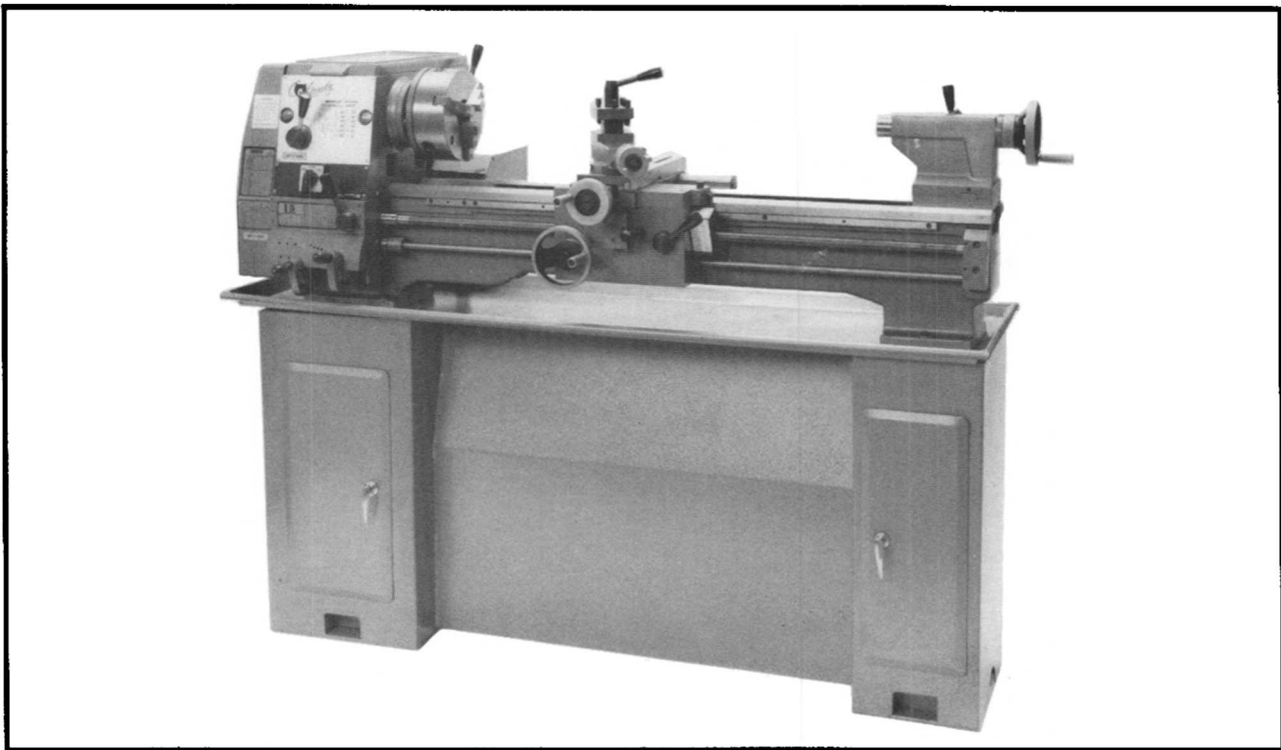




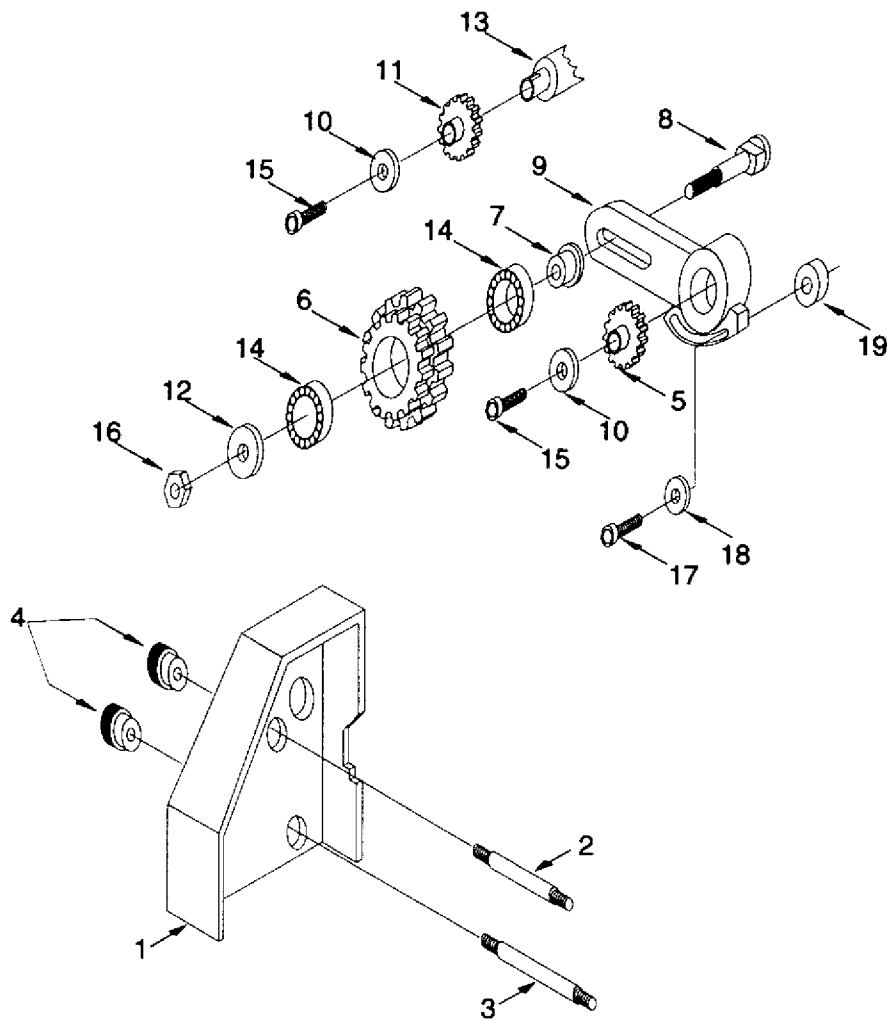
**12" X 37" GAP-BED METAL LATHE
MODEL G1003
INSTRUCTION MANUAL**



GRIZZLY IMPORTS, INC.

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REVISED MARCH, 1993. PRINTED IN USA

XVI. PARTS DIAGRAM, END GEAR & COVER



XVII. PARTS LIST, END GEAR & COVER

Ref. No.	Part No.	Description
1	P1003601	End Cover
2	P1003602	Cover Stud
3	P1003603	Cover Stud
4	P1003604	Cover Set Knob
5	P1003605	Driven Gear (40T)
6	P1003606	Idler Gear
7	P1003607	Bushing
8	P1003608	Idler Gear Axle
9	P1003609	Lever Quadrant
10	P1003610	Special Washer
11	P1003605	Driven Gear (40T)

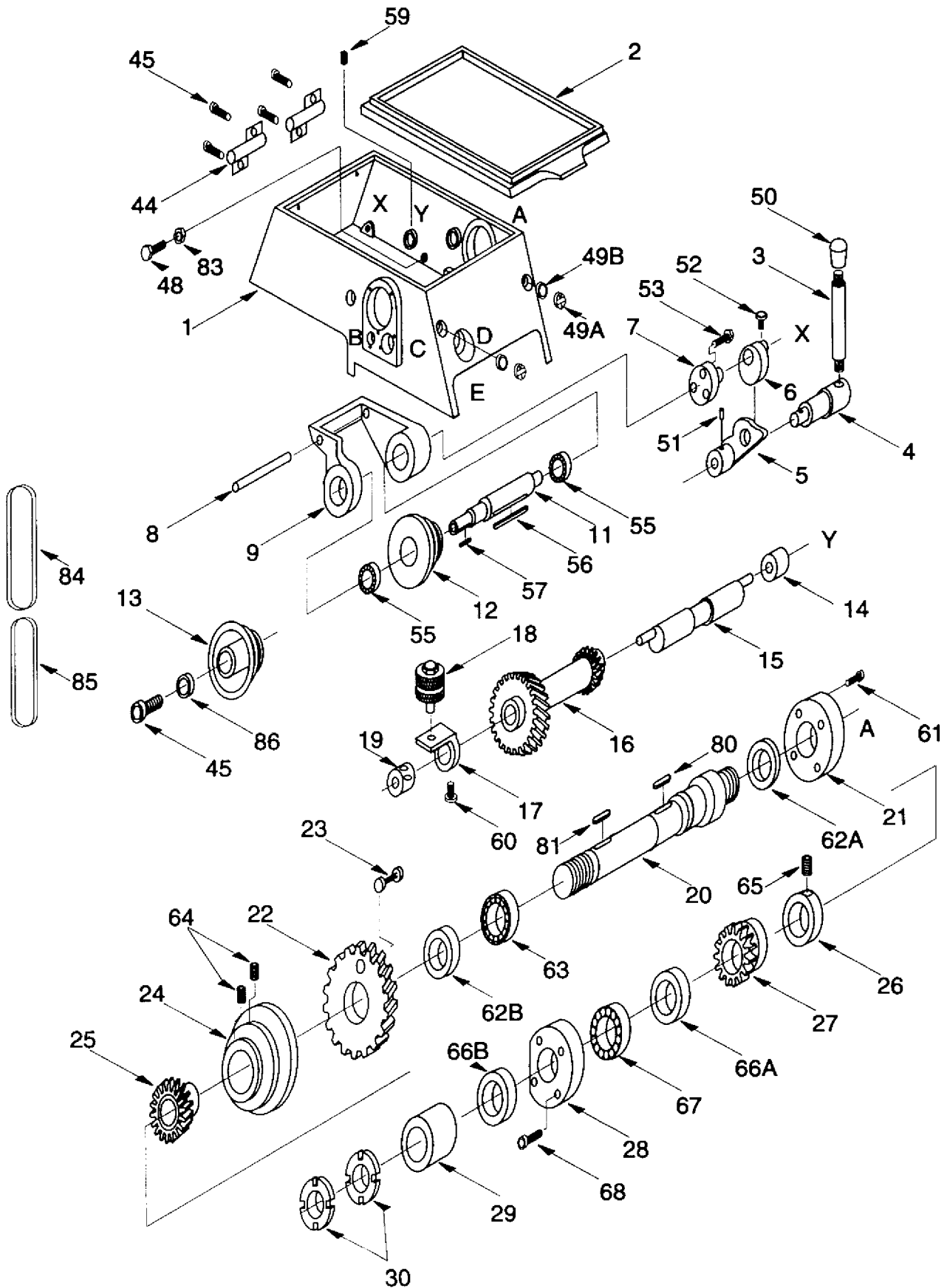
Ref. No.	Part No.	Description
11A	P1003605A	Driven Gear (30T; not shown)
11B	P1003605B	Driven Gear (32T; not shown)
12	P1003612	Special Washer
13	P1003613	Train Shaft
14	P6202ZZ	Bearing (6202)
15	PSB26M	Cap Screw M6-1.0x12 mm
16	PN02M	Hex Nut M10 - 1.5
17	PSB45	Cap Screw M8-1.25x45 mm
18	PW06	Flat Washer 1/4"
19	P1003619	Spacer

XVIII. PARTS LIST, HEADSTOCK

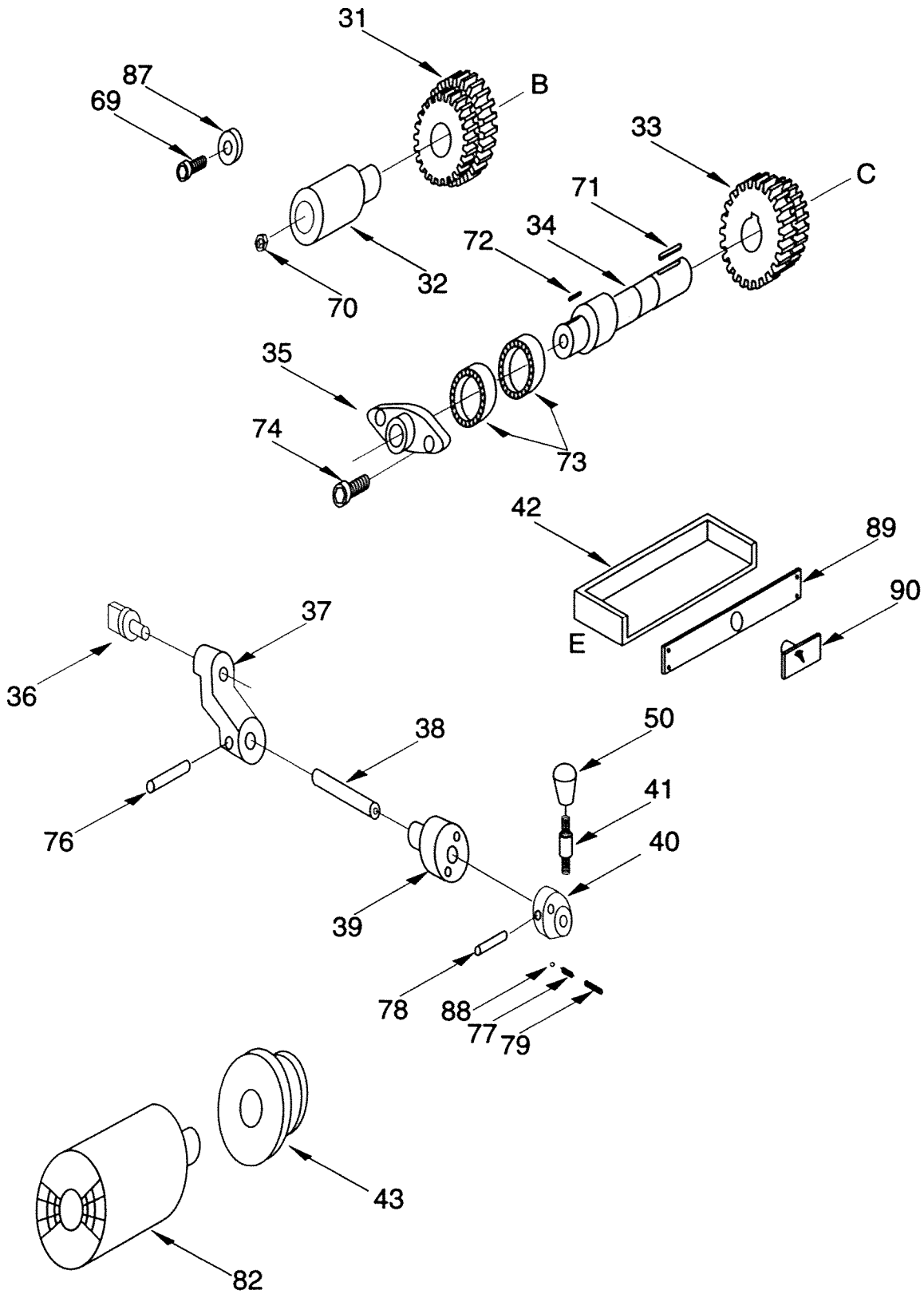
Ref. No.	Part No.	Description
1	P1003001	Headstock Casting
2	P1003002	Headstock Cover
3	P1003003	Locking Lever
4	P1003004	Shaft
5	P1003005	Bracket
6	P1003006	Cam
7	P1003007	Bearing Cap
8	P1003008	Shaft
9	P1003009	Arm
11	P1003011	Pulley Shaft
12	P1003012	3 V-Belt Pulley
13	P1003013	2 V-Belt Pulley
14	P1003014	Bushing
15	P1003015	Cam Shaft
16	P1003016	Rear Axle Gear
17	P1003017	Shift Bushing
18	P1003018	Locating Device
19	P1003019	Locating Bushing
20	P1003020	Main Spindle
21	P1003021	Front Bearing Cap
22	P1003022	Helical Gear
23	P1003023	Locking Bolt Assembly
24	P1003024	Spindle Pulley
25	P1003025	Helical Gear
26	P1003026	Collar
27	P1003027	Shifting Gear
28	P1003028	Rear Bearing Cap
29	P1003029	Spacer
30	P1003030	Spanner Nut
31	P1003031	Idle Gear
32	P1003032	Shaft
33	P1003033	Gear
34	P1003034	Train Shaft
35	P1003035	Bearing Cap
36	P1003036	Gear Shifter
37	P1003037	Shifting Crank
38	P1003038	Knob Shaft
39	P1003039	Bushing
40	P1003040	Direction Control
41	P1003041	Control Lever
42	P1003042	Switch Box
43	P1003043	Motor Pulley
44	P1003044	Hinge
45	PSB26M	Cap Screw M6-1.0 x 12 mm

Ref. No.	Part No.	Description
48	PB07M	Hex Bolt M8-1.25 x 25 mm
49A	P1003049A	Oil Level Window
49B	P1003049B	Gasket
50	P1003050	Knob
51	P1003051	Roll Pin
52	PSB31M	Cap Screw M8-1.25 x 25 mm
53	PB02M	Hex Bolt M6-1.0 x 12 mm
55	P6204	Bearing (6204)
56	P1003056	Key
57	P1003057	Key
59	PSS16	Setscrew 1/4" - 20 x 1/2"
60	PSB14	Cap Screw 3/8" - 16 x 1"
61	PSB02	Cap Screw M6-1.0 x 20 mm
62A	P1003062A	Seal (80-100-12)
62B	P1003062B	Seal (60-80-12)
63	P1003063	Tapered Roller Bearing (30212)
64	PSS16M	Setscrew M8-1.25 x 10 mm
65	PSS02M	Setscrew M6-1.0 x 6 mm
66A	P1003066A	Seal (55-75-12)
66B	P1003066B	Seal (65-85-12)
67	P1003067	Tapered Roller Bearing (30211)
68	PSB32M	Cap Screw M6-1.0 x 17 mm
69	PSB26M	Cap Screw M6-1.0 x 12 mm
70	P1003070	Grease Zerk
71	P1003071	Key
72	P1003072	Key
73	P6203ZZ	Bearing (6203)
74	PSB01M	Cap Screw M6-1.0 x 16 mm
76	P1003076	Roll Pin
77	P1003077	Spring
78	P1003078	Roll Pin
79	PSS17M	Setscrew M8-1.25 x 6 mm
80	P1003080	Key
81	P1003081	Key
82	P1003082	Motor
83	PN03M	Hex Nut M8-1.25
84	PVB32	V-Belt (B-32)
85	PVB33	V-Belt (B-33)
86	PW06	Flat Washer 1/4" - 20
87	P1003087	Special Washer
88	P1003088	Ball
89	P1003089	Switch Mounting Plate
90		

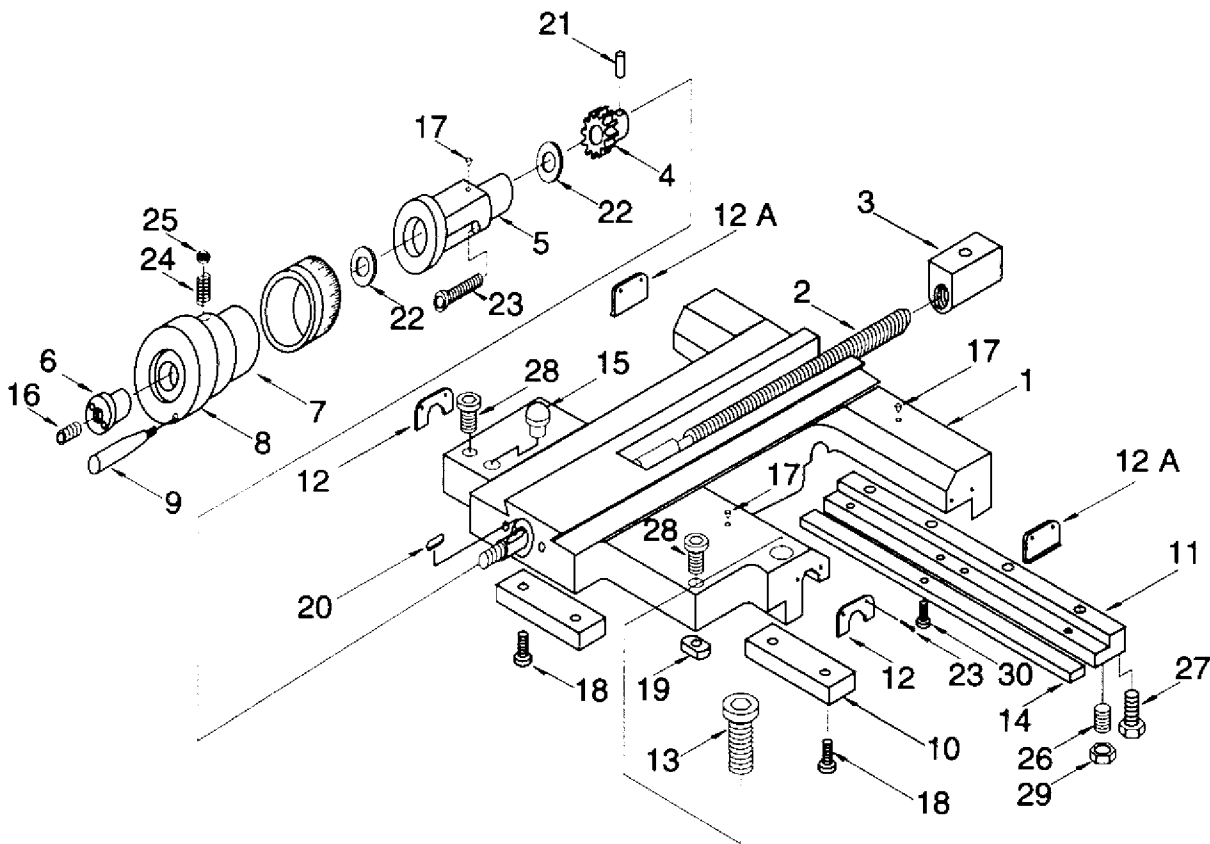
XIX. PARTS DIAGRAM, HEADSTOCK—PART A



XX. PARTS DIAGRAM, HEADSTOCK—PART B



XXI. PARTS DIAGRAM, CARRIAGE

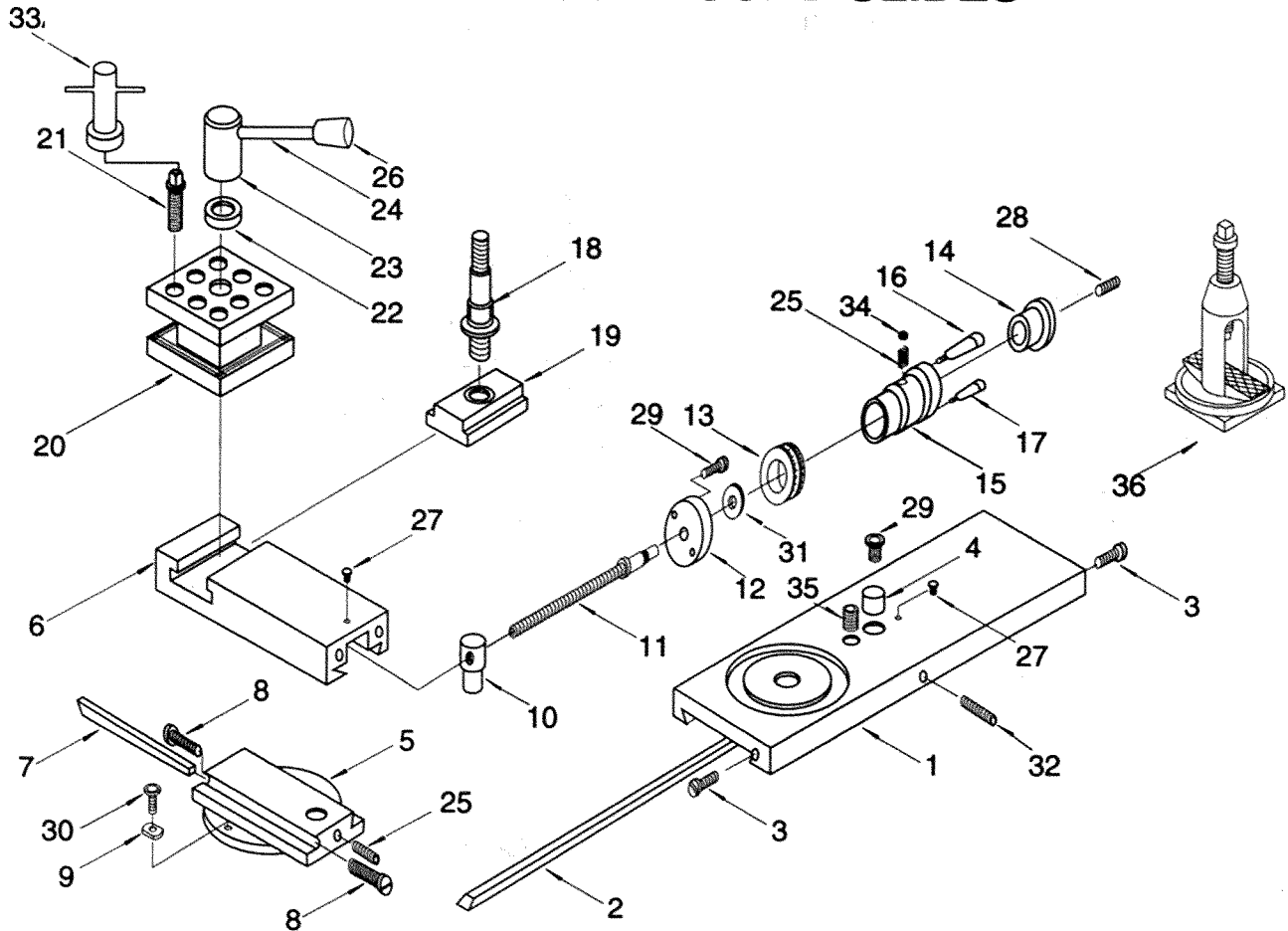


XXII. PARTS LIST, CARRIAGE

Ref. No.	Part No.	Description
1	P1003101	Main Carriage Casting
2	P1003102	Cross Feed Screw
3	P1003103	Cross Feed Nut
4	P1003104	Cross Feed Pinion
5	P1003105	Cross Feed Screw Bushing
6	P1003106	Spanner Nut
7	P1003107	Cross Feed Dial
8	P1003108	Cross Feed Handle
9	P1003109	Hand Knob
10	P1003110	Front Clamp
11	P1003111	Rear Clamp
12	P1003112	V-Wiper
12A	P1003112A	Wiper
13	P1003113	Carriage Lock Bolt
14	P1003114	Gib
15	P1003115	Oil Plug

Ref. No.	Part No.	Description
16	PSS15M	Setscrew M8-1.25 x 16 mm
17	P1003117	Oil Cap
18	PSB11M	Cap Screw M8-1.25 x 16 mm
19	P1003119	Carriage Lock Nut
20	PK17M	Key 5 x 5 x 9
21	P1003121	Roll Pin
22	P1003122	Thrust Bearing
23	PS06	PH Screw #10-24 x 3/8"
24	P1003124	Spring
25	P1003125	Ball
26	PSS11M	Setscrew M6-1.0 x 16 mm
27	PB07M	Hex Bolt M8-1.25 x 25 mm
28	PSB34M	Cap Screw M8-1.25 x 34 mm
29	PN01M	Hex Nut M6-1.0
30	PSB01M	Cap Screw M6-1.0 x 16 mm

XXIII. PARTS DIAGRAM, CROSS-& COMPOUND SLIDES



XXIV. PARTS LIST, CROSS- & COMPOUND SLIDES

Ref. No.	Part No.	Description
1	P1003201	Cross Slide
2	P1003202	Cross Slide Gib
3	P1003203	Gib Adjustment Screw
4	P1003204	Screw Set Bushing
5	P1003205	Swivel
6	P1003206	Compound Slide
7	P1003207	Compound Slide Gib
8	P1003208	Gib Adjustment Screw
9	P1003209	Swivel Lock Nut
10	P1003210	Compound Nut
11	P1003211	Compound Screw
12	P1003212	Compound Screw Bushing
13	P1003213	Compound Dial
14	P1003106	Spanner Nut
15	P1003215	Compound Handle
16	P1003216	Long Handle
17	P1003217	Short Handle
18	P1003218	Tool Post Pin

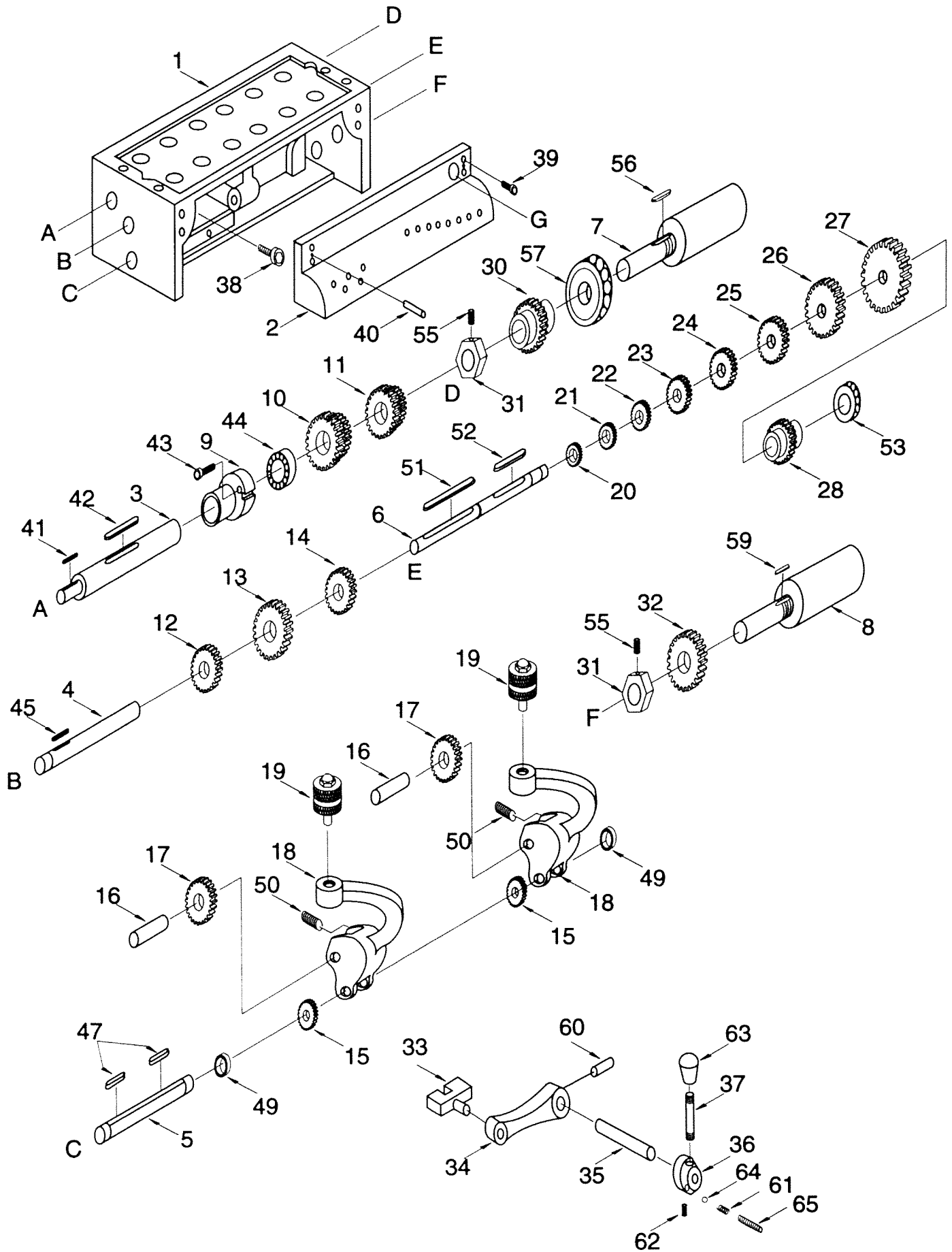
Ref. No.	Part No.	Description
19	P1003219	T-Slot Clamp Nut
20	P1003220	Tool Post
21	P1003221	Set Bolt
22	P1003222	Spacer
23	P1003223	Tool Post Clamp
24	P1003224	Clamp Lever
25	P1003124	Spring
26	P1003050	Knob
27	P1003117	Oil Cap
28	PSS18M	Setscrew M12-1.75x12mm
29	PSB14M	Cap Screw M8-1.25x20mm
30	PSB11M	Cap Screw M8-1.25x16mm
31	P1003231	Thrust Bearing
32	PSS09M	Setscrew M8-1.25x20 mm
33	P1003233	Tool Post Wrench
34	P1003125	Ball
35	PSS09M	Setscrew M8-1.25x20 mm
36	P1003236	Rocker Tool Post Assembly

XXV. PARTS LIST, GEAR BOX

Ref. No.	Part No.	Description
1	P1003701	Gear Box
2	P1003702	Cover
3	P1003703	Spindle Shaft
4	P1003704	Spindle Shaft
5	P1003705	Shifting Shaft
6	P1003706	Spindle Shaft
7	P1003707	Lead Screw Shaft
8	P1003708	Feed Shaft
9	P1003709	Bearing Cap
10	P1003710	Gear 16T/32T
11	P1003711	Gear 16T/32T
12	P1003712	Gear 16T
13	P1003713	Gear 16T/32T
14	P1003714	Gear 16T/32T
15	P1003715	Gear 16T
16	P1003716	Shaft
17	P1003717	Gear 36T
18	P1003718	Gear Change Handle
19	P1003719	Gear 16T
20	P1003720	Gear 16T
21	P1003721	Gear 18T
22	P1003722	Gear 19T
23	P1003723	Gear 20T
24	P1003724	Gear 22T
25	P1003725	Gear 24T
26	P1003726	Gear 26T
27	P1003727	Gear 28T
28	P1003728	Shifting Gear
29	P1003729	Thrust Nut
30	P1003730	Gear 24T
31	P1003731	Thrust Nut
32	P1003732	Gear 24T
33	P1003733	Gear Shifter

Ref. No.	Part No.	Description
34	P1003734	Shifting Crank
35	P1003735	Shaft
36	P1003736	Gear Change Lever
37	P1003737	Control Lever
38	PSB28M	Cap Screw M6-1.0 x 15 mm
39	PPSB01M	Cap Screw M6-1.0 x 16 mm
40	PRP06M	Roll Pin 5 x 24
41	PK17M	Key 5 x 5 x 9 mm
42	P1003742	Key
43	PSB01M	Cap Screw M6-1.0 x 16 mm
44	P6203ZZ	Bearing (6203)
45	P1003745	Key
47	P1003747	Key
49	P6202ZZ	Bearing (6202)
50	PSS02M	Setscrew M6-1.0 x 6 mm
51	PK16M	Key 5 x 5 x 67 mm
52	P1003752	Key
53	P6203ZZ	Bearing (6203)
55	PSS01M	Setscrew M6-1.0 x 10 mm
56	PK17M	Key 5 x 5 x 9 mm
57	P1003757	Thrust Bearing
58	PSS01M	Setscrew M6-1.0 x 10 mm
59	P1003759	Key
60	PRP27M	Roll Pin 5 x 28 mm
61	P1003761	Spring
62	PRP29M	Roll Pin 5 x 45 mm
63	P1003050	Knob
64	P1003064	Ball
65	PSS02M	Setscrew M6-1.0 x 6 mm

XVI. PARTS DIAGRAM, GEARBOX

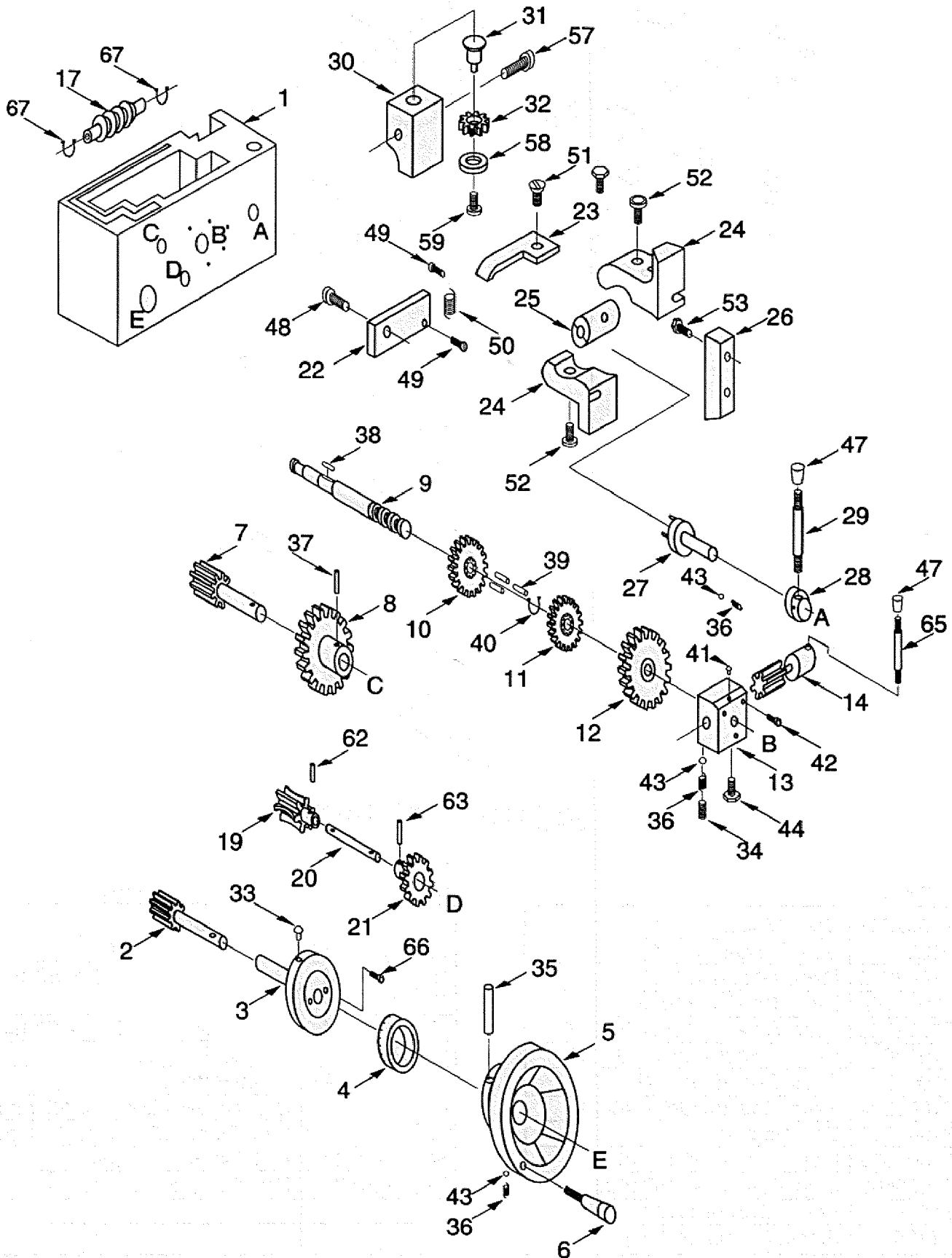


XXVII. PARTS LIST, APRON

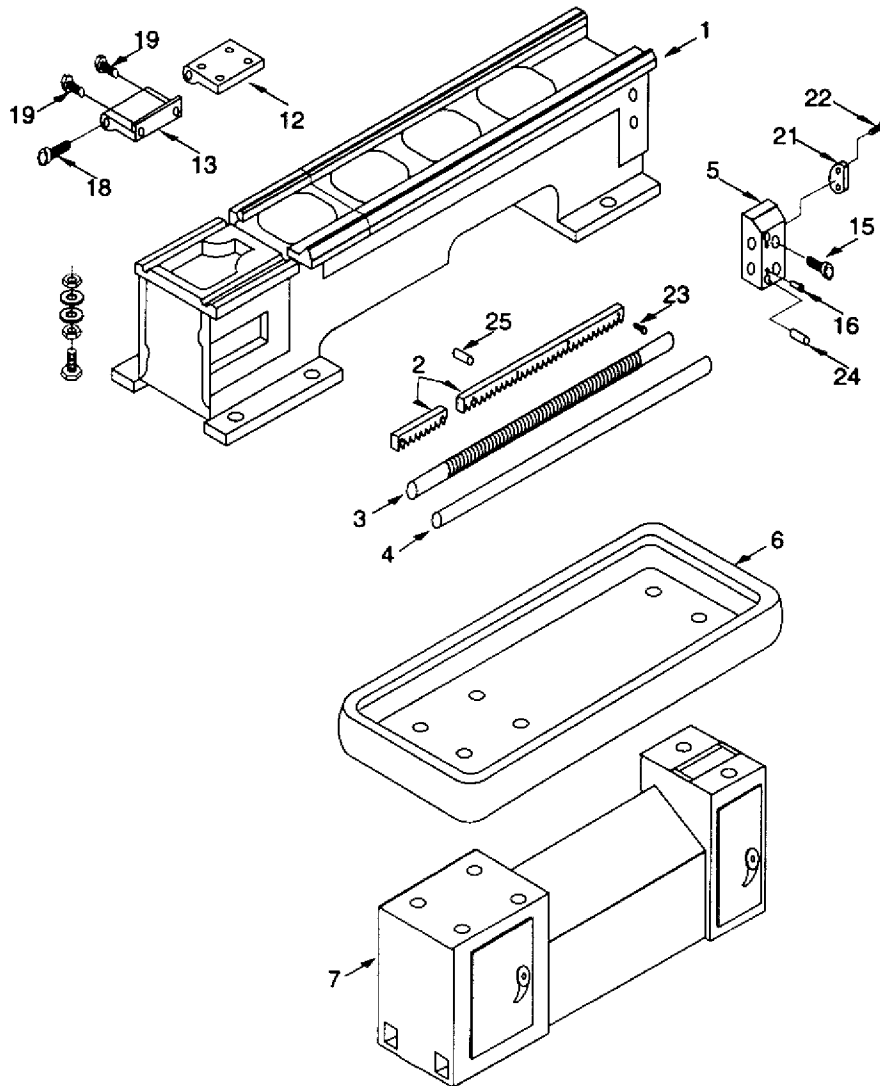
Ref. No.	Part No.	Description
1	P1003301	Apron Body
2	P1003302	Gear Shaft
3	P1003303	Bushing
4	P1003304	Handwheel Dial
5	P1003305	Handwheel
6	P1003306	Handle
7	P1003307	Gear Shaft
8	P1003308	Gear
9	P1003309	Pull-Push Lever
10	P1003310	Clutch Gear
11	P1003311	Clutch Gear
12	P1003312	Clutch Gear
13	P1003313	Bracket
14	P1003314	Pinion Shaft
15	P1003315	Control Plate
16	P1003316	Auto Feed Lever
17	P1003317	Worm
19	P1003319	Worm Gear
20	P1003320	Shaft
21	P1003321	Gear
22	P1003322	Locating Plate
23	P1003323	Control Plate
24	P1003324	Half-Nut Clutch
25	P1003325	Half-Nut
26	P1003326	Half-Nut Gib
27	P1003327	Half-Nut Cam
28	P1003323	Half-Nut Handle
29	P1003329	Handle Lever
30	P1003330	Thread Indicator Body
31	P1003331	Thread Indicator Shaft
32	P1003332	Indicator Gear 32T
33	P1003117	Oil Cap

Ref. No.	Part No.	Description
34	PSS17M	Setscrew M8 x 1.25 x 6 mm
35	PRP30M	Roll Pin 5 x 50 mm
36	P1003336	Spring
38	P1003338	Key
39	P1003339	Pin
40	PEC05M	E-Clip 12 mm
41	P1003117	Oil Cap
42	PSB29M	Cap Screw M6 - 1.0 x 40 mm
43	P1003143	Ball
44	P1003144	Special Hex Bolt
47	P1003050	Knob
48	P1003348	Special Screw
49	PS01	Phillips Screw 3/16" - 24 x 1/2"
50	P1003350	Spring
51	P1003051	C.S. Ph. Hd. Screw 1/4"-20x3/8"
52	PSB26M	Cap Screw M6-1.0 x 12 mm
53	PB08M	Hex Bolt M6-1.0 x 20 mm
57	PSB30M	Cap Screw M6-1.0 x 45 mm
58	PW06	Flat Washer 1/4" - 20
59	PSB26M	Cap Screw M6-1.0 x 12 mm
62	PRP27M	Roll Pin 5 x 28 mm
63	PRP22M	Roll Pin 4 x 32 mm
64	P1003364	Exterior Snap Ring 28 mm
65	P1003365	Stud
66	PSB01M	Cap Screw M6-1.0 x 16 mm
67	P1003367	Retaining Ring

XXVIII. PARTS DIAGRAM, APRON



XXIX. PARTS DIAGRAM, BED

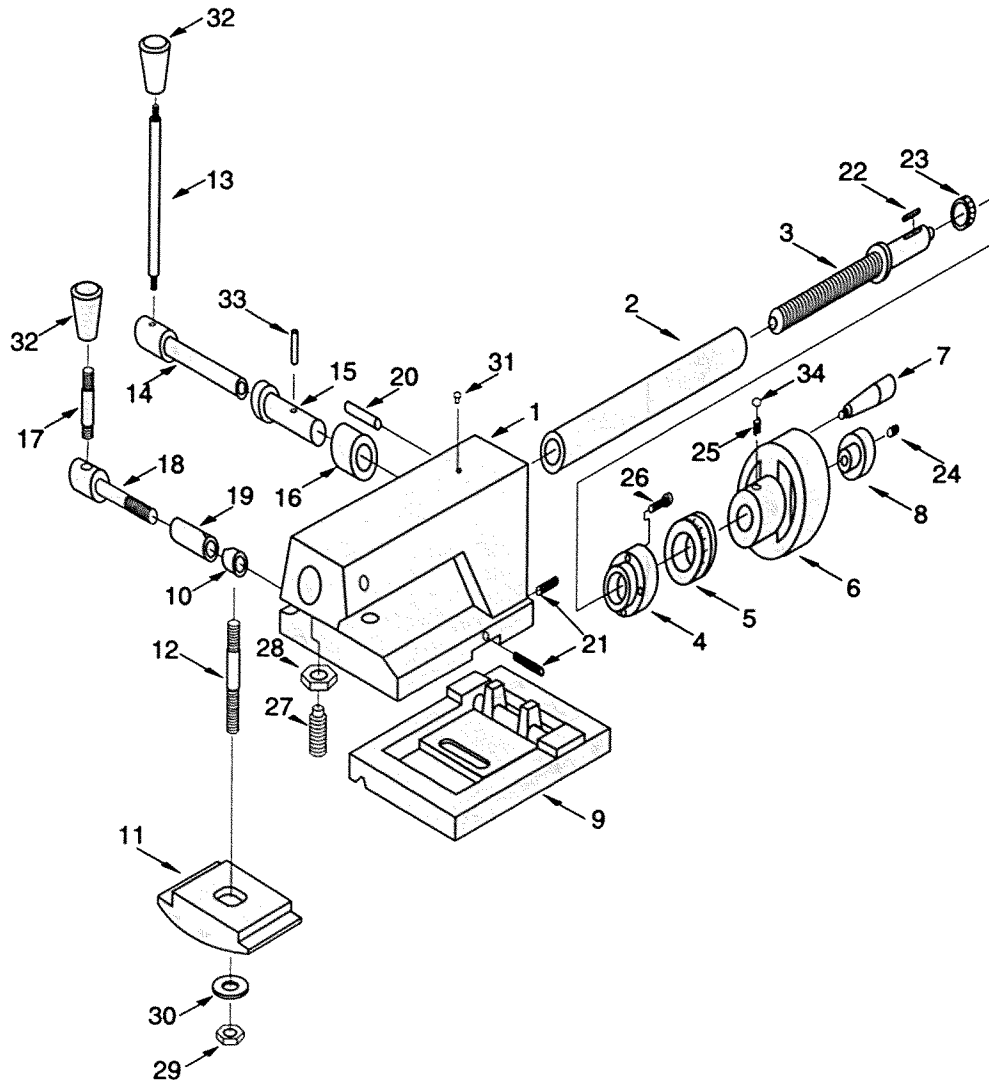


XXX. PARTS LIST, BED

Ref. No.	Part No.	Description
1	P1002501	Bed (Model G1002)
1	P1003501	Bed (Model G1003)
2	P1002502	Rack (Model G1002)
2	P1003502	Rack (Model G1003)
3	P1002503	Lead Screw (Model G1002)
3	P1003503	Lead Screw (Model G1003)
4	P1002504	Feed Rod (Model G1002)
4	P1003504	Feed Rod (Model G1003)
5	P1003505	End Bracket
6	P1002506	Chip Pan (Model G1002)
6	P1003506	Chip Pan (Model G1003)
7	G1184	Stand (Model G1002)
7	G1185	Stand (Model G1003)

Ref. No.	Part No.	Description
12	P1003512	Top Motor Plate
13	P1003513	Bottom Motor Plate
15	PSB05M	Cap Screw M8-1.25 x 50 mm
16	P1003117	Oil Cap
18	PSB44M	Cap Screw M10-1.25 x 28 mm
19	P5003519	Special Hex Bolt
21	P5003521	Shaft Retainer
22	PSB33M	Cap Screw M5-0.8 x 12 mm
23	PSB02M	Cap Screw M6-1.0 x 20 mm
24	PRP34M	Roll Pin 6 x 55 mm
25	PRP07M	Roll Pin 6 x 20 mm

XXXI. PARTS DIAGRAM, TAILSTOCK

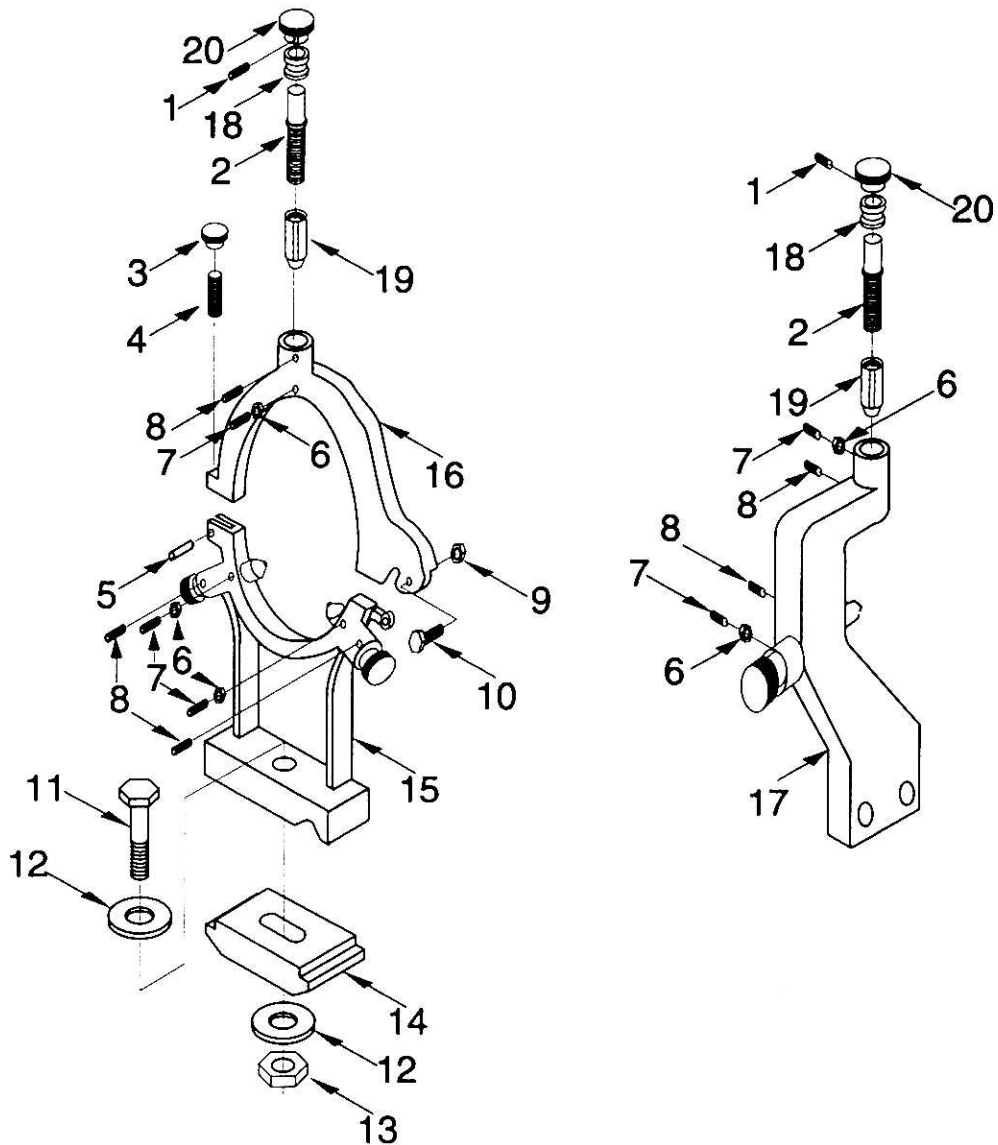


XXXII. PARTS LIST, TAILSTOCK

Ref. No.	Part No.	Description
1	P1003401	Tailstock Casting
2	P1003402	Tailstock Spindle
3	P1003403	Lead Screw
4	P1003404	Lead Screw Bushing
5	P1003107	Dial
6	P1003406	Tailstock Handwheel
7	P1003407	Handle
8	P1003106	Spanner Nut
9	P1003409	Tailstock Base
10	P1003410	Short Clamp Bushing
11	P1003411	Tailstock Clamp
12	P1003412	Clamp Stud
13	P1003413	Clamp Handle Lever
14	P1003414	Clamp Shaft
15	P1003415	Eccentric Bushing
16	P1003416	Eccentric Sleeve
17	P1003417	Locking Lever
18	P1003418	Locking Handle

Ref. No.	Part No.	Description
19	P1003419	Long Clamp Bushing
20	P1003420	Lever Stud
21	PSS19	Setscrew $\frac{5}{16}$ " - 18 x $\frac{1}{4}$ "
22	PK17M	Key 5 x 5 x 9 mm
23	P1003423	Thrust Bearing
24	PSS15M	Setscrew M12-1.75x12mm
25	P1003124	Spring
26	PSB02M	Cap Screw M6-1.0x20 mm
27	P1003427	Special Setscrew M8-1.25x20mm
28	PN03M	Hex Nut M8 - 1.25
29	PN09M	Hex Nut M12 - 1.75
30	P1003430	Special Washer
31	P1003117	Oil Cap
32	P1003050	Knob
33	P1003433	Roll Pin
34	P1003125	Ball

XXXIII. TOOL REST PARTS DIAGRAMS



XXXIV. TOOL REST PARTS LIST

Ref. No.	Part No.	Description
1	PSS02M	Setscrew M6-1.0 x 6 mm
2	P1003902	Adjustment Screw
3	P1003903	Knob
4	P1003904	Stud
5	PRP06M	Roll Pin 5 x 24 mm
6	PN01M	Hex Nut M6 x 1.0
7	P1003907	Special Setscrew
8	PSS02M	Setscrew M6-1.0 x 6 mm
9	PN01M	Hex Nut M6 - 1.0
10	PB29M	Hex Bolt M6 - 1.0 x 30mm

Ref. No.	Part No.	Description
11	PB27	Hex Bolt 1/2" - 13 x 2 1/2"
12	PW01	Flat Washer 1/2"
13	PN13	Hex Nut 1/2" - 13
14	P1003411	Clamp
15	P1003915	Lower Rest Casting
16	P1003916	Upper Rest Casting
17	P1003124	Follow Rest Castng
18	P1003918	Bushing
19	P1003919	Mounted Brass Bearing
20	P1003920	Knob