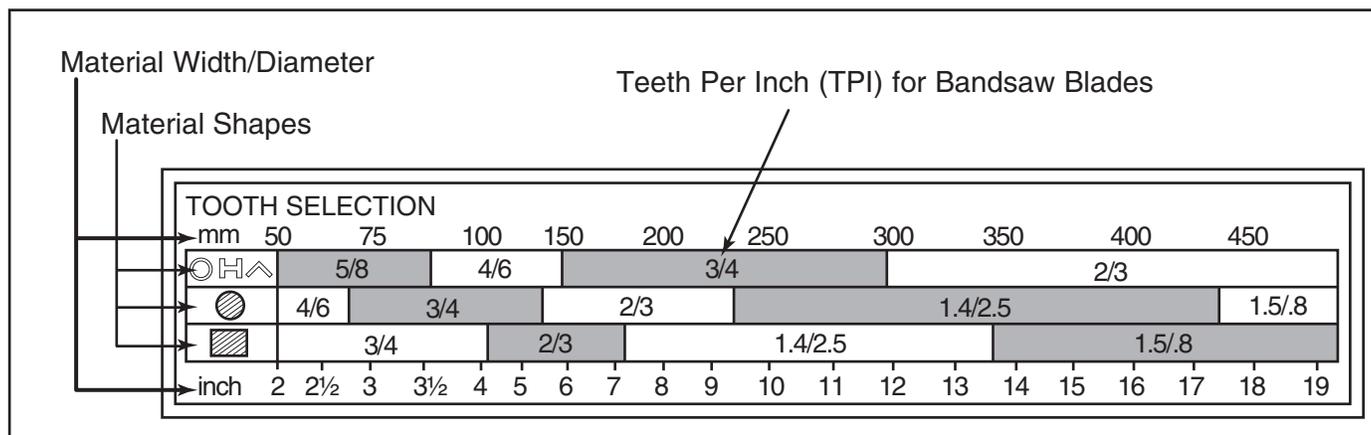


Figure 18. General guidelines for blade selection and speed chart.



Changing Blade



⚠ CAUTION
 All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling and uncoiling saw blades.

Items Needed Qty
 Leather Gloves 1 Pair

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

To change blade on bandsaw:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock about six inches and lock in position by rotating feed rate knob all the way clockwise to "0".
3. Loosen and slide both blade guide arms toward center of headstock (see **Figure 19**).

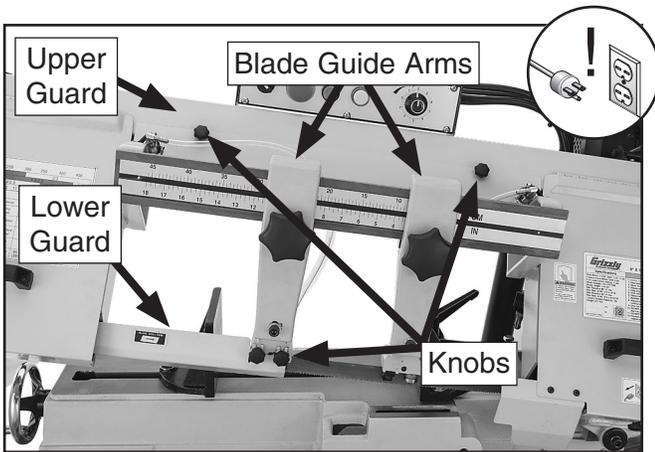


Figure 19. Location of upper and lower blade guards.

4. Loosen or remove knobs that secure upper and lower guards shown in **Figure 19**, then remove both guards.

5. Open both wheel covers. Clean out all chips and shavings with a brush and shop vacuum.
6. Loosen blade tension knob shown in **Figure 20**. Slip old blade off of wheels, then out of blade guide roller bearings.

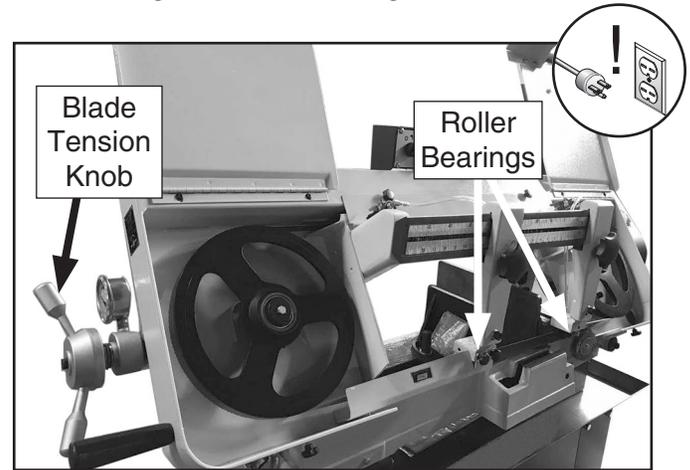


Figure 20. Wheel covers opened for blade removal.

7. Install new blade into front and rear blade guide roller bearings, as shown in **Figure 21**, then position around each wheel.

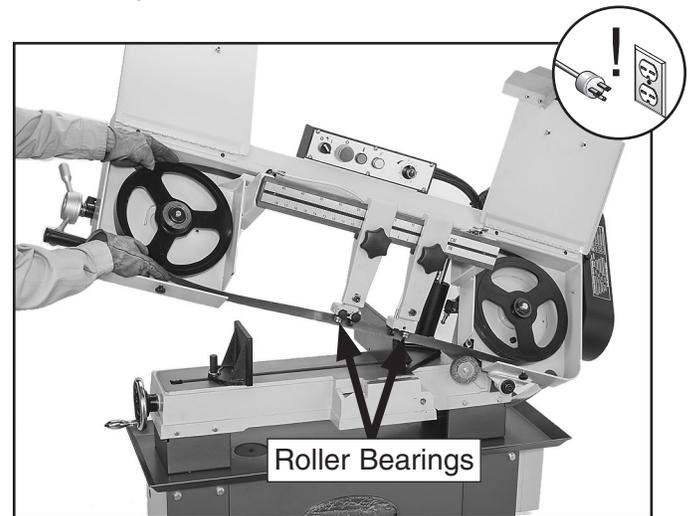


Figure 21. Installing new blade.



Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth face the same direction as blade travel, as shown in **Figure 22**, after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

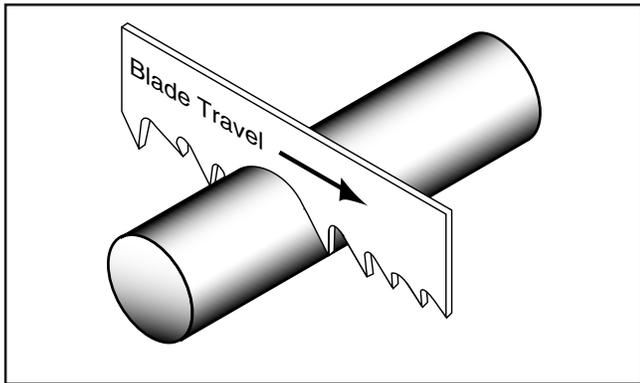


Figure 22. Example of blade cutting direction.

8. Apply a light amount of tension to hold blade in place. Work your way around blade to adjust position so back of blade is against shoulder of wheels, as shown in **Figure 23**.

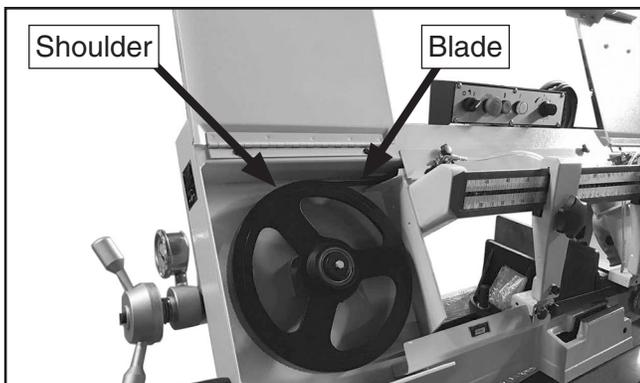


Figure 23. Back of blade against wheel shoulder.

9. Complete blade change using the **Tensioning Blade** procedure that follows this section.
10. Re-install upper and lower blade guards, and close wheel covers.
11. Reposition blade guide arms (refer to **Blade Guide Arms** on **Page 33** for details).

Tensioning Blade

Proper blade tension is essential to avoid blade vibration, twist, or slippage on the wheels. A correctly tensioned blade provides long blade life, straight cuts, and efficient cutting times.

The three major signs of incorrect blade tension are: 1) The blade stalls in the cut and slips on the wheels, 2) the blade frequently breaks, and 3) the bandsaw does not make straight cuts.

To tension bandsaw blade:

1. Make sure blade is tracking properly (refer to **Blade Tracking** on **Page 45** for details).
2. **DISCONNECT MACHINE FROM POWER!**
3. Loosen and slide left blade guide arm (see **Figure 24**) as far left as it will go, then secure.
4. Turn tension knob shown in **Figure 24** clockwise to tighten blade or counterclockwise to loosen blade.

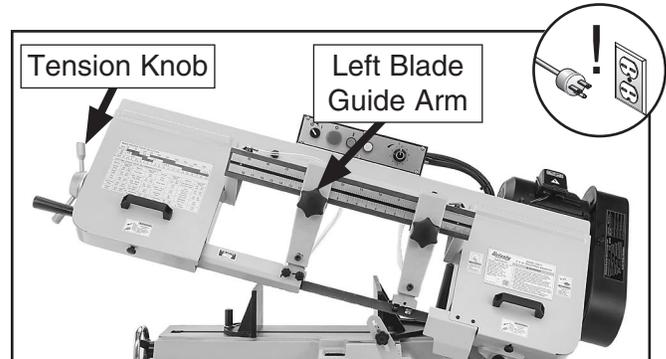


Figure 24. Location of left blade guide arm.

5. Tighten blade until tension gauge needle moves into outer green section of scale for 1" wide blades, as shown in **Figure 25**.

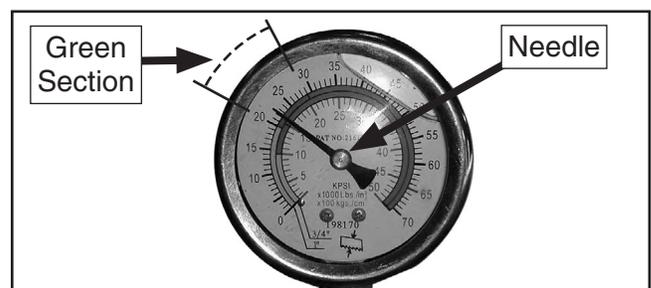


Figure 25. Tension setting for 1" wide blades.



Blade Breakage

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

The most common causes of avoidable blade breakage are:

- Faulty alignment or adjustment of the blade guides.
- Feeding blade through the workpiece too fast.
- Dull or damaged teeth.
- Improperly-tensioned blade.
- Left blade guide assembly set too high above the workpiece. Adjust left blade guide assembly as close to workpiece as possible.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running motor without cutting anything.
- Leaving the blade tensioned when not in use.
- Using the wrong blade pitch (TPI) for the workpiece thickness. The general rule of thumb is to have no fewer than three teeth in contact with the workpiece when starting a cut and at all times during cutting.

Blade Care & Break In

Blade Care

To prolong blade life, always use a blade with the proper width, set, type, and pitch for each application. Maintain the appropriate feed rate, feed pressure, and blade speed, and pay attention to the chip characteristics (Refer to **Blade Speed Chart** on **Page 28** and **Chip Inspection Chart** on **Page 29**). Keep your blades clean, since dirty or gummed up blades pass through the cutting material with much more resistance than clean blades, causing unnecessary heat.

Blade Break In

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

Use the **Chip Inspection Chart** on **Page 29** as a guide to evaluate the chips and ensure that the optimal blade speed and feed rate are being used.

To properly break in new blade:

1. Choose correct speed for blade and material of operation (refer to **Blade Speed Chart** on **Page 29**).
2. Reduce feed pressure by half for first 50–100 in² of material cut.
3. To avoid twisting blade when cutting, adjust feed pressure when total width of blade is in cut.



Blade Speed



The Model G0811 has four speed settings—114, 196, 288, and 377 feet per minute (FPM). Refer to the chart on **Page 28** for cutting speed recommendations by material type.

During operation, pay attention to the chips being produced from the cut and compare them to the **Chip Inspection Chart** on **Page 29** to properly set the feed rate.

To change blade speeds:

1. DISCONNECT MACHINE FROM POWER!
2. Remove knob shown in **Figure 26** and open pulley cover.

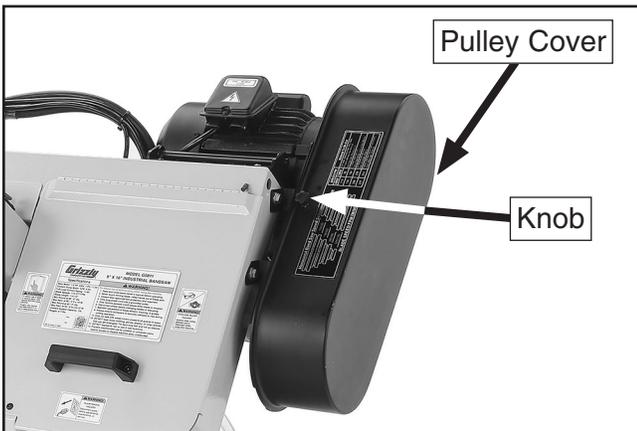


Figure 26. Location of pulley cover knob.

3. Loosen knurled belt tension knob (see **Figure 27**). The motor will drop and V-belt will slacken.

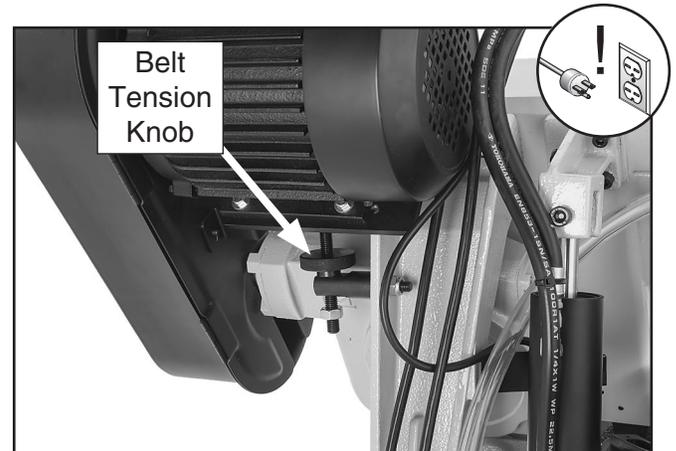


Figure 27. Location of belt tension knob.

4. Move V-belt to desired pulley combination (see **Figure 28**).

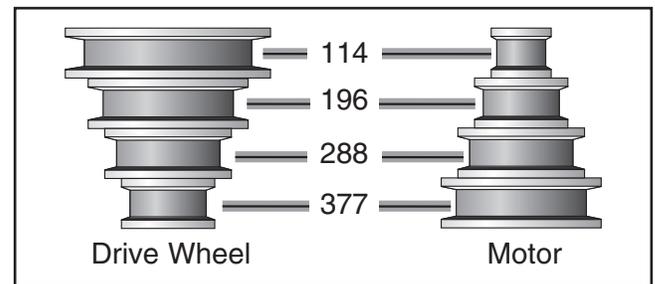


Figure 28. V-belt positions in FPM.

5. Tighten belt tension knob to tension belt.
6. Close and secure belt cover with knob removed in **Step 1**.



Blade Speed Chart

The chart in **Figure 29** offers blade speed guidelines for various metals, given in feet per minute (FPM) and meters per minute (M/Min). Choose the closest available speed on the machine, then adjust the feed rate as necessary, using the appearance of the chips produced as a guide. Refer to the **Chip Inspection Chart** that follows for recommendations on adjusting feed rate or blade speed based on the appearance of the chips produced.

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

Figure 29. Dry cutting blade speed chart.



Chip Inspection Chart

The best method for choosing the cutting speed and feed rate for a cutting operation is to inspect the chips created by the cut. These chips are indicators of what is commonly referred to as the "chip load." Refer to the chip inspection chart below to evaluate chip characteristics and determine whether to adjust feed rate/pressure, blade speed, or both.

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

Figure 30. Chip inspection chart.



Feed Rate

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

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

Tools Needed	Qty
Open-End Wrench 14mm.....	1

Setting Feed Rate

1. Raise headstock to highest position.
2. Set Feed Rate Dial shown in **Figure 31** to desired feed rate—"0" (slowest), "9" (fastest).

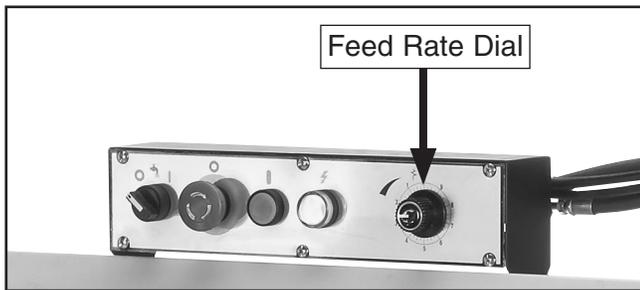


Figure 31. Location of feed rate dial.

Setting Feed Pressure

1. Raise headstock to highest position to remove tension on tension spring (see **Figure 32**).
2. Tighten adjustment nut (see **Figure 32**) enough to remove tension spring play but not enough to apply tension to spring.

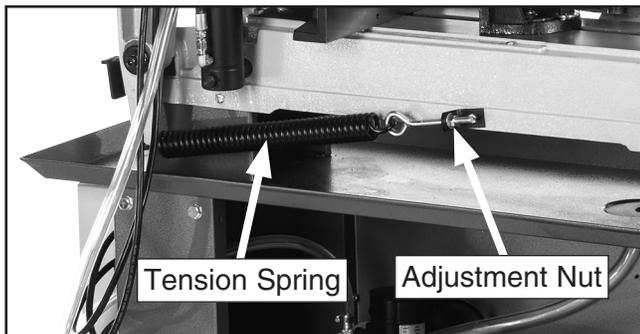


Figure 32. Feed pressure controls.

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

3. Clamp workpiece in vise.
4. Close feed rate dial to lock headstock and blade a few inches above workpiece.
5. With correct saw blade and blade speed selected, turn saw and coolant pump **ON**.
6. Open feed rate dial (see **Figure 31**), then slowly rotate dial clockwise to a slow feed rate until saw begins to cut workpiece.
7. Observe chips that exit cut, and increase or decrease feed rate according to chip characteristics indicated in **Chip Inspection Chart** on **Page 29**.

Work Stop

The Model G0811 is equipped with a work stop that can be used to quickly position the workpiece during a repetitive cutting operation. Adjust the work stop as needed, then tighten the set screw and knob to lock it in place, as shown in **Figure 33**.

Tool Needed	Qty
Hex Wrench 3mm.....	1

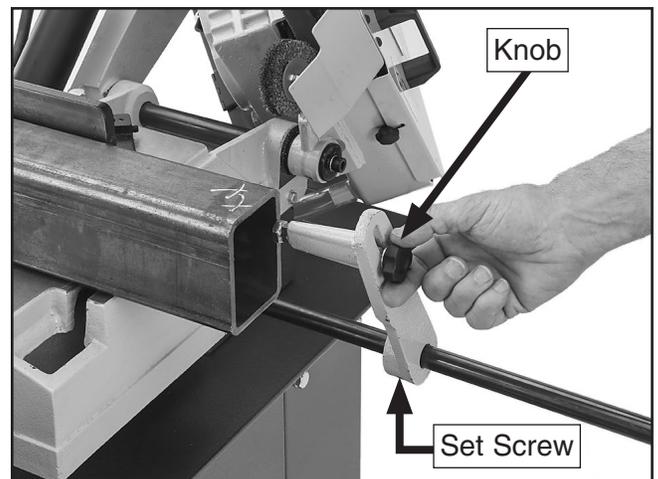


Figure 33. Setting work stop to support repetitive cutting operation.



Vise

⚠ CAUTION

Always turn saw *OFF* and allow blade to come to complete stop before adjusting vise! Failure to follow this caution may lead to injury.

The movable vise (see **Figure 34**) has a quick release feature that allows jaw width to be quickly adjusted when changing from one sized material to another.

The fixed vise (see **Figure 34**) can be adjusted to cut any angle, from a straight 90-degree cut-off to a 45-degree angle, by loosening the front lock bolt and rear vise lock handle. Positive stops at 90° and 45° allow you to quickly return the fixed jaw to either angle. Angles between 90° and 45° can be read using the scale on the side of the vise table. Use a combination square or bevel protractor if higher precision is required when finding these angles.

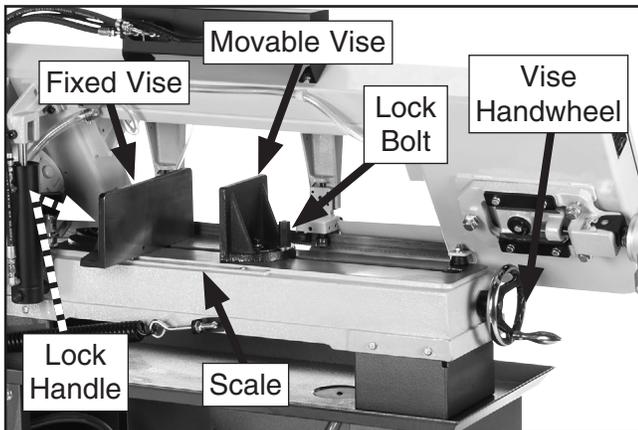


Figure 34. Location of vise components.

Tools Needed	Qty
Hex Wrench 3mm.....	1
Hex Wrench 4mm.....	1

Using Vise

1. Turn vise handwheel (see **Figure 34**) counterclockwise to relieve any pressure on movable vise jaw.
2. Pull or push movable vise jaw in desired direction.
3. Finish tightening jaw against workpiece with handwheel.

Note: *Figure 35 shows correct methods of holding different workpiece shapes.*

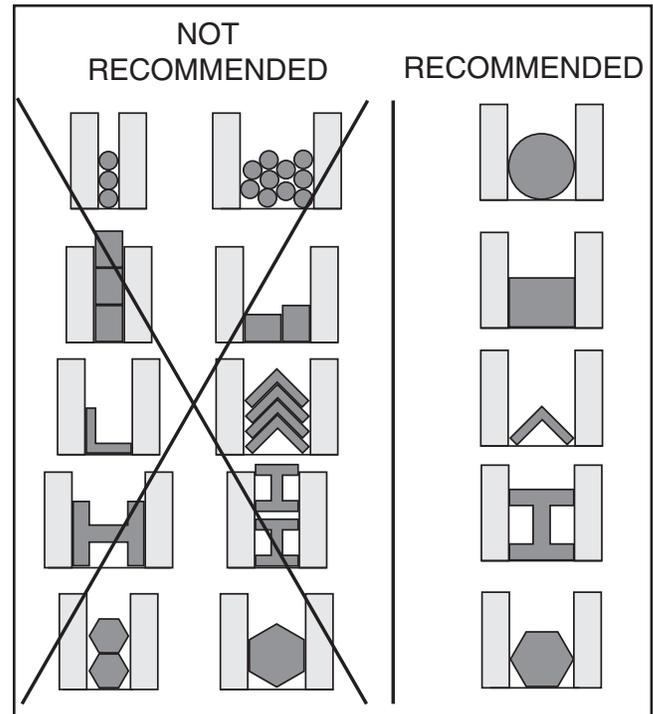


Figure 35. Example of work holding options by material shape.



Adjusting Fixed Jaw Positive Stops

1. Check current fixed vise jaw-to-blade angle with machinist's square (see **Figure 36**).

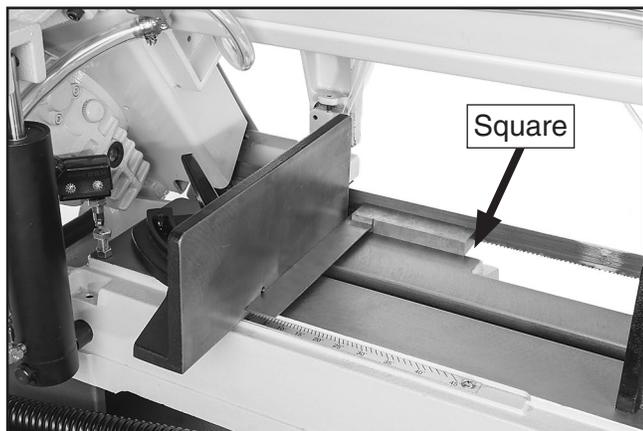


Figure 36. Squaring fixed vise to blade.

- If angle *is* 90°, skip to **Step 3**.
- If angle *is not* 90°, loosen fixed vise lock handle and set screw above 90° stop screw shown in **Figure 37**, then adjust stop screw as needed (see **Figure 37**).

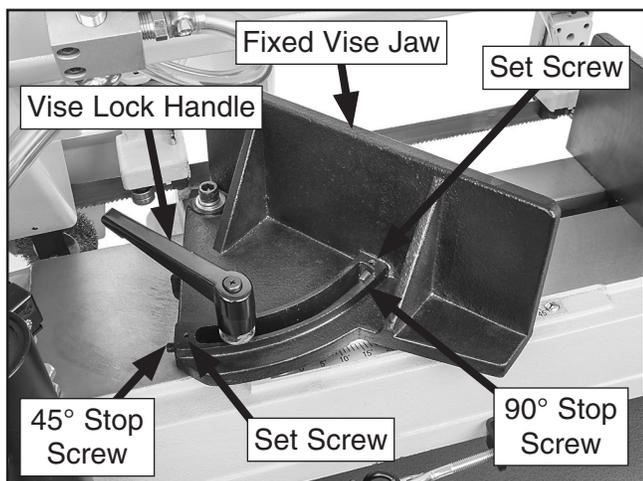


Figure 37. Fixed vise positive stop adjustments.

2. With 90° stop screw contacting lock handle base, tighten lock handle and recheck angle. Repeat **Steps 1–2** as necessary, then tighten set screw above 90° stop screw.
3. Loosen lock handle and swing fixed jaw until 45° stop screw contacts lock handle base.

4. Tighten lock handle and check angle.
 - If angle *is* 45°, no further adjustments are necessary.
 - If angle *is not* at 45°, loosen lock handle and set screw above 45° stop screw (see **Figure 37**), and then adjust stop screw as needed.
5. With 45° stop screw contacting lock handle base, tighten lock handle and recheck angle. Repeat **Steps 4–5** if necessary, then tighten set screw above 45° stop screw.

Setting Angles Between Stops (45°-90°)

1. To find your angle, use scale on side of vise, or use combination square or bevel protractor for more precise measurements.
2. Adjust and lock fixed vise jaw to your chosen angle.
3. Loosen lock bolt shown in **Figure 38** on movable vise so jaw can match angle of workpiece and fixed jaw.

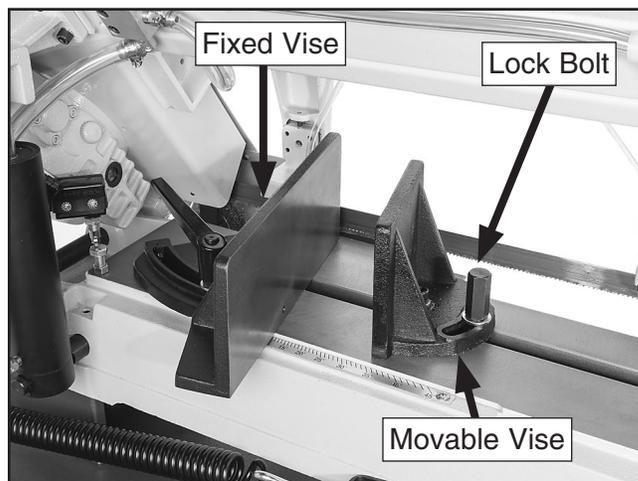


Figure 38. Movable vise positioned to match angle of fixed vise jaw.

4. Tighten movable vise against workpiece, then tighten lock bolt.



Blade Guide Arms

The bearings are mounted on the right and left blade guide arms (facing front of machine). The arms are adjustable and should be set as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off of the cut line.

To adjust blade guide arms:

Loosen blade guide knobs (see **Figure 39**), and slide blade guide arms as close to workpiece as possible, then tighten knob.

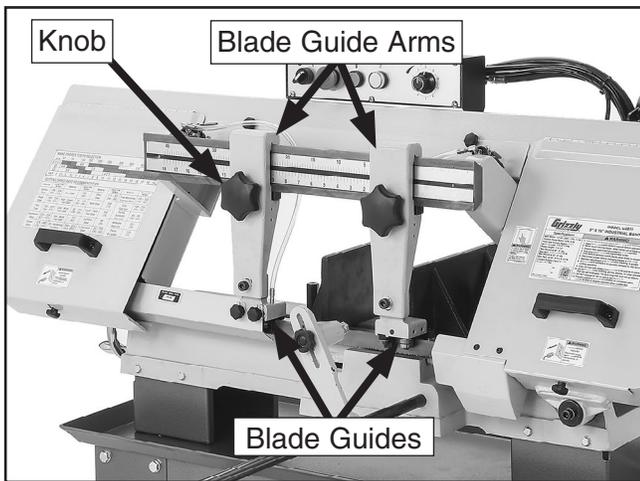


Figure 39. Location of blade guides and blade guide arms.

Coolant

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

Use the information below as a guideline to choose the appropriate coolant. Always refer to the coolant manufacturer for specific application and safety information:

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

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

Tip: Using a refractometer or hydrometer to replenish water in water-based coolant can extend the life of blades and coolant, and ensure consistent cutting results.

	<p>! WARNING BIOLOGICAL AND POISON HAZARD! Use proper personal protection equipment when handling coolant and follow federal, state, and fluid manufacturer requirements to properly dispose of coolant.</p>
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Coolant System



This bandsaw has a built-in coolant system that extends the life of your bandsaw blades by lowering the temperature of the blade and workpiece when cutting. See **Coolant** on **Page 33** for additional information.

To use coolant system:

1. Thoroughly clean and remove any foreign material that may have fallen inside coolant tank during shipping.
2. Place filter screen and drain tube into coolant tank, as shown in **Figure 40**.

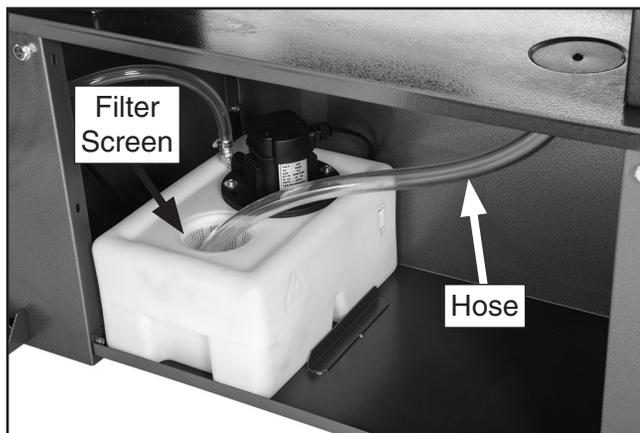


Figure 40. Filter screen and hose installed.

3. Add coolant (refer to **Adding Coolant** on **Page 40**).

4. Make sure coolant control valves are closed (see **Figure 41**).

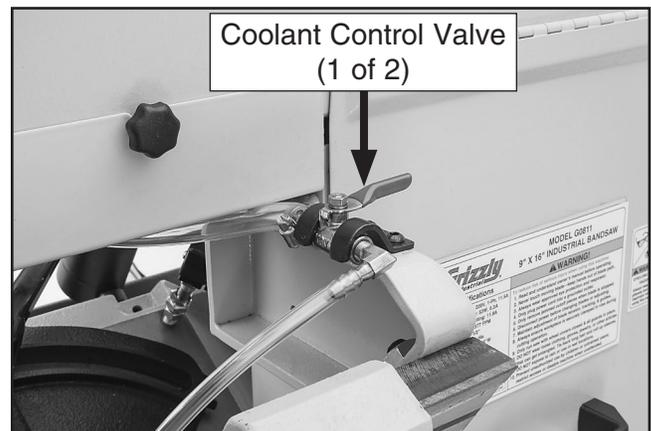


Figure 41. Coolant control valve closed.

5. Turn coolant pump switch **ON** (see **Figure 42**) before starting cut.

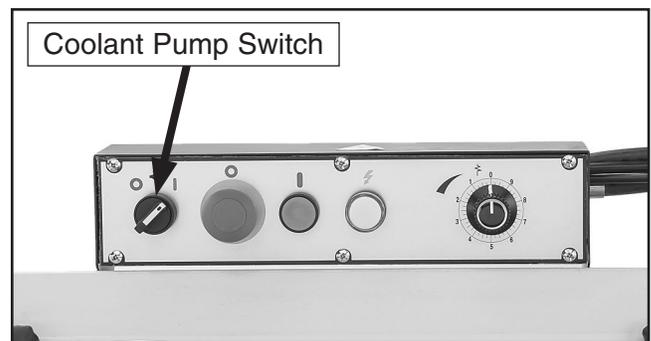


Figure 42. Location of coolant pump switch.

6. Adjust coolant control hose valves to control flow of coolant (see **Figure 41**). Make sure pressure is not so high that coolant spills on floor and creates slipping hazard. When bandsaw reaches bottom of cut, motor and coolant system automatically shut **OFF**.

NOTICE

Keep chip screen tray clear so coolant can recycle to pump reservoir. **NEVER** operate pump with reservoir below low mark or you will overheat pump and void warranty!



Operation Tips

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

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece, and do not start a cut on the sharp edge of a workpiece.
- Chips should be curled and silvery. If the chips are thin and powder-like, increase your feed rate.

- Burned chips indicate a need to reduce your blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut, and flag the ends to alert passers-by of potential danger.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

NOTICE

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



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.

Variable Pitch Bi-Metal Blades

- T27638—114 $\frac{1}{2}$ " x 1 x .035 3-4 Variable Pitch
- T27639—114 $\frac{1}{2}$ " x 1 x .035 4-6 Variable Pitch
- T27640—114 $\frac{1}{2}$ " x 1 x .035 5-8 Variable Pitch
- T27641—114 $\frac{1}{2}$ " x 1 x .035 6-10 Variable Pitch
- T27642—114 $\frac{1}{2}$ " x 1 x .035 8-12 Variable Pitch
- T27643—114 $\frac{1}{2}$ " x 1 x .035 10-14 Variable Pitch



Figure 43. Typical variable pitch bi-metal cutting blade.

H9240—Water Soluble Machining Oil

Rustlick water soluble machining oil contains effective chlorinated E.P. additive to provide excellent tool life. Guaranteed to protect neoprene seals. Great for general purpose or heavy duty applications. Can be used on all metals except titanium.



Figure 44. H9240 Rustlick Machining Oil.

SB1365—South Bend Way Oil-ISO 68

T23964—Moly-D Multi-purpose NLGI#2 Grease

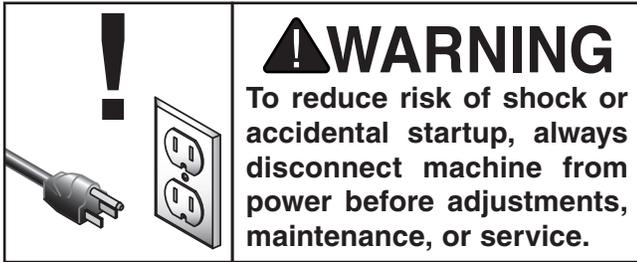


Figure 45. Recommended products for machine lubrication.

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:

- Check/correct loose mounting bolts.
- Check/correct damaged or dull saw blade.
- Check/correct worn or damaged wires.
- Clean/protect table.
- Clean metal chips from upper and lower wheel areas.
- Correct any other unsafe condition.

Monthly:

- Lubricate vise leadscrew (**Page 38**).
- Change coolant and clean tank (**Page 40**).
- Monitor gearbox oil level (**Page 39**); check that oil level is even with halfway mark on sight glass with headstock in down position.

Yearly:

- Change gearbox oil (**Page 39**).

Cleaning & Protecting

Use a brush and shop vacuum to remove chips and other debris from the working surfaces.

Remove any rust build-up from unpainted cast iron surfaces of your machine and treat with a non-staining lubricant after cleaning.

Keep unpainted cast iron surfaces rust-free with regular applications of ISO 68 way oil (see **Page 36** for offerings from Grizzly).

Lubrication

The bearings on your bandsaw are factory lubricated and sealed. Leave them alone unless they need to be replaced.

Use the schedule below and the following instructions to properly lubricate the other components that require lubrication.

Lubrication Task	Frequency (Hours of Operation)	Page Ref.
Blade Tension Leadscrew	8 Hrs.	38
Blade & Guides	8 Hrs.	38
Table & Vise	8 Hrs.	38
Vise Leadscrew	40 Hrs.	38
Gearbox	50 Hrs.	39

Figure 46. Recommended lubrication tasks, schedules, and instruction page references.



Items Needed

Qty

- NLGI#2 Grease or Equivalent As Needed
- ISO 68 Oil (SB1365 or Equivalent) As Needed
- Mineral Spirits..... As Needed
- Brush 1
- Clean Shop Rags As Needed
- 3-Gallon Catch Pan..... 1

Blade Tension Leadscrew

- Lube Type.. Model SB1365 or ISO 68 Equivalent
- Oil Amount.....1-2 Drops
- Lubrication Frequency.....8 Hrs. of Operation

Lubricate the blade tension leadscrew with 1-2 drops of light machine oil daily (see **Figure 47**). Wipe off excess oil with a clean rag.

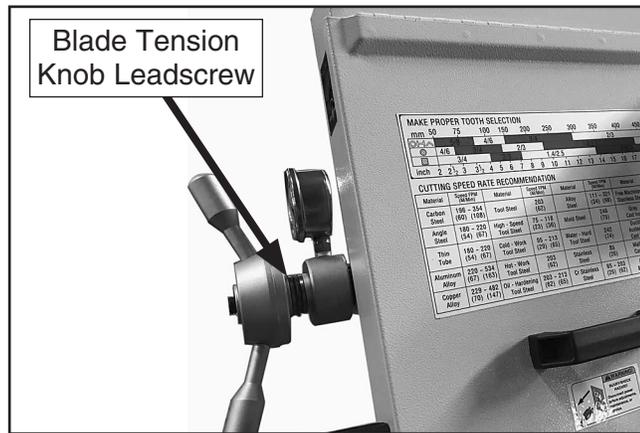


Figure 47. Blade tension leadscrew lubrication location.

Blade & Guides

- Lube Type.. Model SB1365 or ISO 68 Equivalent
- Oil Amount.....1-2 Drops
- Lubrication Frequency.....8 Hrs. of Operation

Place one or two drops of light machine oil on blade and guides daily, especially when cutting cast iron, as no coolant is recommended.

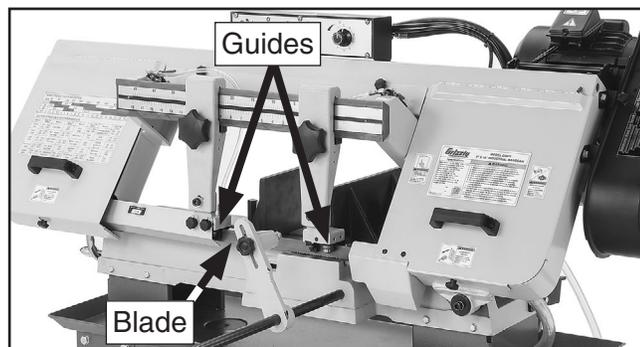


Figure 48. Blade and guide lubrication points.

Table & Vise

- Lube Type.. Model SB1365 or ISO 68 Equivalent
- Oil Amount.....Thin Coat
- Lubrication Frequency.....8 Hrs. of Operation

Keep the table, vise (see **Figure 49**), and other machined surfaces rust-free with regular applications of a quality way oil.

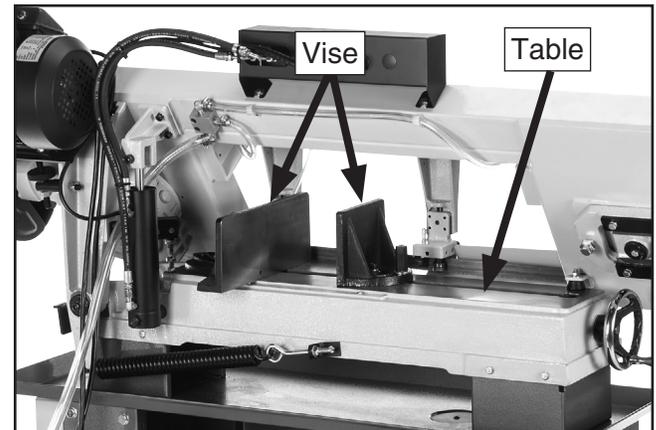


Figure 49. Table and vise.

Vise Leadscrew

- Lube Type..... SB1365 or ISO 68 Equivalent
- Oil Amount.....Thin Coat
- Lubrication Frequency.....40 Hrs. of Operation

Use mineral spirits, shop rags, and a brush to clean the vise leadscrew from underneath the table. When dry, use a clean brush to apply a thin coat of oil to the leadscrew threads (see **Figure 50**).

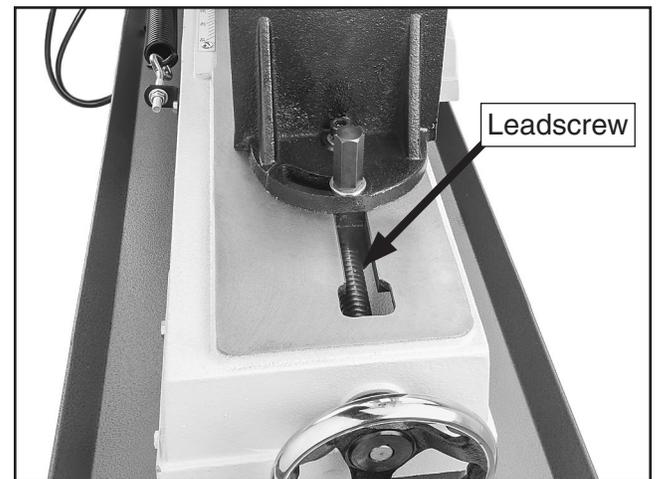


Figure 50. Vise leadscrew lubrication area.



Gearbox

Lube Type.. Model SB1365 or ISO 68 Equivalent
Oil Amount..... 2.6 Qt.
Lubrication Frequency.....50 Hrs. of Operation

The gearbox should be drained and refilled after the first 50 hours of use, then once every year.

To change gearbox oil:

1. Run machine for several minutes to warm up oil in gearbox.
2. DISCONNECT MACHINE FROM POWER!
3. Raise headstock to highest position and rotate feed control dial all the way clockwise.
4. Remove fill plug shown in **Figure 51**.

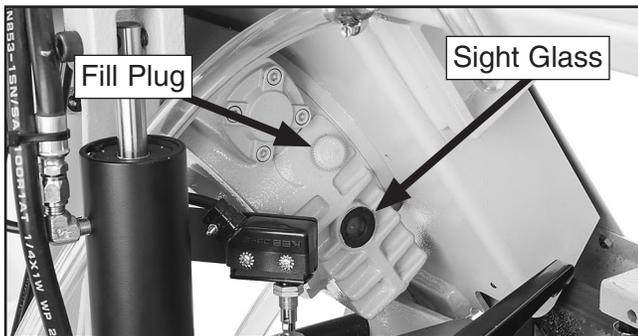


Figure 51. Gearbox fill plug and sight glass.

5. Place drain pan under drain plug, then remove drain plug (see **Figure 52**) to drain oil.

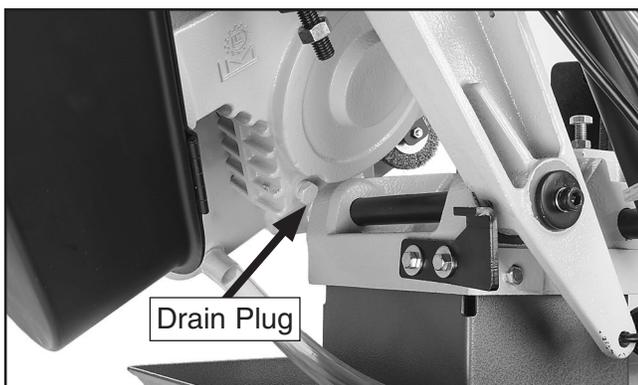


Figure 52. Location of drain plug.

6. Re-install drain plug, remove drain pan, then lower headstock to its lowest position.
7. Fill gearbox with oil until oil level is at halfway point in sight glass, then replace fill plug.

Model G0811 (Mfd. Since 02/16)



Inspecting V-Belt

Inspect regularly for tension and wear. Refer to **Figure 53** for proper belt tension. Belt deflection should be approximately $\frac{1}{4}$ " under moderate pressure. The replacement V-belt can be found in the back of this manual in the parts breakdown.

To replace the V-belt, refer to **Blade Speed** on **Page 27** to loosen it. Remove the old belt from the pulleys, then install a new V-belt and ensure it is properly tensioned.

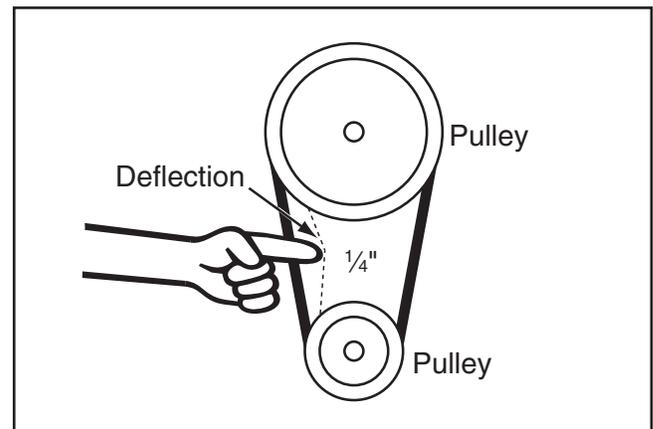


Figure 53. Checking belt tension.

Coolant System Service

The coolant system consists of a fluid tank, pump, and hose with valves. The pump pulls fluid from the tank and sends it to the valves, which control the flow of coolant. As the fluid leaves the work area, it drains through the cabinet, where the swarf and metal chips are screened out, and back into the tank.

Although most swarf from machining operations is screened out of the coolant before it returns to the tank, small particles will accumulate in the bottom of the tank in the form of sludge. To prevent this sludge from being pulled into the pump and damaging it, the pump's intake is positioned above the bottom of the tank. This works well when the tank is regularly cleaned; however, if excess sludge is allowed to accumulate, the pump will inevitably begin sucking it up. Therefore, we recommend always cleaning the coolant tank whenever changing the coolant.

Hazards

As coolant ages and gets used, dangerous microbes can proliferate and create a biological hazard. The risk of exposure to this hazard can be greatly reduced by replacing the old fluid on a monthly basis, or as indicated by the fluid manufacturer.

When working with the coolant, minimize exposure to your skin, eyes, and lungs by wearing the proper PPE (Personal Protective Equipment), such as long-sleeve waterproof gloves, protective clothing, splash-resistant safety goggles, and a NIOSH-approved respirator.

	<p>⚠️ WARNING</p> <p>BIOLOGICAL & POISON HAZARD!</p> <p>Use correct personal protection equipment when handling coolant. Follow federal, state, and fluid manufacturer requirements for proper disposal.</p>
  	

Adding Coolant

Items Needed	Qty
Safety Wear.....	See Hazards
New Coolant.....	10.5 Quarts
Disposable Shop Rags.....	As Needed

To add coolant:

1. DISCONNECT MACHINE FROM POWER!
2. Fill reservoir with coolant through filter screen (see **Figure 54**) until it is at "high" mark.

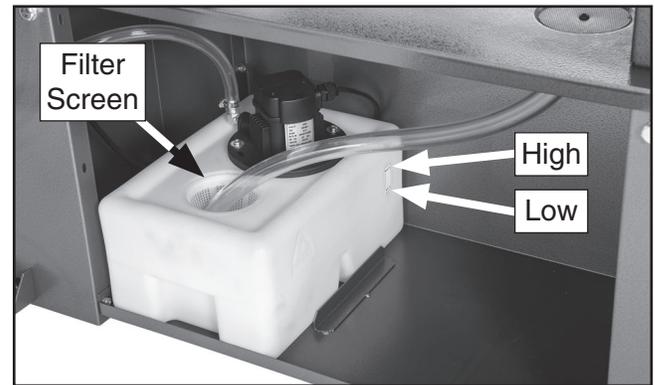


Figure 54. Location of filter screen and "high" mark on tank.

Changing Coolant

Items Needed	Qty
3-Gallon Bucket w/Lid	1
Flat Head Screwdriver #2.....	1

To change coolant:

1. DISCONNECT MACHINE FROM POWER!
2. Remove return hose and filter screen (see **Figure 54**) from tank.
3. Empty tank contents into bucket and dispose of fluid following federal, state, and fluid manufacturer requirements.
4. Thoroughly clean tank and pump with hot soapy water.
5. When dry, refill tank with coolant.
6. Replace filter screen and return hose.



Machine Storage

All machinery will develop serious rust problems and corrosion damage if it is not properly prepared for storage. If decommissioning this machine, use the steps in this section to ensure that it remains in good condition.

Items Needed	Qty
NLGI#2 Grease	As Needed
Rust Preventative	As Needed
Control Tags	As Needed
Tarp/Plastic Sheet	1
Desiccant Packs	As Needed

Preparing Machine for Storage

1. DISCONNECT MACHINE FROM POWER!
2. Thoroughly clean all unpainted, bare metal surfaces, then coat them with light weight grease or rust preventative. Take care to ensure these surfaces are completely covered but that grease or rust preventative is kept off of painted surfaces.

If machine will be out of service for only a short period of time, use quality medium-weight machine oil (not auto engine oil) in place of grease or rust preventative.

3. Remove old coolant, then add a few drops of way oil and blow out lines with compressed air.

4. Loosen or remove blade so it does not stretch or rust while machine is stored.

— If machine will be out of service for only a short period of time, start machine once a week and run all gear-driven components for a few minutes. This will put fresh coat of gear oil on gearing components inside gearbox.

— If it will be out of service for a long period of time, drain, then completely fill gearbox with recommended gear oil so components above normal oil level do not develop rust. (Make sure to put a tag on controls as a reminder for re-commissioning process to adjust gear oil level before starting machine.)

5. Place a few moisture-absorbing desiccant packs inside of electrical box.
6. Completely cover machine with tarp or plastic sheet that will keep out dust and resist liquid or moisture. If machine will be stored in/near direct sunlight, use a cover that will block the sun's rays.

Bringing Machine Out of Storage

1. DISCONNECT MACHINE FROM POWER!
2. Remove moisture-absorbing desiccant packs from electrical box.
3. Repeat **Test Run** on **Page 19**.
4. Add coolant, as described in **Coolant System Service** on **Page 40**.



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. **Note:** Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> Emergency stop button depressed/at fault. Incorrect power supply voltage or circuit size. Power supply circuit breaker tripped or fuse blown. Motor wires connected incorrectly. Wiring open/has high resistance. Motor stop limit switch engaged/at fault. Motor centrifugal switch out of adjustment or at fault. ON button at fault. Start capacitor at fault. Thermal overload relay has tripped. Contactors not energized/has poor contacts. Motor at fault. 	<ol style="list-style-type: none"> Rotate button clockwise to reset. Replace if at fault. Ensure correct power supply voltage and circuit size. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. Correct motor wiring connections. Check/fix broken, disconnected, or corroded wires. Adjust/replace. Adjust/replace. Replace switch. Test/replace. Allow to cool, then reset; replace. Test all legs for power/replace if at fault. Test/repair/replace.
Machine stalls or underpowered.	<ol style="list-style-type: none"> Feed rate too fast; blade speed too low. Machine undersized for task. Blade not correct for material being cut. Improper workpiece material for saw/blade. Blade slipping on wheels. Belt slipping; oil/grease on V-belt. Motor overheated. Motor wired incorrectly. Blade dull. Pulley/sprocket slipping on shaft. Contactors has poor contacts. Motor at fault. 	<ol style="list-style-type: none"> Reduce feed rate/pressure; increase blade speed. Use correct, sharp blade; reduce feed rate/pressure; use coolant if possible. Use correct blade for operation (Page 22). Only cut correct material for saw blade/type. Adjust blade tracking (Page 45), tension (Page 25). Tension/replace belt (Page 27 & 39); clean belt. Clean motor, let cool, reduce workload. Wire motor correctly (Page 50). Replace blade (Page 24). Replace loose pulley/shaft. Test all legs for power/replace if at fault. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> Motor or component loose. Blade at fault. Belt worn or loose. Motor fan rubbing on fan cover. Pulley loose. Motor mount loose/broken. Machine incorrectly mounted to floor. Motor bearings at fault. Gearbox at fault. 	<ol style="list-style-type: none"> Retighten/replace damaged bolts/nuts. Replace/resharpen blade. Inspect or replace belt (Page 39). Fix/replace fan cover; replace loose/damaged fan. Re-align/replace shaft, pulley, set screw, and key. Tighten/replace. Tighten mounting bolts; relocate/shim machine. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. Rebuild gearbox for bad gear(s)/bearing(s).



Operation

Symptom	Possible Cause	Possible Solution
Vibration when operating or cutting.	<ol style="list-style-type: none"> Loose or damaged blade. Bent, damaged or dull blade. Machine component loose. Worn wheel bearing. Wheel bent/worn. 	<ol style="list-style-type: none"> Tighten or replace blade (Pages 24–25). Replace blade (Page 24). Fix/replace fan cover; replace loose/damaged fan. Check/replace wheel bearing. Check/replace wheel and wheel bearing.
Ticking sound when saw is running.	<ol style="list-style-type: none"> Blade missing teeth. Blade weld contacting blade guides. Blade weld may be failing. 	<ol style="list-style-type: none"> Replace blade (Page 24). Grind blade weld down smaller. Cut and reweld blade, or replace blade (Page 24).
Machine or blade bogs down in cut.	<ol style="list-style-type: none"> Feed rate too fast; blade speed too low. Blade tension too low. V-belt slipping; oil/grease on belt; improper tension. Blade gullets loading up with chips. Blade dull, wanders, or gets pinched in cut. Blade TPI too coarse. Material requires cutting fluid/lubrication. 	<ol style="list-style-type: none"> Reduce feed rate (Page 30); increase blade speed (Page 27). Increase blade tension (Page 25). Tighten/clean/replace V-belt (Page 39). Install blade with more suitable TPI or tooth style (Page 22). Replace blade (Page 24), adjust guides (Page 46), or adjust tracking (Page 45). Use blade with at least 2 teeth contacting material at all times (Page 22). Use applicable coolant/lubricant.
Cuts are not square, or the intended angle is incorrect.	<ol style="list-style-type: none"> Vise positive stops set incorrectly. Loose lock levers. Blade not square to table. 	<ol style="list-style-type: none"> Adjust/tighten positive stops (Page 32). Tighten loose vise lock lever/lock bolt (Page 31). Adjust blade square to table (Page 47).
Blade dulls prematurely, or metal sticking to the blade.	<ol style="list-style-type: none"> Incorrect coolant mixture for workpiece/cut. Incorrect feed/speed. Blade gullets loading up with chips. Blade improperly broken in. Blade brush worn/misadjusted. 	<ol style="list-style-type: none"> Use correct coolant mixture (refer to coolant manufacturer's recommended mixture). Adjust feed rate (Page 30) or blade speed (Page 27). Use blade with larger gullets/fewer TPI (Page 23). Replace blade (Page 24); complete blade break in procedure (Page 26). Adjust/replace blade brush (Page 44).
Blade wears on one side or shows overheating.	<ol style="list-style-type: none"> Blade guides worn or misadjusted. Blade support inadequate. Dull/incorrect blade. Incorrect coolant mixture for workpiece/cut. 	<ol style="list-style-type: none"> Re-adjust (Page 46)/replace. Tighten blade guide close to workpiece as possible. Replace blade (Page 24). Use correct coolant mixture (refer to coolant manufacturer's recommended mixture).
Blade tracks incorrectly, or comes off wheels.	<ol style="list-style-type: none"> Feed rate too fast/wrong TPI. Blade tension too low. Blade bell-mouthed. Blade guides need adjustment. Metal chip buildup on wheels. Blade tracking requires adjustment. 	<ol style="list-style-type: none"> Reduce feed rate/pressure (Page 30); decrease blade TPI (Page 23). Increase blade tension (Page 25). Install new blade (Page 24); regularly remove tension from blade when not in use (Page 25). Adjust blade guides (Page 46). Clean metal chips from wheels. Adjust blade tracking (Page 45).
Cuts are crooked.	<ol style="list-style-type: none"> Feed rate too fast; blade speed too low. Guide bearings out of adjustment; guide arms too far from workpiece. Blade tension too low. Blade dull. 	<ol style="list-style-type: none"> Reduce feed rate (Page 30); increase blade speed (Page 27). Re-adjust (Page 33, 46)/replace. Increase blade tension (Page 25). Replace blade (Page 24).



Blade Brush

The Model G0811 has a blade brush to help keep metal chips off the blade wheels. It will wear over time and require re-adjustment when it no longer contacts the blade.

Tool Needed	Qty
Hex Wrench 4mm.....	1

To adjust blade brush:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen button headstock cap screw shown in **Figure 55**.

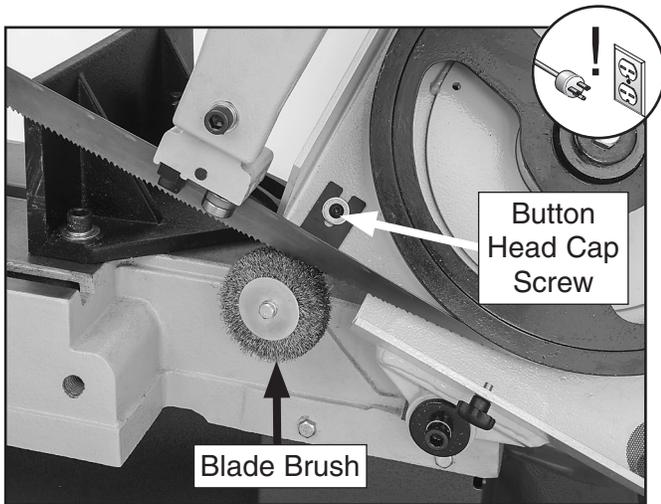


Figure 55. Blade brush adjustment location.

3. Slide blade brush bracket as needed so blade extends approximately $\frac{1}{8}$ " into bristles of brush. Hold bracket in position, then re-tighten button head cap screw.

Limit Switch Stop Bolt

The limit switch stop bolt will need to be adjusted if the machine does not turn **OFF** after it completes a cut.

Tools Needed	Qty
Open-End Wrench 14mm.....	1
Open-End Wrench 17mm.....	1

To adjust limit switch stop bolt:

1. DISCONNECT MACHINE FROM POWER!
2. Lift headstock, then adjust feed rate dial as needed, and lower headstock.
3. Listen for click from limit switch (see **Figure 56**) when headstock reaches bottom of its travel. If switch does not click, loosen jam nut (see **Figure 56**), slightly adjust stop bolt, and repeat until satisfactory.
4. Tighten jam nut (see **Figure 56**) against base to prevent stop bolt from loosening during use.

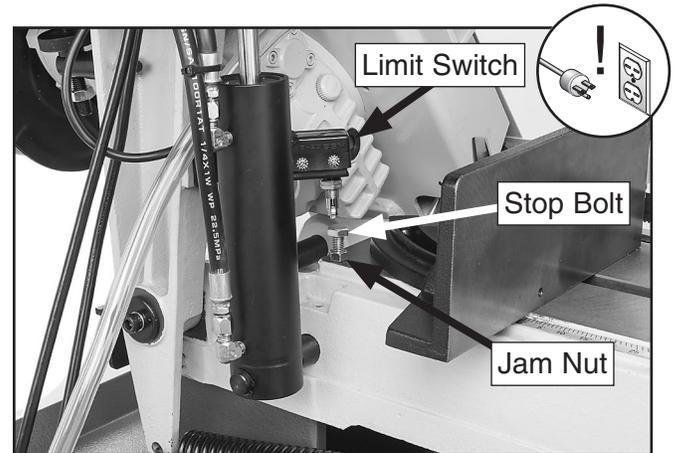


Figure 56. Limit switch stop bolt and jam nut location.



Blade Tracking

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

Tools Needed	Qty
Hex Wrench 8mm.....	1
Adjustable Wrench	1
Open-End Wrench 17mm.....	1
Open-End Wrench 24mm.....	1

To adjust blade tracking:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock all the way up and open both wheel covers.
3. Remove air hoses from blade guide assemblies, then remove both assemblies.
4. Ensure blade is properly tensioned (refer to **Blade Tension** on **Page 25** for details).
5. Making sure coolant hoses are out of blade path, quickly turn machine **ON** and **OFF**.

— If blade lightly touches shoulder of idler wheel without rubbing (see **Figure 57**), blade is tracking properly and no adjustments are needed. Go to **Step 6**.

— If blade moves away from shoulder of idler wheel or rubs against it, loosen all (3) jam bolts, adjust (3) tracking adjustment bolts, and repeat **Step 5** as needed until back of blade lightly touches shoulder of idler wheel, then tighten all (3) jam bolts.

Note: We recommend making small, incremental adjustments with adjustment bolts.

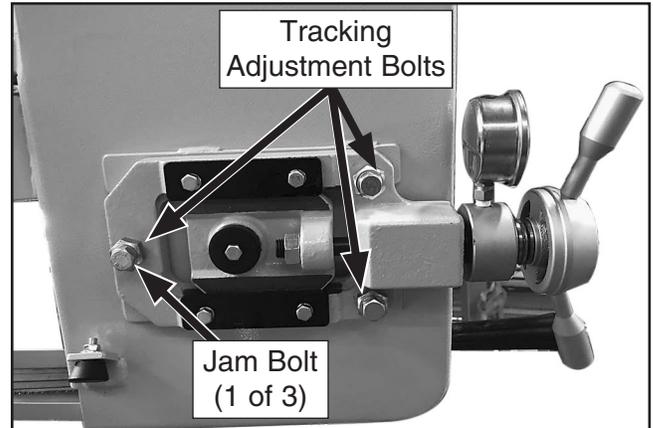


Figure 58. Blade tracking controls on idler wheel.

6. Re-install coolant hoses onto both blade guide assemblies, then re-install them, making sure they are correctly adjusted (refer to **Blade Guide Bearings**) on **Page 46**.
7. Close wheel covers.

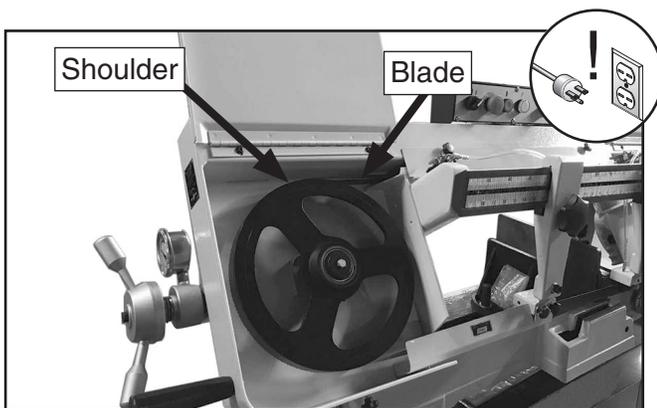


Figure 57. Blade tracking properly against idler wheel shoulder.



Blade Guide Bearings

The blade guide bearings come adjusted from the factory, but due to shipping and storage may need adjustment. Uneven blade wear and crooked cuts may be the result of improper adjustment.

Tools Needed	Qty
Hex Wrench 3mm.....	1
Hex Wrench 5mm.....	1
Hex Wrench 8mm.....	1
Flat Head Screwdriver.....	1

Adjusting Backing Bearings

1. Before making adjustments, make sure blade is tensioned and tracking correctly.
2. DISCONNECT MACHINE FROM POWER!
3. Raise headstock high enough to give you room to work, then lock in place.
4. Remove blade guard from left blade arm.
5. Loosen cap screw on right blade guide arm (facing front of machine), as shown in **Figure 59**, and move assembly up or down until backing bearing lightly touches back of blade, then tighten cap screw.

Note: If it is difficult to slide blade guide assembly onto blade, adjust blade guide roller bearings and carbide guides away from blade (refer to next sub-section).

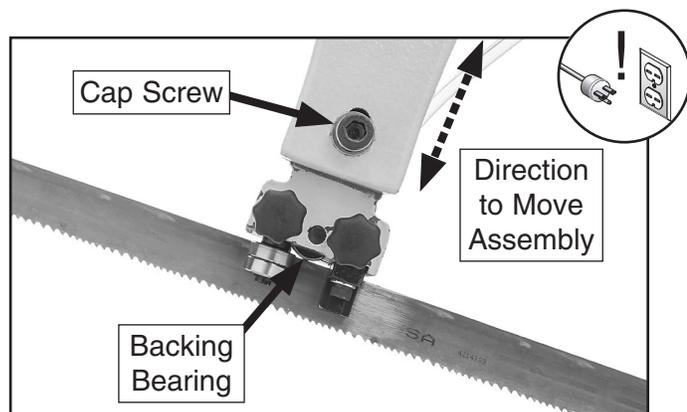


Figure 59. Backing bearing touching blade.

6. Repeat **Step 5** for left blade guide arm.

Adjusting Blade Guide Roller Bearings

1. Loosen set screws shown in **Figure 60** to allow guide bearings on front blade guide arm to turn.

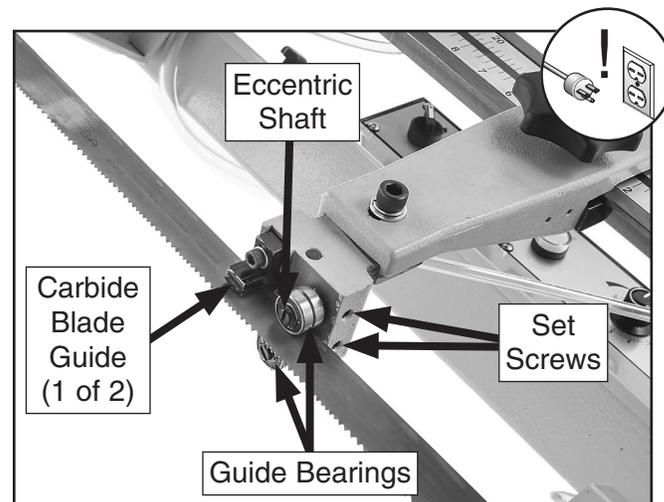


Figure 60. Adjustment controls on right front blade guide.

2. Turn eccentric shaft and adjust guide bearings (see **Figure 60**) so they lightly contact blade or have maximum clearance of 0.002".

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

3. Tighten set screws.
4. Adjust carbide blade guides (see **Figure 60**) so they make same contact with blade as guide bearings.
5. Reposition right blade guide arm flush with right end of blade guide scale, so it does not contact vise during operation.
6. Adjust blade guide bearings on left blade guide arm in same manner.
7. Re-install blade guard onto left blade arm.



Squaring Blade to Table

This adjustment has been made at the factory and should not need to be adjusted under normal circumstances. However, if you find the saw is not cutting square, you may need to adjust the blade. Only make this adjustment after ruling out other potential factors, such as excessive feed rate or the blade guide being set too far away from the workpiece.

Tools Needed	Qty
Hex Wrench 3mm.....	1
Hex Wrench 8mm.....	1
Machinist's Square	1

To square blade to table:

1. DISCONNECT MACHINE FROM POWER!
2. Lower headstock of bandsaw until it contacts downfeed stop bolt.
3. Place square on table bed and against edge of blade (see **Figure 61**), and check different points along length of table between blade guide assemblies.

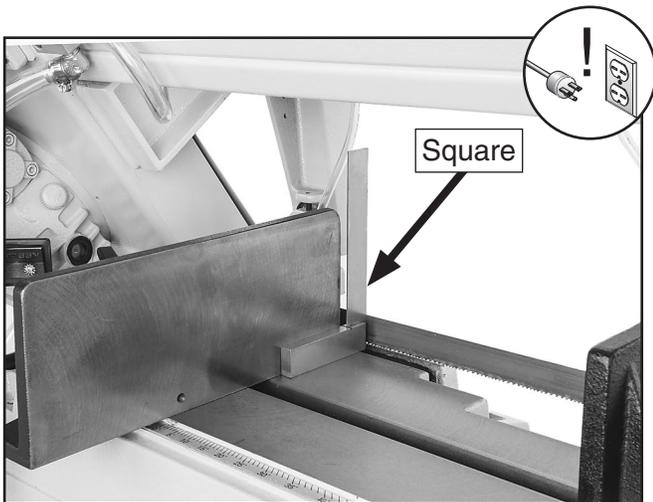


Figure 61. Checking blade-to-table squareness.

- If blade *is* square to table, no further adjustments need to be made.
- If blade *is not* square to table, loosen cap screw shown in **Figure 62** one to two turns and repeat on second blade guide assembly.
 - If top of blade tilts away from square, loosen top two set screws shown in **Figure 62** and tighten bottom two set screws an equal amount while keeping an eye on blade squareness (the amount you tighten and loosen the screws depends on how far from square the blade is). Repeat for second blade guide assembly.
 - If bottom of blade tilts away from square, tighten top two set screws shown in **Figure 62** an equal amount and loosen bottom two set screws while keeping an eye on blade squareness (the amount you tighten and loosen screws depends on how far from square blade is). Repeat for second blade guide assembly.

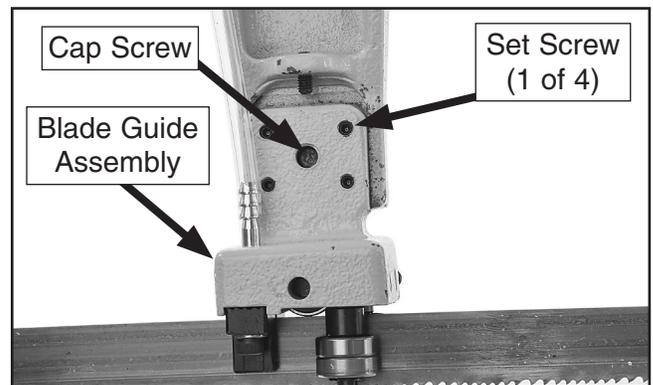


Figure 62. Set screws for adjusting blade-to-table squareness.

4. Tighten cap screw loosened earlier.
5. Repeat **Step 3** and adjustments above as necessary until blade is perfectly square to table.

Tip: Cut small section from scrap piece of material with known square end and measure for uniform thickness. If thickness is not uniform, repeat adjustments above until your personal requirements are met.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

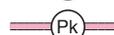
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

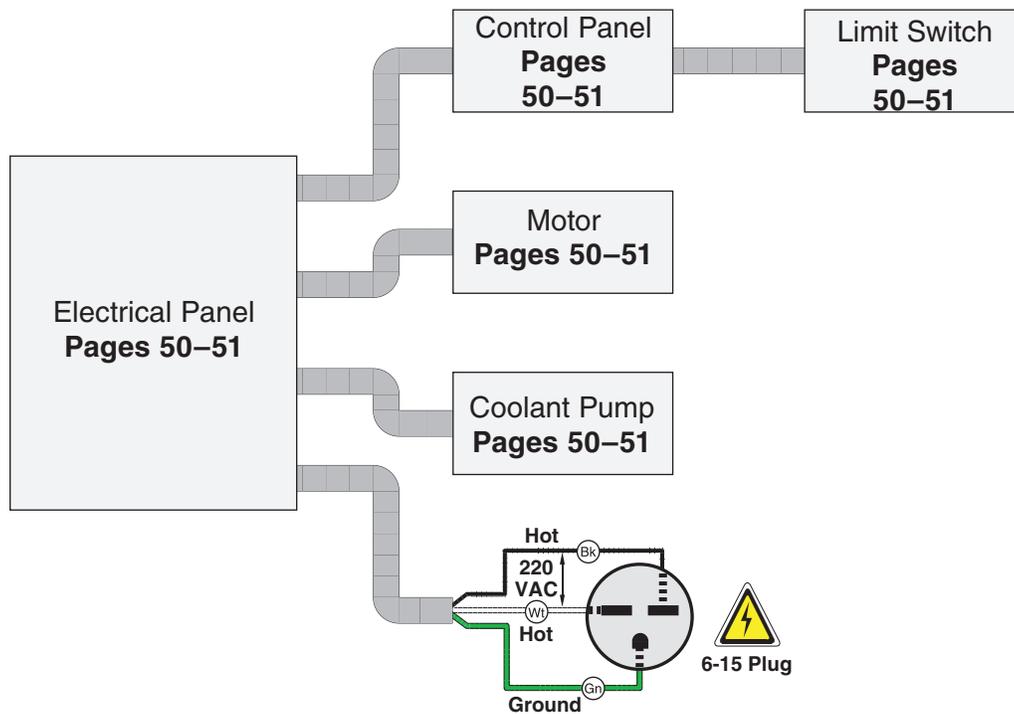
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

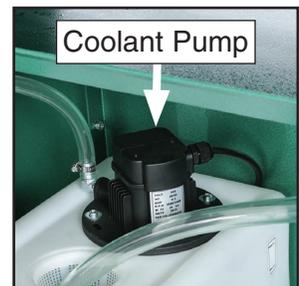
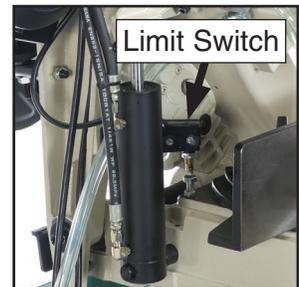
BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



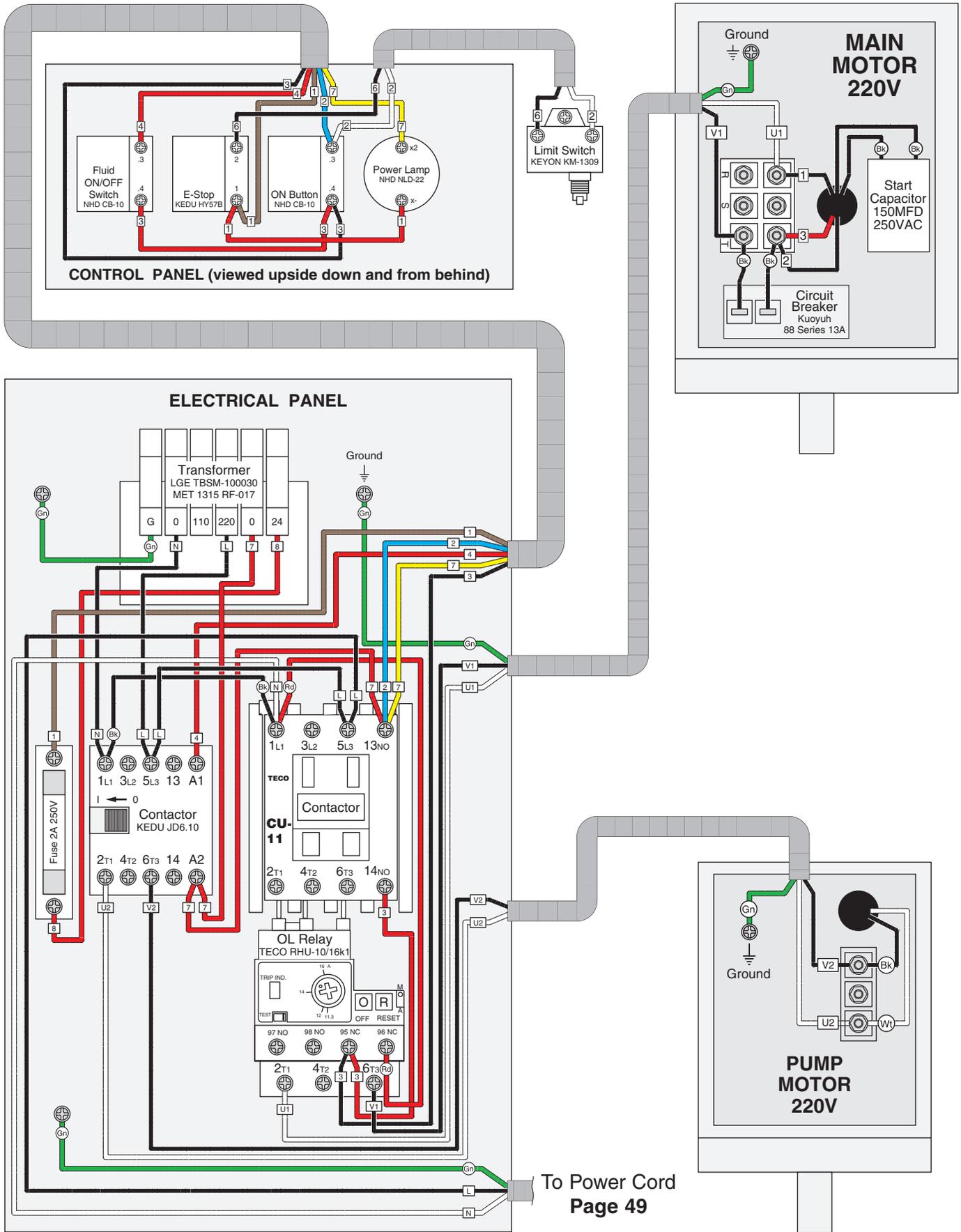
Electrical Overview



Component Locations



Wiring Diagram



Wiring Photos

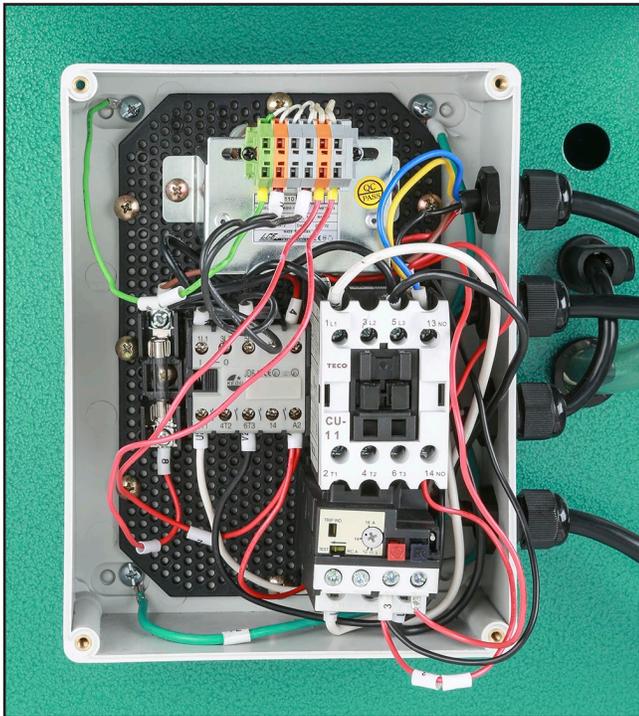


Figure 63. Electrical panel wiring.



Figure 66. Motor wiring.



Figure 67. Circuit breaker wiring.

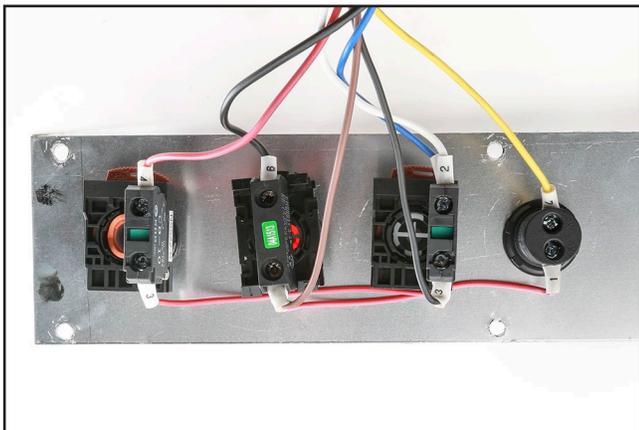


Figure 64. Control panel wiring.



Figure 65. Limit switch wiring.



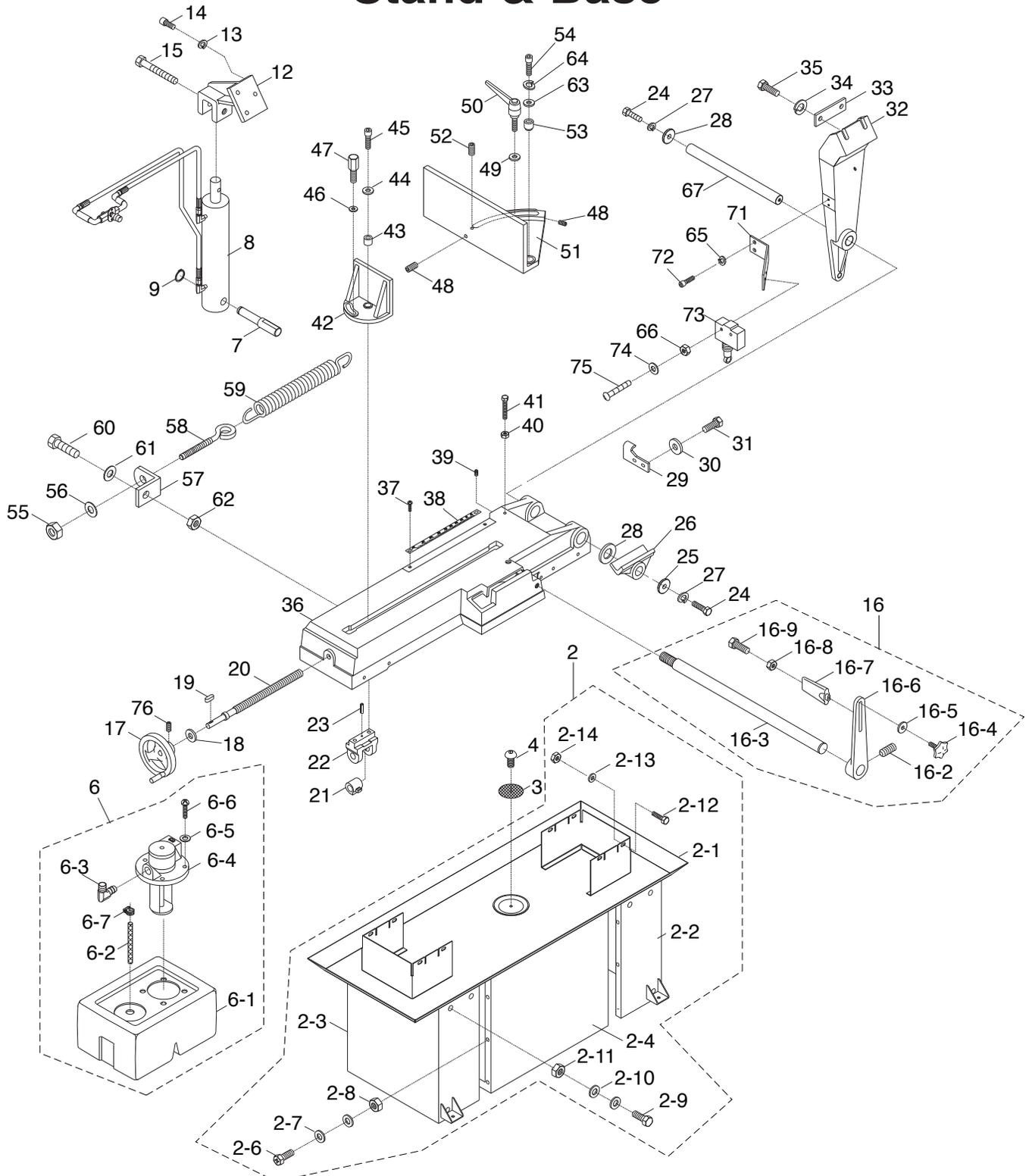
Figure 68. Coolant pump wiring.



SECTION 9: PARTS

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

Stand & Base



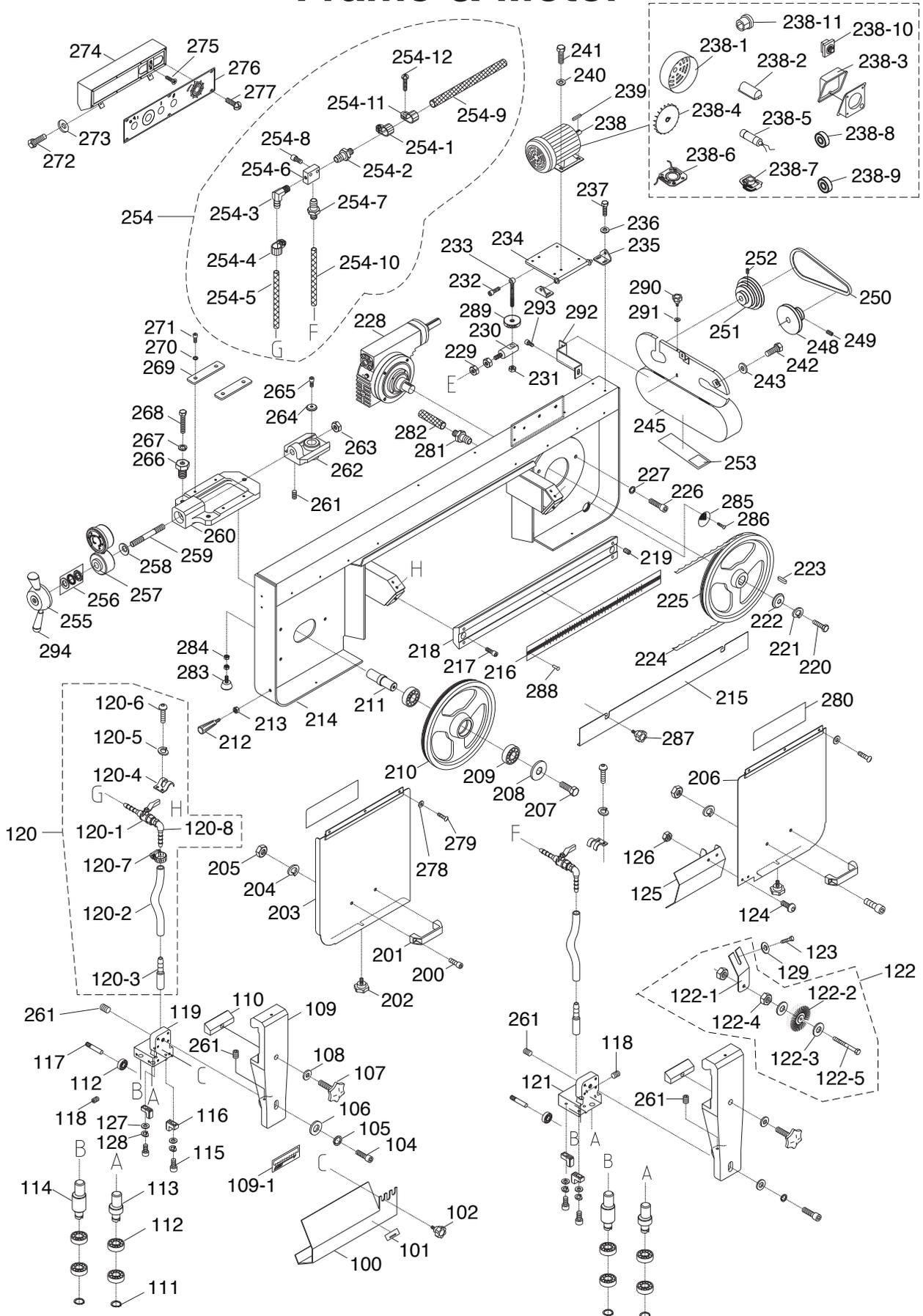
Stand & Base Parts List

REF	PART #	DESCRIPTION
2	P0811002	STAND ASSEMBLY
2-1	P0811002-1	COOLANT PAN
2-2	P0811002-2	STAND LEG (RIGHT)
2-3	P0811002-3	STAND LEG (LEFT)
2-4	P0811002-4	STAND LEG (FRONT)
2-6	P0811002-6	HEX BOLT 1/4-20 X 3/4
2-7	P0811002-7	FLAT WASHER 1/4
2-8	P0811002-8	HEX NUT 1/4-20
2-9	P0811002-9	HEX BOLT M10-1.5 X 20
2-10	P0811002-10	FLAT WASHER 10MM
2-11	P0811002-11	HEX NUT M10-1.5
2-12	P0811002-12	HEX BOLT M8-1.25 X 25
2-13	P0811002-13	FLAT WASHER 8MM
2-14	P0811002-14	HEX NUT M8-1.25
3	P0811003	COOLANT SCREEN
4	P0811004	BUTTON HD CAP SCR M6-1 X 15
6	P0811006	COOLANT PUMP ASSEMBLY
6-1	P0811006-1	COOLANT TANK
6-2	P0811006-2	COOLANT HOSE 3/4" X 20"
6-3	P0811006-3	PIPE ELBOW 1/2" X 3/8"
6-4	P0811006-4	COOLANT PUMP MOTOR 53W 220V 1-PH
6-5	P0811006-5	FLAT WASHER 1/4
6-6	P0811006-6	PHLP HD SCR 1/4-20 X 5/8
6-7	P0811006-7	HOSE CLAMP 3/4"
7	P0811007	CYLINDER PIVOT SHAFT
8	P0811008	HYDRAULIC CYLINDER ASSEMBLY
9	P0811009	EXT RETAINING RING 18MM
12	P0811012	UPPER CYLINDER BRACKET
13	P0811013	LOCK WASHER 8MM
14	P0811014	CAP SCREW M8-1.25 X 30
15	P0811015	CAP SCREW M10-1.5 X 50
16	P0811016	WORK STOP ASSEMBLY
16-2	P0811016-2	SET SCREW M6-1 X 10
16-3	P0811016-3	WORK STOP ROD
16-4	P0811016-4	KNOB BOLT M6-1 X 30, 6-LOBE
16-5	P0811016-5	FLAT WASHER 1/4
16-6	P0811016-6	WORK STOP BRACKET
16-7	P0811016-7	DISTANCE SET BRACKET
16-8	P0811016-8	HEX NUT M10-1.5
16-9	P0811016-9	HEX BOLT M10-1.5 X 25
17	P0811017	HANDWHEEL TYPE-3 140D X 14B-K X M8-1.25
18	P0811018	FLAT WASHER 7/16
19	P0811019	KEY 5 X 5 X 15
20	P0811020	WISE LEADSCREW
21	P0811021	LEADSCREW NUT
22	P0811022	LEADSCREW NUT BRACKET
23	P0811023	DOWEL PIN 5 X 34
24	P0811024	CAP SCREW M10-1.5 X 25

REF	PART #	DESCRIPTION
25	P0811025	DOCK WASHER 10 X 40 X 6MM
27	P0811027	LOCK WASHER 10MM
28	P0811028	SPACER 10MM
29	P0811029	LIMIT SWITCH BRACKET
30	P0811030	FLAT WASHER 8MM
31	P0811031	HEX BOLT M8-1.25 X 20
32	P0811032	REAR PIVOT BRACKET
33	P0811033	SPRING BRACKET
34	P0811034	LOCK WASHER 10MM
35	P0811035	HEX BOLT M10-1.5 X 35
36	P0811036	WISE BASE
37	P0811037	PHLP HD SCR M5-.8 X 8
38	P0811038	WISE SCALE
39	P0811039	SET SCREW M8-1.25 X 10
40	P0811040	HEX NUT M10-1.5
41	P0811041	HEX BOLT M10-1.5 X 45
42	P0811042	WISE JAW BRACKET
43	P0811043	BUSHING
44	P0811044	FLAT WASHER 10MM
45	P0811045	CAP SCREW M10-1.5 X 35
46	P0811046	FLAT WASHER 10MM
47	P0811047	HEX LOCK BOLT M10-1.5 X 35, 80L
48	P0811048	SET SCREW M8-1.25 X 30
49	P0811049	FLAT WASHER 10MM
50	P0811050	ADJUSTABLE HANDLE M10-1.5 X 40, 100L
51	P0811051	WISE JAW BRACKET (REAR)
52	P0811052	SET SCREW M6-1 X 10
53	P0811053	BUSHING
54	P0811054	CAP SCREW M12-1.75 X 40
55	P0811055	HEX NUT M10-1.5
56	P0811056	FLAT WASHER 10MM
57	P0811057	SPRING HANDLE BRACKET
58	P0811058	EYE BOLT M10-1.5 X 70, 20 I.D.
59	P0811059	EXTENSION SPRING 6.65 X 300 X 38
60	P0811060	HEX BOLT M8-1.25 X 10
61	P0811061	FLAT WASHER 8MM
62	P0811062	HEX NUT M8-1.25
63	P0811063	FLAT WASHER 12MM
64	P0811064	LOCK WASHER 12MM
65	P0811065	FLAT WASHER 6MM
66	P0811066	HEX NUT M4-.7
67	P0811067	PIVOT SHAFT
71	P0811071	LIMIT SWITCH SUPPORT
72	P0811072	BUTTON HD CAP SCR M6-1 X 12
73	P0811073	LIMIT SWITCH KEYON KM1309
74	P0811074	EXT TOOTH WASHER 6MM
75	P0811075	PHLP HD SCR M4-.7 X 30
76	P0811076	SET SCREW M8-1.25 X 14



Frame & Motor



Frame & Motor Parts List

REF	PART #	DESCRIPTION
100	P0811100	BLADE GUARD (FRONT)
101	P0811101	BLADE DIRECTION LABEL
102	P0811102	KNOB BOLT M6-1 X 10, 6-LOBE
104	P0811104	CAP SCREW M10-1.5 X 30
105	P0811105	LOCK WASHER 10MM
106	P0811106	FLAT WASHER 10MM
107	P0811107	KNOB BOLT M10-1.5, 6-LOBE
108	P0811108	FLAT WASHER 10MM
109	P0811109	ARM (LEFT)
109-1	P0811109-1	BLADE DIRECTION LABEL
110	P0811110	GIB
111	P0811111	EXT RETAINING RING 8MM
112	P0811112	BALL BEARING 608-2RS
113	P0811113	BLADE GUIDE SHAFT (REAR)
114	P0811114	BLADE GUIDE SHAFT (FRONT)
115	P0811115	CAP SCREW M6-1 X 20
116	P0811116	BLADE GUIDE, CARBIDE
117	P0811117	BEARING SHAFT
118	P0811118	SET SCREW M6-1 X 10
119	P0811119	BLADE GUIDE ADJ BRACKET (LEFT)
120	P0811120	COOLANT HOSE ASSEMBLY
120-1	P0811120-1	COOLANT VALVE 1/2"
120-2	P0811120-2	COOLANT HOSE 1/4" X 60"
120-3	P0811120-3	HOSE FITTING 1/4"
120-4	P0811120-4	COOLANT VALVE MOUNTING BRACKET
120-5	P0811120-5	LOCK WASHER 6MM
120-6	P0811120-6	BUTTON HD CAP SCR M6-1 X 12
120-7	P0811120-7	HOSE CLAMP 1/4"
120-8	P0811120-8	COOLANT VALVE BODY 1/8 X 1/4 (90 DEG)
121	P0811121	BLADE GUIDE ADJ BRACKET (REAR)
122	P0811122	BLADE BRUSH ASSEMBLY
122-1	P0811122-1	BRUSH SUPPORT
122-2	P0811122-2	BRUSH
122-3	P0811122-3	FLAT WASHER 6MM
122-4	P0811122-4	HEX NUT M6-1
122-5	P0811122-5	HEX BOLT M6-1 X 35
123	P0811123	HEX BOLT M6-1 X 10
124	P0811124	BUTTON HD CAP SCR M6-1 X 12
125	P0811125	BLADE GUARD (REAR)
126	P0811126	HEX NUT M6-1
127	P0811127	FLAT WASHER 6MM
128	P0811128	LOCK WASHER 6MM
129	P0811129	FLAT WASHER 6MM
200	P0811200	CAP SCREW M8-1.25 X 15
201	P0811201	HANDLE
202	P0811202	KNOB BOLT M6-1 X 10, 7-LOBE
203	P0811203	BLADE COVER (LEFT)
204	P0811204	LOCK WASHER 8MM
205	P0811205	HEX NUT M8-1.25
206	P0811206	BLADE COVER (RIGHT)
207	P0811207	HEX BOLT M8-1.25 X 20
208	P0811208	DOCK WASHER 8 X 40 X 6.3MM
209	P0811209	BALL BEARING 6205ZZ
210	P0811210	IDLER WHEEL 1-1/8" X 12"
211	P0811211	IDLER SHAFT
212	P0811212	HANDLE M10-1.5 X 16, 112L

REF	PART #	DESCRIPTION
213	P0811213	HEX NUT 3/8-16
214	P0811214	BODY FRAME
215	P0811215	BLADE COVER
216	P0811216	SCALE
217	P0811217	CAP SCREW M12-1.75 X 20
218	P0811218	SCALE BRACKET
219	P0811219	SET SCREW M8-1.25 X 20
220	P0811220	HEX BOLT M10-1.5 X 20
221	P0811221	LOCK WASHER 10MM
222	P0811222	DOCK WASHER 10 X 40 X 6MM
223	P0811223	KEY 7 X 7 X 30
224	P0811224	BLADE 114-1/2" X 1" X .035"
225	P0811225	DRIVE WHEEL 1-1/8" X 12"
226	P0811226	CAP SCREW M10-1.5 X 20
227	P0811227	LOCK WASHER 10MM
228	P0811228	GEARBOX ASSEMBLY
229	P0811229	LOCK NUT M10-1.5
230	P0811230	MOTOR ELEVATION MOUNT M10-1.5 X 30
231	P0811231	HEX NUT M12-1.75
232	P0811232	CAP SCREW M10-1.5 X 50
233	P0811233	MOTOR ELEVATION BOLT M12-1.75 X 120
234	P0811234	MOTOR PLATE
235	P0811235	MOTOR BRACKET
236	P0811236	FLAT WASHER 6MM
237	P0811237	HEX BOLT M6-1 X 15
238	P0811238	MOTOR 1.5HP 220V 1-PH
238-1	P0811238-1	MOTOR FAN COVER
238-2	P0811238-2	CAPACITOR COVER
238-3	P0811238-3	MOTOR JUNCTION BOX
238-4	P0811238-4	MOTOR FAN
238-5	P0811238-5	S CAPACITOR 150M 250V 1-3/8 X 2-5/8
238-6	P0811238-6	CONTACT PLATE
238-7	P0811238-7	CENTRIFUGAL SWITCH
238-8	P0811238-8	BALL BEARING 6205ZZ
238-9	P0811238-9	BALL BEARING 6203ZZ
238-10	P0811238-10	CIRCUIT BREAKER KUOYUH 88 SERIES 13A
238-11	P0811238-11	STRAIN RELIEF TYPE-2 16MM
239	P0811239	KEY 6 X 6 X 35
240	P0811240	FLAT WASHER 8MM
241	P0811241	HEX BOLT M8-1.25 X 15
242	P0811242	HEX BOLT M8-1.25 X 15
243	P0811243	FLAT WASHER 8MM
245	P0811245	MOTOR PULLEY COVER ASSEMBLY
248	P0811248	SPINDLE PULLEY
249	P0811249	SET SCREW M8-1.25 X 10
250	P0811250	V-BELT A32
251	P0811251	MOTOR PULLEY
252	P0811252	SET SCREW M8-1.25 X 10
253	P0811253	BLADE SPEED LABEL
254	P0811254	3-WAY VALVE ASSEMBLY
254-1	P0811254-1	HOSE CLAMP 1/2"
254-2	P0811254-2	MICRO CONTROL BLOCK 1/4" X 1/2" (ST)
254-3	P0811254-3	MICRO CONTROL BLOCK 1/4" X 1/2" (90 DEG)
254-4	P0811254-4	HOSE CLAMP 1/2"
254-5	P0811254-5	COOLANT HOSE 1/4" X 3/32" X 32"
254-6	P0811254-6	3-WAY VALVE



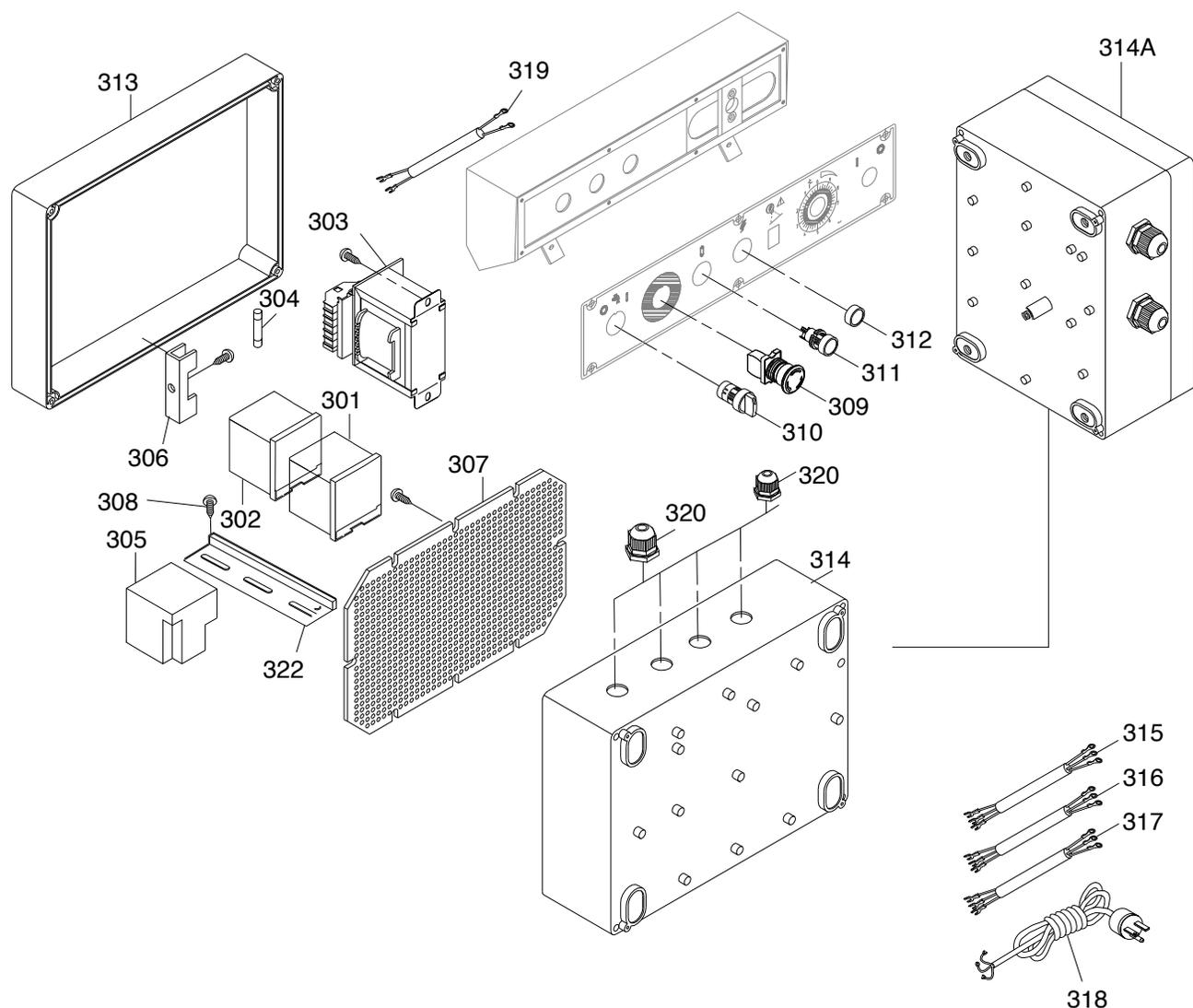
Frame & Motor Parts List (Cont.)

REF	PART #	DESCRIPTION
254-7	P0811254-7	STRAIGHT CONNECTOR PT 1/4" X 1/4"
254-8	P0811254-8	CAP SCREW M6-1 X 30
254-9	P0811254-9	COOLANT HOSE 1/4" X 3/32" X 57"
254-10	P0811254-10	COOLANT HOSE 1/4" X 1/8" X 13"
254-11	P0811254-11	HOSE CLIP 1/2"
254-12	P0811254-12	PHLP HD SCR M6-1 X 10
255	P0811255	BLADE TENSION HUB
256	P0811256	THRUST BEARING 51203
257	P0811257	HYDRAULIC BLADE TENSION GAUGE W/BASE
258	P0811258	BELLEVILLE DISC SPRING 16.3 X 31.5 X 1.8
259	P0811259	BLADE TENSION LEADSCREW
260	P0811260	BLADE TENSION BRACKET
261	P0811261	SET SCREW M6-1 X 16
262	P0811262	ANCHOR BRACKET
263	P0811263	HEX NUT M16-2
264	P0811264	DOCK WASHER 8MM
265	P0811265	HEX BOLT M8-1.25 X 20
266	P0811266	HEX BOLT W/INT. THREADS M10-1.5
267	P0811267	LOCK WASHER 10MM
268	P0811268	HEX BOLT M10-1.5 X 60
269	P0811269	SLIDING PLATE
270	P0811270	LOCK WASHER 8MM
271	P0811271	CAP SCREW M8-1.25 X 10

REF	PART #	DESCRIPTION
272	P0811272	HEX BOLT M6-1 X 12
273	P0811273	FLAT WASHER 6MM
274	P0811274	CONTROL PANEL BOX
275	P0811275	FLAT HD SCR M6-1 X 12
276	P0811276	CONTROL PANEL FACEPLATE
277	P0811277	PHLP HD SCR M5-.8 X 8
278	P0811278	FLAT WASHER 6MM
279	P0811279	BUTTON HD CAP SCR M6-1 X 10
280	P0811280	BLADE COVER GASKET
281	P0811281	COOLANT HOSE CONNECTOR 1/2" NPT
282	P0811282	COOLANT HOSE 18 X 2.4 X 190MM
283	P0811283	ADJUSTABLE STOP M8-1.25 X 20 RUBBER
284	P0811284	HEX NUT M8-1.25
285	P0811285	SCREEN
286	P0811286	BUTTON HD CAP SCR M6-1 X 10
287	P0811287	KNOB BOLT M6-1 X 10, 6-LOBE
288	P0811288	RIVET 2 X 5MM NAMEPLATE STEEL
289	P0811289	KNURLED KNOB M12-1.75
290	P0811290	KNOB BOLT M6-1 X 14, 6-LOBE
291	P0811291	FLAT WASHER 6MM
292	P0811292	PULLEY COVER BRACKET
293	P0811293	CAP SCREW M6-1 X 10
294	P0811294	HANDLE M12-1.75 X 10, 97L



Electrical Components

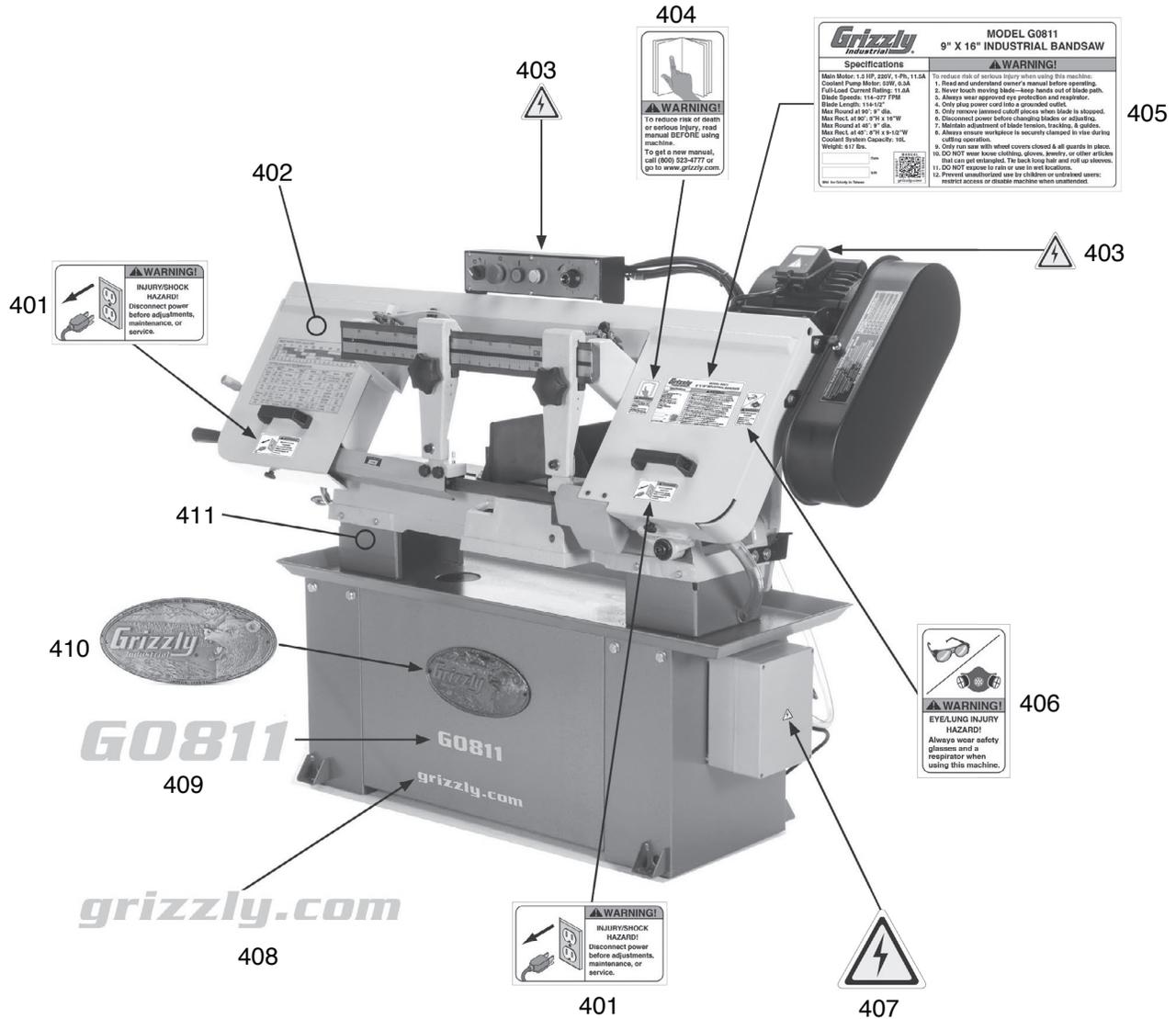


REF	PART #	DESCRIPTION
301	P0811301	CONTACTOR TECO CU-11 24V
302	P0811302	CONTACTOR KEDU JD6 24V
303	P0811303	TRANSFORMER LCE TBSM-100030
304	P0811304	FUSE 2A 250V FAST-ACTING GLASS
305	P0811305	OL RELAY TECO RHU-10/16K 11.3-16A
306	P0811306	FUSE BASE
307	P0811307	MOUNTING PANEL
308	P0811308	TAP SCREW #10 X 3/8
309	P0811309	E-STOP KEDU HY57B 22MM
310	P0811310	PUMP SWITCH NHD CB-10 22MM
311	P0811311	POWER SWITCH NHD CB-10 22MM

REF	PART #	DESCRIPTION
312	P0811312	POWER LIGHT NHD NLD-22
313	P0811313	ELECTRICAL BOX COVER (REAR)
314A	P0811314A	ELECTRICAL BOX ASSEMBLY
314	P0811314	ELECTRICAL BOX COVER (FRONT)
315	P0811315	CONTROL CORD 19G 5W 62"
316	P0811316	MOTOR CORD 14G 3W 46"
317	P0811317	PUMP CORD 18G 3W 30"
318	P0811318	POWER CORD 14G 3W 72" 6-15P
319	P0811319	LIMIT SWITCH CORD 18G 2W 36"
320	P0811320	STRAIN RELIEF TYPE-3 PG11
322	P0811322	DIN RAIL 3-1/2"



Labels & Cosmetics



REF	PART #	DESCRIPTION
401	P0811401	DISCONNECT POWER LABEL
402	P0811402	TOUCH-UP PAINT, GRIZZLY BEIGE
403	P0811403	ELECTRICITY LABEL, MEDIUM
404	P0811404	READ MANUAL LABEL
405	P0811405	MACHINE ID LABEL
406	P0811406	GLASSES/RESPIRATOR LABEL

REF	PART #	DESCRIPTION
407	P0811407	ELECTRICITY LABEL, LARGE
408	P0811408	GRIZZLY.COM LABEL
409	P0811409	MODEL NUMBER LABEL
410	P0811410	GRIZZLY NAMEPLATE
411	P0811411	TOUCH-UP PAINT, GRIZZLY GREEN

WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.





WARRANTY 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.**

- How did you learn about us?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
- Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	
- What is your annual household income?

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
- What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- How long have you been a woodworker/metalworker?

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------
- How many of your machines or tools are Grizzly?

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
------------------------------	------------------------------	------------------------------	------------------------------
- Do you think your machine represents a good value? Yes No
- Would you recommend Grizzly Industrial 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 3 times. Yes No

10. Comments: _____

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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 _____

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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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