

Grizzly *Industrial, Inc.*®

MODEL G7150 60" HAND BRAKE OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#JB10974 PRINTED IN CHINA

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

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

The owner of this machine/equipment 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, blade/cutter 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

Foreword

We are proud to offer the Model G7150 60" Hand Brake. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The specifications, drawings, and photographs illustrated in this manual represent the Model G7150 when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

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

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Functional Overview

A brake is a tool that is used to bend metal. A crease can be formed in a sheet metal workpiece by clamping the workpiece securely between two flat plates and using a third, hinged, movable plate to bend the workpiece along a straight edge.

The Model G7150 60" Hand Brake is a floor-mounted brake that allows the user to create bends in sheet metal up to 18 gauge and 60" wide.

To create a bend, the user positions the clamping leaf to the workpiece thickness with turn-buckles located at each end of the machine. The cam adjusters are positioned to adjust the setback according to the workpiece thickness and the desired radius of the crease. The user clamps the workpiece by lowering the clamping leaf handle, then lifts the bending leaf until the desired crease angle is created.

To remove the workpiece, the user lifts the clamping leaf handle and slides the workpiece out of the front of the machine.



Identification

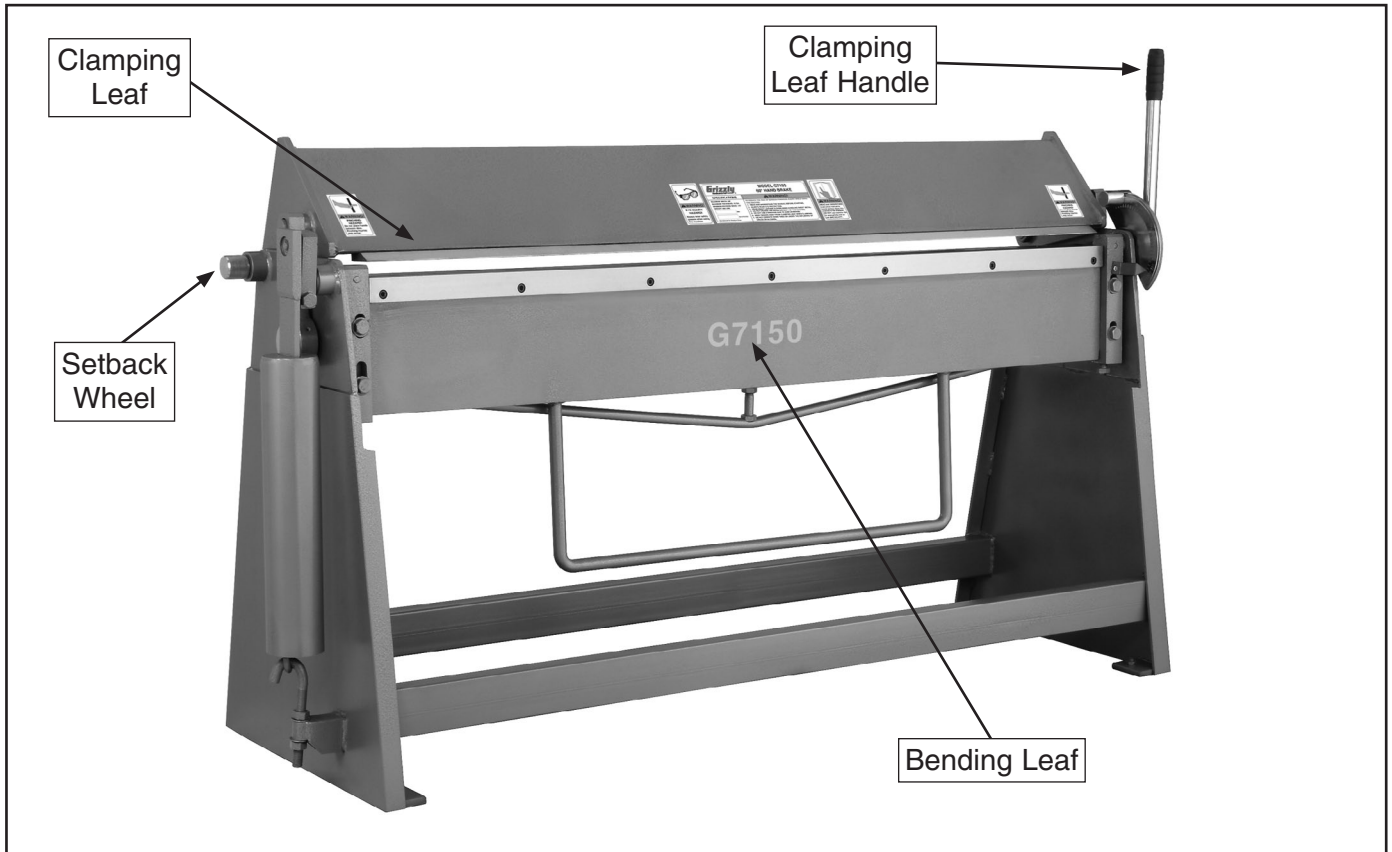


Figure 1. Identification.

Illustration Legend (Figure 2)

Throughout this manual, diagrams are used to illustrate how the components of the machine are used during the various steps of operation.

Familiarize yourself with the illustration to the right, its relationship to the machine, and the symbols used in it before proceeding through this manual.

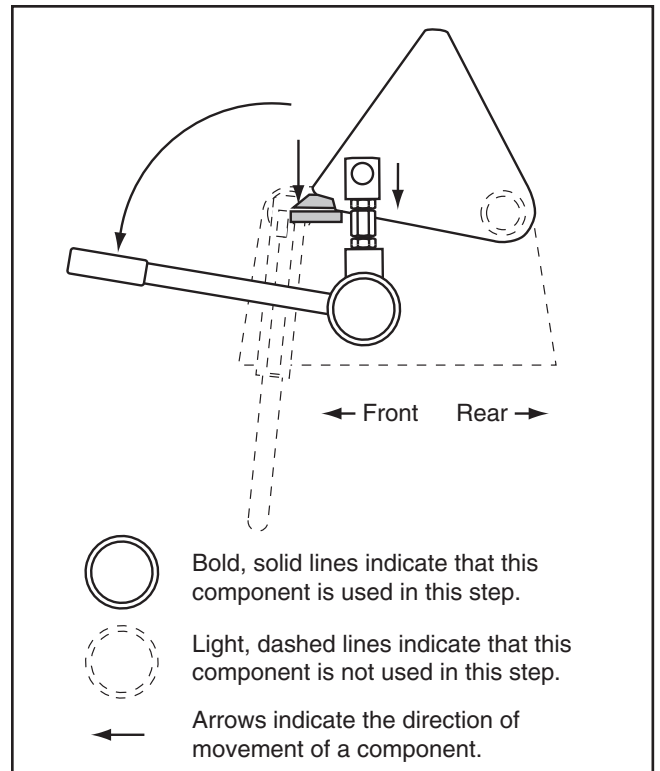


Figure 2. Illustration Legend.





MACHINE DATA SHEET

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

MODEL G7150 60" HAND BRAKE

Product Dimensions:

Weight 661 lbs.
 Length/Width/Height 74½" x 23½" x 41"
 Foot Print (Length/Width)..... 23½" x 66½"

Shipping Dimensions:

Type Wood Crate
 Content..... Machine
 Weight..... 837 lbs.
 Length/Width/Height..... 79" x 30" x 47"

Capacities:

Maximum Width 60"
 Maximum Thickness 18 Ga. Mild Steel
 Minimum Reverse Bend..... ½"

Construction

Brake..... Precision Ground Steel, Hardened Edge
 Frame..... Welded Steel
 Table Precision Ground Steel
 Stand..... Steel

Other Specifications:

Country Of Origin China
 Warranty..... 1 Year
 Serial Number Location ID Label on Front of Machine
 Assembly Time 10 minutes

Features:

Easy-to-Adjust Thickness and Setback
 Spring-Assisted Bending Leaf



SECTION 1: SAFETY

WARNING

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.



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.

WARNING

Safety Instructions for Machinery

- 1. READ ENTIRE MANUAL BEFORE STARTING.** Operating machine before reading the manual greatly increases the risk of injury.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN/VISITORS AWAY.** Keep all children and visitors away from machinery. When machine is not in use, disconnect it from power, lock it out, or disable the switch to make it difficult for unauthorized people to start the machine.
9. **UNATTENDED OPERATION.** Leaving machine unattended while its running greatly increases the risk of an accident or property damage. Turn machine **OFF** and allow all moving parts to come to a complete stop before walking away.
10. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
11. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
12. **USE A GROUNDED POWER SUPPLY RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Operating machine on an incorrect size of circuit increases risk of fire.
13. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
14. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
16. **REMOVE CHUCK KEYS OR ADJUSTING TOOLS.** Make a habit of never leaving chuck keys or other adjustment tools in/on the machine—especially near spindles!
17. **DAMAGED MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, other conditions that may impair machine operation. Always repair or replace damaged parts before operation.
18. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
19. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
20. **DO NOT OVERREACH.** Maintain stability and balance at all times when operating machine.
21. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
22. **STABLE MACHINE.** Machines that move during operations greatly increase the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.
23. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.
24. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



WARNING

Additional Safety Instructions for Hand Brakes

- 1. OVERLOADING HAND BRAKE** Overloading this tool can cause injury from flying parts. Do not exceed the machine capacities.
- 2. SECURING HAND BRAKE.** Secure hand brake to the floor before using. Tipping may occur during use and the machine could fall, causing serious injury or property damage.
- 3. METAL EDGES.** Sharp edges on sheet metal can result in severe cuts. Always chamfer and de-burr sharp sheet metal edges before bending in the hand brake.
- 4. PINCHING.** To prevent pinching hazards, lower the clamping leaf when not in use.
- 5. GLOVES AND GLASSES.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. BACK INJURIES.** The lifting motion required to operate this machine is potentially harmful if proper technique is not used. To avoid back injuries, keep your back vertical and lift with your legs while raising the bending leaf, and never over-exert yourself.
- 7. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, STOP using the tool and contact our Technical Support at (570) 546-9663, or ask a qualified expert how the operation should be performed.
- 8. TOOLS IN POOR CONDITION.** Loose hardware or cracks could result in sudden, uncontrolled movements during use. Inspect the hand brake for any cracked linkage, levers, or loose fasteners. Correct any problems before use.

WARNING

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

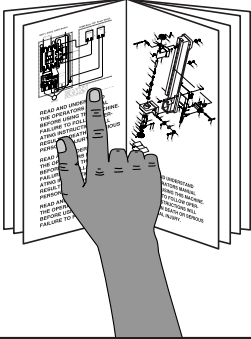
CAUTION

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



SECTION 2: SETUP

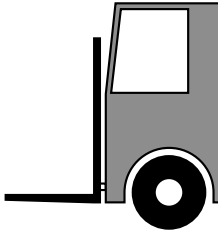
Setup Safety



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



!WARNING
Wear safety glasses during the entire setup process!



!WARNING
This machine and its components are very heavy. Use power lifting equipment such as a forklift to move heavy items.

Items Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Mounting Hardware	4
• Power Lifting Equipment (Rated for at least 1000 lbs.)	1

Unpacking

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


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

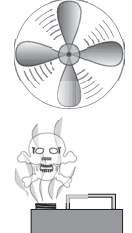
When you are completely satisfied with the condition of your shipment, inventory the contents.



Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in **Figure 3**. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>! WARNING Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.</p>
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	<p>! CAUTION Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.</p>
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G2544—Solvent Cleaner & Degreaser
A great product for removing the waxy shipping grease from your machine during clean up.

<p>Call 1-800-523-4777 To Order</p>	
--	---

Figure 3. Cleaner/degreaser available from Grizzly.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and workpiece.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

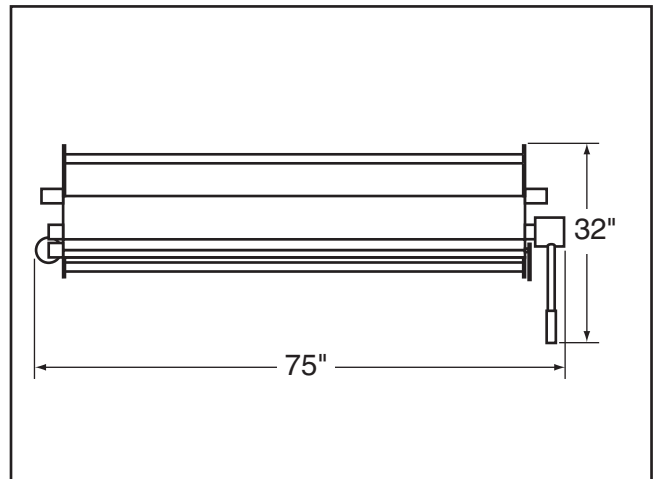
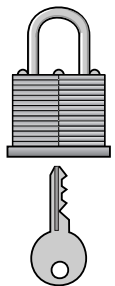
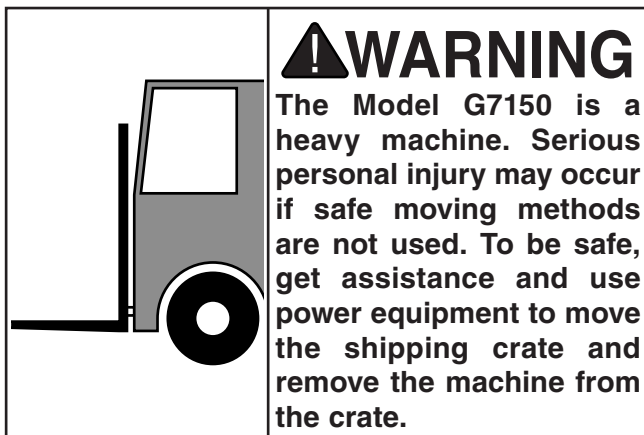


Figure 4. Minimum working clearances.

	<p>! CAUTION Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop to prevent unsupervised use.</p>
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Moving & Placing Machine



Remove the shipping crate from the pallet, then remove the screws that secure the machine to the pallet.

Use a forklift to lift the machine from the pallet and move it to a suitable location. Before using the machine, mount it to the floor.

Mounting to Shop Floor

It is required that you mount your new hand brake to the floor. Because floor materials vary, floor mounting hardware is not included.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 5**) and anchor studs (**Figure 15**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

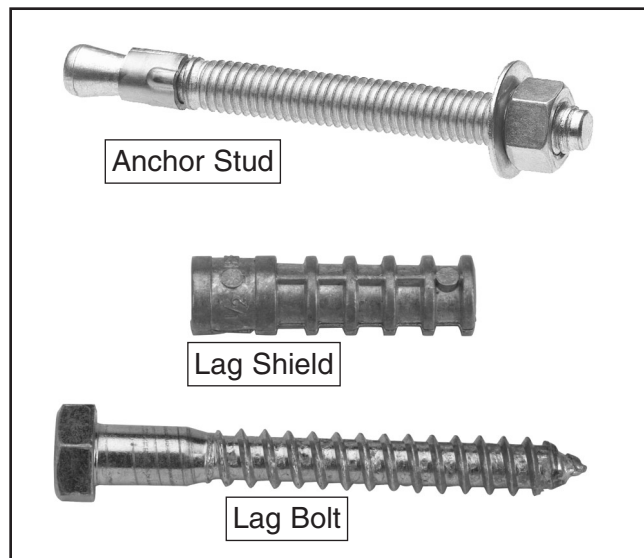
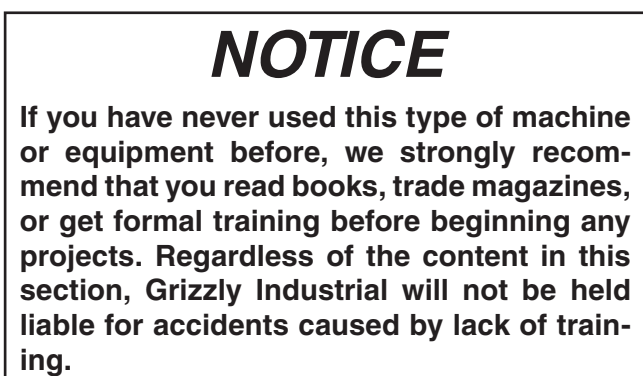
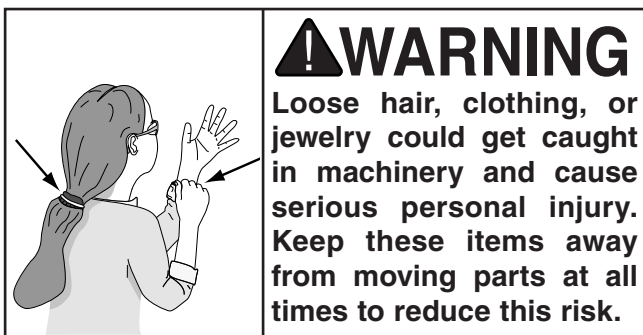
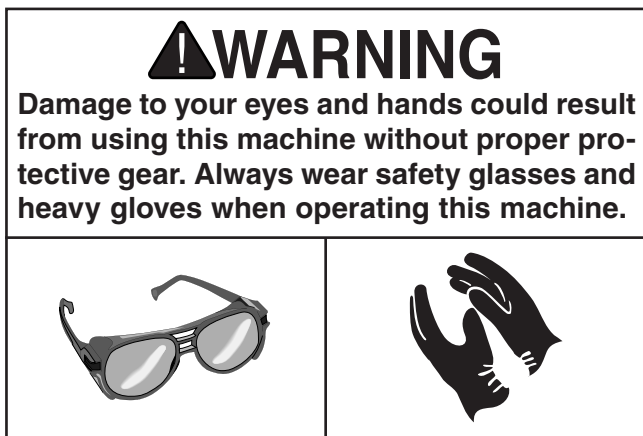
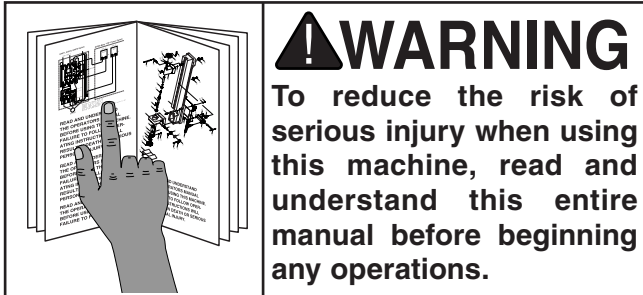


Figure 5. Typical fasteners for mounting to concrete floors.



SECTION 3: OPERATIONS

Operation Safety



Basic Controls

Use the descriptions and **Figures 6–7** to become familiar with the basic controls of your bench hand brake.

Setback Wheel: Adjusts the setback of the clamping leaf for the workpiece thickness and desired crease radius.

Turn-buckle: Adjusts the height of the clamping leaf for workpiece thickness.

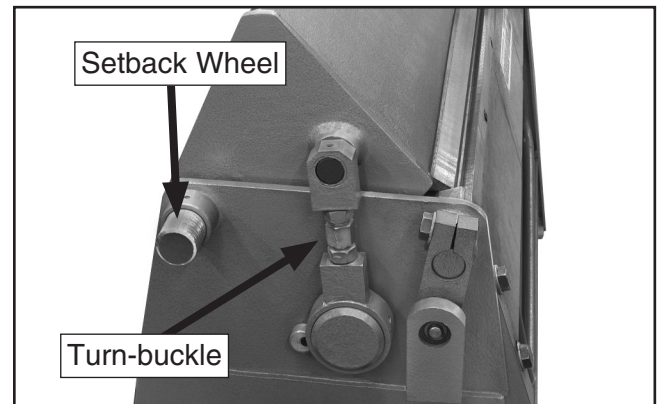


Figure 6. Setback wheel and turn-buckle.

Clamping Leaf Handle: Moves the clamping leaf down to clamp the workpiece and up to release the workpiece.

Bending Leaf: Pivots upward to create the crease in the workpiece.

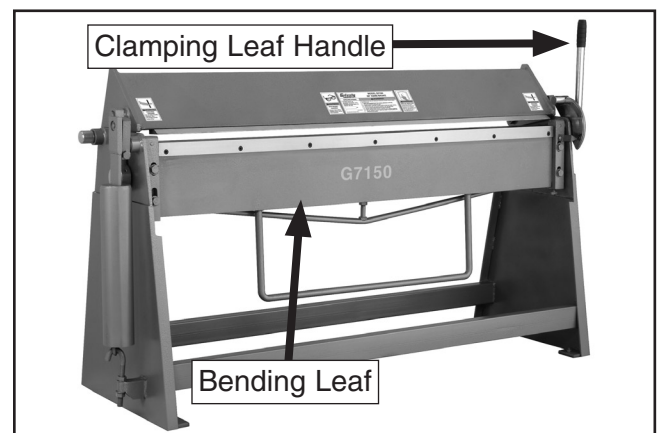


Figure 7. Controls.



Adjusting Setback

Before beginning bending operations, consider the differences in sheet metal gauges when trying to achieve either sharp or rounded bends, and allow for the differences by adjusting the setback.

The setback (**A**) is the distance from the forward edge of the clamping leaf to the edge of the clamping block, as shown in **Figure 8**. The setback distance is determined by the gauge of the workpiece and the desired radius of the bend.

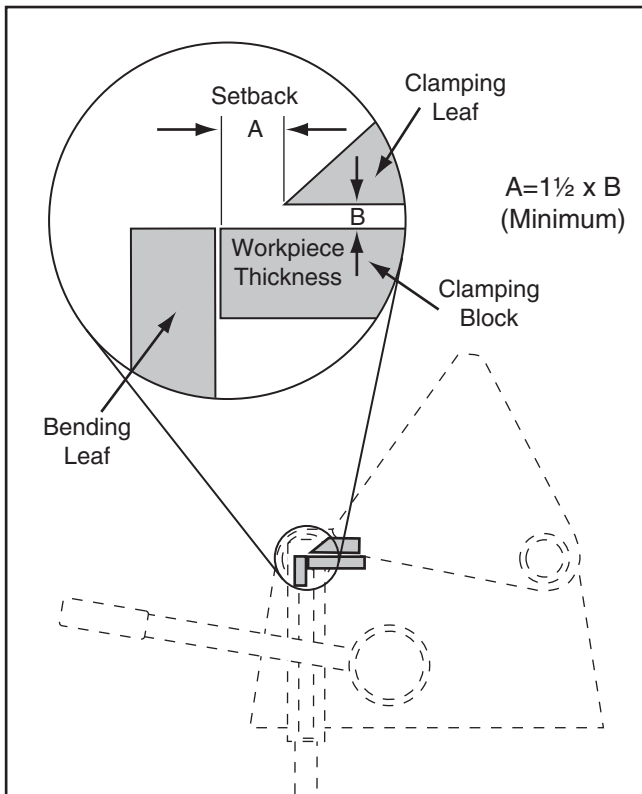


Figure 8. Setback distance.

Normally, setback (**A**) is adjusted at least $1\frac{1}{2}$ –2 times the thickness (**B**) of the workpiece. Thicker or tempered workpieces will need a larger setback.

NOTICE

You must include the thickness of folded edges or joints when determining the proper setback, or the brake may be damaged.

To adjust the setback:

1. Use the clamping leaf lever to raise the clamping leaf off of the clamping block, then locate the setback wheels located at each end of the machine (**Figure 9**).

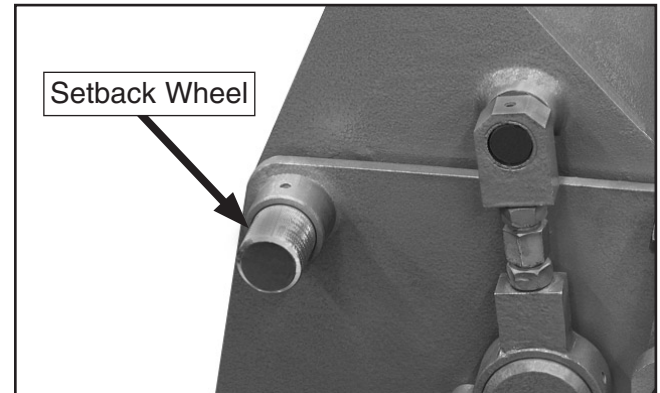


Figure 9. Setback wheel (left side shown).

2. Rotate the two setback wheels. Turning the wheels one way will move the clamping leaf forward. Turning them the other way will move the clamping leaf backward. (Because the adjusting mechanism is an eccentric, turning the adjusting wheels a full turn will only bring the clamping leaf to its original position.) Be sure the setback is set evenly across the clamping leaf.
3. Lower the clamping leaf over the clamping block, then check for setback distance.
4. Repeat **Steps 1–3** until the desired setback is achieved.

Note: After performing these adjustments, make sure the clamping leaf is parallel with the bending leaf, or your bend will be distorted (**Figure 10**).

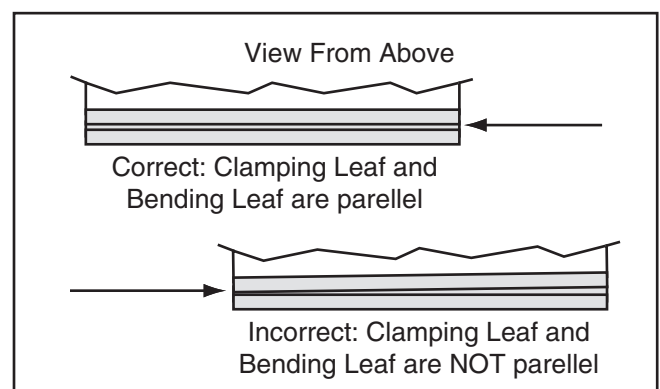


Figure 10. Setback parallelism.



Adjusting Clamping Pressure

The clamping pressure must be adjusted for different workpiece thicknesses. The ideal pressure will have medium resistance at the clamp handle, and will lock the workpiece into position easily. This pressure is controlled by adjusting the turn-buckles located at each end of the machine.

To adjust the clamping pressure:

1. Lower the bending leaf onto the workpiece. It is best if the workpiece is the same width as the bench hand brake. This will ensure that the clamping pressure is set evenly across the machine. If the workpiece is not the same width as the machine, place two pieces of metal the same thickness as the workpiece at each end.
2. When the clamping leaf is just touching the workpiece, the clamping leaf handle should be between the 7 and 8 o'clock position (angled below horizontal). This position will apply the optimal clamping force and minimize the likelihood of loosening.

3. Use a 24mm wrench to loosen the upper and lower lock nuts shown in **Figure 11**, and adjust the turn-buckle until the clamp handle is in the 7–8 O'clock position (as shown) when the clamping leaf just touches the workpiece.

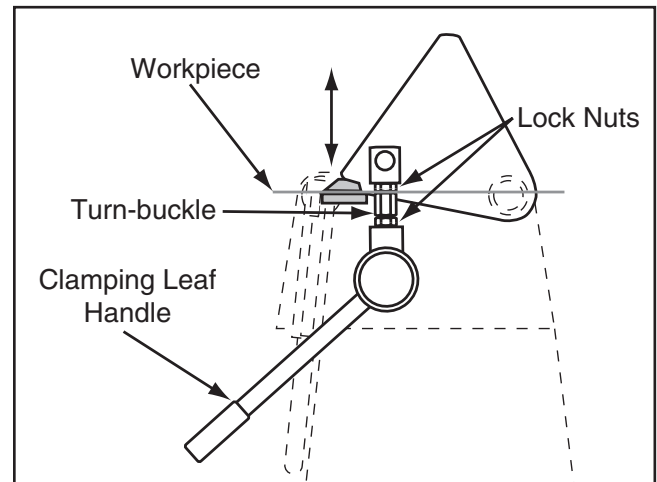


Figure 11. Clamping pressure adjustment.

4. Tighten the lock nuts to ensure that the position is maintained.
5. Make sure the clamping pressure is even on both ends of the workpiece.
6. Make adjustments as needed for sufficient and even clamping pressure, repeating **Steps 3–5**.



Basic Bending

!WARNING

Do not operate the Model G7150 unless it has been securely mounted to the floor. During use it could tip over and fall, causing property damage or injury.

Bending operations require that the clamping leaf be parallel with the edge of the clamping block and that the setback and clamping pressure are correctly adjusted for the thickness of the workpiece.

To perform a basic bending operation:

1. Raise the clamping leaf.
2. Insert the workpiece between the clamping leaf and the clamping block.
3. Align the area on the workpiece to be bent with the edge of the clamping leaf and clamp the workpiece in place using the clamping leaf handle (**Figure 12**).

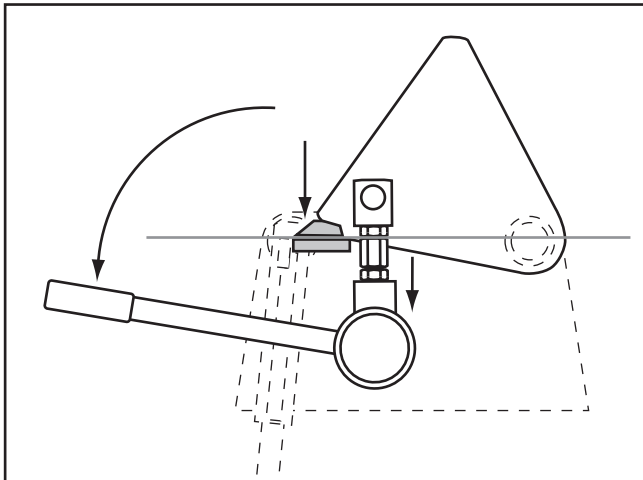


Figure 12. Clamping workpiece.

Note: If the handle does not clamp the workpiece when you lower the clamping leaf over the workpiece, the clamping pressure will need to be increased. (See **Adjusting Clamping Pressure** on Page 13.)

4. Lift the bending leaf until the workpiece has reached the desired bend angle, then lower the bending leaf (**Figure 13**).

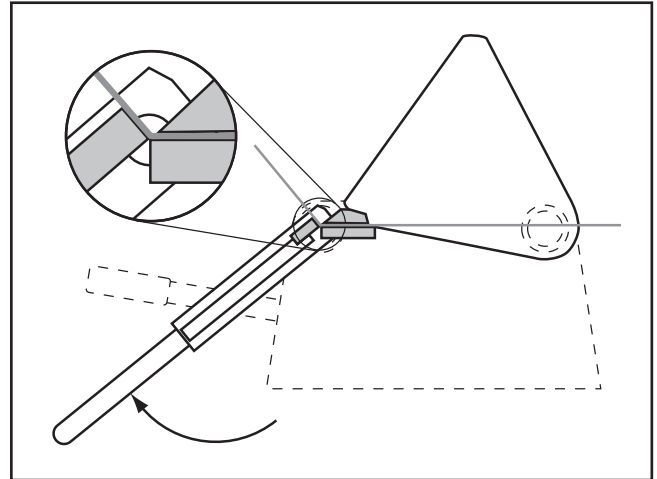


Figure 13. Bending workpiece.

5. Raise the clamping leaf handle to release the workpiece from the machine.

Bending Allowance

To bend metal objects accurately, you need to consider the total length of each bend, especially when more than one bend is required. This is called bend allowance.

Subtract bend allowance from the sum of the workpiece outside dimensions to obtain the overall length and width of the blank needed to make a particular part.

Exact allowances can only be obtained by trial-and-error due to differences in sheet metal hardness, whether the bend is with or across the grain, and difficulties in making an exact bend radius. Bend allowances accurate enough for average use may be found in metalworking handbooks.



Angle Stop

The Model G7150 has an angle stop to efficiently create the same angle bend in multiple workpieces.

Note: *The angle indicated by the scale may not reflect the final angle of the workpiece once the workpiece is removed from the machine. This is due to the variation in malleability and "spring" in different materials and in workpieces of different dimensions. An amount of trial-and-error may be required.*

To adjust the angle stop:

1. Loosen the hex bolt on the angle stop to release it (**Figure 14**).

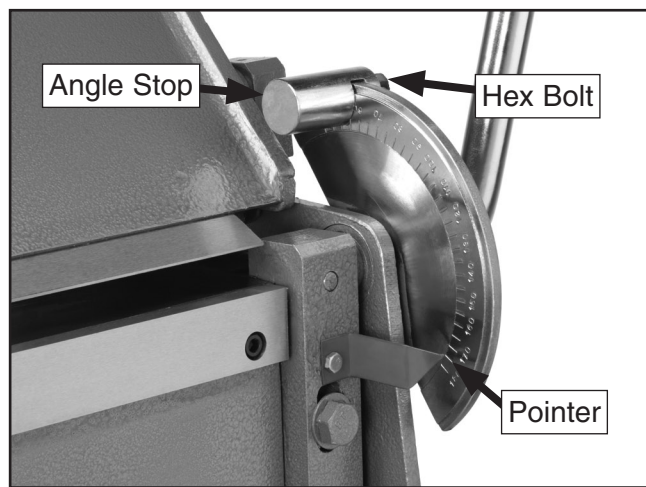


Figure 14. Angle stop.

2. Bend a workpiece to the desired angle. While still holding the bending leaf at that angle, have an assistant place the angle stop against the pointer.
3. For each following bend, lift the bending leaf until the pointer reaches the angle stop.

Spring-Assist Adjustment

The Model G7150 is equipped with a spring-assist mechanism to reduce the effort required to create bends. If you find that the spring assist is not correct for the thickness material you are bending, you can adjust the level of assist.

To adjust the spring-assist:

1. Loosen the spring bracket hex bolt (**Figure 15**).

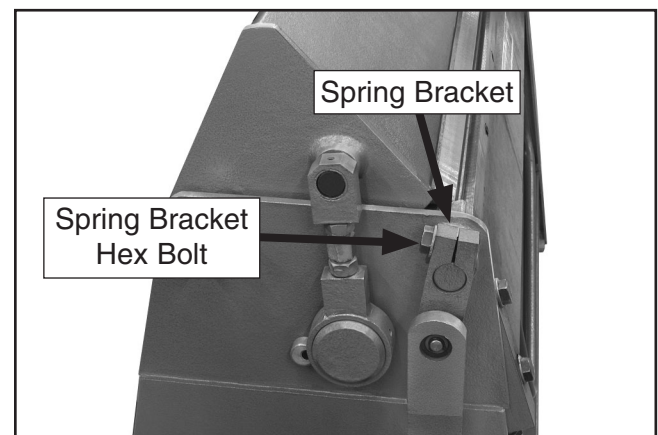


Figure 15. Spring-assist assembly.

2. Have an assistant hold the bending leaf at an angle of about 45°.

Note: *With the spring bracket hex bolt loosened, the bending leaf should move without rotating the spring bracket. If the spring bracket still moves with the bending leaf, use a dead blow hammer to loosen the spring bracket so it rotates freely on the bending leaf shaft.*

3. Re-tighten the spring bracket hex bolt.
4. Repeat **Steps 1–3**, if necessary, until the desired spring tension is achieved.

—To increase the tension, have your assistant hold the bending leaf higher while you tighten the spring bracket hex bolt.

—To decrease the tension, have your assistant hold the bending leaf lower while you tighten the spring bracket hex bolt.



SECTION 4: ACCESSORIES

G5618—Deburring Tool with two Blades

The quickest tool for smoothing freshly sheared metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



Figure 16. Model G5618 Deburring tool.

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

This ozone friendly protective spray penetrates deep and really holds up against corrosive environments. Lubricates metals for months and is safe for use on most paints, plastics, and vinyls.



Figure 17. Boeshield® T-9 spray.

H6073—Deluxe Power Snip

Lightweight aluminum cast handles. Full 3½" length of cut. Replaceable steel blades. Fully enclosed finger loops protect hands from sharp edges. Long handles provide plenty of leverage. Multi-purpose snip for sheet metal, vinyl and plastic.



Figure 18. Model H6073 Deluxe Power Snip.

G8124—Pneumatic Nibbler

Push type Pneumatic Nibbler makes quick work of sheet steel up to 1/16" thick and soft metal up to 5/64" thick. Features 3500 strokes per minute at an average air consumption of 6 CFM.



Figure 19. Model G8124 Pneumatic Nibbler

Call 1-800-523-4777 To Order



G4956—Super Nibbler

The super nibbler is just the ticket for cutting sheet metal up to $\frac{3}{64}$ " thick. Extremely narrow headed design allows cuts in hard-to-reach areas, yet still features a safety guard to prevent flying splinters. 10 $\frac{1}{4}$ " overall.



Figure 20. Model G4956 Super Nibbler.

H5958—Sheet Metal Pliers

For bending and forming sheet metal. Jaws are 3 $\frac{1}{2}$ " wide. Rubber grips. Overall length is 8". Ideal for HVAC Installers.



Figure 21. Model H5958 Sheet Metal Pliers.

G8781—4 $\frac{1}{2}$ " Suction Cup

Handle plate glass, glass mirrors and sheet metal with safety and security. Simple hand lever action provides tremendous gripping power on any flat, smooth material. Buy two Suction Cups for two-handed control!

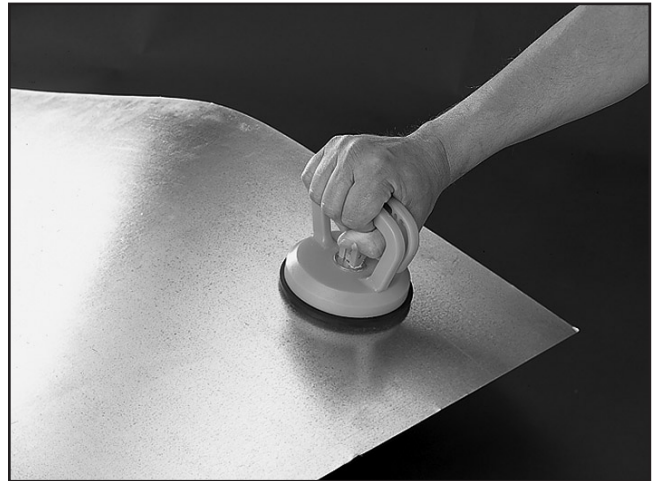


Figure 22. Model G8781 4 $\frac{1}{2}$ " Suction Cup.

H6131—Heavy-Duty Hand Riveter

Whether you're a full time sheet metal fabricator, or just making occasional repairs, you might as well invest in the best. This Heavy-Duty Hand Riveter with reinforced cast construction will be one of your most dependable tools.



Figure 23. Model H6131 Heavy-Duty Hand Riveter.

Call 1-800-523-4777 To Order



SECTION 5: MAINTENANCE

Schedule

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

Daily Check:

- Loose mounting bolts.
- Damaged Dies
- Any other unsafe condition.

Weekly Maintenance:

- Clean machine.
- Lubricate apron pivots.
- Lubricate bushings.

Cleaning

Cleaning the Model G7150 is relatively easy. Periodically wipe down the machine to remove dust and oil. Treat all unpainted surfaces with a non-staining lubricant after cleaning.

Unpainted Surfaces

Protect the unpainted surfaces on the machine by wiping it clean after every use—this ensures rust-promoting debris does not remain on bare metal surfaces.

Keep the machine rust-free with regular applications of products like Boeshield® T-9 (see **Section 4: Accessories** on **Page 16** for more details).

Lubrication

Lubricating the Model G7150 consists of applying lubricant to the cam wheels, bushings, and the hinge pins.

Oiling Locations

Apply several drops of SAE 30 or equivalent oil from an oil can into the oil holes shown in **Figure 24**. Move each component back-and-forth several times to disperse the oil, then wipe off excess oil. Be sure to lube the oil holes on both sides of the machine.

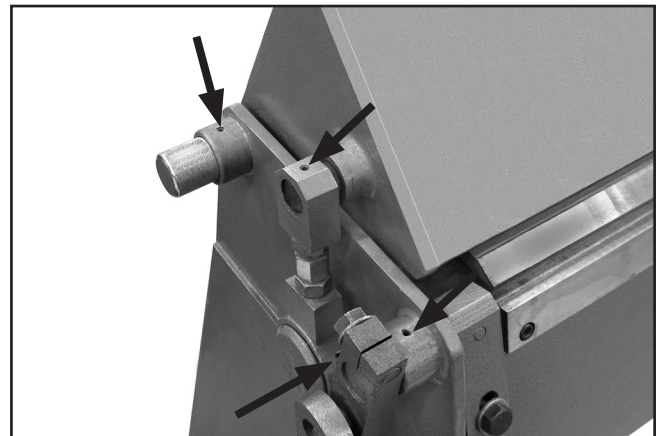


Figure 24. Oil locations (left side shown).



SECTION 6: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting

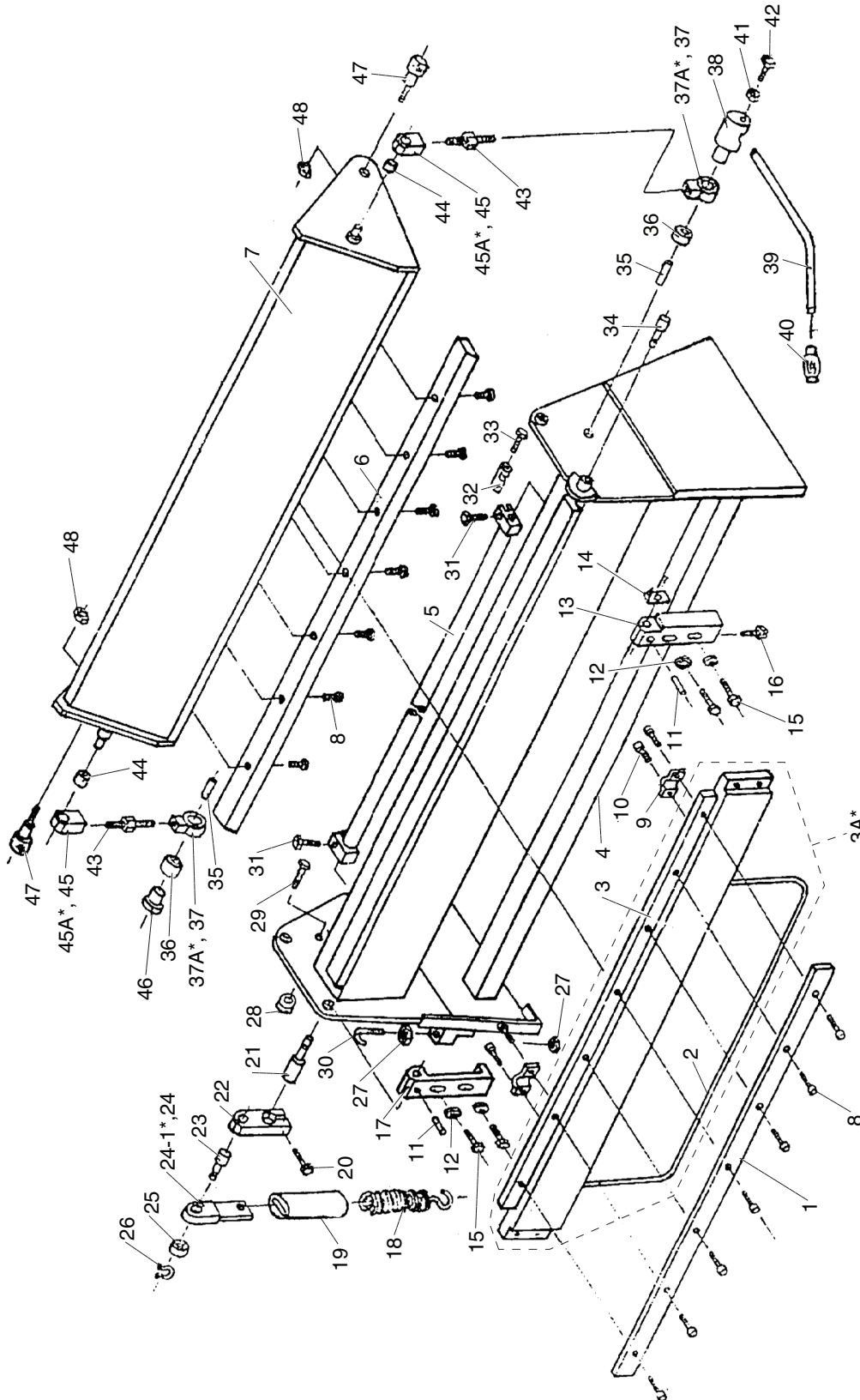
Operations

Symptom	Possible Cause	Possible Solution
Heavy resistance is felt when bends are being created.	<ol style="list-style-type: none">1. Machine capacities are exceeded.2. Setback is insufficient and workpiece is being pinched.	<ol style="list-style-type: none">1. Use materials within the capacity of the machine.2. Increase setback (Page 12).
Bend radius is not consistent across workpiece.	<ol style="list-style-type: none">1. Machine capacities are exceeded.2. Clamping leaf is not vertically parallel to the clamping block.3. Clamping pressure is insufficient.4. Setback is not equal on both sides.	<ol style="list-style-type: none">1. Use materials within the capacity of the machine.2. Adjust turn-buckles as needed (Page 13).3. Adjust turn-buckles (Page 13).4. Adjust setback as needed (Page 12).
Leading edge of clamping leaf is chipping or rolling.	<ol style="list-style-type: none">1. Setback is insufficient.2. Workpiece is too thick.	<ol style="list-style-type: none">1. Increase setback (Page 12).2. Use materials within the capacity of the machine.
Clamping leaf does not stay clamped.	<ol style="list-style-type: none">1. Turn-buckles are improperly adjusted (too short).	<ol style="list-style-type: none">1. Lengthen turn-buckles as necessary (Page 13).



SECTION 7: PARTS

Parts Breakdown



* Version 2. These parts appear on machines manufactured since May, 2008



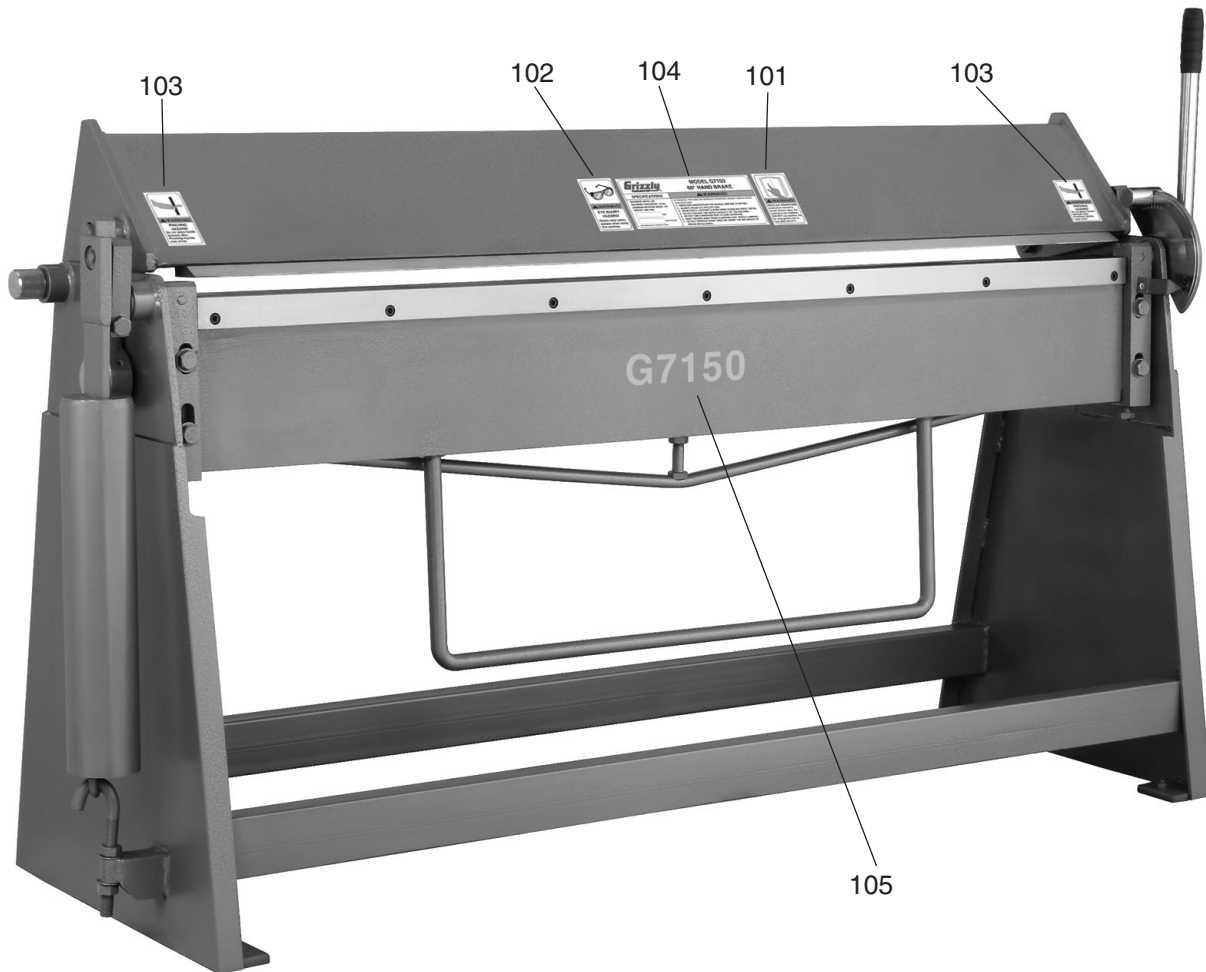
Parts List

REF	PART #	DESCRIPTION
1	P7150001	LOWER BENDING DIE
2	P7150002	HANDLE
3	P7150003	BENDING LEAF
3A	P7150003A	BENDING LEAF ASSEMBLY V2.08.08
4	P7150004	BODY
5	P7150005	CONNECTING SHAFT
6	P7150006	UPPER DIE
7	P7150007	CLAMPING LEAF
8	PSB14M	CAP SCREW M8-1.25 X 20
9	P7150009	HANDLE CLAMP
10	P7150010	HANDLE MOUNTING SCREW
11	P7150011	SPECIAL PIN
12	PW08M	FLAT WASHER 16MM
13	P7150013	BENDING LEAF BRACKET RIGHT
14	P7150014	POINTER
15	PB132M	HEX BOLT M16-2 X 40
16	PB132M	HEX BOLT M16-2 X 40
17	P7150017	BENDING LEAF BRACKET LEFT
18	P7150018	TENSION SPRING
19	P7150019	SPRING COVER
20	PB132M	HEX BOLT M16-2 X 40
21	P7150021	SPRING BRACKET SHAFT
22	P7150022	SPRING BRACKET
23	P7150023	SPRING POST
24	P7150024	UPPER CONNECTING SLEEVE
24-1	P7150024-1	SPRING HANGER V2.05.08

REF	PART #	DESCRIPTION
25	P6301	BALL BEARING 6301ZZ
26	PR03M	EXT RETAINING RING 12MM
27	PN13M	HEX NUT M16-2
28	P7150028	CAM
29	PB25M	HEX BOLT M12-1.75 X 25
30	P7150030	HOOK BOLT M12-1.75 X 180
31	PB132M	HEX BOLT M16-2 X 40
32	P7150032	ANGLE STOP
33	PB07M	HEX BOLT M8-1.25 X 25
34	P7150034	SHAFT
35	P7150035	SMALL SHAFT
36	P7150036	LARGE BUSHING
37	P7150037	BOTTOM TURNBUCKLE BRACKET RH V1.01.02
37A	P7150037A	BOTTOM TURNBUCKLE BRACKET LH V2.05.08
38	P7150038	RIGHT ECCENTRIC SHAFT
39	P7150039	HANDLE
40	P7150040	HANDLE GRIP
41	PN09M	HEX NUT M12-1.75
42	PB25M	HEX BOLT M12-1.75 X 25
43	P7150043	DOUBLE-END THREADED TURNBUCKLE
44	P7150044	BUSHING
45	P7150045	TOP TURNBUCKLE BRACKET LH V1.01.02
45A	P7150045A	TOP TURNBUCKLE BRACKET RH V2.05.08
46	P7150046	LEFT ECCENTRIC SHAFT
47	P7150047	ECCENTRIC BOLT
48	PN28M	HEX NUT M20-2.5



Labels Breakdown and List



REF	PART #	DESCRIPTION
101	PLABEL-12A	READ MANUAL LABEL VL
102	PLABEL-11A	SAFETY GLASSES VL
103	P7150103	PINCHING HAZARD LABEL

REF	PART #	DESCRIPTION
104	P7150104	MACHINE ID LABEL
105	P7150105	MODEL NUMBER LABEL

WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.





WARRANTY CARD

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

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

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

<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	

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

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

Note: We never use names more than 3 times. Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



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



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Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

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

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

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

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

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

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

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