

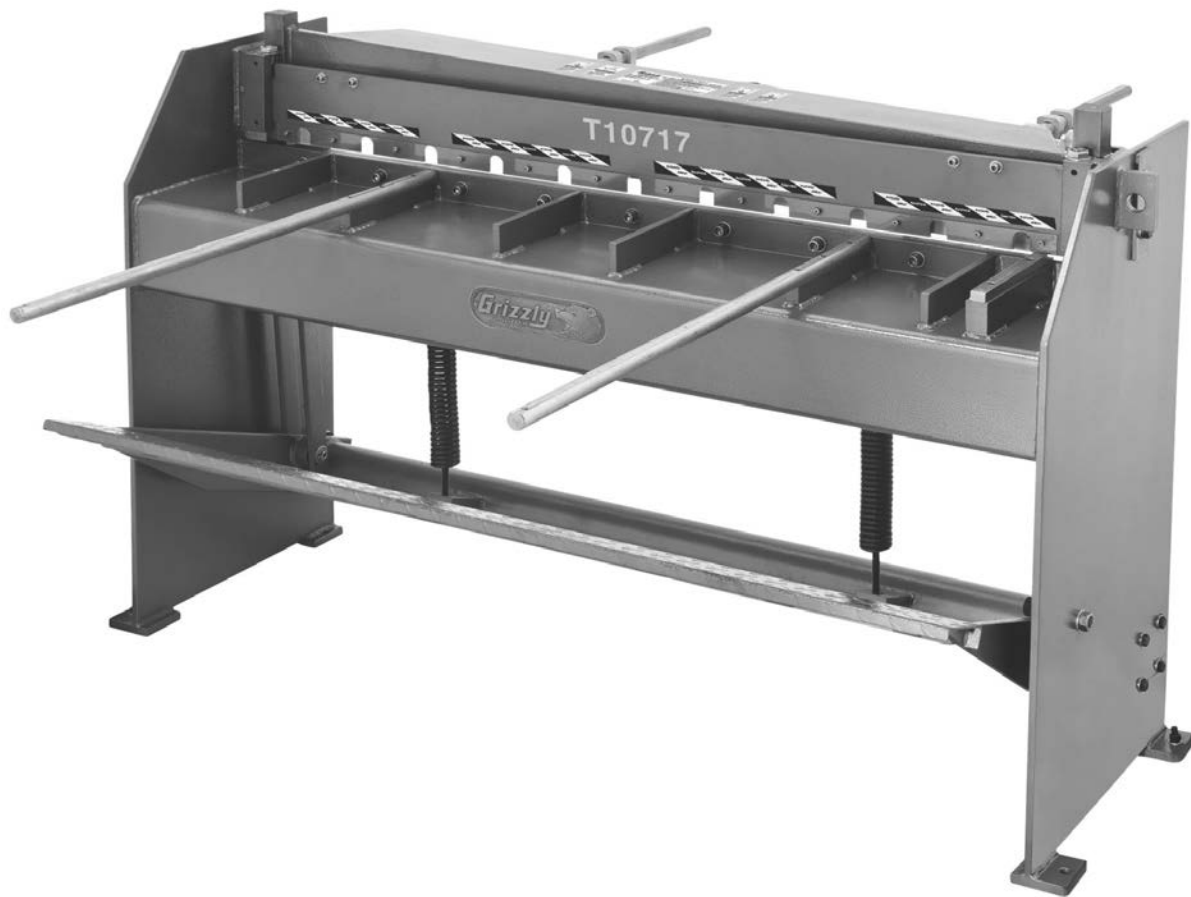


MODEL T10717

50" FOOT SHEAR

OWNER'S MANUAL

(For models manufactured since 1/13)



COPYRIGHT © FEBRUARY, 2013 BY GRIZZLY INDUSTRIAL, INC.
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#TS15551 PRINTED IN CHINA



WARNING!

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

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

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

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



WARNING!

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

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

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

Table of Contents

INTRODUCTION	2	SECTION 5: MAINTENANCE.....	18
Machine Description	2	Schedule	18
Contact Info.....	2	Cleaning & Protecting	18
Manual Accuracy	2	Lubrication	18
Identification.....	3	Slide Shaft.....	18
Machine Data Sheet	4	Pivot Cartridge Bearing.....	19
SECTION 1: SAFETY	5	SECTION 6: SERVICE	20
Safety Instructions for Machinery	5	Troubleshooting	20
Additional Safety for Foot Shears.....	7	Adjusting Blade Gap	21
SECTION 2: SETUP	8	Checking Blade Gap.....	21
Unpacking	8	Adjusting Upper Blade	21
Needed for Setup.....	8	Adjusting Blade Bow	22
Inventory	8	Sharpening/Replacing Blades.....	22
Cleanup.....	9	Adjusting Gibs.....	23
Site Considerations.....	10	SECTION 7: PARTS	24
Lifting & Placing	11	Main	24
Mounting	11	Labels & Cosmetics	26
Leveling.....	12	WARRANTY & RETURNS	29
Assembly	12		
SECTION 3: OPERATIONS	13		
Operation Overview	13		
Basic Controls.....	14		
Cutting Tips.....	14		
Rear Work Stop	15		
Side Work Stop.....	15		
SECTION 4: ACCESSORIES	16		



Machine Description

Contact Info

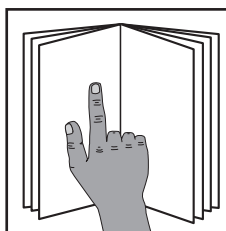
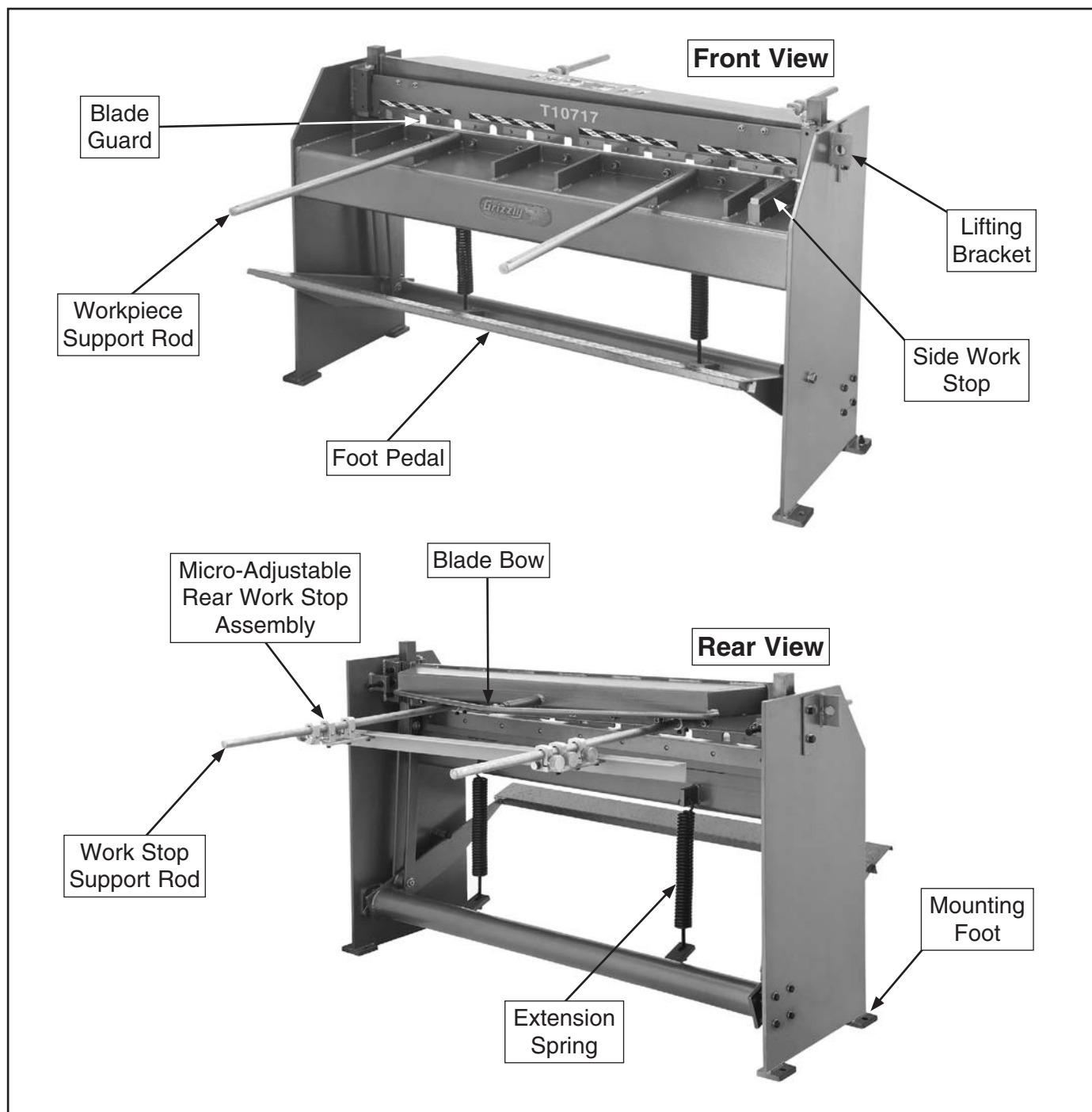
Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Manual Accuracy

Alternatively, you can call our Technical Support for help. Before calling, please write down the **Manufacture Date** and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		 WARNING!	
Motor: Specification: Specification: Specification: Specification: Weight:	<p>To reduce risk of serious injury when using this machine:</p> <p>1. Read the manual before operation.</p> <p>2. Wear safety glasses and respirator.</p> <p>3. Make sure the machine is properly adjusted/setup and power is connected to ground circuit before starting.</p> <p>4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.</p> <p>5. DO NOT expose to rain or dampness.</p> <p>6. DO NOT modify this machine in any way.</p> <p>7. _____</p> <p>8. _____</p> <p>9. _____</p> <p>10. Maintain machine carefully to prevent accidents.</p>		
<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> _____ Date </div> <div style="border: 1px solid black; padding: 5px;"> _____ </div> <p>Manufactured for Grizzly in Taiwan</p>		<div style="border: 1px solid black; padding: 10px; text-align: center;"> <p>Manufacture Date</p> <p>Serial Number</p> </div>	

Identification



⚠ WARNING

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





MACHINE DATA SHEET

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

MODEL T10717 50" DELUXE HEAVY DUTY SHEAR

Product Dimensions:

Weight..... 635 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 62-1/2 x 72 x 39-1/2 in.
Footprint (Length x Width)..... 62-1/2 x 20 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 720 lbs.
Length x Width x Height..... 68-3/4 x 35-1/2 x 44-1/2 in.
Must Ship Upright..... N/A

Main Specifications:

Capacities

Maximum Width..... 50 in.
Maximum Thickness at Half Width Mild Steel..... 16 Gauge
Maximum Thickness at Full Width Mild Steel..... 18 Gauge
Maximum Beam Lift..... 2 in.
Front Stop Scale Range..... 0 – 35 in.
Rear Stop Scale Range..... 0 – 24 in.

Construction

Frame..... Cast Iron
Hold-Down Clamp..... Cast Iron
Shear Table..... Machined Cast Iron
Shear Blades..... 7/16" Thick Precision-Ground Hardened Steel
Shear Blade Type..... Square-Edged

Other Specifications:

Country Of Origin China
Warranty 1 Year
Serial Number Location Machine ID Label on Blade Bow



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.



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



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



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

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

Safety Instructions for Machinery



OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

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

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

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



WARNING

Additional Safety for Foot Shears

FINGER AMPUTATION. The shear blades or hold-down can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from the blades and hold-down during operation.

BLADE CONDITION. Blades that are sharp, undamaged, and properly adjusted will reduce the risk of injury from workpiece or machine breakage and ensure good results. Always keep blades properly adjusted and sharp.

CAPACITY. Exceeding the capacity of the shear may eject dangerous metal debris at the operator or bystanders, or cause machine damage. Only use sheet metal that is within the rated capacity of this shear (refer to the **Machine Data Sheet** on **Page 4**).

BLADE GUARD. The blade guard is designed to reduce the risk of amputation when using the shear. Always keep the guard properly attached and in good condition during operation.

SHARP METAL EDGES. Sharp sheet metal edges can easily cause severe laceration injuries. Always chamfer and debur the workpiece edges, and wear leather gloves when handling sheet metal.

FOOTING. The foot shear requires you to apply moderate force to the foot pedal while cutting. If your foot slips, you could fall down or into the shear, which could cause personal injury. Always stand with one foot comfortably on the floor during operation, and never use both feet on the foot pedal or jump on it. Never have a foot under the foot pedal during operation to avoid crushing injuries.

COMFORTABLE BODY POSITION. The required body motion to operate the shear can result in operator injury over time if proper ergonomics are not used during operation. Always keep your body centered with the machine and your back straight when using the foot pedal.

PROPER USAGE. This foot shear was designed to **ONLY** cut sheet metal within its rated capacity. Do not attempt to cut round stock, glass, wood, drywall, backer board, or plywood. Cutting incorrect materials can produce unexpected results, which increases the risk of injury, and may result in damage to the machine.

SHEET METAL PIECES. Sheet metal pieces left on the floor can easily slide under foot and cause falling injuries. Always remove sheet metal pieces from the floor after operation. Keep work area clean.

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

Unpacking

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

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

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



Needed for Setup

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

Description	Qty
• Additional People	1
• Safety Glasses	1 for Each Person
• Cleaner/Degreaser (Page 9)	As Needed
• Disposable Shop Rags.....	As Needed
• Hex Wrench 5mm.....	1
• Hex Wrench 6mm.....	1
• Mounting Hardware (Page 11) ...	As Needed
• Forklift.....	1
• Lifting Straps (rated for 1000 lbs.)	2
or	
• Lifting Chains (rated for 1000 lbs.)	2
• Lifting Safety Hooks (rated for 1000 lbs.) ...	2

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.

Small Component Inventory: (Figure 1) Qty

A.	Rear Work Stop Assembly	1
B.	Rear Work Stop Support Rods	2
C.	Workpiece Support Rods	2
D.	Cap Screws M6-1 x 25	6

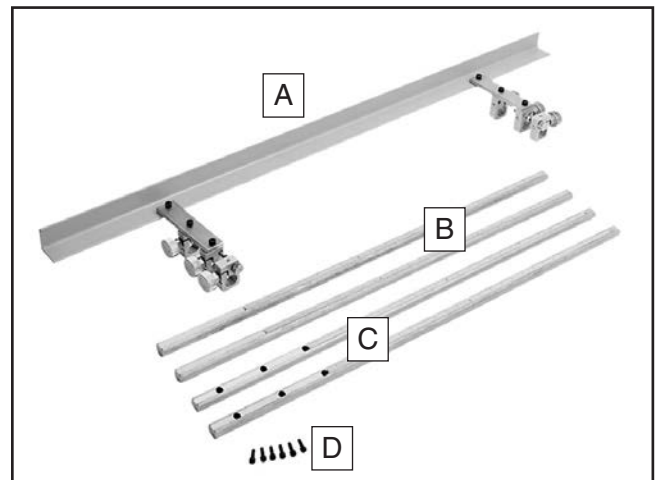


Figure 1. Small component inventory

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.

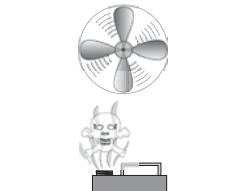
Before cleaning, gather the following:

- 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.

	⚠ WARNING Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.
--	--

	⚠ CAUTION Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.
--	---

NOTICE Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

T23692—Orange Power Degreaser

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

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

Figure 2. T23692 Orange Power Degreaser.



Site Considerations

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of 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.

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.**

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.

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.

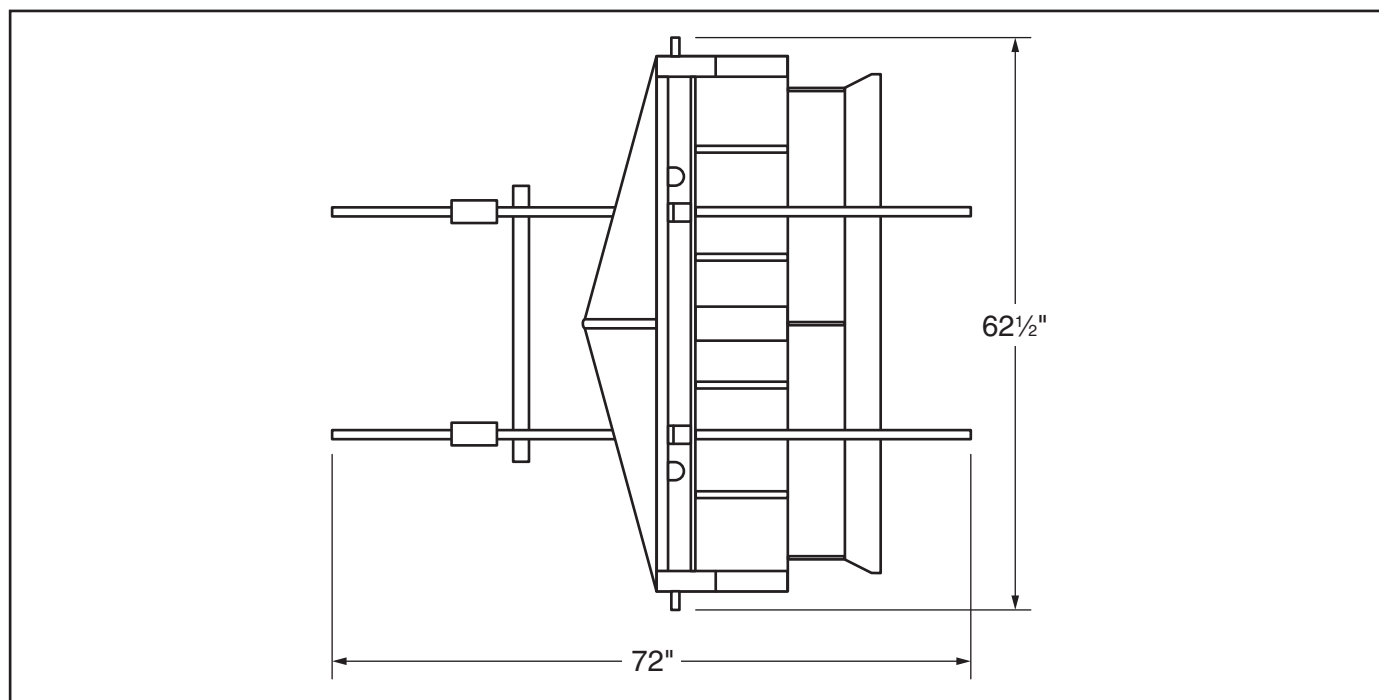
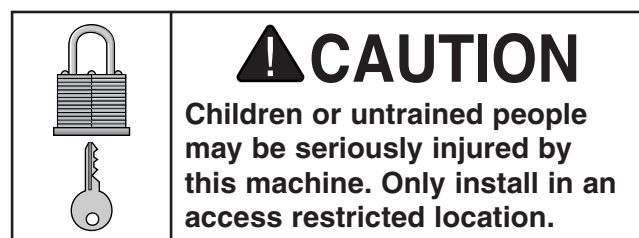
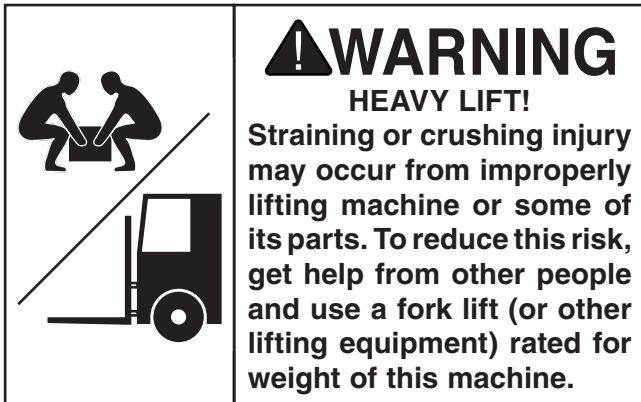


Figure 3. Working clearances.



Lifting & Placing



There are two recommended ways to lift the foot shear: 1) Use a forklift with lifting straps, or 2) Use a forklift with chains and safety hooks. Whichever way you choose to lift the shear, make sure each component is rated for at least 1000 lbs.

To lift and place the foot shear:

1. Move the shear (while it is still on the shipping pallet) to the installation location.
2. Unbolt the shear from the shipping pallet.
3. Wrap the lifting straps around the shear, as illustrated in **Figure 4**, or attach safety hooks and chains to the side lifting brackets, as illustrated in **Figure 5**.

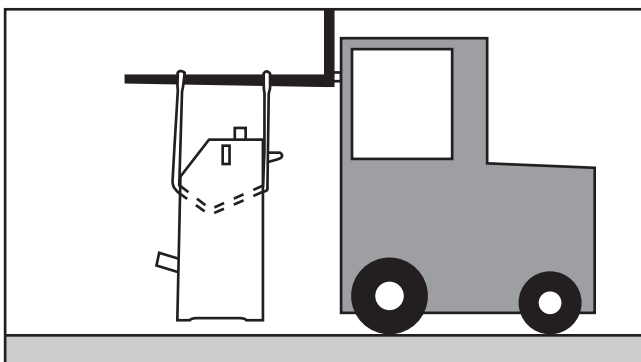


Figure 4. Lifting shear with lifting straps.

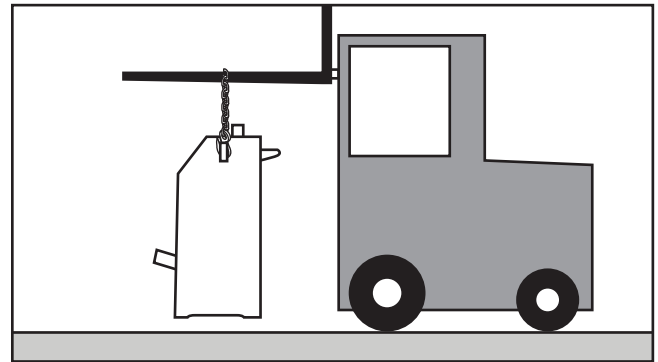


Figure 5. Lifting shear with chains and safety hooks.

4. With the help of another person to steady the load, use the forklift to raise the shear just enough to clear the shipping pallet, then remove the shipping pallet.
5. Lower the shear into place, and mount it to the floor as recommended in the next sub-section.

Mounting

Due to the significant dynamic forces on the shear during operation, you must secure it to the floor to prevent tipping. Because floor materials may vary, floor mounting hardware is not included.

Anchor studs and lag shield anchors with lag screws (**Figure 6**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

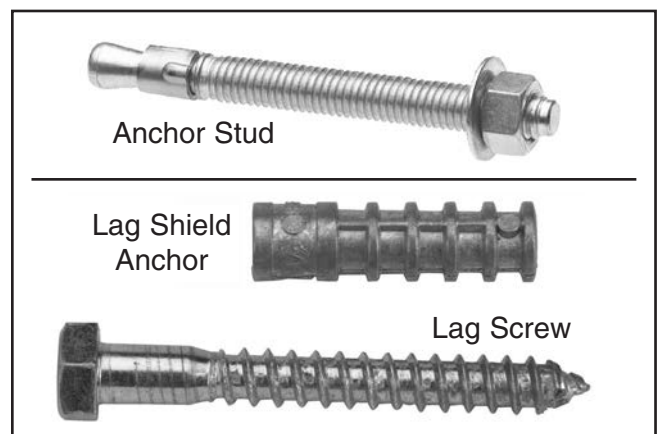


Figure 6. Typical fasteners for mounting to concrete floors.



Leveling

Leveling the shear helps the blades and other cast-iron components remain straight and flat during the life of the machine. Components on an unlevelled machine may slowly twist over time due to the dynamic loads placed on the machine during operation. Twisted components will negatively affect the ability of the machine to cut straight or square.

If needed, use metal shims between the base and the floor to level the machine.

For best results, use a precision level that is at least 12" long and sensitive enough to show a distance movement when a 0.003" shim (approximately the thickness of one sheet of standard newspaper) is placed under one end of the level.

See **Figure 7** for an example of a high-precision level available from Grizzly.

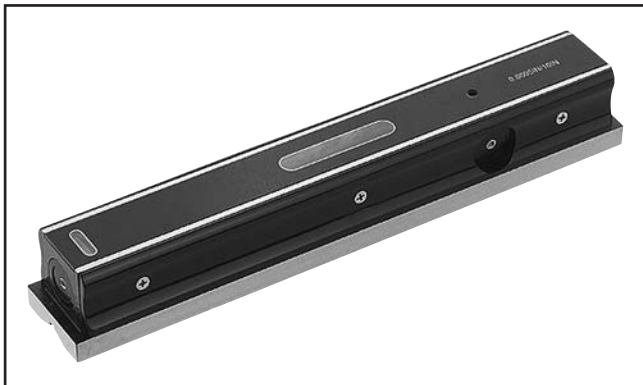


Figure 7. Model H2683 Master Machinist's Level.

Assembly

Assembly of the Model T10717 consists of attaching the workpiece support rods and the rear work stop assemblies.

To assemble the foot shear:

1. Attach the two workpiece support rods with the (6) M6-1 x 25 cap screws (see **Figure 8**).

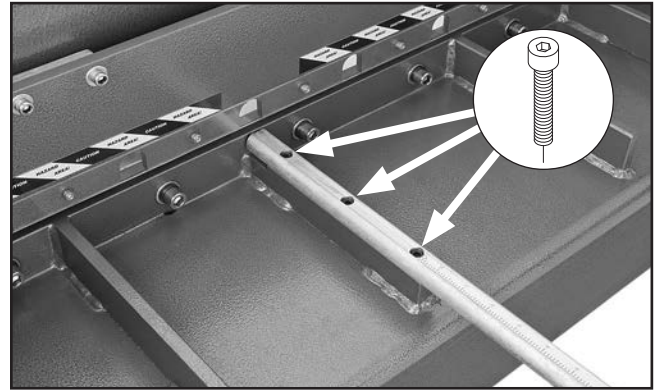


Figure 8. Workpiece support rod attached.

2. Orient the rear work stop support rods so the scales face up, slide them into the brackets underneath the rear of the shear (see **Figure 9**), then tighten the pre-installed cap screws to secure the rods in place.

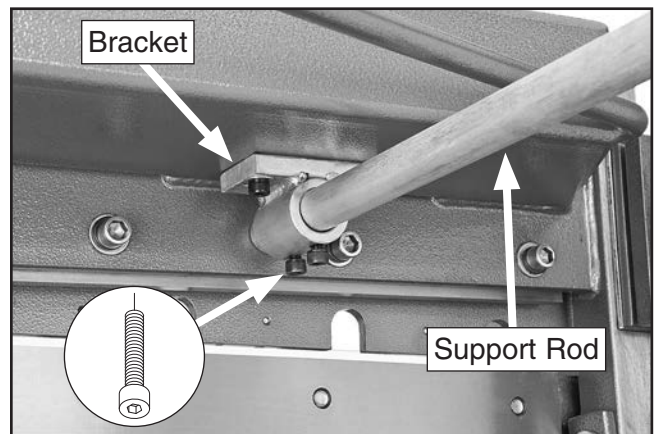


Figure 9. Rear work stop support rods secured in brackets with scales facing up.

3. Slide the rear work stop assembly onto the work stop support rods, as shown in **Figure 10**, with the work stop L-bracket facing the shear.

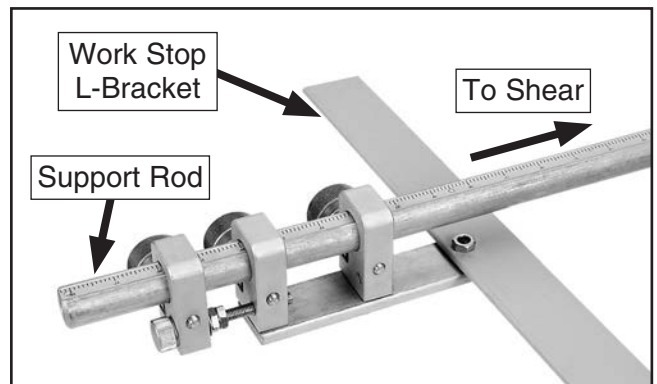


Figure 10. Rear work stop assembly installed.

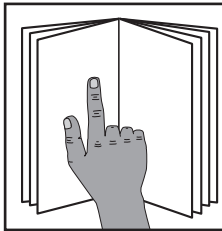


SECTION 3: OPERATIONS

Operation Overview

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

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

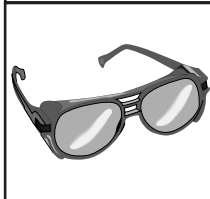


WARNING

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

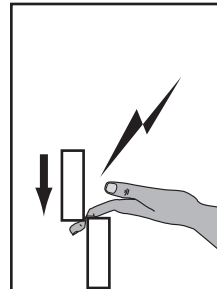
WARNING

Bodily injury could result from using this machine. Always wear safety glasses, leather work boots, and heavy duty leather work gloves when operating this machine or whenever handling sheet metal.



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

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the rear work stop for the length of the cut.
3. Puts on safety glasses, leather boots, and leather gloves.
4. Places the workpiece on the front support rods and up against the side work stop.
5. Slides the workpiece under the blades and up against the rear work stop.
6. Using good body position, firmly presses down on the foot pedal to make the cut.
7. Raises the foot pedal and either removes the workpiece or repeats **Steps 5–6** to make additional cuts.



WARNING

The shear blades or hold-down can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from the blades and hold-down during operation.

NOTICE

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



Basic Controls

Use **Figures 11–12** and the descriptions below to become familiar with the basic controls of the foot shear.

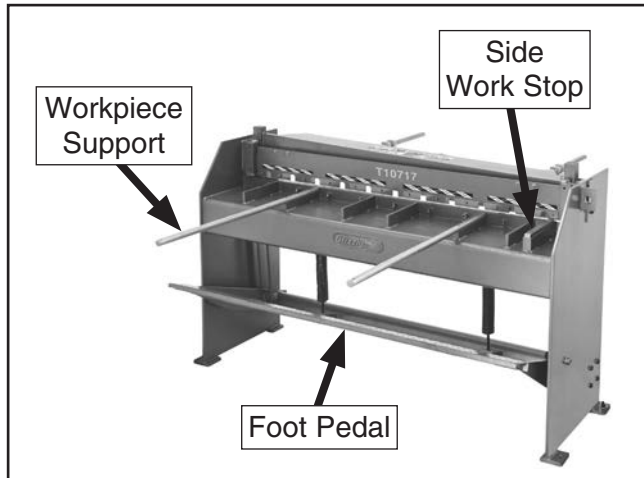


Figure 11. Front basic controls.

Workpiece Supports. Provide support for large workpieces. Scales along the top show the distance to the blades.

Side Work Stop. Helps the operator square the workpiece with the blades.

Foot Pedal. Controls the cutting action of the upper blade.

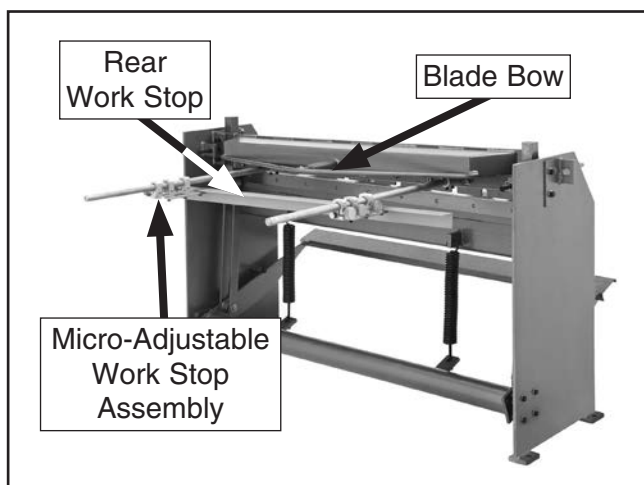


Figure 12. Rear basic controls.

Rear Work Stop. Allows the operator to setup the shear for multiple cuts of the same length.

Blade Bow: Adjustable to keep the upper blade straight along its length.

Micro-Adjustable Work Stop Assembly. Adjusts and secures the rear work stop at a specific distance from the blades.

Cutting Tips

- Keep the upper blade properly adjusted to the lower blade (refer to **Adjusting Blade Gap** on **Page 21** for detailed instructions). This will help ensure good cutting results and avoid blade damage.
- Before each operation, clean cut-offs or debris away from the shear.
- Make sure the side work stop is square with the blades. This will help ensure the cut is square.
- Use the foot pedal to engage the hold-down with the workpiece, then check the workpiece position. If it is correct, continue lowering the foot pedal to complete the cut.
- The shearing action of the blades works similarly to a pair of scissors (see the illustration in **Figure 13**). Use even pressure on the foot pedal to produce good results.

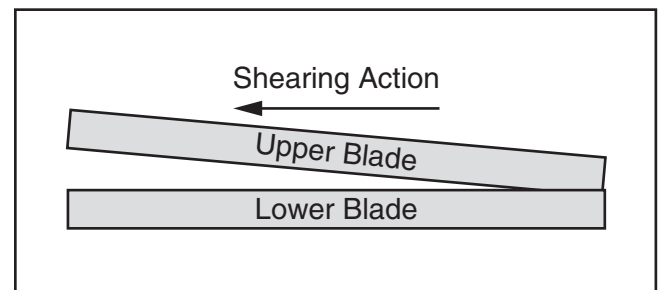


Figure 13. Blade shearing action.



Rear Work Stop

The rear work stop is used for making repetitive cuts of the same length. The micro-adjustment assemblies allow for precise positioning of the work stop.

To position the rear work stop:

1. Slide the work stop assembly evenly along the support rods so the work stop leading edge is at the approximate desired distance from the cutting edges of the blades.

Note: Use the scales on top of the support rods for approximate positioning. Use a fine ruler or tape measure for more precise positioning.

2. Tighten the micro-adjustable slide knob (see **Figure 14**) on each assembly.

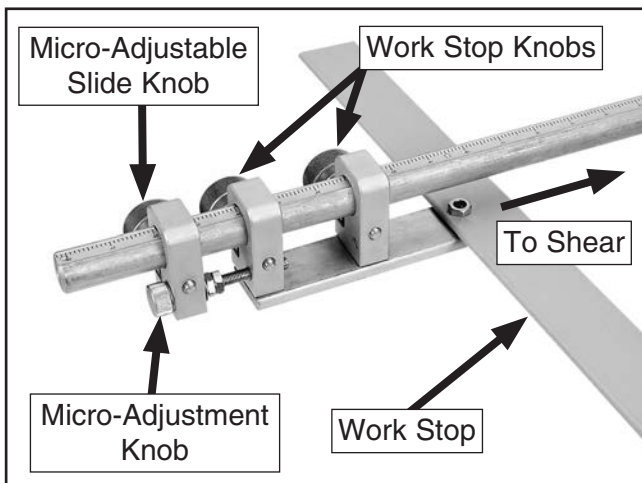


Figure 14. Work stop controls.

3. Use the micro-adjustment knob on each assembly to position the work stops in small, precise amounts until they are exactly where needed.

Note: Move the work stop evenly on both sides to keep it parallel with the blades.

4. To keep the work stop secured in the desired position, tighten the work stop knobs on each assembly (see **Figure 14**).

Side Work Stop

The side work stop (see **Figure 15**) helps the operator square the workpiece with the blades. To work properly, it must be square with the blades.

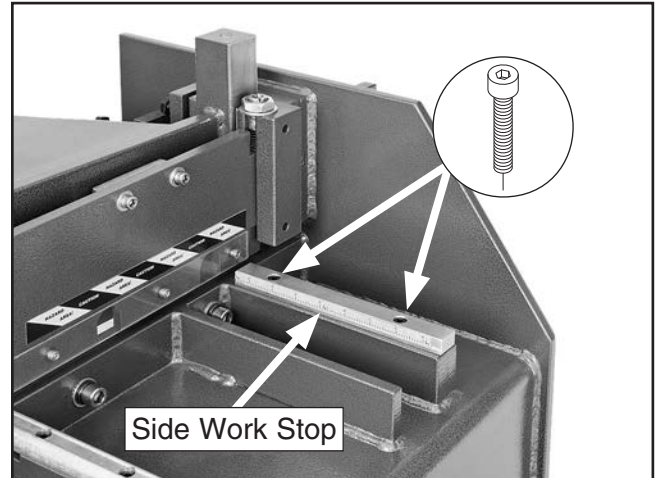


Figure 15. Side work stop.

Needed	Qty
Another Person.....	1
Square	1
Hex Wrench 5mm.....	1

To square the side work stop with the blades:

1. Loosen the two cap screws that secure the side work stop.
2. Have another person use the foot pedal to lower the upper blade all the way down, then hold it there.
3. Place the square against the blade guard and the side work stop.
4. Keeping the square evenly against the blade guard, adjust the side work stop so that it is evenly against the square.
5. Without moving the side work stop, re-tighten the cap screws to secure the setting.



SECTION 4: 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.

Bostitch Compound Action Aviation Snips

T22298—Straight

T22299—Left

T22300—Right

These 10" Aviation Snips are designed for cutting heavy stock in a straight, left, or right cutting direction. Developed with TiN-coated cutting blades to reduce wear and extend blade life, they cut up to 18 gauge cold-rolled steel or 23 gauge stainless steel. The patented flush-mounted side hardware also helps prevent metal from catching while cutting. These snips meet or exceed ANSI standards.



Figure 16. Bostitch Compound Aviation Snips.

H5614—Sheet Metal Gauge US Standard

Calibrated for sheet metal sized from 0 to 30 gauge. The front is marked with gauge sizes, the back is marked with actual inch measurements.

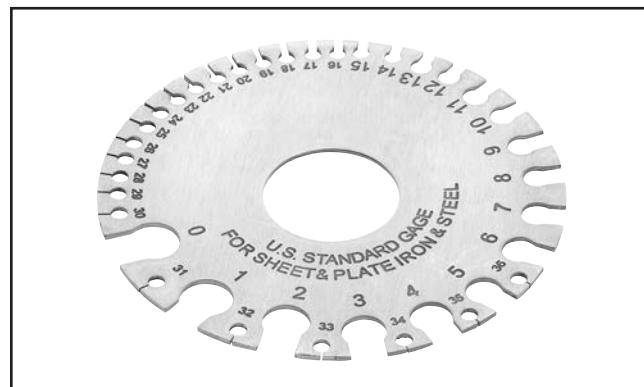


Figure 17. H5614 Sheet Metal Gauge.

T25208—23-Piece Deburring Set

Includes: 380-0060 double burr; 2-piece 380-0088 handle; 380-0097, 380-0098, and 380-0091 holders; D25 and D40 scrapers; C20 countersink; ES100 and ES200 blades (5 each); V13, and A13 blades; wrench and hex wrenches; case.



Figure 18. Model T25208 Deburring Set.

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



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 19. Model G4956 Super Nibbler.

G8781—4" 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 21. Model G8781 4" Suction Cup.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

H3788—G96® Gun Treatment 12 oz Spray

H3789—G96® Gun Treatment 4.5 oz Spray



Figure 20. Recommended products for protecting unpainted cast iron/steel part on machinery.

H5503—Electric Sheet Metal Shear

- Motor: $\frac{1}{2}$ HP, 110V, 2500 RPM, 3.8 Amp
- Swivel head adjust 360°
- Variable speed: 0–2500 RPM
- Cuts up to 14-gauge in mild steel and 18 gauge in stainless, at up to 150 in./min.
- Weighs 5 lbs.



Figure 22. Model H5503 Electric Sheet Metal Shear.

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



SECTION 5: MAINTENANCE

Schedule

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

Daily:

- Loose mounting bolts.
- Loose or damaged blade guard.
- Damaged or worn blades.
- Loose or bent support rods.
- Lubricate slide shafts.
- Any other unsafe condition.

Weekly:

- Lubricate pivot cartridge bearings.

Cleaning & Protecting

Use a brush to clear away any metal debris from the blades, hold-down, and the flat area in front of the blades.

Use a shop rag to carefully apply a thin coat of quality metal protectant (see **Page 17** for offerings from Grizzly) to all exposed surfaces of the blades to prevent corrosion.

Lubrication

Slide Shaft

Oil Type ... Mobil DTE Light or ISO 32 Equivalent
Oil Amount..... 1 or 2 Squirts
Lubrication Frequency Daily

The slide shaft ball oilers (see **Figure 23**) provide lubrication to the sliding surfaces between the shafts and the copper slide plates.

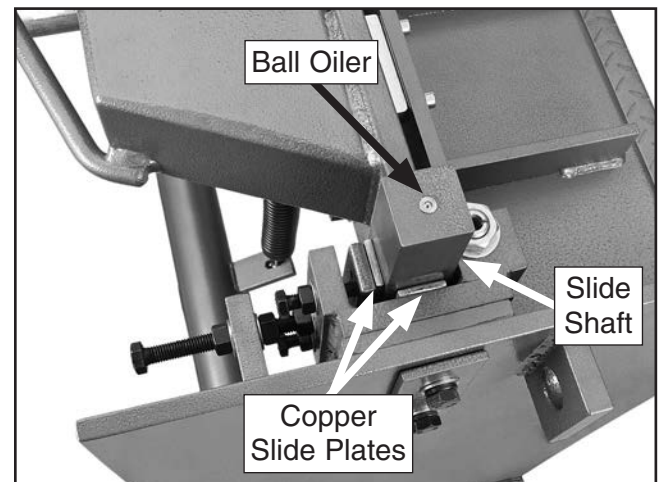


Figure 23. Slide shaft ball oiler.

Only lubricate these ball oilers with a pump-type oil can that has a plastic or rubberized cone tip. Do not use oil cans with a metal needle or lance tip, as they can push the ball too far into the oiler, break the spring seat, and lodge the ball in the oil galley.

When lubricating the ball oilers, first clean the outside surface to remove any dust or grime. Push the tip of the oil can nozzle against the ball oiler to create a hydraulic seal, then pump the oil can once or twice to add oil.



Pivot Cartridge Bearing

Grease Type Mobil 1 or NLGI#2 Equivalent
Grease Amount One Pump
Lubrication Frequency Weekly

The pivot cartridge bearings handle the majority of the torque produced by the foot pedal action, and must remain lubricated for smooth operation and long life.

Clean the outside of the grease fittings (see **Figure 24**) and the immediate area to prevent contamination of the added grease.



Figure 24. Pivot cartridge bearing grease fitting (1 of 2).

Fit the nozzle of the grease gun over the grease fitting and add one pump of grease. Press and release the foot pedal a few times to distribute the grease.



SECTION 6: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

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

Troubleshooting

Symptom	Possible Cause	Possible Solution
Shear will not cut workpiece.	1. Workpiece thickness exceeds shear capacity. 2. Blade gap not correct. 3. Not enough pressure applied to foot pedal.	1. Only use workpiece material that is within shear capacity (Page 4). 2. Properly adjust blade gap (Page 21). 3. Safely increase pressure on foot pedal.
Cuts are not square.	1. Side work stop not square with blades. 2. Rear work stop not parallel to blades. 3. Blade gap not correct.	1. Adjust side work stop square with blades (Page 15). 2. Properly adjust rear work stop parallel to blades (Page 15). 3. Properly adjust blade gap (Page 21).
Poor quality of cuts (ripping or tearing).	1. Blade gap not correct. 2. Blades worn or damaged. 3. Gibs too loose.	1. Properly adjust blade gap (Page 21). 2. Sharpen/replace blades (Page 22). 3. Properly adjust gibs (Page 23).
Foot pedal difficult to use.	1. Blade gap not correct. 2. Gibs too tight.	1. Properly adjust blade gap (Page 21). 2. Properly adjust gibs (Page 23).



Adjusting Blade Gap

The gap between the upper and lower blades (as they pass each other) must remain even along the length of blades to produce clean cuts. Initially, this adjustment has been made at the factory. However, over time and with normal wear, you may need to re-adjust the blade gap.

If the blade gap is too wide, the workpiece will not cut correctly and show signs of bending, ripping, or tearing. If the blade gap is too narrow, the upper blade will have difficulty lowering past the lower blade and the cutting edges may become damaged.

Checking Blade Gap

Use a piece of paper to make cuts along the full length of the shear blades. All cuts should be sharp without bending or tearing the paper.

- If the paper does not cut cleanly only on one end of the shear, the upper blade needs to be adjusted on that end.
- If the paper does not cut cleanly along the entire length of the blades, both ends of the upper blade need to be adjusted.
- If the paper cuts cleanly on the ends but not the center, or it cuts cleanly in the center but not the ends, the blade bow needs to be adjusted (refer to **Adjusting Blade Bow** on the next page for detailed instructions).

Adjusting Upper Blade

The blade gap is controlled by the position of the upper blade as it passes the lower blade. This gap is adjusted by moving one or both slide shafts (see **Figure 25**) forward or backward.

If the paper does not cut cleanly after proper adjustment of the upper blade, the blades may need to be sharpened or replaced (refer to **Blade Sharpening/Replacing** on the next page for detailed instructions).

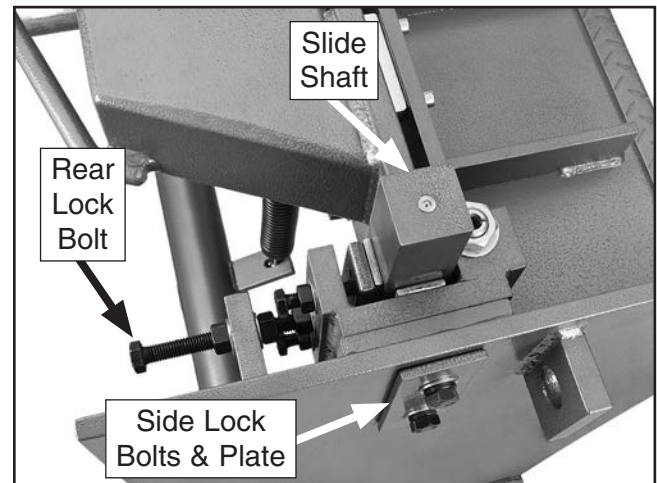


Figure 25. Upper blade adjustment controls.

Tools Needed

	Qty
Wrench 18mm	1
Dead-Blow Hammer	1

To adjust the upper blade:

1. Completely remove the rear lock bolt with the hex nuts and flat washers from the slide shaft that needs adjustment.

Note: Remember the order that the hex nuts and flat washers are arranged on the lock bolt.

2. Loosen the side lock bolts but do not remove them.
3. Tap the front or back of the slide shaft a small amount to increase or decrease the blade gap.
4. Repeat the previous **Checking Blade Gap** procedure to test the adjustment you made.

—If the blade gap is correct, re-tighten the side lock bolts and re-install the rear lock bolt with hex nuts and flat washers.

—If the blade gap is not correct, repeat **Steps 2–4** until it is.



Adjusting Blade Bow

The blade bow is used to keep the upper blade straight along its full length by adjusting the amount of force that the bow exerts on the blade ends.

The blade bow is adjusted by loosening or tightening the bow nut on the centering rod (see **Figure 26**).

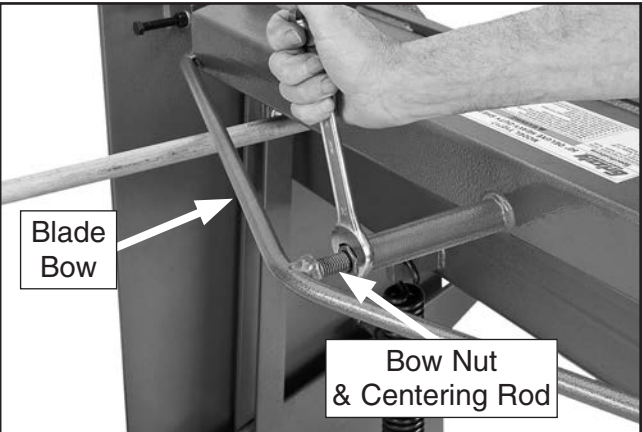


Figure 26. Using the bow nut to adjust the blade bow.

Tool Needed	Qty
Wrench 24mm	1

To adjust the blade bow:

1. Perform **Steps 1–2** in the previous **Adjusting Upper Blade** procedure for both sliding shafts.
2. Perform the **Checking Blade Gap** procedure on the previous page.
 - If the paper cuts cleanly at the ends but not the center, turn the bow nut clockwise until the paper cuts cleanly along the entire length of the blades.
 - If the paper cuts cleanly at the center but not the ends, turn the bow nut counter-clockwise until the paper cuts cleanly along the entire length of the blades.
3. Re-tighten the side lock bolts, and re-install the rear lock bolts with hex nuts and flat washers.

Sharpening/ Replacing Blades

Both blades have two cutting edges so that if one cutting edge becomes dull, you can reverse the blade and use the fresh, sharp cutting edge.

If both cutting edges are dull, re-sharpen the blades on a surface grinder and make sure they stay flat along their entire length. If the blade becomes too thin and the cap screws that secure it extend beyond the opposite side of the cutting edge, you will need to replace it. If the blade is nicked or damaged, replace it. Contact Grizzly at (800) 523-4777 or online at grizzly.com to purchase Part No. P10717031. We recommend you keep an extra set of blades on hand to avoid downtime.

Needed	Qty
Another Person.....	1
Hex Wrench 10mm.....	1

To remove/re-install a blade:

1. Have another person support the blade so it does not fall as you remove the nine cap screws that secure it (see **Figure 27**).

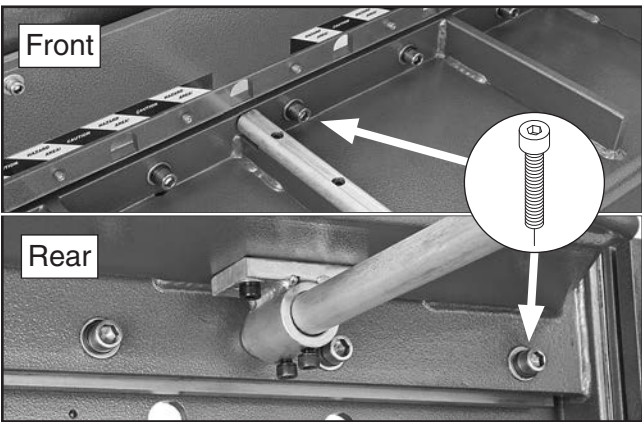


Figure 27. Blade cap screws.

2. Before re-installing the blade, clean it with mineral spirits, then apply a thin coat of quality metal protectant.
3. Orient the cutting edge to the other blade, then secure the blade in place with the nine cap screws removed in **Step 1**.



Adjusting Gibs

Tool Needed	Qty
Wrench 16mm	1

There are three copper sliding plates for each of the slide shafts (see **Figure 28**)—front, rear, and side. They are made of copper so the plates wear instead of the shafts. The rear sliding plates act as gibs that apply pressure to keep the movement tight and precise.

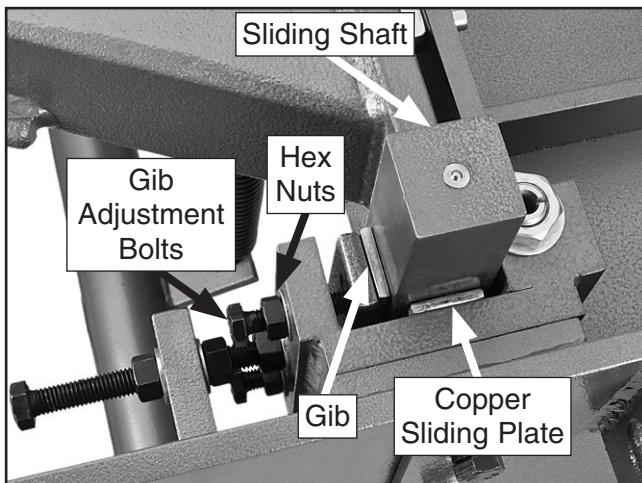


Figure 28. Gib adjustment controls.

If the gibs are too loose, the quality of the cuts will suffer because the movement will be sloppy when the foot pedal is pressed. If the gibs are too tight, it will be difficult to lower the upper blade, and the cutting edges of the blades may become damaged.

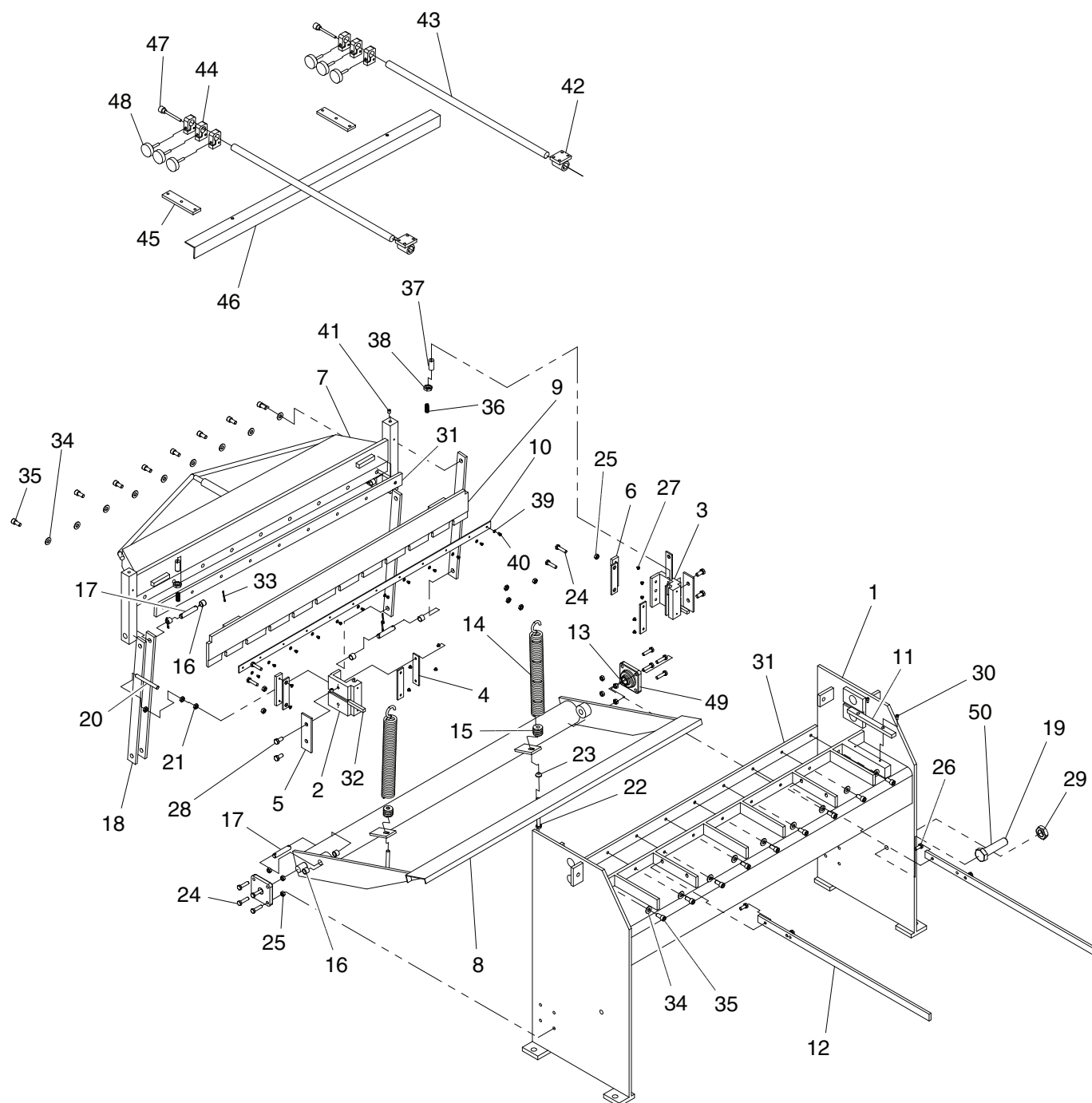
The goal of adjusting the gibs is to keep the front-to-back movement of the sliding shafts snug without interfering with the sliding action.

To adjust the gibs:

1. On each side of the shear, loosen the hex nuts on the gib adjustment bolts.
2. Tighten all four gib adjustment bolts in even increments until the gibs are snug against the sliding shafts, then back off the adjustment bolts $\frac{1}{8}$ th of a turn.
3. Make a test cut to check the sliding action and the quality of the cut. If necessary, rotate the gib adjustment bolts clockwise to tighten the gib or counterclockwise to loosen it, then then repeat the test and adjust as necessary until you are satisfied with the gib adjustment.
4. Re-tighten the hex nuts without moving the adjustment bolts.



Main



Main Parts List

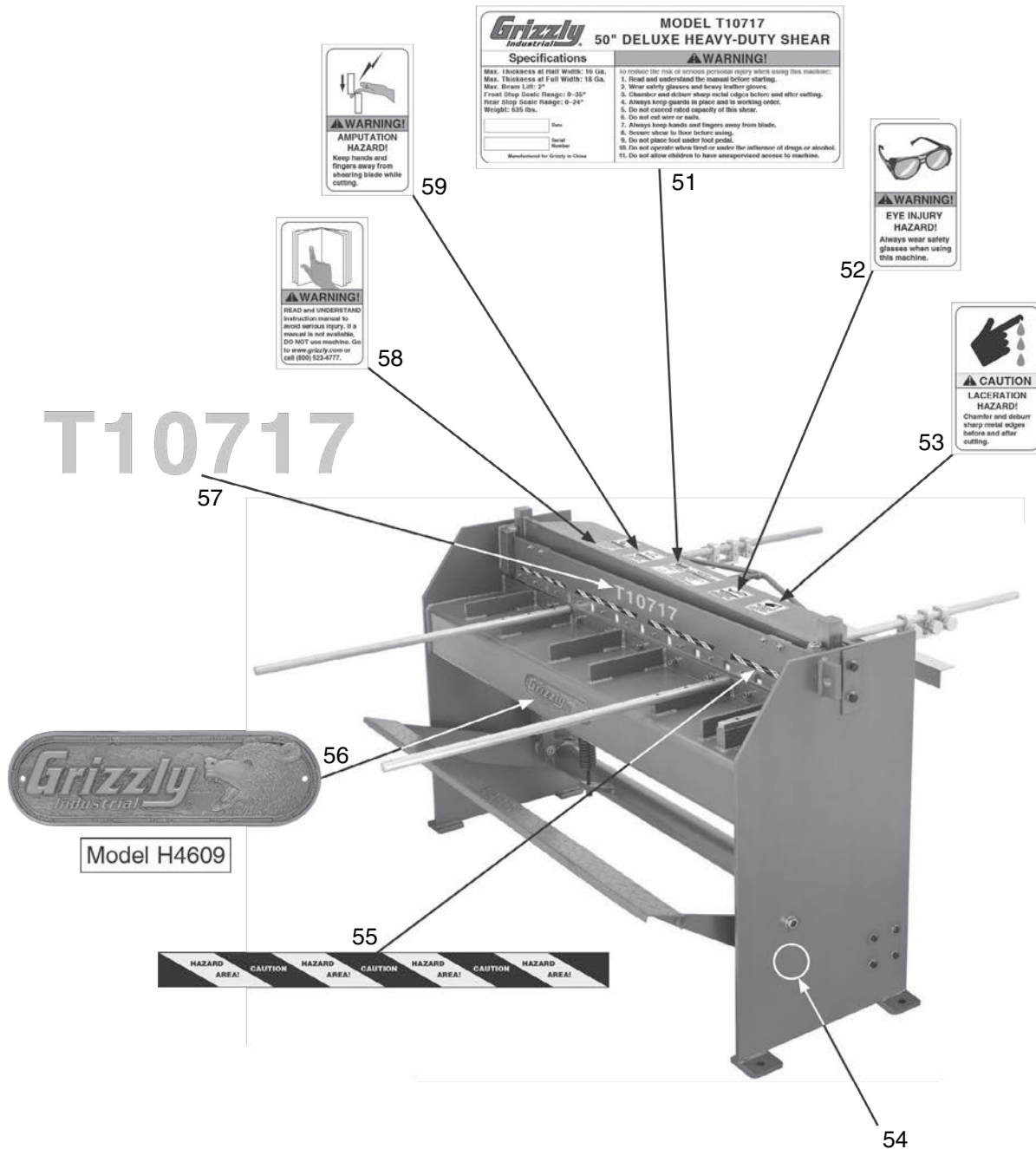
REF	PART #	DESCRIPTION
1	PT10717001	FRAME
2	PT10717002	LEFT SLIDE BRACKET
3	PT10717003	RIGHT SLIDE BRACKET
4	PT10717004	COPPER SLIDE PLATE
5	PT10717005	PRESSURE PLATE
6	PT10717006	CONNECTING PLATE
7	PT10717007	BLADE BOW ASSEMBLY
8	PT10717008	FOOT PLATE
9	PT10717009	HOLD-DOWN PLATE
10	PT10717010	BLADE GUARD
11	PT10717011	SIDE WORKPIECE STOP
12	PT10717012	WORKPIECE SUPPORT ROD
13	PUCC205	CARTRIDGE BEARING UCC205
14	PT10717014	EXTENSION SPRING
15	PT10717015	SPRING RETAINING NUT
16	PT10717016	PIVOT SHAFT BUSHING
17	PT10717017	PIVOT SHAFT W/2 THREADED HOLES
18	PT10717018	CONNECTING PLATE
19	PB192M	HEX BOLT M16-2 X 80 C8.8
20	PB193M	HEX BOLT M12-1.75 X 120 C8.8
21	PN09M	HEX NUT M12-1.75
22	PB194M	HEX BOLT M12-1.75 X 130 C8.8
23	PT10717023	SPRING RETAINING WASHER
24	PB116M	HEX BOLT M10-1.5 X 45
25	PN02M	HEX NUT M10-1.5

REF	PART #	DESCRIPTION
26	PCAP06M	CAP SCREW M6-1 X 25
27	PFH29M	FLAT HD SCR M6-1 X 10
28	PB195M	HEX BOLT M12-1.75 X 25 C8.8
29	PN47M	HEX NUT M16-2 C8
30	PCAP01M	CAP SCREW M6-1 X 16
31	PT10717031	BLADE
32	PK181M	KEY 12 X 12 X 100
33	PCOT03M	STANDARD COTTER PIN 5 X 40MM
34	PW06M	FLAT WASHER 12MM
35	PCAP77M	CAP SCREW M12-1.75 X 30
36	PT10717036	COMPRESSION SPRING
37	PT10717037	SLOTTED STUD-FT M18-1.5 X 32
38	PN29M	HEX NUT M18-2.5
39	PW02M	FLAT WASHER 5MM
40	PCAP03M	CAP SCREW M5-.8 X 8
41	PLUBE003M	TAP-IN BALL OILER 10MM
42	PT10717042	SUPPORT BAR MOUNT
43	PT10717043	WORK STOP SUPPORT ROD
44	PT10717044	WORK STOP BRACKET
45	PT10717045	WORK STOP PLATE
46	PT10717046	WORK STOP L-BRACKET
47	PT10717047	KNURLED KNOB SCREW M8-1.25 X 75
48	PT10717048	KNURLED KNOB SCREW M8-1.25 X 45
49	PT10717049	BEARING HOUSING
50	PT10717050	STOP BOLT WRAPPING

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.



Labels & Cosmetics



REF	PART #	DESCRIPTION
51	PT10717051	MACHINE ID LABEL
52	PLABEL-11A	EYE INJURY HAZARD LABEL
53	PT10717053	LACERATION HAZARD LABEL
54	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
55	PT10717055	HAZARD AREA LABEL

REF	PART #	DESCRIPTION
56	H4609	GRIZZLY OBLONG NAMEPLATE
57	PT10717057	MODEL NUMBER LABEL
58	PLABEL-12A	READ MANUAL LABEL
59	PT10717059	AMPUTATION HAZARD LABEL

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.**

1. How did you learn about us?

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

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

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

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

_____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend?

_____ Yes _____ No

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

Note: We never use names more than 3 times.

_____ Yes _____ No

10. Comments: _____

FOLD ALONG DOTTED LINE



Place
Stamp
Here



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



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____
Street_____
City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY & RETURNS

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

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

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

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

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

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

grizzly.com® **TOOL WEBSITE**

Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!
~Since 1983~

***Visit Our Website Today For
Current Specials!***

**ORDER
24 HOURS A DAY!
1-800-523-4777**

