Grizzly Industrial, Inc.®

# 18" & 20"
# SUPER HEAVY-DUTY BANDSAWS
## MODELS G0506/G0507/G0511
# INSTRUCTION MANUAL


Model G0506


Model G0507/G0511

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REVISED DECEMBER, 2003 PRINTED IN TAIWAN

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# 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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# Table Of Contents



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# SECTION 1: SAFETY

## ⚠WARNING

## For Your Own Safety Read Instruction Manual Before Operating This Equipment

**The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are 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.**

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

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

**⚠CAUTION** **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 equipment.**

## ⚠WARNING
## Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.



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# ⚠WARNING
# Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

| | LENGTH | | |
|---|---|---|---|
| AMP RATING | 25ft | 50ft | 100ft |
| 0-6 | 18 | 16 | 16 |
| 7-10 | 18 | 16 | 14 |
| 11-12 | 16 | 16 | 14 |
| 13-16 | 14 | 12 | 12 |
| 17-20 | 12 | 12 | 10 |
| 21-30 | 10 | 10 | No |

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.

13. **DO NOT OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **MANY WOODWORKING TOOLS CAN "KICKBACK" THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create "kickback" and know how to avoid them. Read the manual accompanying the machine thoroughly.

18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

20. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

21. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.



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# ⚠WARNING

# Additional Safety Instructions For Bandsaws

1. **DO NOT OPERATE WITH DULL OR BADLY WORN BLADES.** Dull blades require more effort to use and are difficult to control. Inspect blades before each use.

2. **NEVER POSITION FINGERS OR THUMBS IN LINE WITH THE CUT.** Serious personal injury could occur.

3. **DO NOT OPERATE THIS BANDSAW WITHOUT WHEEL, PULLEY, AND BLADE GUARDS IN PLACE.**

4. **WHEN REPLACING BLADES,** make sure teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned after installing.

5. **WORKPIECE SHOULD ALWAYS BE FULLY SUPPORTED** by the table or some type of support fixture. Always support round stock in a V-block.

6. **DO NOT BACK WORKPIECE AWAY** from the blade while the saw is running. Plan your cuts so you always cut out of the wood. If you need to back the work out, turn the bandsaw off or use the foot brake and wait for the blade to come to a complete stop. Do not twist or put excessive stress on the blade while backing work away. Inspect blade for damage such as kinks before continuing to use it. Discard it if necessary.

7. **BLADE SHOULD BE RUNNING AT FULL SPEED** before beginning a cut.

8. **ALWAYS FEED STOCK EVENLY AND SMOOTHLY.** Do not force or twist blade while cutting, especially when sawing small radii.

9. **THIS MACHINE IS NOT DESIGNED TO CUT METAL** or other material except wood.

10. **DO NOT MANUALLY STOP OR SLOW BLADE** except with the foot brake. Allow it to come to a complete stop before you leave it unattended.

11. **ALL INSPECTIONS, ADJUSTMENTS, AND MAINTENANCE ARE TO BE DONE WITH THE POWER OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.

12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.

13. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

## ⚠WARNING

**To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your bandsaw will be time well spent. DO NOT operate this machine until you are completely familiar with the contents of this manual or 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.**



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# SECTION 2: INTRODUCTION

## Commentary

Grizzly Industrial, Inc. is proud to offer the 18" and 20" Super Heavy-Duty Bandsaws. These bandsaws are a part of Grizzly's growing family of fine woodworking machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

The chart below has been provided to help identify the differences between the 18" and 20" Super Heavy-Duty Bandsaws.

We are also pleased to provide this manual with the 18" and 20" Super Heavy-Duty Bandsaw. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any comments or criticisms that you feel we should address in our next printing, please write to us at:

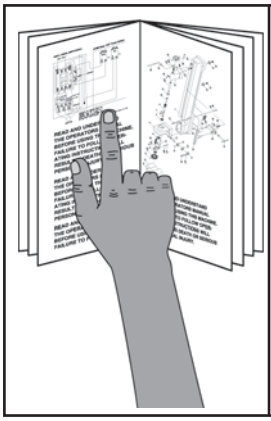
Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

Most important, we stand behind our machines. We have excellent regional service departments at your disposal should the need arise.

If you have any service questions or parts requests, please call or write to 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
Web Site: http://www.grizzly.com

The specifications, drawings, and photographs illustrated in this manual represent the 18" and 20" Super Heavy-Duty Bandsaw as supplied 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. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.



**⚠WARNING**

**Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.**

| Description | G0506 | G0507 | G0511 |
|---|---|---|---|
| **Motor** | 2 HP | 3 HP | 5 HP |
| **Phase** | 1-Phase | 1-Phase | 3-Phase |
| **Size** | 18" | 20" | 20" |



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# SECTION 3: CIRCUIT REQUIREMENTS

## Model G0506/G0507

The Model G0506/G0507 Bandsaw is pre-wired for single-phase, 220V operation. Under normal use, the Model G0506 2 HP motor draws approximately 12 amps. We recommend a 15 amp circuit. This includes a 15 amp circuit breaker, plug, receptacle and wiring rated for at least 15 amps. Under normal use, the Model G0507 3 HP motor draws approximately 22 amps. We recommend a 25 amp circuit. This includes a 25 amp circuit breaker, plug and wiring rated for at least 25 amps. These circuits should be satisfactory for normal use, while providing enough protection against damage caused by an overloaded circuit. If frequent circuit failures occur when using the bandsaw, contact our service department or your local electrical contractor.

This bandsaw must be connected to its own dedicated circuit; it should not share a circuit with any other machine. A standard 2-pole breaker is necessary for use with the Model G0506/G0507.

This bandsaw is not supplied with a cord and power plug. We recommend using a NEMA-style L6-25 plug and outlet similar to **Figure 1.** You may also “hard-wire” the bandsaw directly to your panel, provided you place a disconnect switch near the machine. Check the electrical codes in your area for specifics on wiring requirements.

Please refer to the wiring diagram on **page 30** for power hook-up information.

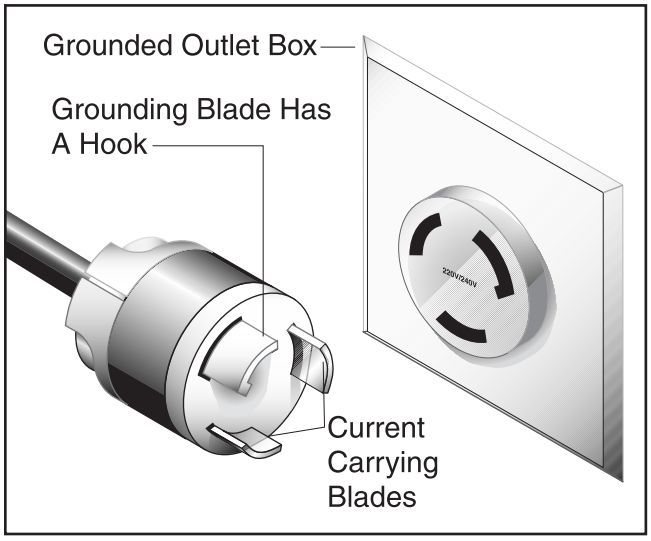


**Figure 1.** Typical 220V 3-prong plug and outlet.

**⚠ CAUTION**

**Be sure that your particular electrical configuration complies with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician.**



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# Model G0511

The Model G0511 Bandsaw is pre-wired for 3-phase, 220V operation. Under normal use, the 5 HP motor draws approximately 13 amps. We recommend using a 15 amp circuit, including a 15 amp circuit breaker, plug, receptacle and wiring rated for at least 15 amps. If frequent circuit breaker failures occur when using the bandsaw, contact our service department.

This bandsaw must be connected to its own dedicated circuit. It should not share a circuit with any other machine. A standard 3-pole breaker is necessary for use with the Model G0511.

This bandsaw is not supplied with a cord and power plug. We recommend using a NEMA-style L15-20 plug and outlet, similar to **Figure 2**. You may also "hard-wire" the bandsaw directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

Please refer to the wiring diagram on **page 31** for power hook-up information.

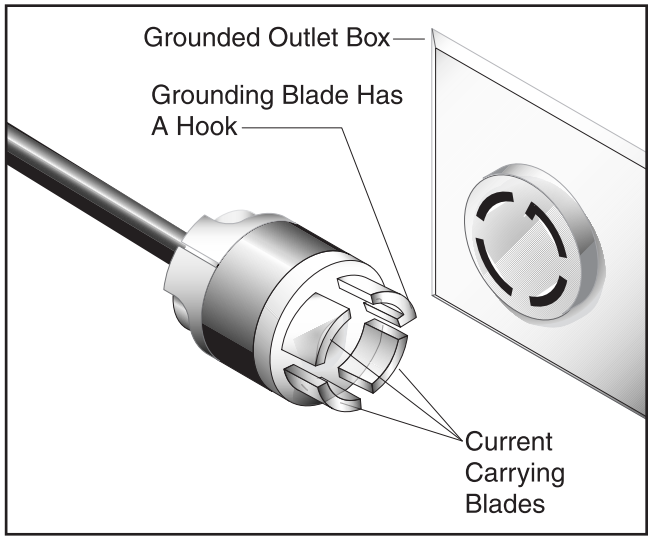


**Figure 2.** Typical plug configuration for 220V, three-phase operation.

# 440V Operation

The Model G0511 Bandsaw is furnished with a 3 HP 3-phase motor that can be wired to 440V. Under normal use, this motor draws approximately 6.5 amps at 440V. If 440V operation is desired, we recommend using a 10 amp circuit that includes the appropriate wiring, plug and circuit breaker. If frequent circuit failures occur when using the bandsaw, contact our service department.

The bandsaw must be connected to its own dedicated 10A circuit. It should not share a circuit with any other machine. A standard 3-pole breaker is necessary for 440V use.

We recommend using a NEMA-style L16-20 plug and outlet similar to that in **Figure 3.** You may also "hard-wire" the bandsaw directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

**If you convert the bandsaw to 440V, the stock magnetic switch must be replaced with a different magnetic switch specifically for 440V use. The 440 magnetic switch is not included with your bandsaw.**

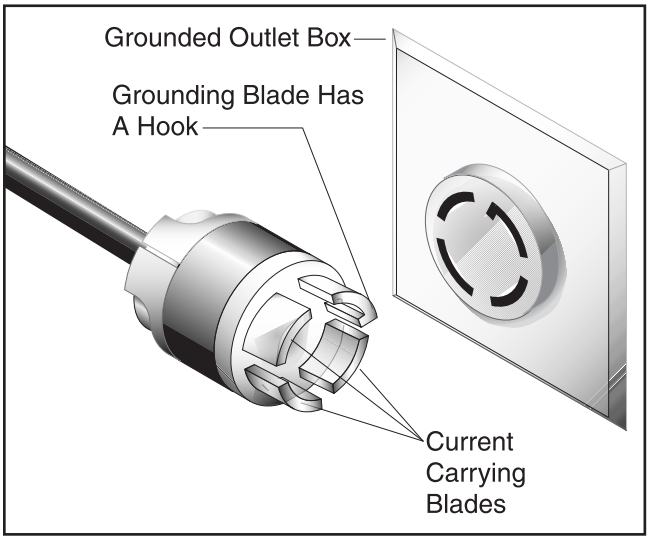


**Figure 3.** Typical plug configuration for 440V, 3-phase operation.



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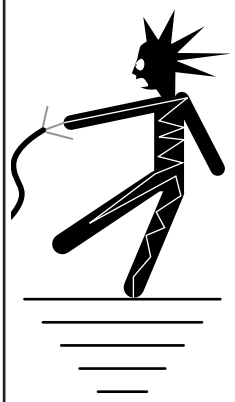
# Grounding

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is not supplied with an electric cord. A cord with a plug with a grounding pin must be wired into the junction box on the back of the machine. Also needed is a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.



**⚠WARNING**

**This equipment must be grounded. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. Under no circumstances should the grounding pin from any three-pronged plug be removed. Serious injury may occur.**

Under no circumstances should the grounding blade from any plug be removed. If it will not fit the outlet, have the proper outlet installed by a qualified electrician. Repair or replace damaged or worn cords immediately.

Check with a qualified electrician or one of our service personnel if the grounding instructions are not completely understood, or if you are in doubt as to whether the tool is properly grounded. Use only extension cords that have grounding type plugs and receptacles that accept the plug on the machine.

# Extension Cords

We do not recommend the use of extension cords on 220V or 440V equipment. It is much better to arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords. Should it be necessary to use an extension, make sure the cord is rated Hard Service (Grade S) or better. Refer to the chart on **page 3** to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords when they become worn or damaged.

**⚠CAUTION**

**We have covered some basic electrical requirements for the safe operation of your bandsaw. These requirements are not necessarily comprehensive. You must be sure that your particular electrical configuration complies with local and state codes. Ensure compliance by checking with your local municipality or a licensed electrician.**



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# SECTION 4: CONTROLS AND COMPONENTS

## Identification

The 18" and 20" Super Heavy-Duty Bandsaw controls and components are frequently referred to in this section. Please take the time to identify the following controls. Their locations are shown in **Figures 4 and 5**:

**1.** Electrical Junction Box

**2.** Guide Post Handwheel

**3.** Blade Guard

**4.** Guide Post Lock Knob

**5.** Blade Tracking Handknob

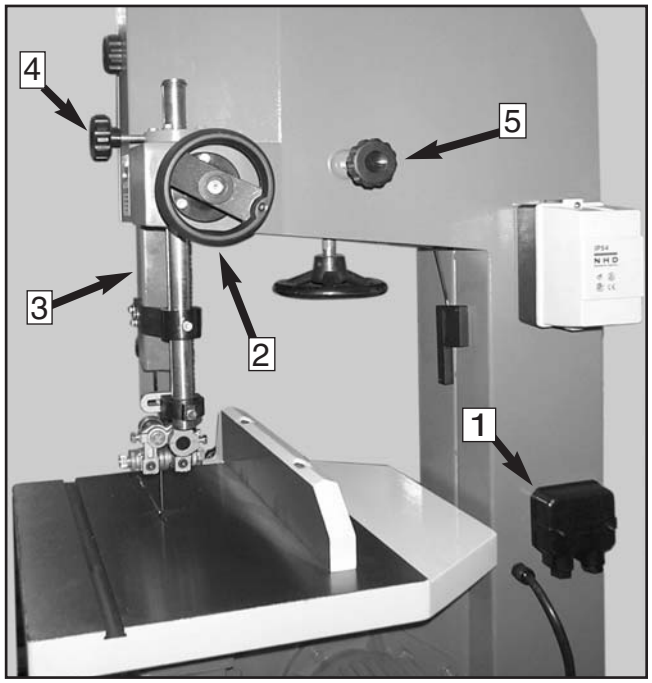


**Figure 4.** Rear view of bandsaw.

**6.** Upper Blade Guide Assembly

**7.** Fence

**8.** Control Panel

**9.** Blade Tension Handwheel

**10.** Emergency Stop

**11.** Blade Tensioning Scale

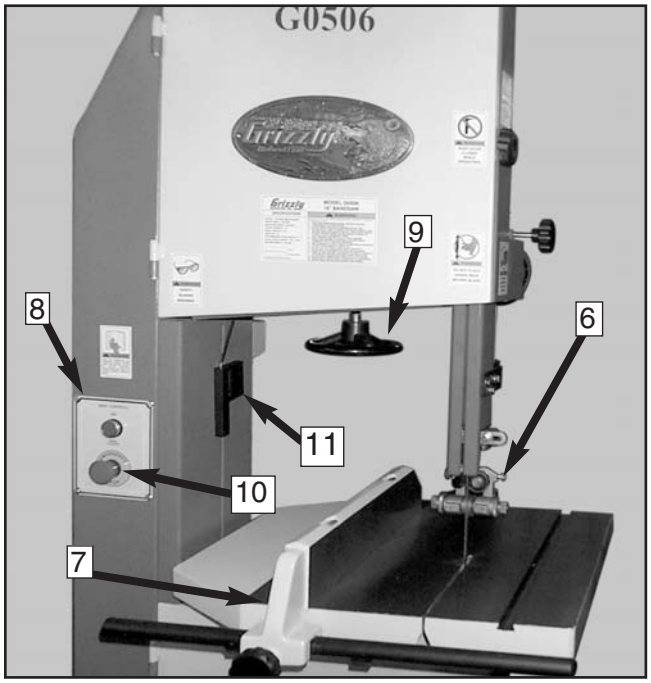


**Figure 5.** Front view of bandsaw.



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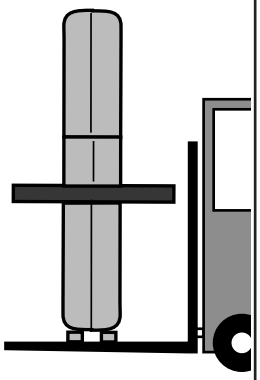
# SECTION 5: SET UP

## Unpacking

The 18" and 20" Super Heavy-Duty Bandsaws are shipped from the manufacturer in a carefully packed crate. If you discover the machine is damaged after you have signed for delivery, *please call Customer Service immediately 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, you should inventory its parts.



**⚠WARNING**

**The 18" and 20" Super Heavy-Duty Bandsaws are heavy machines. DO NOT over-exert yourself while unpacking or moving your machine – you will need assistance and power equipment. Serious personal injury may occur if safe moving methods are not followed.**

**⚠CAUTION**

**Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.**

## Piece Inventory

After all the parts have been removed from the carton, you should have:

- Bandsaw Unit with Blade
- Table and Fence Rail
- Fence
- Dust Port
- Miter Gauge
- Hardware Bag
  - (4) Phillip Head Screws
  - (4) Hex Bolts
  - (4) Flat Washers

In the event that any non-proprietary parts are missing (e.g. nuts or washers), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



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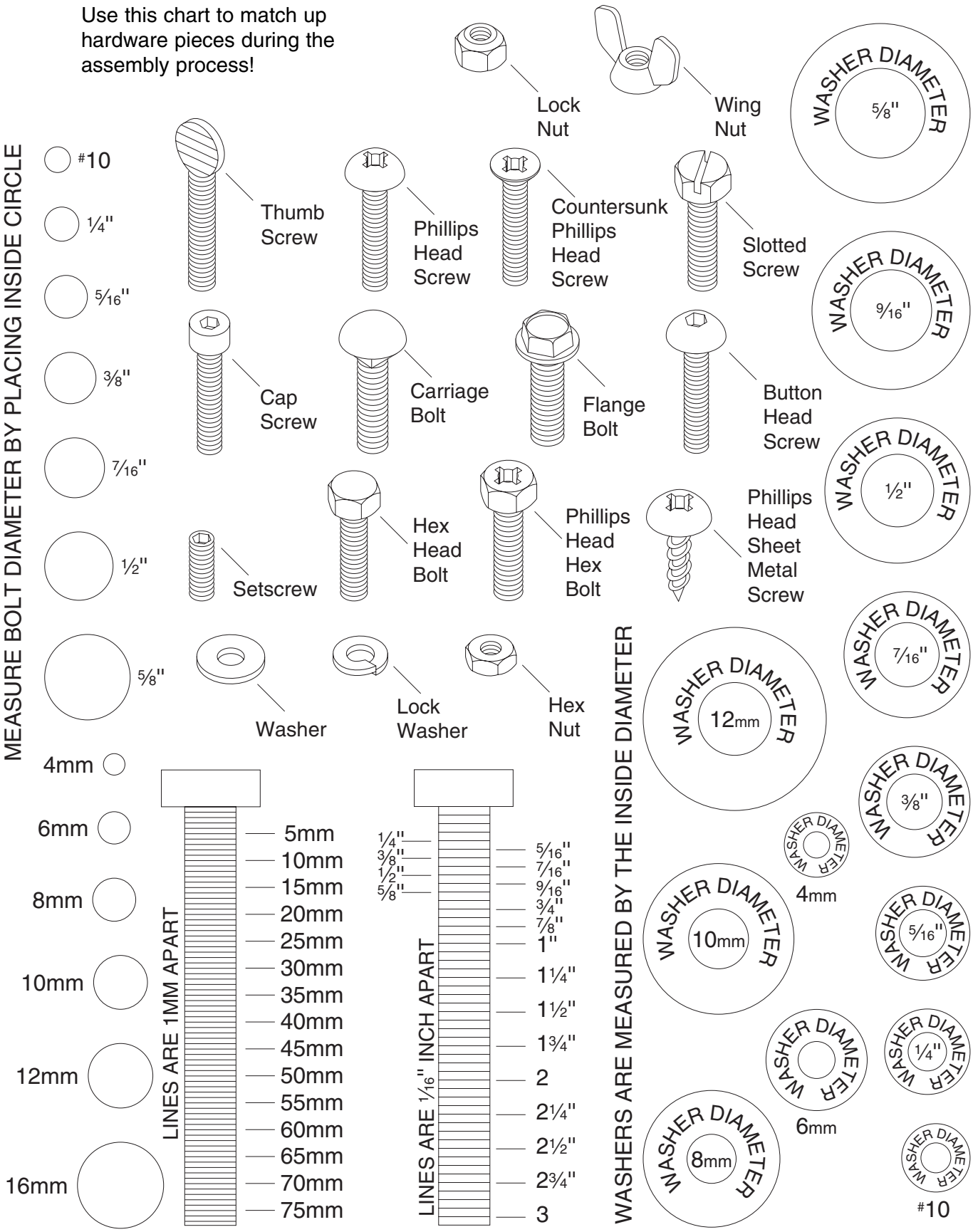
# Hardware Chart

Use this chart to match up hardware pieces during the assembly process!



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# Clean Up

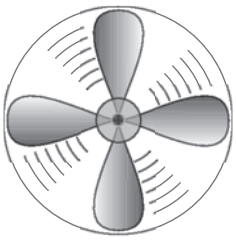
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

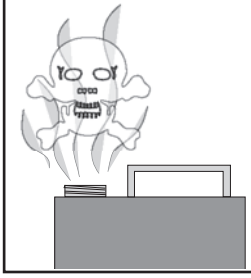

**⚠WARNING**

**Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used.**

**⚠WARNING**

**Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.**





**⚠CAUTION**

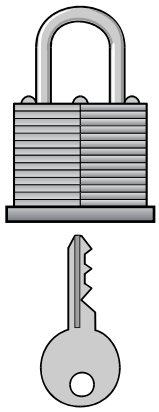
**Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.**

# Site Considerations

1. **Floor Load:** The 18" and 20" Super Heavy-Duty Bandsaws represent a large weight load in a small footprint. Most commercial floors are suitable for your machine. Some residential floors may require additional reinforcement to support both machine and operator.

2. **Working Clearances:** 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 bandsaw.

3. **Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.



**⚠CAUTION**

**Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting, or operating equipment.**



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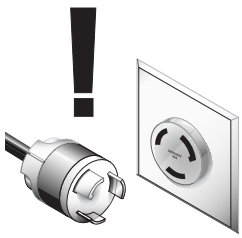

**⚠WARNING**

**DO NOT connect power to the bandsaw until instructed to do so. Failure to do this may result in serious personal injury.**

# Table

**⚠CAUTION**

**The table for this bandsaw is very heavy. Get help when placing it on the trunnion.**

**To mount the table:**

1. Installing the table is easiest if the blade is out of the way. Remove the blade by first loosening the blade tension handwheel, move the blade guide bearings (refer to the section titled **Blade Changes** on page 25) then by sliding it off the bandsaw wheels. Wear heavy leather gloves to protect your hands.

2. With the help of another person, lift the table onto the trunnion.

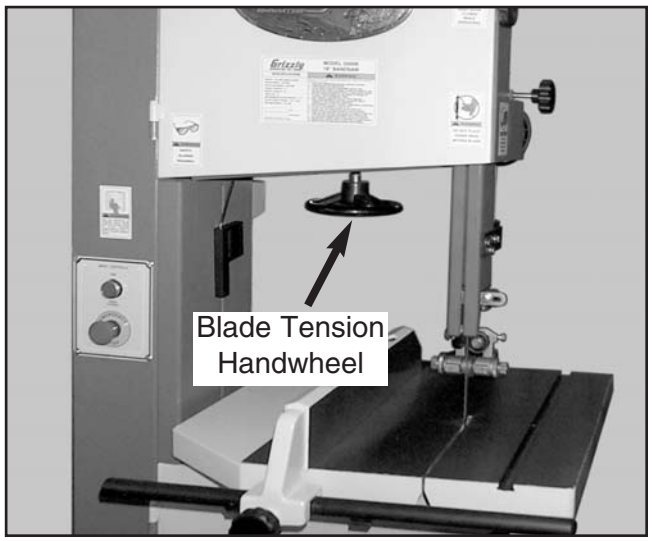


**Figure 6.** Table installed correctly.

3. Place the large hex bolt with washer through the table trunnion mount and the trunnion. The assembly should now look similar to **Figure 6**.

# Fence

**To mount the fence:**

1. Loosen the lock knob and slide the fence onto the rail.

2. Slide the fence beyond the center of the table so the blade can be installed without blocking the fence as shown in **Figure 7**.

**Figure 7.** Fence mounted on rail.

3. Please refer to the section titled **Blade Changes** on page 25 to install the blade.

4. Tension the blade enough to keep it on the saw so it does not spring off during the rest of the assembly process.



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# Dust Port

**To install the dust port:**

1. Place the dust port on the saw as shown in **Figure 8**.

2. Secure it with the included Phillips head screws.

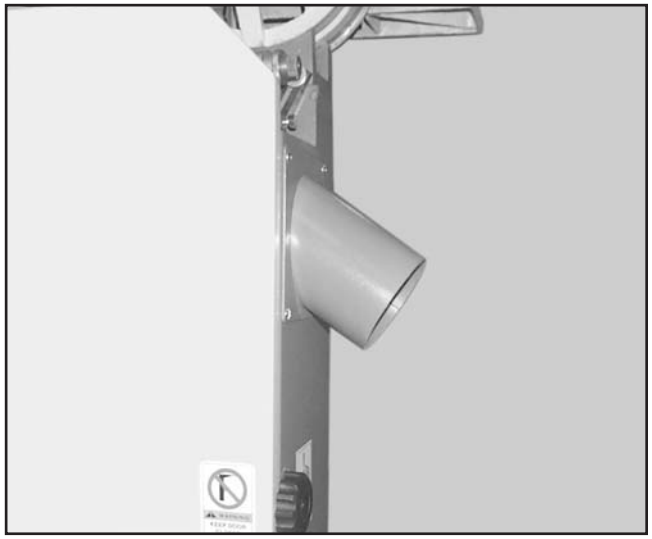

**Figure 8.** Dust port installed.

# Guide Post

The rack and pinion guide post can be easily raised and lowered.

**To adjust the guide post:**

1. Loosen the guide post lock knob indicated by the arrow in **Figure 9**.

2. Turn the guide post handwheel.

3. Tighten the lock knob.

Because the blade guard and the entire upper blade guide assembly are attached to the guide post, these items move up or down with the guide post.


**Figure 9.** Guide post lock knob.



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# Blade Guard

The blade guard can be adjusted along the support rod to help facilitate adjustments made to the blade guide assembly. **The blade guard must be adjusted to the lowest position on the support rod before starting the machine.**

**To move the blade guard:**

1. Loosen the hex bolt shown in **Figure 9** that secures the blade guard bracket to the guide post.

2. Move the blade guard up prior to making adjustments to the guide bearing assembly, or **down, prior to using the machine.**

3. Align the slot in the front of the guard with the blade and tighten the hex bolt that secures the it to the guide post.

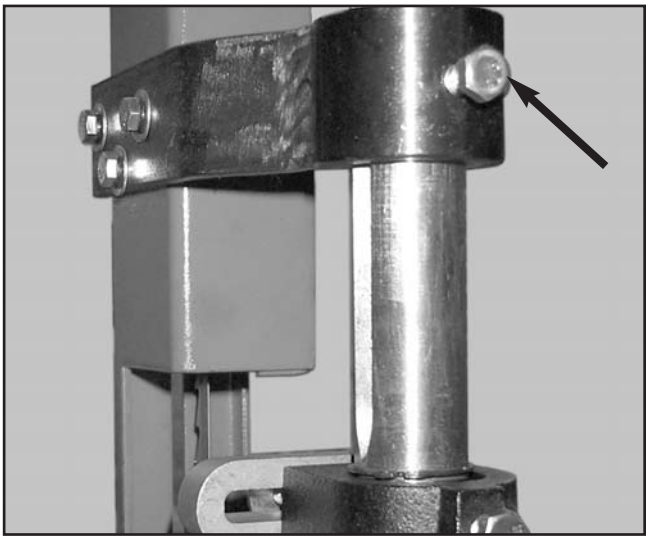

**Figure 10.** Blade guard mounting bracket.

# Blade Guides

Always adjust the upper and lower blade guides away from the blade before removing, installing or tracking a new blade.

**To adjust the blade guides:**

1. Loosen the 4 knurled jam nuts (the upper guide assembly is shown in **Figure 11**) that lock the adjusting knob for the guide bearings in place.

2. Rotate the knurled adjuster knob counterclockwise.

3. Loosen the hex bolt for the back bearing and slide it back. This will allow the blade to be removed or tracked without interference.

4. After the blade tension and the blade tracking are set correctly, follow the “Guide Bearing” and “Support Bearing” instructions in this section for adjustment details.

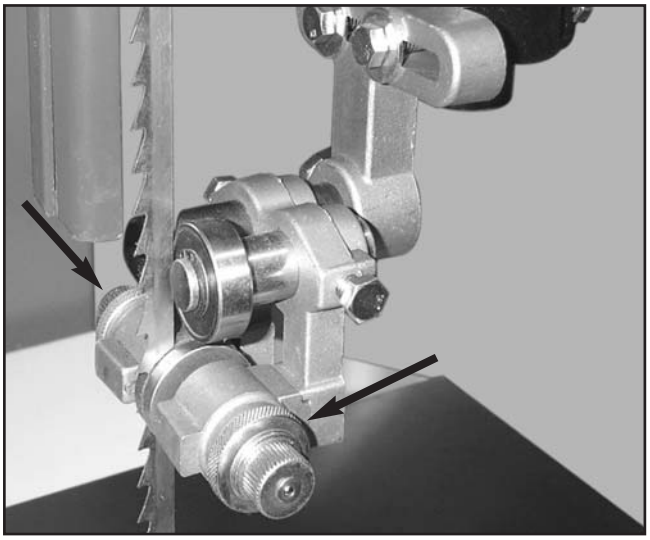

**Figure 11.** Loosen the jam nuts on both sides of the guide block assembly to release the blade guide adjusting knobs.



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# Blade Tracking

Always adjust the blade guides away from the blade before making blade tracking adjustments.

The wheels on the Model G0506/G0507/G0511 Super Heavy-Duty Bandsaws are crowned and have rubber tires. This style requires center blade tracking for proper operation.

**To adjust blade tracking:**

1. Open the upper wheel cover door. Slowly rotate the upper wheel and watch where the blade rides on the wheel. If the blade stays centered on the crown of the wheel, then it is properly tracked.

2. If the blade does not ride centered on the crown of the wheel, then spin the upper wheel by hand and adjust the tracking hand-knob shown in **Figure 12**, until the blade is positioned correctly.

3. Spin the wheel approximately three more times to ensure that the blade stays centered. Adjust and check if necessary.

4. Close the upper wheel cover door.

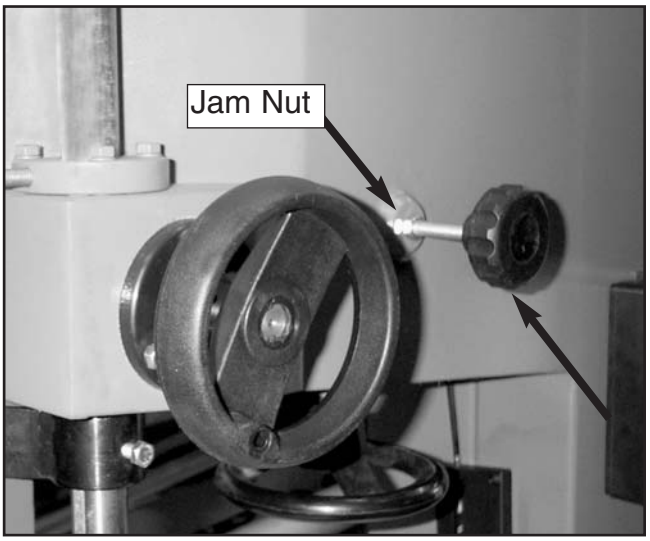


**Figure 12.** Loosen the jam nut. Turning this handwheel clockwise will move the blade further into the saw body.

# Gullet Line

Before further adjustments can be made to the guide assembly, the guide bearings must be set even with the “gullet line.” This is the inside edge of the gullets for the bandsaw teeth.

**To adjust blade guides to the gullet line:**

**Figure 13** shows the edge of the guide bearings set even with the gullet line. A white line (**A**) has been superimposed to the photo and the blade guard has been moved for clarity.

1. Loosen the hex bolt on the right side of the guide assembly (**B**).

2. Move the assembly in or out until the edge of the guide roller is even with the gullet. If the back bearing interferes with this, loosen the lock bolt (**C**) and slide it back.

3. Tighten the bolt for the guide assembly.

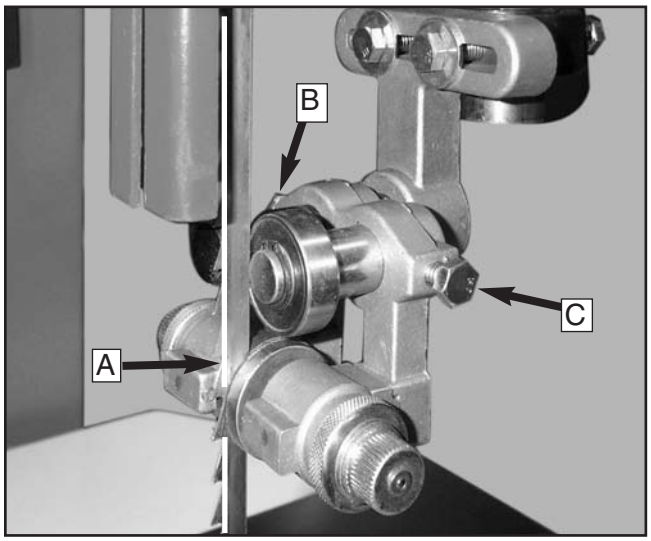


**Figure 13.** Adjust the guide assembly so the guide bearings are even with the “gullet line.”



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# Support Bearings

The support bearings support the back of the blade during the sawing operation. The adjustments that can be made to the support bearings are lateral placement and backing placement. Make sure the guide bearings are adjusted away from the blade before making this adjustment. **Figure 14** shows the upper support bearings. **Figure 15** shows the lower assembly. When making adjustments to the lower bearing the assembly will move up and down as it moves from side-to-side.

**To adjust the lateral placement:**

1. Loosen the hex bolts (shown in **Figures 14 & 15**) that allow the assembly to move side-to-side.

2. Shift the entire assembly so the blade intersects the face of the bearing by at least ⅛".

3. Tighten the hex bolts.

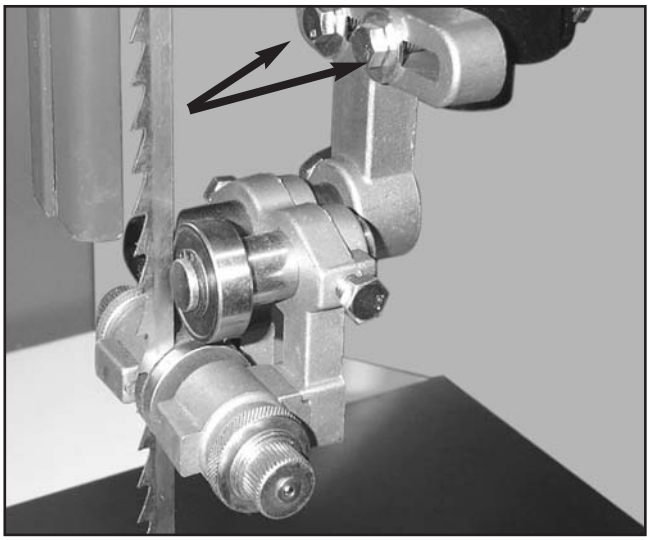

**Figure 14.** Loosen these bolts to adjust upper bearing assembly laterally.

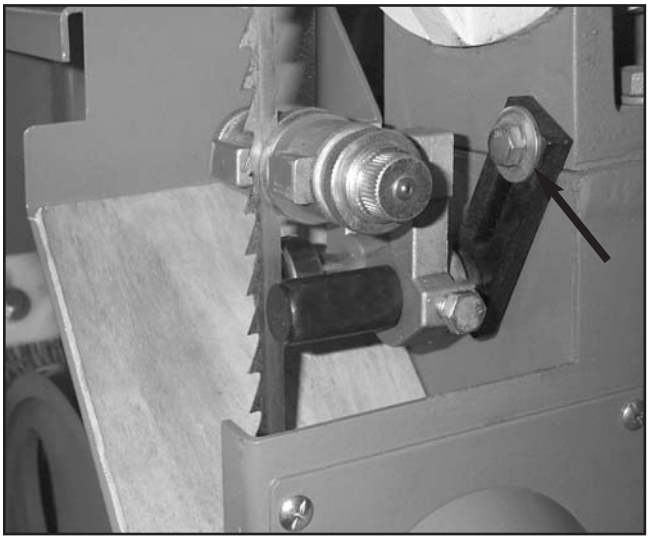

**Figure 15.** Loosen this bolt to adjust lower bearing assembly laterally.

**To adjust the backing placement:**

1. Loosen the hex bolt that secures the support bearing shaft in place.

2. Adjust the support bearing shaft so it just touches the back of the blade as in **Figure 16**.

3. Tighten the hex bolt.

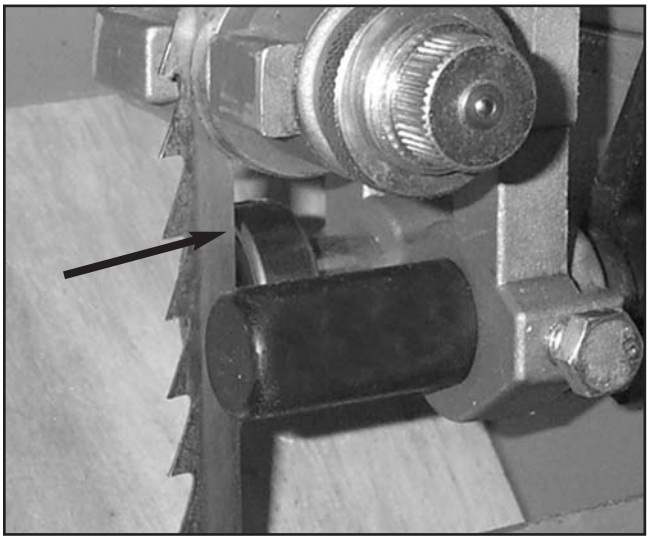

**Figure 16.** Back bearing just touches the back of the blade.



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# Guide Bearings

The guide bearings ensure that the blade cannot twist during operation. Perform the steps below for both upper and lower guide bearings.

**To adjust the guide bearings:**

1. Carefully tighten the guide adjustment knobs until the guide bearings just touch the blade on each side as in **Figure 17**. Do not deflect the blade while making this adjustment and do not over-tighten!

2. Tighten each of the jam nuts.

Ideally, the guide bearings should have 1 or 2 thousandths (0.001-2") clearance from the blade and should not pinch the blade. The blade could become hot and deformed if excessive pressure is applied by the guide bearings. The system employed by this bearing assembly will give clearance for the blade when the jam nuts are tightened. Make sure the jam nuts are tight before starting the machine.

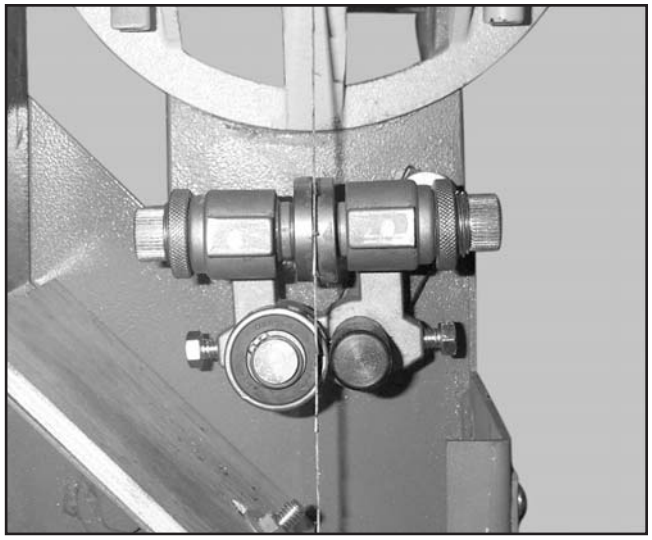

**Figure 17.** Guide bearings properly adjusted.

# Table Tilt

**To tilt the table:**

1. Loosen the large hex bolt under the table and in the center of the table trunnion as shown in **Figure 18**.

2. Tilt the table to the desired angle. Use the angle gauge for easy reference.

3. Tighten the large hex bolt in the center of the table trunnion.

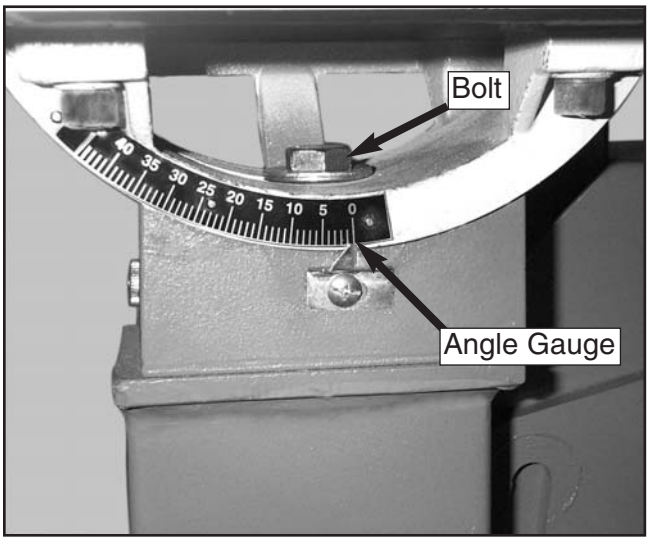


**Figure 18.** Loosen the bolt to tilt the table.



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# Table Stop

The positive stop under the table (**see Figure 19**) allows you to repeatedly square up the table after adjusting the table to another angle.

**To adjust the positive stop:**

1. Loosen the large hex bolt in the center of the table trunnion as described in the "Table Tilt" instructions.

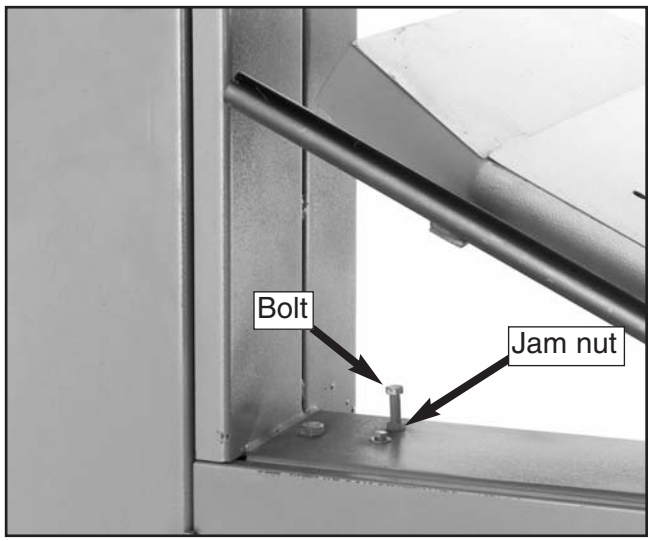


**Figure 19.** Positive stop and jam nut.

2. Loosen the jam nut on the positive stop bolt shown in **Figure 19**.

3. Raise the upper blade guide assembly and place a 6" machinist's square on the table against the blade as shown in **Figure 20.** Notice how far out of square your table is and approximate this distance by adjusting the positive stop up or down. Turning the positive stop counterclockwise will raise it and clockwise will lower it. Adjust the positive stop so the table will stop at a 90° angle (square) to the blade.

4. Lock the positive stop by tightening the jam nut. Do not let the stop turn while tightening the jam nut. Tighten the large hex bolt in the center of the table trunnion.

5. Set the angle pointer to zero on the table tilt gauge.

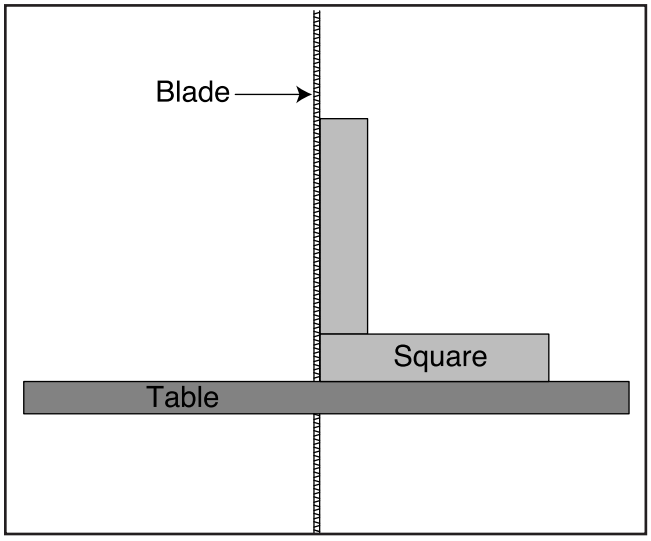


**Figure 20.** Squaring table to blade.



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# Foot Brake

The Model G0506/G0507 and G0511 is supplied with a foot brake. When used, power to the motor is disconnected and as pressure is applied to the pedal, friction forces the blade wheels to come to a halt.

**⚠CAUTION**

**The foot brake will not stop the bandsaw wheels and blade instantly. DO NOT become over confident and relax your safety awareness because of the foot brake feature.**

**Figure 21.** The foot brake is located below the dust collection port.

# Test Run

**⚠WARNING**

**The rest of the adjustments in this section require you to start the bandsaw. Before starting the bandsaw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning may result in serious personal injury or even death!**

**⚠WARNING**

**Wear safety glasses while testing this machine. Failure to comply may result in serious personal injury.**

**⚠WARNING**

**Read through this entire manual to become familiar with the controls and the operations of the bandsaw before turning it on.**

Turn on the power supply at the main panel and/or plug in the bandsaw. Push the *START* button to turn on the bandsaw. Make sure that your hand is poised over the switch and your foot is situated so you can use the emergency foot brake in case there is a problem. The bandsaw should run smoothly with little or no vibration or rubbing noises. If strange or unnatural noises are immediately apparent, press the *STOP* button or the foot brake. Investigate and correct before operating the machine further.

If you cannot easily locate the source of an unusual noise or vibration, feel free to contact our service department for help.



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# Blade Tension

Proper blade tension is essential to any cutting operation on the bandsaw. Any time you change blades or remove a blade, you must re-adjust the tension.

**To adjust the tension:**

1. Adjust the upper and lower guide bearings so the guide bearings are away from the blade. Tighten the jam nut.

2. Lower the upper guide block assembly to the table and tighten.

3. With moderate tension already on the blade, turn the bandsaw *ON*.

4. If you see the blade start to flutter, increase the tension until the blade stops fluttering, then tighten the tension handle an additional half turn.

   If the blade does not flutter, decrease the tension until it begins to flutter, then tighten it to the point that it stops fluttering. Now tighten the tension handle an additional half turn.

5. Turn the bandsaw *OFF.* Double check the tracking and blade guides to make sure that they do not need to be adjusted after tensioning the blade. Reset the guide bearings and upper blade guide assembly for height.

   If the blade does not cut properly, the tension may be incorrect. Re-adjust the tension.

After setting the tension, make a note of what the tension gauge reads. See **Figure 22**. Use this to go back to your tension setting during later tensioning and retensioning with that particular blade.

Keep in mind that blades will last longer if you release the tension after every use. Also, new blades will often stretch with use, and not all blades will be exactly the same length. Use the blade tension gauge as a guide for individual blades.

**Figure 22.** Blade tension gauge.



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# Fence Adjustment

The fence slides along the rail for adjustment and can be secured in place by tightening the star knob located on the front of the fence.

If you notice that the fence is not parallel to the blade, adjustments can be made where the rail mounts to the bottom of the table.

**To adjust the fence so it is parallel with the blade:**

1. Get a 1" x 4" x 28" board. Joint one edge perfectly straight, or rip a narrow strip off the length of the board with a table saw.

2. On the face of the board, draw a straight line parallel to the jointed or ripped edge.

3. Slide the bandsaw fence out of the way and cut free-hand along the line. Stop at the halfway point. Turn the bandsaw *OFF*, press the foot brake and *wait for the blade to stop.*

4. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.

5. Loosen the two hex bolts that secure the fence rail to the underside of the table**.**

6. Skew the fence left or right so it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.

7. While maintaining the skew, tighten the rail mounting bolts.

8. Make a few cuts using the fence. If the fence still does not seem parallel to the blade, read the "Blade Lead" instructions, or repeat **steps 1-7** until the blade and fence are parallel with each other.

# Blade Lead

Sometimes the bandsaw blade will not cut straight even when the fence and blade are parallel (**see Figure 23**). This condition is called "lead." Lead occurs (1) if the blade tension is incorrect, (2) if the teeth are dull on one side, or (3) if the teeth are set heavier on one side of the blade than the other.

If you determine that your blade is causing lead problems, you should:

- Checking/adjusting the blade tension
- Replacing the blade
- Sharpening the blade
- Skewing the fence to match the lead
- Attaching an after market or shop made resaw fence attachment.

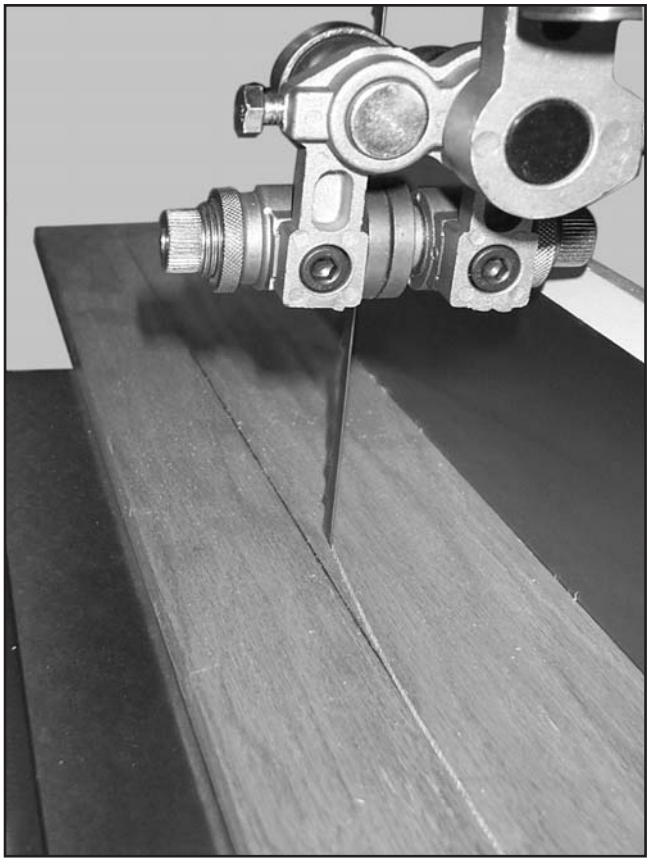

**Figure 23.** Typical example of blade leading away from line of cut.



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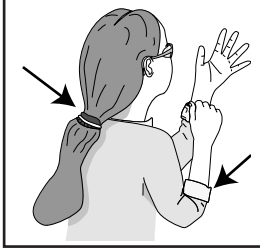
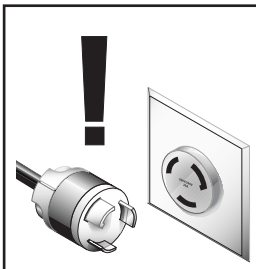
# SECTION 6: OPERATIONS



**⚠WARNING**

**Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.**

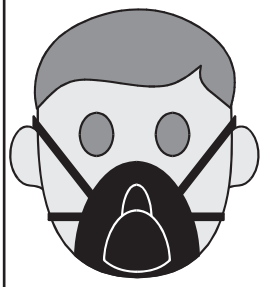


**⚠WARNING**

**Disconnect power to the machine when performing any maintenance or adjustments. Failure to do this may result in serious personal injury.**

**⚠WARNING**

**Wear safety glasses during the entire operation process. Failure to comply may result in serious personal injury.**



**⚠CAUTION**

**Using this machine produces sawdust which may cause allergic reactions and respiratory problems. Use an approved dust mask to protect yourself from dust hazards!**

**⚠CAUTION**

**WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your machine. The following section was designed to give instructions on the basic operations of this bandsaw. However, it is in no way comprehensive of every bandsaw application. There are many different jigs that can be built to increase safety, accuracy, and types of cuts.**

## Blade Selections

Selecting the right blade requires a combination of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

**Blade Length**

Measured by the circumference, blade lengths are usually unique to the model of your bandsaw and the wheel diameter. The Model G0506 is designed for blades that are 147⅝"-149⅝" long. The Model G0507/G0511 requires blades that are 160$^{13}/_{16}$"-162⅜" long.

**Blade Width**

Measured from the the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection.

A narrow blade can cut tight curves (a small radius) but is not very good at cutting straight lines, because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines and this makes them a natural choice for resaw applications

The 18" & 20" Super Heavy-Duty Bandsaws function best with blades that are ⅜" - 1" wide. Refer to the current Grizzly catalog for prices and ordering information. Always pick the size of blade that best suits your application.

**Tooth Style**

When selecting blades, another option to consider is the shape, gullet size and angle of the teeth—otherwise known as “Tooth Style.”



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**Figure 24** shows the three main categories of tooth style.

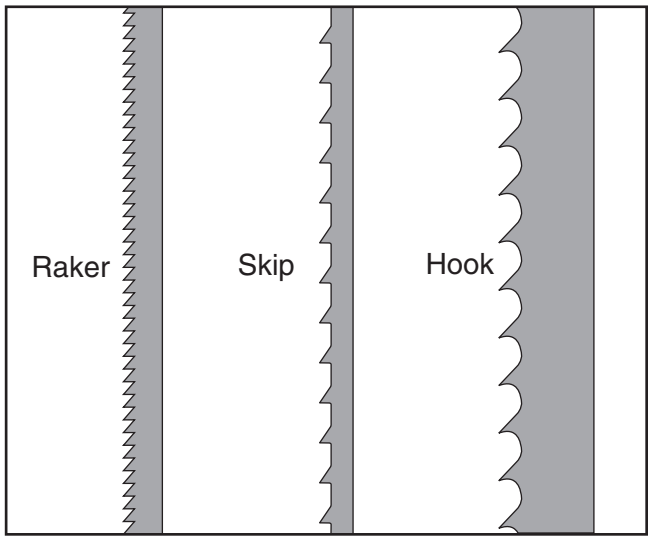


**Figure 24.** Raker, Skip and Hook blades.

- RAKER — This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on Raker blades are usually very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but at the same time do not cut fast and generate more heat while cutting.These blades also work well for cutting curves.

- SKIP — This style is like a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades. Great for super Heavy-Duty and ripping thin stock.

- HOOK — The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick stock.

**Tooth Pitch**

Usually measured as T.P.I. (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut faster, but rougher. As a general rule, choose blades that will have at least three, but not more than twelve teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

**Blade Care**

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. A dirty blade passes through the cutting material with much more resistance than a clean blade. This extra resistance will also cause unnecessary heat. Maintain your blades with a cutting blade lubricant like SLIPIT® (Model G5562/3 in the Grizzly Catalog).

**Blade Breakage**

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are: (1) faulty alignment or adjustment of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding too fast, (4) tooth dullness or absence of sufficient set, (5) excessive tension, (6) top blade guide assembly set too high above the work piece, (7) using a blade with a lumpy or improperly finished braze or weld and (8) running the bandsaw when not in use.



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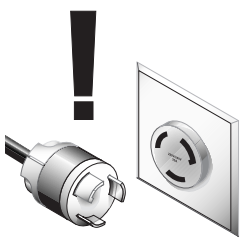
# Blade Changes



**⚠WARNING**

**Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.**

**To remove the blade:**

1. **Disconnect power to the bandsaw!**

2. Release the tension on the blade by turning the tension control knob counterclockwise.

3. Remove the upper guide assembly from the support bar by loosening the hex bolt shown in **Figure 25**.

4. Adjust the lower guide bearings away from the blade.

5. Put on leather gloves to protect your hands from the sharp teeth of the blade.

**Caution—the blades are sharp!**

6. Open the upper and lower wheel covers and slide the blade off both wheels.

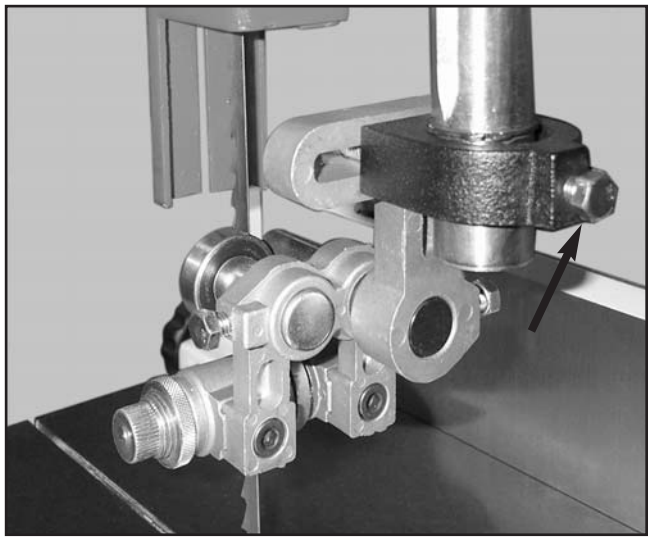


**Figure 25.** Loosen this bolt to remove assembly.

**⚠CAUTION**

**Wear gloves and safety goggles when handling blades. Coiled blades spring open as they are uncoiled and could cause deep cuts or lacerations.**

**To replace the blade:**

1. Put on leather gloves to protect your hands from the sharp teeth of the blade.

2. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table.

   If the teeth will not point downward on the right hand side, the blade is inside-out. Remove the blade, and twist it right side-out.

3. Slip the blade through the lower guides, and mount it over the upper and lower wheels so the blade is centered on the wheels.

4. Mount the upper guides by sliding the blade between the guide bearings and then guide the bearing bracket onto the guide post. Use care when aligning the guide assembly so that it does not twist the blade.

5. Apply tension, then check and adjust tracking as described in the section titled **Blade Tracking**.

6. Adjust the upper and lower guide blocks and support bearings.

7. Close and latch the wheel covers.



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# Ripping

Ripping is the process of cutting a wide board into two or more narrower boards. The maximum board width that can be ripped is limited by the maximum throat dimension of the bandsaw.

For ripping, a wider blade is better. In most ripping applications, a standard raker tooth style will be sufficient. Also, since most ripped lumber will be jointed smooth, you can choose blades with fewer teeth-per-inch.

**To perform ripping operations:**

1. The bandsaw must be adjusted correctly. See “Blade Tension/Tracking” instructions and “Fence Adjustment” instructions.

2. Adjust the blade guard so it is just above the workpiece with a minimum amount of blade exposed. Read instructions on “Blade Lead” before making a cut.

3. Use a fence to guide the work. Set the distance between the fence and the blade to the desired width.

4. Support the ends of the board if necessary.

5. Feed the work slowly and evenly with the straightest edge against the fence.

# Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

Before making stacked cuts, it is essential to ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece from the top to the bottom of the stack.

**To complete a stacked cut:**

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.

2. Secure all the pieces together using brad nails through the waste portion or using beads of hot glue across the outside edges.

3. Lay out the shape you intend to cut on the face of the top piece.

4. Adjust the blade guard so it is just above the workpiece with a minimum amount of the blade exposed. One inch is ideal.

5. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the blade.

6. Cut the stack of pieces as though you were cutting a single piece. Follow the layout line with the blade kerf on the waste side of your line.



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# Resawing

Resawing is the process of cutting the thickness of a board into two or more thinner boards. Each new board is the same width and length as the original board, but the thickness is less. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

The most important consideration when resawing is blade selection. When selecting a blade, keep in mind that generally a wider blade makes cutting a straight line easier.

In most applications a hook or skip tooth style will work best. Also, since most resawn lumber will be planed smooth, you can choose blades with fewer teeth per inch (3 to 6). While blades with fewer teeth per inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust, they produce less heat, and they yield more horsepower per tooth.

**To resaw lumber, follow the procedure below:**

**1.** The blade must be adjusted correctly for tension and tracking.

**2.** The fence must be parallel to the blade.

**3.** Adjust the upper blade guide so it is just above the workpiece with a minimum amount of blade exposed.

**4.** Use the widest blade that will fit your bandsaw. (Your saw has a 1" width capacity). The blade must also be sharp and in good condition. Read “Blade Lead” instructions.

**5.** Use the fence to guide the work.

**6.** Support the weight of the board with infeed and/or outfeed rollers, if necessary.

**7.** Feed the work slowly and evenly.

## ⚠WARNING

**Do not force the wood into the blade during cutting. This will distort the blade, cause excessive heat and often results in blade breakage. Breakage can cause abrasions, cuts, or serious personal injury.**

When resawing, consider using an auxiliary fence that is higher than the standard fence. This provides a more solid surface for the workpiece to slide against. An auxiliary fence can be made from any straight and flat piece of lumber and can be bolted or screwed to the standard fence.

When using a fence to guide the board, the actual line of cut may not be exactly parallel to the fence. This is due to a number of reasons involving the configuration of the table, condition of the blade, the cutting forces, and the blade tension. To correct this condition, refer to the “Blade Lead” instructions.



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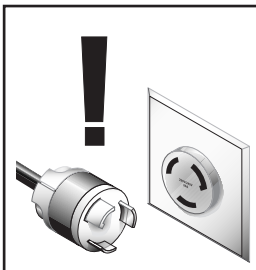
# SECTION 7: MAINTENANCE



**⚠WARNING**

**Always disconnect power to the machine when performing maintenance. Failure to do this may result in serious personal injury.**

## V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension. The belt should be checked for cracks, fraying and wear. Belt tension should be checked at least every 3 months; more often if the bandsaw is used daily.

**To adjust the V-belt:**

1. The V-belt is accessed via the bottom cover.
2. Squeeze the center of the V-belt.
3. Note the amount of deflection.
4. Deflection should be approximately ¾".
5. Loosen the bolts which secure the motor support bracket to the back of the bandsaw and pull the motor and bracket up.
6. Tighten the bolts and recheck the tension.
7. Make further adjustments if needed until the belt deflects ¾".

## Miscellaneous

Always be aware of the condition of your bandsaw. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts
- Worn switch
- Worn or damaged blade
- Worn or damaged support bearings or guide bearings

## Table

The table and other non-painted surfaces on the 18" and 20" Super Heavy-Duty Bandsaws should be protected against rust and pitting. Wiping the saw clean after every use ensures that wood dust is not allowed to trap moisture against bare metal surfaces.

**To keep table rust free:**

1. Use regular applications of products like SLIPIT®.
2. For long term storage consider using products like Boeshield® T-9. See the current Grizzly catalog for complete list of these products.



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# Lubrication

The sealed and pre-lubricated ball bearings on most of the moving parts of this bandsaw require no lubrication for the life of the bearings. These bearings are standard sizes, and replacements can be purchased from our parts department or a bearing supply store.

The guide bearings do require oil daily or after every 8 hours of use. They are supplied with a detent ball valve for an oiling port and can be oiled with a “squirt-gun” type oiler. We recommend 10 wt. non-detergent oil.

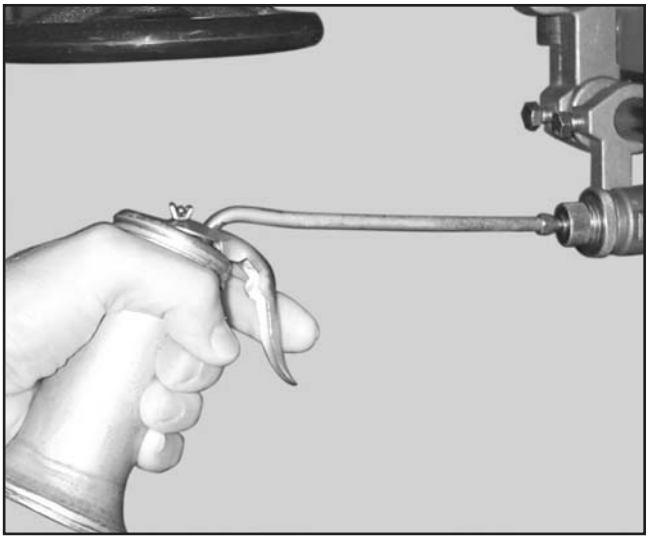

**Figure 26.** Oiling an upper blade guide bearing.

**To oil the guide bearings:**

1. Clean all the oiling ports with a paper towel or a clean rag.

2. Press the tip of the oiler against the ball as shown in **Figure 23**.

3. Apply only a small amount of oil. Excess oil can spread to the blade and contaminate the workpiece and bandsaw wheels.

4. Wipe off excess oil from around the oiling port.

**As for other items on this machine:**

1. Wipe off any sawdust with a clean cloth or dry paint brush on and around the guide post assembly.

2. Lubricate the guide post assembly with an occasional “shot” of spray on lubricant.

Ensure that oil does not get on the pulleys or V-belt because it could cause belt deterioration and slipping.

# Wheel Brush

The bandsaw is supplied with a lower wheel brush. This may need occasional cleaning and adjustment. It is advisable to check it once a day and make sure that it is clear of dust and any small bits of wood that may have become trapped between it and the lower wheel. The mounting bracket that secures it to the bandsaw body is slotted for adjustments as the bristles become worn. Please contact our parts department should replacement become necessary.



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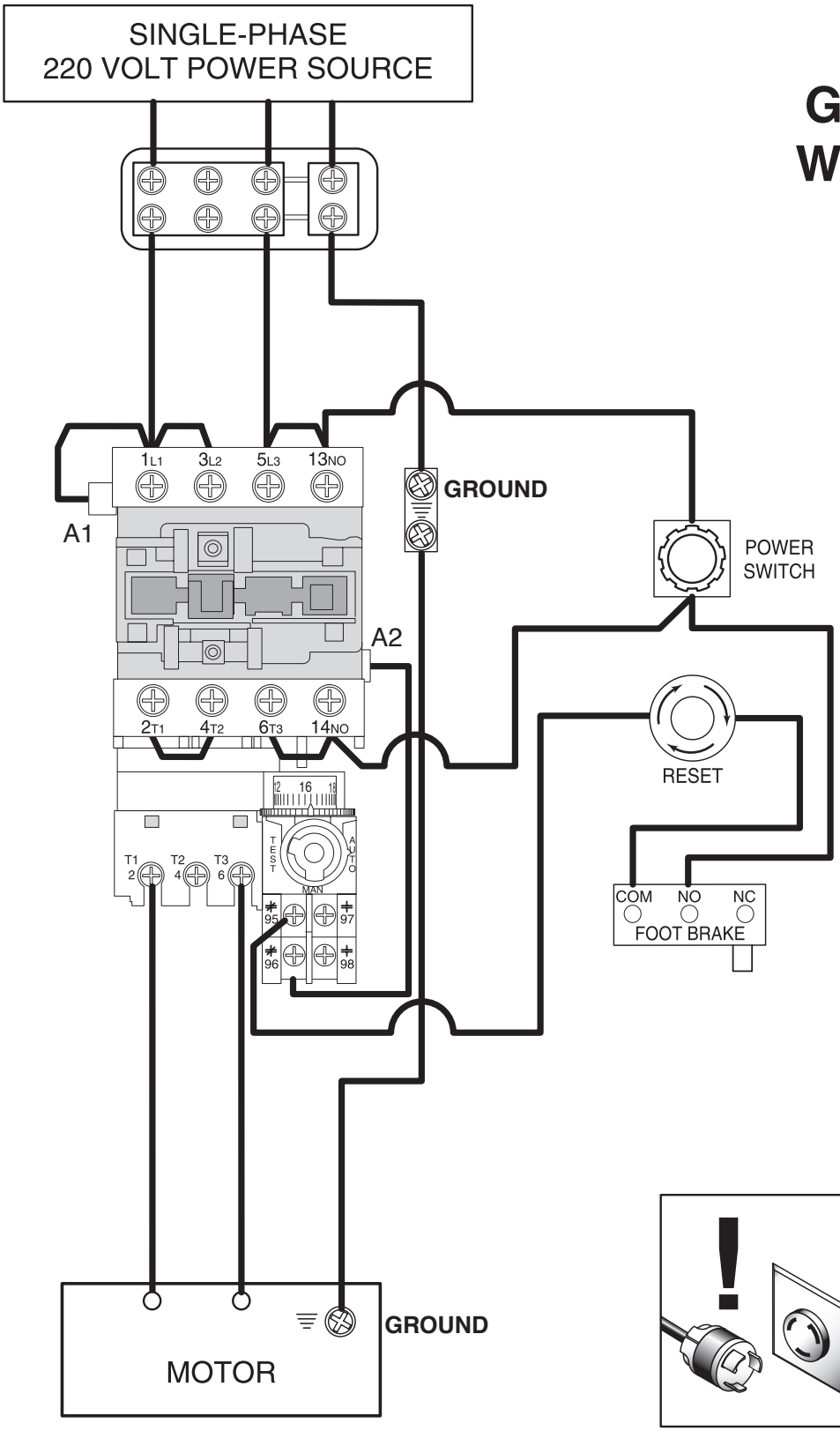
# G0506 &G0507
# Wiring Diagram






**⚠WARNING**

**Keep power disconnected from machine when performing any wiring to the machine, or serious personal injury may result!**



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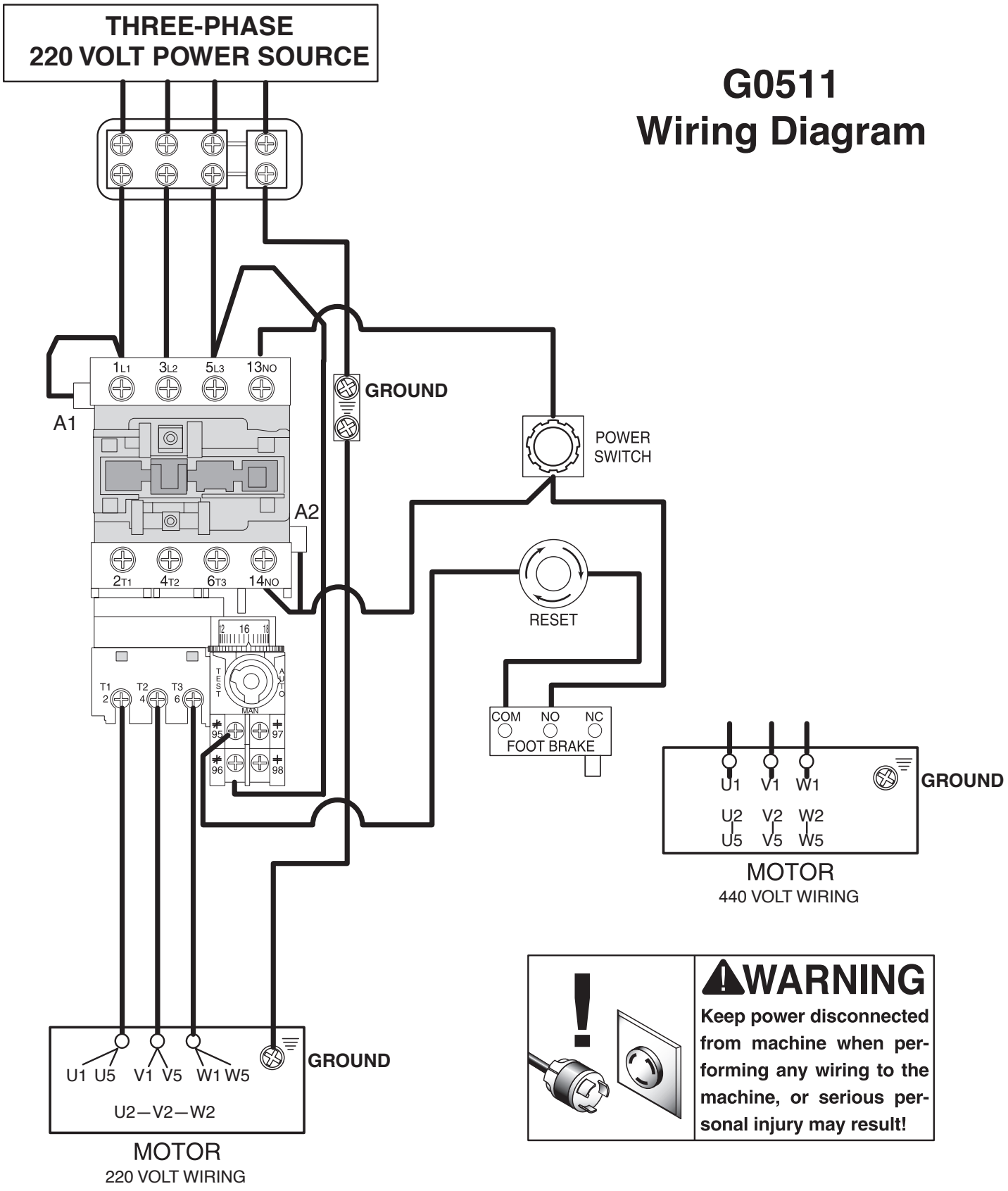
# G0511
# Wiring Diagram






**⚠WARNING**

**Keep power disconnected from machine when performing any wiring to the machine, or serious personal injury may result!**



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# SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your 18" and 20" Super Heavy-Duty Bandsaws.

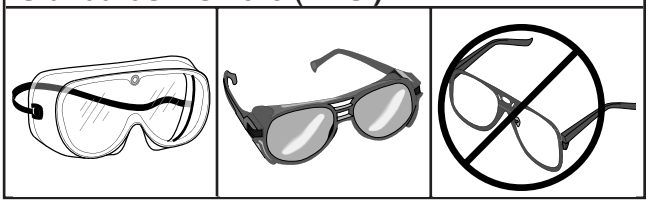
If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the *General Information* section. The specifications, drawings, and photographs illustrated in this manual represent the 18" and 20" Super Heavy-Duty Bandsaws as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

We have included some important safety measures that are essential to the operation of this machine. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation.*

## ⚠WARNING

**Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).**



We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to your machine, or if you need general assistance or replacement parts, please contact the Service Department listed in the *General Information* section.

Additional information sources are necessary to realize the full potential of your machine. Trade journals, woodworking magazines, and your local library are good places to start.

## ⚠WARNING

**Like all power tools, there is danger associated with the 18" and 20" Super Heavy-Duty Bandsaws. Use your bandsaw with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.**

## ⚠WARNING

**The 18" and 20" Super Heavy-Duty Bandsaws were specifically designed for wood cutting operations. DO NOT MODIFY AND/OR USE THESE BANDSAWS FOR ANY OTHER PURPOSE. Modifications or improper use will void the warranty. If you are confused about any aspect of your machine, DO NOT use it until all your questions are answered. Serious personal injury may occur.**



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# MACHINE DATA SHEET

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# MODEL G0506 18" SUPER HEAVY-DUTY BANDSAW

Design Type ..... Floor Model

**Overall Dimensions:**

Table Size ..... 24"W x 19¾"D x 1⅞"T
Height From Floor To Table ..... 35¾"
Overall Height ..... 72"
Overall Width ..... 32"
Overall Depth (Including Fence) ..... 29½"
Shipping Weight ..... 616 lbs.
Machine Weight ..... 462 lbs.
Crate Size ..... 76¾"H x 26"W x 36¼"L
Footprint ..... 26¾"W x 15"L

**Capacities:**

Throat Capacity (Left of Blade) ..... 17"
Height Capacity ..... 9¾"
Table Tilt ..... 45°R
Blade Size Range ..... ⅜"~1"
Standard Blade Length ..... 147⅝"-149⅝"
Blade Speed ..... 4610 FPM

**Construction:**

Table ..... Precision Ground Cast Iron
Wheels ..... Fully Balanced Cast Iron w/Polyurethane Tires
Rip Fence ..... Precision Ground Cast Iron
Wheel Covers ..... Pre-Formed Steel
Guides ..... Sturdy Roller Disc Blade Guides

**Main Motor:**

Type ..... TEFC Capacitor-Start Induction
Horsepower ..... 2 HP
Phase / Voltage ..... Single-Phase / 220V
Amps ..... 12A
Cycle / RPM ..... 60 Hertz / 1725 RPM
Switch ..... Magnetic w/Thermal Overload Protector
Bearings ..... Shielded & Lubricated Ball Bearings

**Features:**

4" Dust Hood
Foot Brake
Blade Tensioning Scale
Miter Gauge
Rack & Pinion Adjustable Upper Guide
Hinged Wheel Covers

*Specifications, while deemed accurate, are not guaranteed.*



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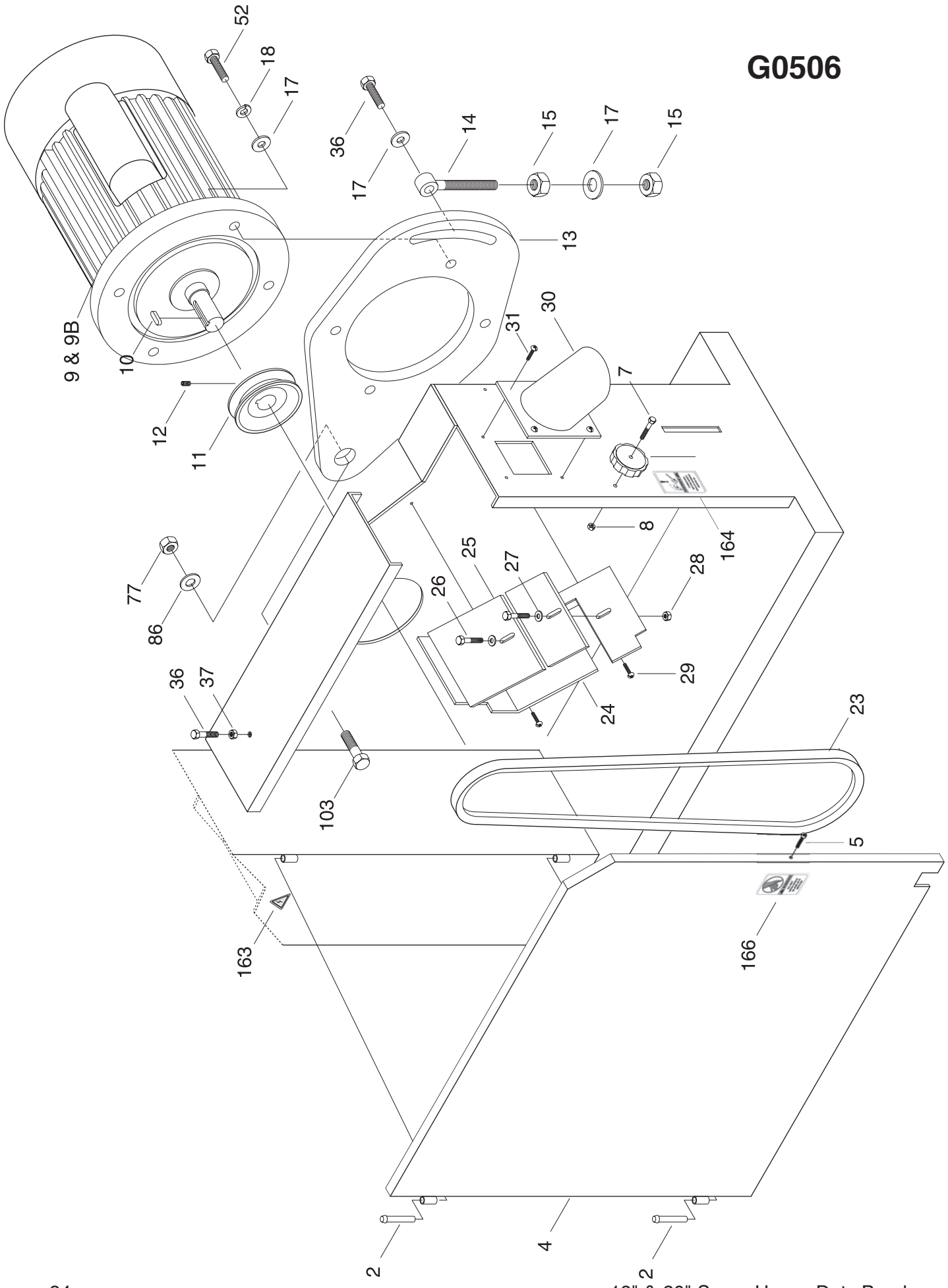




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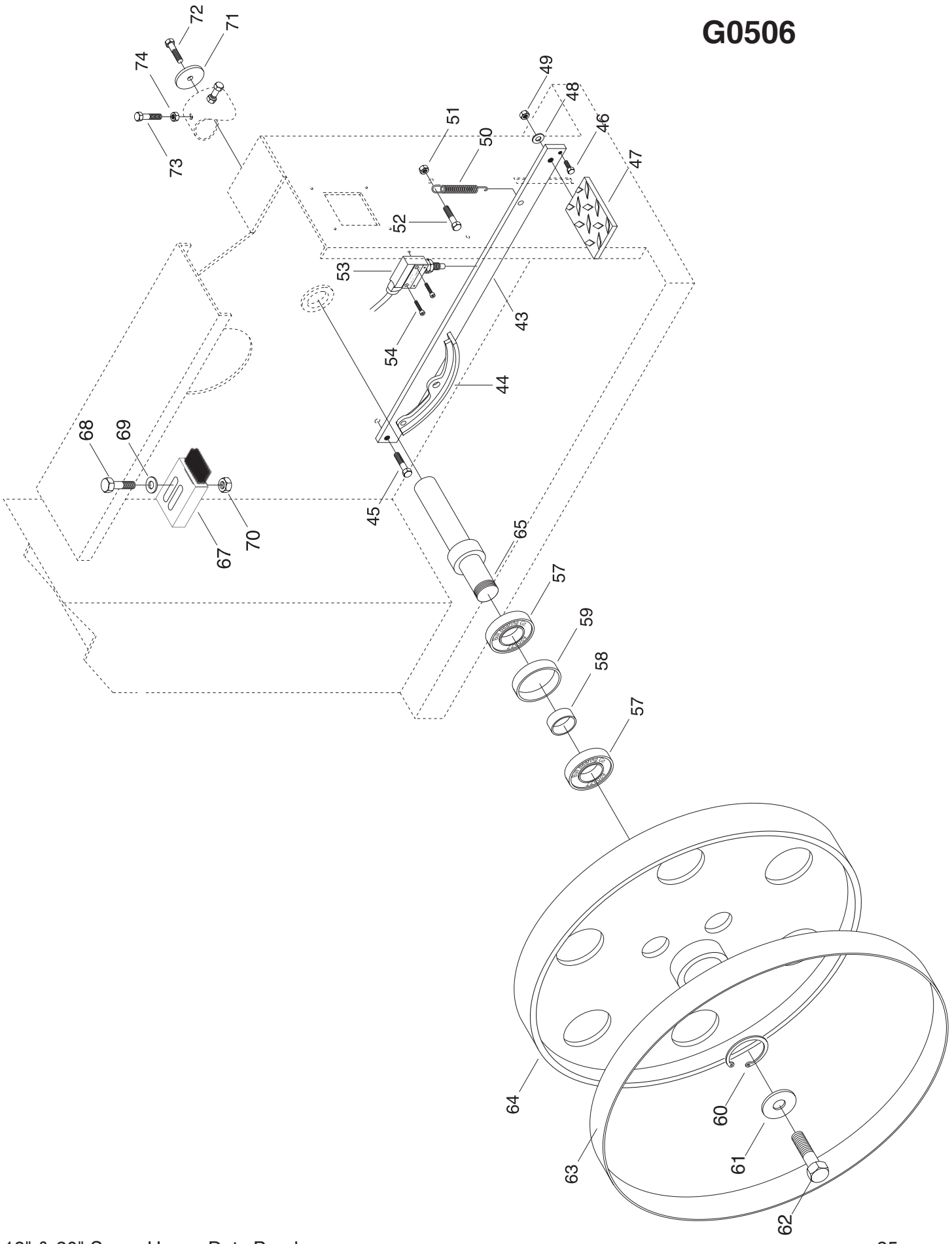




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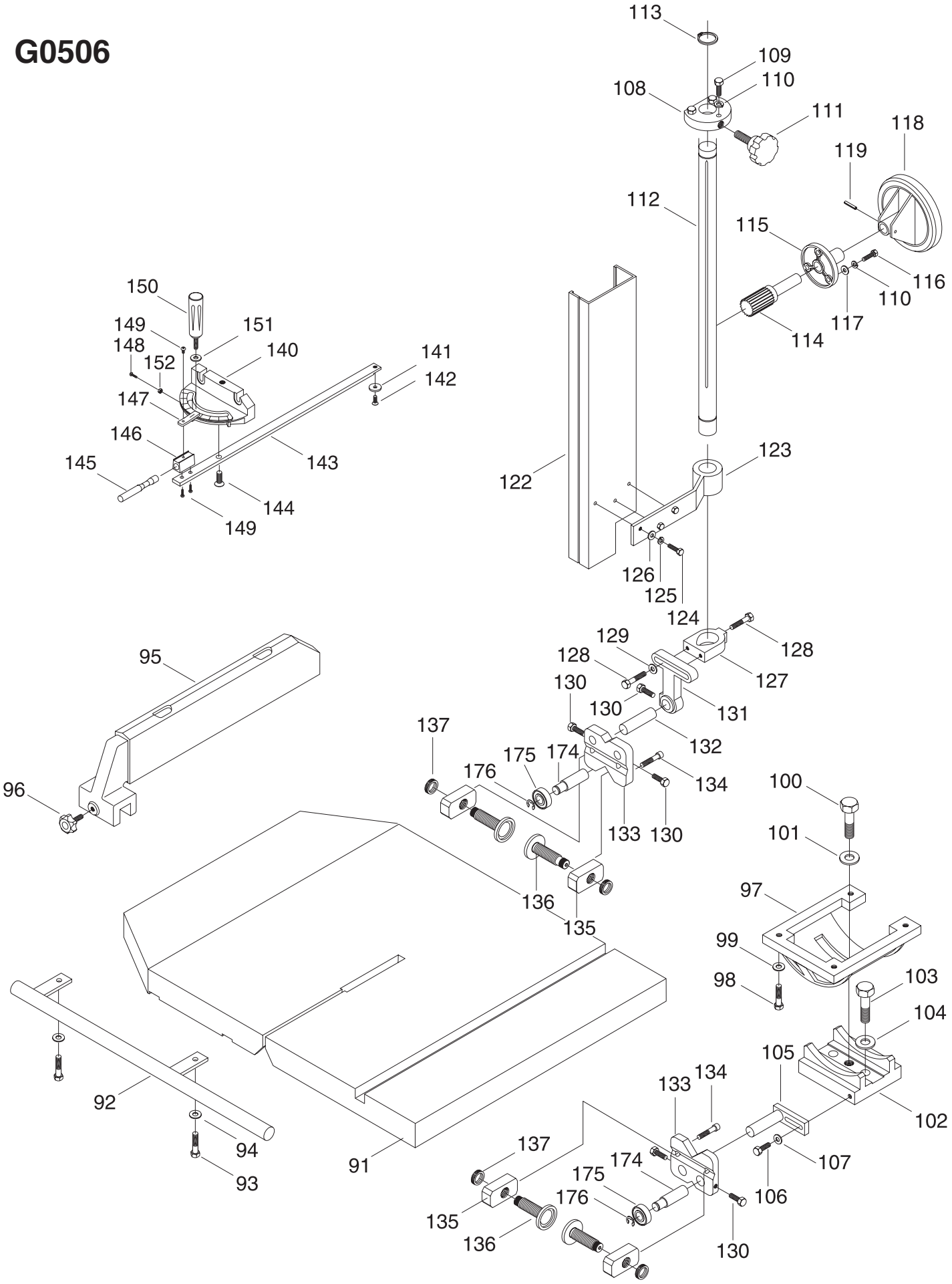




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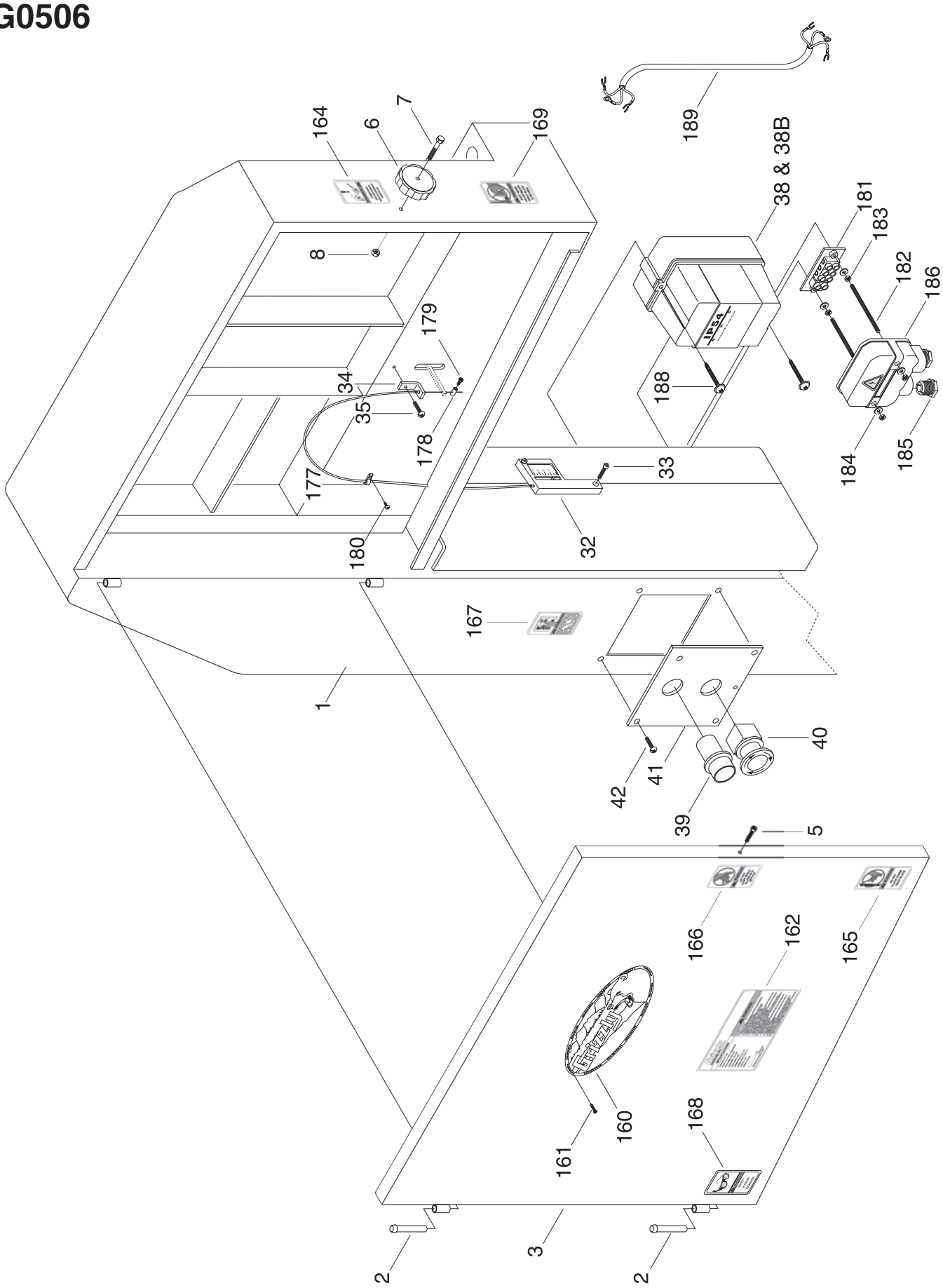




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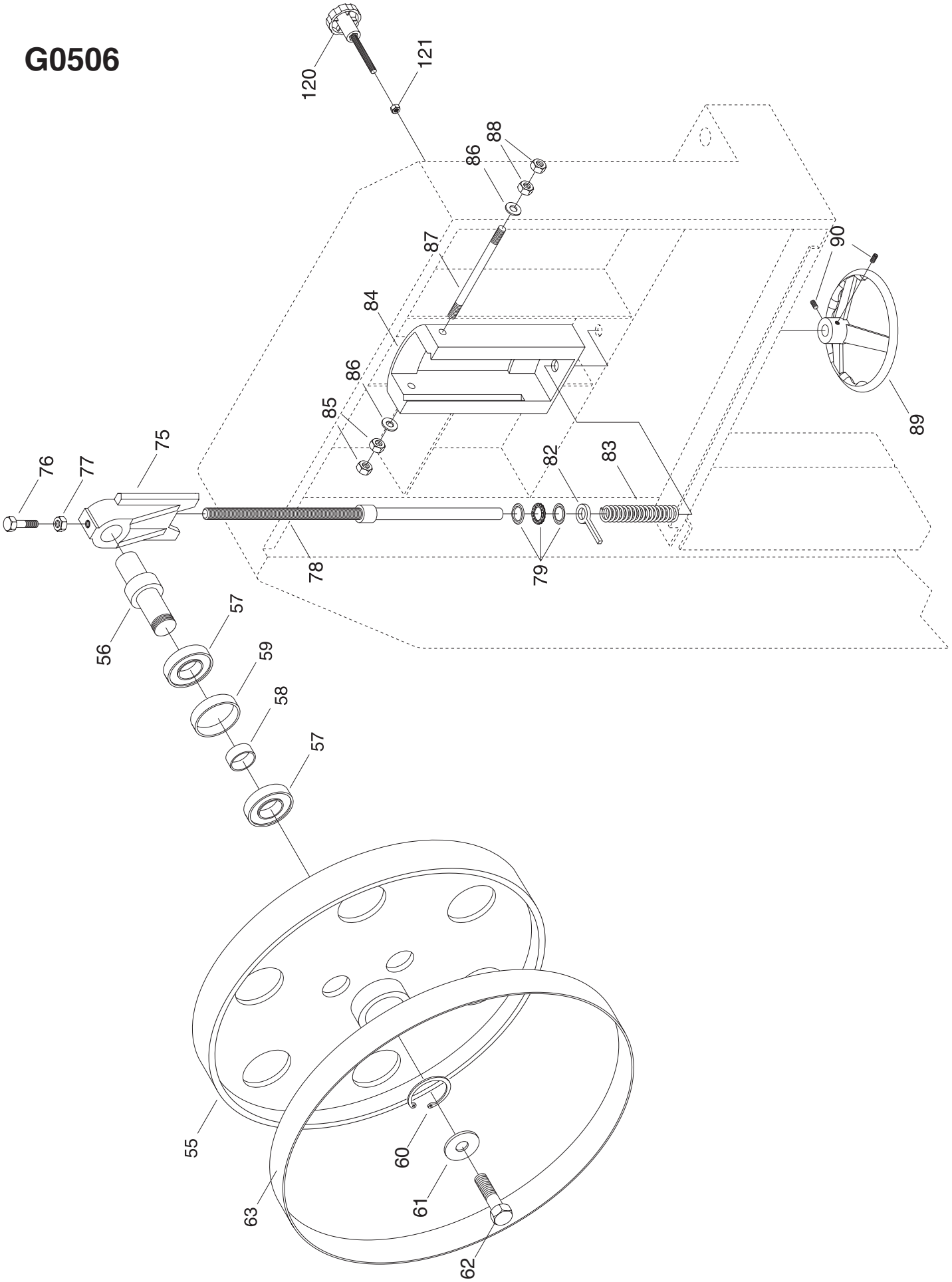




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# G0506

| REF | PART # | DESCRIPTION |
|---|---|---|
| 001 | P0506001 | FRAME |
| 002 | P0506002 | HINGE |
| 003 | P0506003 | UPPER WHEEL GUARD |
| 004 | P0506004 | LOWER WHEEL GUARD |
| 005 | PSB17 | CAP SCREW ¼"-20 X ⅜" |
| 006 | P0506006 | WHEEL GUARD LOCK KNOB |
| 007 | PSB05 | CAP SCREW ¼"-20 X ¾" |
| 008 | PN05 | HEX NUT ¼" |
| 009 | P0506009 | 1-PH 2 HP MOTOR |
| 09-1 | P0506009-1 | CAPACITOR 400MFD-125V |
| 010 | PK43M | KEY 8 X 8 X 45 |
| 011 | P0506011 | MOTOR PULLEY |
| 012 | PSS08 | SETSCREW 5⁄16"-18 X ½" |
| 013 | P0506013 | MOTOR FLANGE |
| 014 | P0506014 | ADJUSTING SCREW ⅜"-16 |
| 015 | PN08 | HEX NUT ⅜"-16 |
| 017 | PW02 | FLAT WASHER ⅜" |
| 018 | PLW04 | LOCK WASHER ⅜" |
| 023 | PVA37 | V-BELT A37 |
| 024 | P0506024 | DUST BOARD |
| 025 | P0506025 | WOOD BOARD |
| 026 | PB03 | HEX BOLT 5⁄16"-18 X 1" |
| 027 | PW07 | FLAT WASHER 5⁄16" |
| 028 | PN02 | HEX NUT 5⁄16" |
| 029 | PS06 | HEX BOLT 10-24 X ⅜" |
| 030 | P0506030 | CHIP CHUTE |
| 031 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 032 | P0506032 | BLADE TENSION INDICATOR |
| 033 | PSB04 | CAP SCREW ¼"-20 X ½" |
| 034 | P0506034 | WIRE BRACKET |
| 035 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 036 | PB58 | HEX BOLT ⅜"-16 X 2" |
| 037 | PN08 | HEX NUT ⅜"-16 |
| 038 | P0506038 | 1-PH MAG SWITCH |
| 38-1 | P0506038-1 | CONTACTOR/THERMAL OVRLD |
| 039 | P0506039 | ON SWITCH (GREEN) |
| 040 | P0506040 | OFF SWITCH (RED) |
| 041 | P0506041 | POWER CONTROL PANEL |
| 042 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 043 | P0506043 | CONNECTION PLATE |
| 044 | P0506044 | BRAKE LINING |
| 045 | PB18 | HEX BOLT ⅜"-16 X 1" |
| 046 | PB19 | HEX BOLT ¼"-20 X ½" |
| 047 | P0506047 | FOOT BRAKE PEDAL |
| 048 | PLW04 | LOCK WASHER ⅜" |
| 049 | PN08 | HEX NUT ⅜"-16 |
| 050 | P0506050 | SPRING |
| 051 | PN08 | HEX NUT ⅜"-16 |

| REF | PART # | DESCRIPTION |
|---|---|---|
| 052 | PB21 | HEX BOLT ⅜"-16 X ¾" |
| 053 | P0506053 | STOP SWITCH |
| 054 | PSB21M | CAP SCREW M4-.7 X 30 |
| 055 | P0506055 | UPPER WHEEL |
| 056 | P0506056 | UPPER WHEEL SHAFT |
| 057 | P6205 | BEARING 6205Z |
| 058 | P0506058 | IN BUSHING |
| 059 | P0506059 | OUT BUSHING |
| 060 | P0506060 | INT SNAP RING 52MM |
| 061 | PW021 | FLAT WASHER ⅜" |
| 062 | PB03 | HEX BOLT ⅜"-16 X 1" |
| 063 | P0506063 | RUBBER CROWN |
| 064 | P0506064 | LOWER WHEEL |
| 065 | P0506065 | LOWER WHEEL SHAFT |
| 066 | P0506066 | BRUSH BRACKET |
| 067 | P0506067 | BRUSH |
| 068 | PB03 | HEX BOLT 5⁄16"-18 X 1" |
| 069 | PW07 | FLAT WASHER 5⁄16" |
| 070 | PN02 | HEX NUT 5⁄16"-18 |
| 071 | P0506071 | SPECIAL WASHER ⅜"~2" |
| 072 | PB24 | HEX BOLT ⅜"-16 X 1¼" |
| 073 | PB24 | HEX BOLT ⅜"-16 X 1¼" |
| 074 | PN08 | HEX NUT ⅜"-16 |
| 075 | P0506075 | ARBOR BRACKET |
| 076 | PB24 | HEX BOLT ⅜"-16 X 1¼" |
| 077 | PN08 | HEX NUT ⅜"-16 |
| 078 | P0506078 | BLADE TENSION SHAFT |
| 079 | P51104 | THRUST BEARING 51104 |
| 082 | P0506082 | INDICATOR WIRE PULLER |
| 083 | P0506083 | SPRING |
| 084 | P0506084 | BRACKET HOLDER |
| 085 | PN08 | HEX NUT ⅜"-16 |
| 086 | PW02 | FLAT WASHER ⅜" |
| 087 | P0506087 | BRACKET SHAFT |
| 088 | PN08 | HEX NUT ⅜"-16 |
| 089 | P0506089 | TENSION HANDWHEEL |
| 090 | PSS08 | SETSCREW 5⁄16"-18 X ½" |
| 091 | P0506091 | TABLE |
| 092 | P0506092 | FENCE RAIL |
| 093 | PB18 | HEX BOLT ⅜"-16 X 1" |
| 094 | PW02 | FLAT WASHER ⅜" |
| 095 | P0506095 | FENCE |
| 096 | P0506096 | FENCE KNOB ⅜"-16 X 1¼" |
| 097 | P0506097 | TRUNNION |
| 098 | PSB19 | CAP SCREW ⅜"-16 X 1¼" |
| 099 | PLW04 | LOCK WASHER ⅜" |
| 100 | P0506100 | HEX BOLT ½"-12 X 1¾" |
| 101 | PW01 | FLAT WASHER ½" |



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# G0506

| REF | PART # | DESCRIPTION |
|---|---|---|
| 102 | P0506102 | TRUNNION BRACKET |
| 103 | P0506100 | HEX BOLT ½"-12 X 1¾" |
| 104 | PLW07 | LOCK WASHER ½" |
| 105 | P0506105 | BLADE GUIDE FORK |
| 106 | PB07 | HEX BOLT 5/16"-18 X ¾" |
| 107 | PW02 | FLAT WASHER ⅜" |
| 108 | P0506108 | SHAFT CAP |
| 109 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 110 | PLW01 | LOCK WASHER 5/16" |
| 111 | P0506111 | LOCK KNOB ⅜"-16 X 2¼" |
| 112 | P0506112 | GUIDE SHAFT |
| 113 | P0506113 | C-CLIP |
| 114 | P0506114 | ELEVATION GEAR SHAFT |
| 115 | P0506115 | GEAR SHAFT BASE |
| 116 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 117 | PLW01 | LOCK WASHER 5/16" |
| 118 | P0506118 | HANDWHEEL |
| 119 | P0506119 | SPRING KEY M4 |
| 120 | P0506120 | TRACK KNOB ⅜"-16 X 2½" |
| 121 | PN08 | HEX NUT ⅜"-16 |
| 122 | P0506122 | BLADE GUIDE GUARD |
| 123 | P0506123 | BLADE GUARD BRACKET |
| 124 | PB19 | HEX BOLT ¼"-20 X ½" |
| 125 | PLW02 | LOCK WASHER ¼" |
| 126 | PW06 | FLAT WASHER ¼" |
| 127 | P0506127 | BLADE GUIDE HOLDER |
| 128 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 129 | PW07 | FLAT WASHER 5/16" |
| 130 | PB07 | HEX BOLT 5/16"-18 X ¾" |
| 131 | P0506131 | ADJUSTMENT BRACKET |
| 132 | P0506132 | BRACKET ARBOR |
| 133 | P0506133 | BLADE GUIDE BASE |
| 134 | PSB07 | CAP SCREW 5/16"-18 X ¾" |
| 135 | P0506135 | GUIDE WHEEL BRACKET |
| 136 | P0506136 | GUIDE WHEEL |
| 137 | P0506137 | GUIDE WHEEL NUT |
| 140A | P0506140A | COMPLETE MITER GAUGE |
| 140 | P0506140 | MITER GAUGE BODY |

| REF | PART # | DESCRIPTION |
|---|---|---|
| 141 | P0506141 | T-SLOT WASHER |
| 142 | PFH09 | FLAT HD SCR ¼"-20 X 5/16" |
| 143 | P0506142 | MITER BAR |
| 144 | P0506144 | SPECIAL BOLT ¼"-20 X 7/16" |
| 145 | P0506145 | STOP PIN |
| 146 | P0506146 | BLOCK |
| 147 | P0506147 | INDICATOR |
| 148 | PS29 | PHLP HD SCR 6-32 X ⅝" |
| 149 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 150 | P0506150 | HANDLE 5/16"-18 X 1½" |
| 151 | PW07 | FLAT WASHER 5/16" |
| 152 | PN12 | HEX NUT 6-32 |
| 160 | G8589 | LARGE GRIZZLY LOGO |
| 161 | P05060161 | SELF TAP SCR #5 X ⅜" |
| 162 | P05060162 | G0506 ID LABEL |
| 163 | PLABEL-14 | ELECTRICITY LABEL |
| 164 | PLABEL-18 | UNPLUG BANDSAW LABEL |
| 165 | PLABEL-19 | HANDS/BLADE LABEL |
| 166 | PLABEL-20 | DON'T OPEN LABEL |
| 167 | PLABEL-12 | READ MANUAL LABEL |
| 168 | PLABEL-11 | SAFETY GLASSES LABEL |
| 169 | PLABEL-20 | MOVING/ADJUST LABEL |
| 174 | P0506174 | THRUST BEARING SHAFT |
| 175 | P6202RS | BALL BEARING 6202 |
| 176 | PEC05M | E-CLIP 15MM |
| 177 | P0506177 | CABLE CLIP |
| 178 | P0506178 | CABLE NUT 6-32 |
| 179 | PS37 | PHLP HD SCR 6-32 X 5/16" |
| 180 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 181 | P0506181 | TERMINAL BLOCK |
| 182 | P0506182 | STUD 10-24 X 2½" |
| 183 | PN07 | HEX NUT 10-24 |
| 184 | PW03 | FLAT WASHER 10-24 |
| 185 | PSW10 | STRAIN RELIEF ¾" |
| 186 | P0506186 | COVER |
| 188 | PHTEK5 | SELF TAP SCR 10-24 X 2¼" |
| 189 | P0506189 | POWER CORD |
| | | |



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# MACHINE DATA SHEET

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# MODEL G0507 & G0511
# 20" SUPER HEAVY-DUTY BANDSAWS

Design Type .....Floor Model

**Overall Dimensions:**

- Table Size .....27" x 20½"
- Overall Height .....76"
- Height From Floor to Table .....36¼"
- Width .....37"
- Depth Including Fence .....29½"
- Shipping Weight .....748 lbs
- Machine Weight .....625 lbs
- Crate Size .....80 11/16"L x 27 9/16"W x 39 3/8"H
- Footprint .....30½" x 15½"

**Capacities:**

- Throat Capacity (Left of Blade) .....19"
- Cutting Height Capacity .....11½"
- Table Tilt .....45˚R
- Blade Size Range .....⅜"~1"
- Standard Blade Length .....160 13/16"-162⅜"
- Blade Speed .....4510 FPM

**Construction:**

- Table .....Precision Ground Cast Iron
- Wheels .....Fully Balanced Cast Iron w/Polyurethane Tires
- Rip Fence .....Precision Ground Cast Iron
- Wheel Covers .....Pre-Formed Steel
- Guides .....Sturdy Roller Disc Blade Guides

**Motor:**

- Type (G0507) .....TEFC Capacitor-Start Induction
- Horsepower .....3 HP
- Phase / Voltage .....Single-Phase / 220V
- Amps .....23A
- Type (G0511) .....TEFC Induction
- Horsepower .....5 HP
- Phase / Voltage .....Three-Phase / 220V/440V
- Amps .....13A/6.5
- Cycle / RPM .....60 Hertz / 3450 RPM
- Switch .....Magnetic w/Thermal Overload Protector
- Bearings .....Shielded & Lubricated Ball Bearings

**Features:**

- .....4" Dust Hood
- .....Foot Brake
- .....Blade Tensioning Scale
- .....Miter Gauge
- .....Rack & Pinion Upper Guide Adjustment
- .....Hinged Wheel Covers

*Specifications, while deemed accurate, are not guaranteed.*



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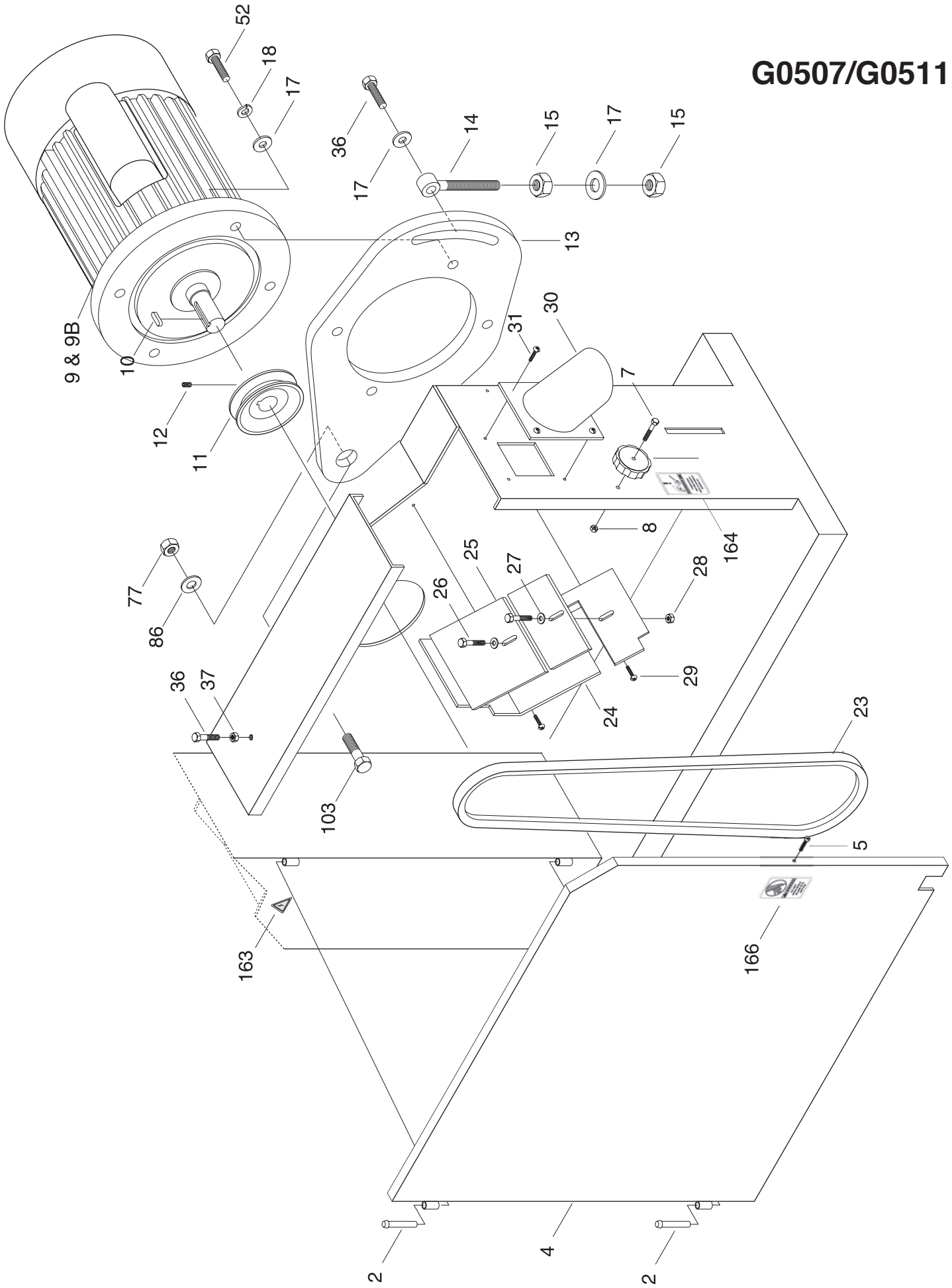




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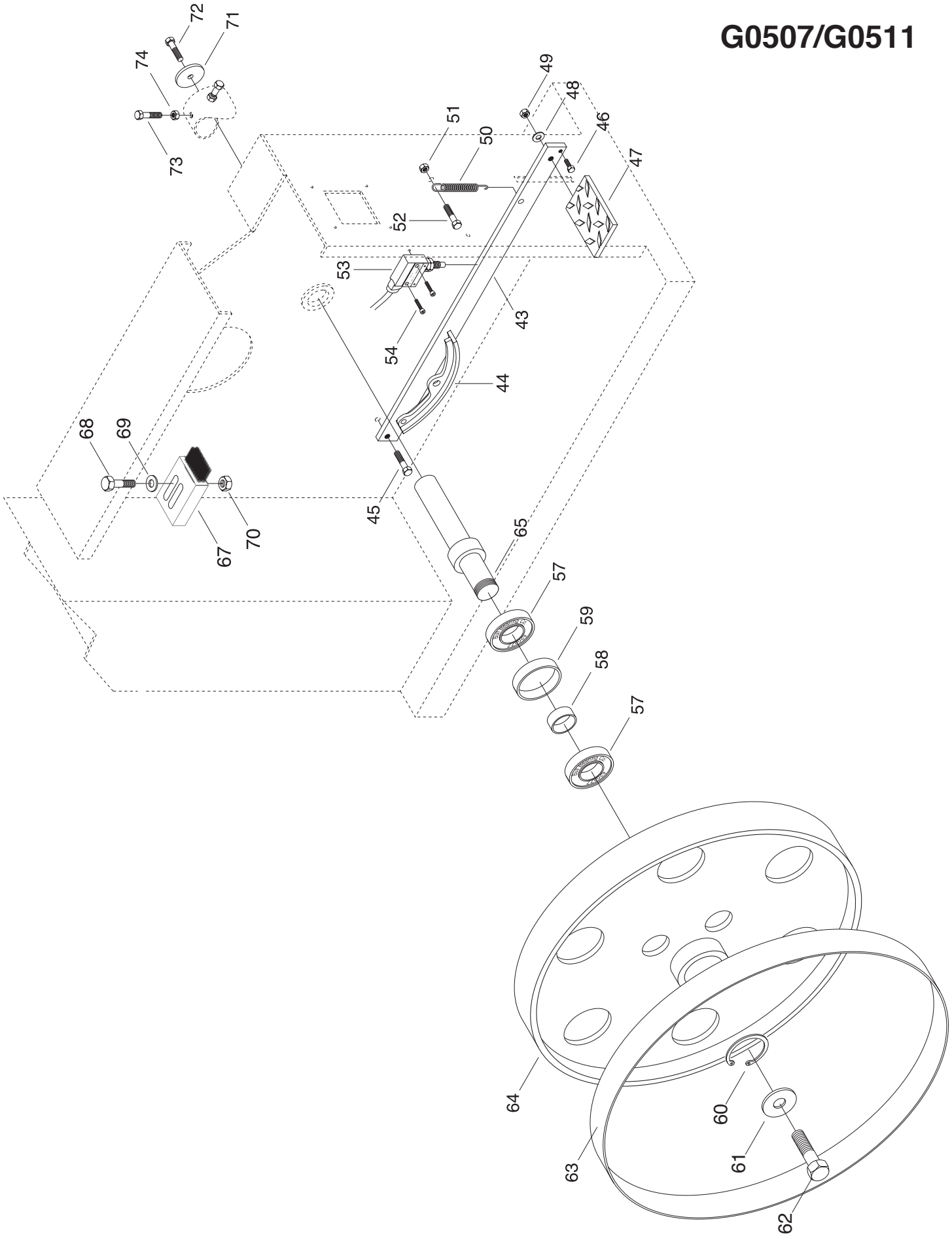




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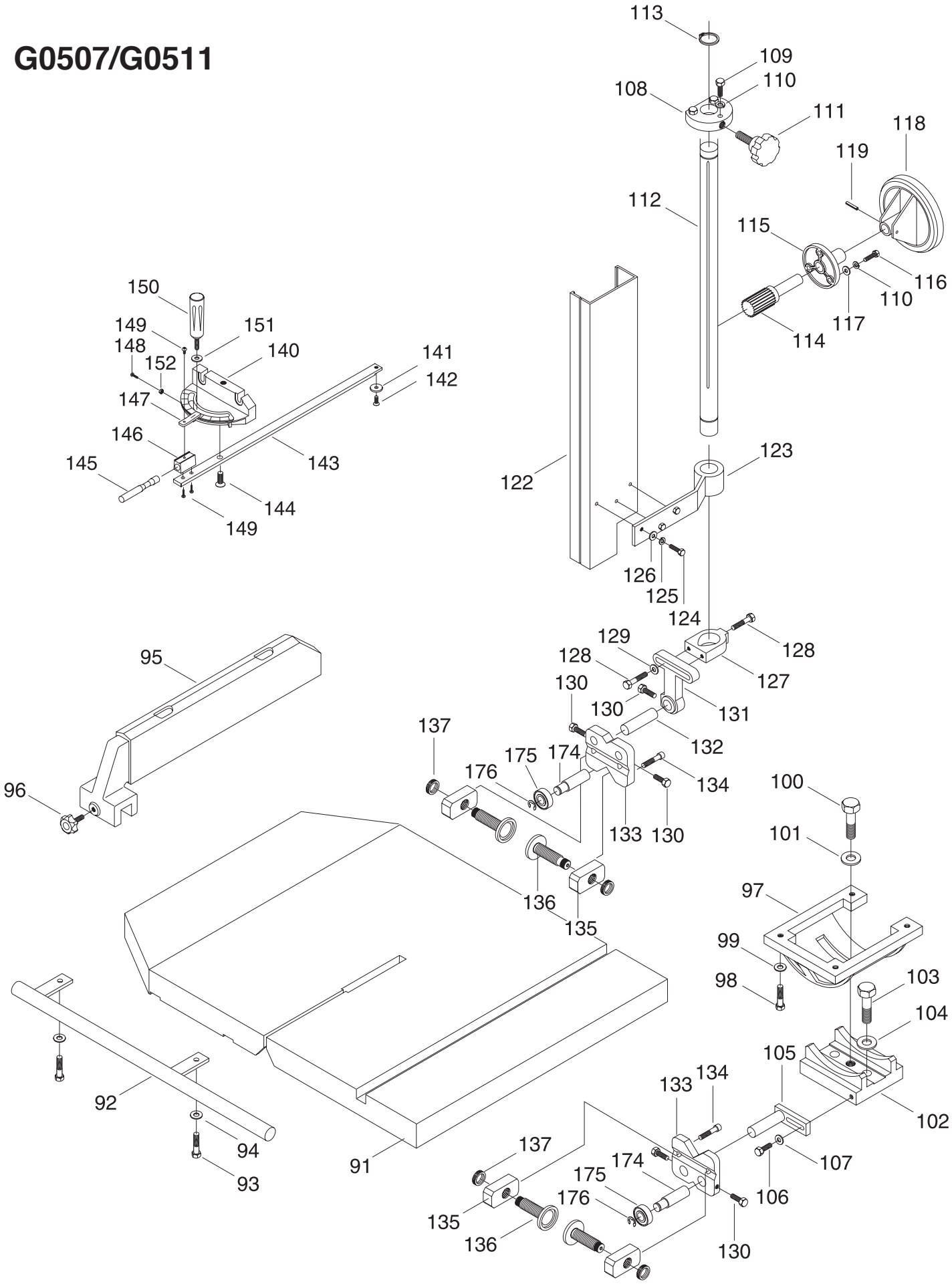
# G0507/G0511



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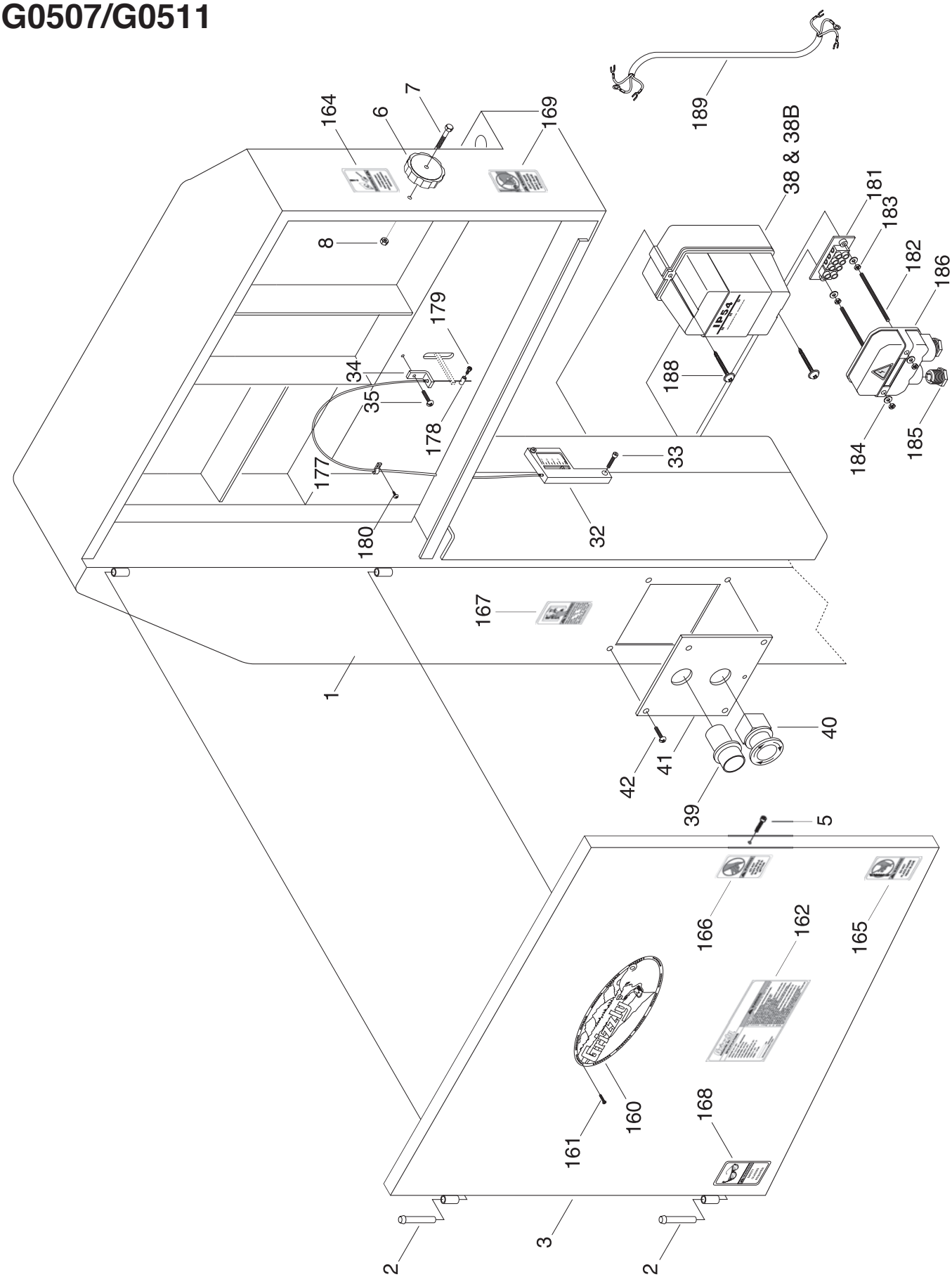




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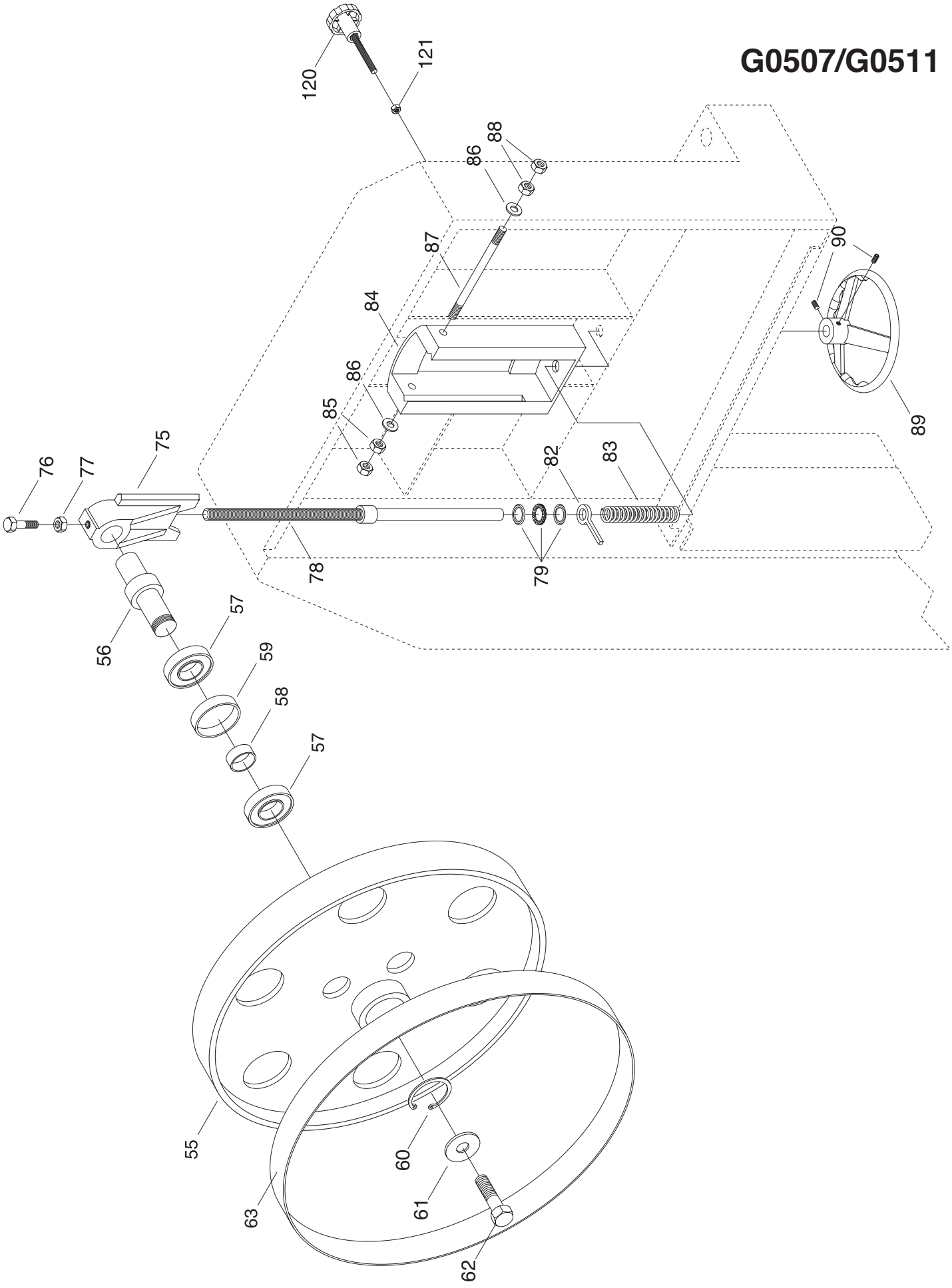




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# G0507/G0511

| REF | PART # | DESCRIPTION |
|---|---|---|
| 001 | P0507001 | FRAME |
| 002 | P0507002 | HINGE |
| 003 | P0507003 | UPPER WHEEL GUARD |
| 004 | P0507004 | LOWER WHEEL GUARD |
| 005 | PSB17 | CAP SCREW ¼"-20 X ⅜" |
| 006 | P0507006 | WHEEL GUARD LOCK KNOB |
| 007 | PSB05 | CAP SCREW ¼"-20 X ¾" |
| 008 | PN05 | HEX NUT ¼" |
| 009 | P0507009 | 1-PH 3 HP MOTOR |
| 009B | P0511009 | 3-PH 5 HP MOTOR |
| 09-1 | P0507009-1 | CAPACITOR 400MFD-250V |
| 010 | PK43M | KEY 8 X 8 X 45 |
| 011 | P0507011 | MOTOR PULLEY |
| 012 | PSS08 | SETSCREW 5/16"-18 X ½" |
| 013 | P0507013 | MOTOR FLANGE |
| 014 | P0507014 | ADJUSTING SCREW ⅜"-16 |
| 015 | PN08 | HEX NUT ⅜"-16 |
| 017 | PW02 | FLAT WASHER ⅜" |
| 018 | PLW04 | LOCK WASHER ⅜" |
| 023 | PVA46 | V-BELT A46 |
| 024 | P0507024 | DUST BOARD |
| 025 | P0507025 | WOOD BOARD |
| 026 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 027 | PW07 | FLAT WASHER 5/16" |
| 028 | PN02 | HEX NUT 5/16" |
| 029 | PS06 | HEX BOLT 10-24 X ⅜" |
| 030 | P0507030 | CHIP CHUTE |
| 031 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 032 | P0507032 | BLADE TENSION INDICATOR |
| 033 | PSB04 | CAP SCREW ¼"-20 X ½" |
| 034 | P0507034 | WIRE BRACKET |
| 035 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 036 | PB58 | HEX BOLT ⅜"-16 X 2" |
| 037 | PN08 | HEX NUT ⅜"-16 |
| 038 | G4573 | 1-PH MAG SWITCH (G0507) |
| 38-1 | P0507038-1 | CONTACTOR/THERMAL OVRLD |
| 038B | G4674 | 3-PH MAG SWITCH (G0511) |
| 38B-1 | P0511038B-1 | CONTACTOR/THERMAL OVRLD |
| 039 | P0507039 | ON SWITCH (GREEN) |
| 040 | P0507040 | OFF SWITCH (RED) |
| 041 | P0507041 | POWER CONTROL PANEL |
| 042 | PS06 | PHLP HD SCR 10-24 X ⅜" |
| 043 | P0507043 | CONNECTION PLATE |
| 044 | P0507044 | BRAKE LINING |
| 045 | PB18 | HEX BOLT ⅜"-16 X 1" |
| 046 | PB19 | HEX BOLT ¼"-20 X ½" |
| 047 | P0507047 | FOOT BRAKE PEDAL |
| 048 | PLW04 | LOCK WASHER ⅜" |

| REF | PART # | DESCRIPTION |
|---|---|---|
| 049 | PN08 | HEX NUT ⅜"-16 |
| 050 | P0507050 | SPRING |
| 051 | PN08 | HEX NUT ⅜"-16 |
| 052 | PB21 | HEX BOLT ⅜"-16 X ¾" |
| 053 | P0507053 | STOP SWITCH |
| 054 | PSB21M | CAP SCREW M4-.7 X 30 |
| 055 | P0507055 | UPPER WHEEL |
| 056 | P0507056 | UPPER WHEEL SHAFT |
| 057 | P6205 | BEARING 6206Z |
| 058 | P0507058 | IN BUSHING |
| 059 | P0507059 | OUT BUSHING |
| 060 | P0507060 | INT SNAP RING 62 |
| 061 | P0507061 | FLAT WASHER ⅜" |
| 062 | PB03 | HEX BOLT ⅜"-16 X 1" |
| 063 | P0507063 | RUBBER CROWN |
| 064 | P0507064 | LOWER WHEEL |
| 065 | P0507065 | LOWER WHEEL SHAFT |
| 066 | P0507066 | BRUSH BRACKET |
| 067 | P0507067 | BRUSH |
| 068 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 069 | PW07 | FLAT WASHER 5/16" |
| 070 | PN02 | HEX NUT 5/16"-18 |
| 071 | P0507071 | SPECIAL WASHER ⅜"~2" |
| 072 | PB24 | HEX BOLT ⅜"-16 X 1¼" |
| 073 | PB24 | HEX BOLT ⅜"-16 X 1¼" |
| 074 | PN08 | HEX NUT ⅜"-16 |
| 075 | P0507075 | ARBOR BRACKET |
| 076 | PB42 | HEX BOLT ½"-12 X 2" |
| 077 | PN06 | HEX NUT ½"-12 |
| 078 | P0507078 | BLADE TENSION SHAFT |
| 079 | P51104 | THRUST BEARING 51104 |
| 082 | P0507082 | INDICATOR WIRE PULLER |
| 083 | P0507083 | SPRING |
| 084 | P0507084 | BRACKET HOLDER |
| 085 | PN06 | HEX NUT ½"-12 |
| 086 | PW01 | FLAT WASHER ½" |
| 087 | P0507087 | BRACKET SHAFT |
| 088 | PN06 | HEX NUT ½"-12 |
| 089 | P0507089 | TENSION HANDWHEEL |
| 090 | PSS08 | SETSCREW 5/16"-18 X ½" |
| 091 | P0507091 | TABLE |
| 092 | P0507092 | FENCE RAIL |
| 093 | PB18 | HEX BOLT ⅜"-16 X 1" |
| 094 | PW02 | FLAT WASHER ⅜" |
| 095 | P0507095 | FENCE |
| 096 | P0507096 | FENCE KNOB ⅜"-16 X 1¼" |
| 097 | P0507097 | TRUNNION |
| 098 | PSB19 | CAP SCREW ⅜"-16 X 1¼" |



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| REF | PART # | DESCRIPTION |
|---|---|---|
| 099 | PLW04 | LOCK WASHER 3/8" |
| 100 | P0507100 | HEX BOLT 5/8"-11 X 2" |
| 101 | PW14 | FLAT WASHER 5/8" |
| 102 | P0507102 | TRUNNION BRACKET |
| 103 | P0506100 | HEX BOLT 1/2"-12 X 1 3/4" |
| 104 | PLW07 | LOCK WASHER 1/2" |
| 105 | P0507105 | BLADE GUIDE FORK |
| 106 | PB07 | HEX BOLT 5/16"-18 X 3/4" |
| 107 | PW02 | FLAT WASHER 3/8" |
| 108 | P0507108 | SHAFT CUP |
| 109 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 110 | PLW01 | LOCK WASHER 5/16" |
| 111 | P0507111 | LOCK KNOB 3/8"-16 X 2 1/4" |
| 112 | P0507112 | GUIDE SHAFT |
| 113 | P0507113 | C-CLIP |
| 114 | P0507114 | ELEVATION GEAR SHAFT |
| 115 | P0507115 | GEAR SHAFT BASE |
| 116 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 117 | PLW01 | LOCK WASHER 5/16" |
| 118 | P0507118 | HANDWHEEL |
| 119 | P0507119 | SPRING KEY M4 |
| 120 | P0507120 | TRACK KNOB 3/8"-16 X 2 1/2" |
| 121 | PN08 | HEX NUT 3/8"-16 |
| 122 | P0507122 | BLADE GUIDE GUARD |
| 123 | P0507123 | BLADE GUARD BRACKET |
| 124 | PB19 | HEX BOLT 1/4"-20 X 1/2" |
| 125 | PLW02 | LOCK WASHER 1/4" |
| 126 | PW06 | FLAT WASHER 1/4" |
| 127 | P0507127 | BLADE GUIDE HOLDER |
| 128 | PB03 | HEX BOLT 5/16"-18 X 1" |
| 129 | PW07 | FLAT WASHER 5/16" |
| 130 | PB07 | HEX BOLT 5/16"-18 X 3/4" |
| 131 | P0507131 | ADJUSTMENT BRACKET |
| 132 | P0507132 | BRACKET ARBOR |
| 133 | P0507133 | BLADE GUIDE BASE |
| 134 | PSB07 | CAP SCREW 5/16"-18 X 3/4" |
| 135 | P0507135 | GUIDE WHEEL BRACKET |
| 136 | P0507136 | GUIDE WHEEL |
| 137 | P0507137 | GUIDE WHEEL NUT |

| REF | PART # | DESCRIPTION |
|---|---|---|
| 140A | P0507140A | COMPLETE MITER GAUGE |
| 140 | P0507140 | MITER GAUGE BODY |
| 141 | P0507141 | T-SLOT WASHER |
| 142 | PFH09 | FLAT HD SCR 1/4"-20 X 5/16" |
| 143 | P0507143 | MITER BAR |
| 144 | P0507144 | SPECIAL BOLT 1/4"-20 X 7/16" |
| 145 | P0507145 | STOP PIN |
| 146 | P0507146 | BLOCK |
| 147 | P0507147 | INDICATOR |
| 148 | PS29 | PHLP HD SCR 6-32 X 5/8" |
| 149 | PS06 | PHLP HD SCR 10-24 X 3/8" |
| 150 | P0507150 | HANDLE 5/16"-18 X 1 1/2" |
| 151 | PW07 | FLAT WASHER 5/16" |
| 152 | PN12 | HEX NUT 6-32 |
| 160 | G8589 | LARGE GRIZZLY LOGO |
| 161 | P05070161 | SELF TAP SCR #5 X 3/8" |
| 162 | P05070162 | G0507 ID LABEL |
| 163 | PLABEL-14 | ELECTRICITY LABEL |
| 164 | PLABEL-18 | UNPLUG BANDSAW LABEL |
| 165 | PLABEL-19 | HANDS/BLADE LABEL |
| 166 | PLABEL-20 | DON'T OPEN LABEL |
| 167 | PLABEL-12 | READ MANUAL LABEL |
| 168 | PLABEL-11 | SAFETY GLASSES LABEL |
| 169 | PLABEL-21 | MOVING/ADJUST LABEL |
| 174 | P0507174 | THRUST BEARING SHAFT |
| 175 | P6202RS | BALL BEARING 6202 |
| 176 | PEC05M | E-CLIP 15MM |
| 177 | P0507177 | CABLE CLIP |
| 178 | P0507178 | CABLE NUT 6-32 |
| 179 | PS37 | PHLP HD SCR 6-32 X 5/16" |
| 180 | PS06 | PHLP HD SCR 10-24 X 3/8" |
| 181 | P0507181 | TERMINAL BLOCK |
| 182 | P0507182 | STUD 10-24 X 2 1/2" |
| 183 | PN07 | HEX NUT 10-24 |
| 184 | PW03 | FLAT WASHER 10-24 |
| 185 | P0507185 | STRAIN RELIEF 3/4" |
| 186 | P0507186 | COVER |
| 188 | PHTEK5 | SELF TAP SCR 10-24 X 2 1/4" |
| 189 | P0507189 | POWER CORD |

Parts for the G0511 are identical to the G0507 except those with the prefix of P0511.



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# TROUBLESHOOTING

| | | |
|---|---|---|
| Motor will not start. | **1.** Low voltage.<br>**2.** Open circuit in motor or loose connections. | **1.** Check power line for proper voltage.<br>**2.** Inspect all lead connections on motor for loose or open connections. |
| Motor will not start; fuses or circuit breakers blow. | **1.** Short circuit in line cord or plug.<br>**2.** Short circuit in motor or loose connections.<br>**3.** Circuit Overloaded | **1.** Inspect cord or plug for damaged insulation and shorted wires.<br>**2.** Inspect all connections on motor for loose or shorted terminals or worn insulation.<br>**3.** Reduce load on circuit. |
| Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals). | **1.** Power line overloaded with lights, appliances, and other motors.<br>**2.** Undersized wires or circuits too long.<br>**3.** General overloading of power company facilities. | **1.** Reduce load on power line.<br>**2.** Increase wire sizes or reduce length of wire.<br>**3.** Request a power check from the power company. |
| Motor overheats. | **1.** Motor overloaded.<br>**2.** Air circulation through the motor restricted. | **1.** Reduce load on motor.<br>**2.** Clean out motor to provide normal air circulation. |
| Motor stalls (resulting in blown fuses or tripped circuit). | **1.** Short circuit in motor or loose connections.<br>**2.** Low voltage.<br>**3.** Incorrect fuses or circuit breakers in power line.<br>**4.** Motor overloaded. | **1.** Inspect connections on motor for loose or shorted terminals or worn insulation.<br>**2** Correct the low voltage conditions.<br>**3.** Install correct fuses or circuit breakers.<br>**4.** Reduce load on motor. |
| Machine slows when operating. | Applying too much pressure to workpiece. | Feed workpiece slower. |
| Blade does not run evenly on wheels or runs off. | **1.** Tracking is not adjusted properly.<br>**2.** Wheels are not coplanar. | **1.** Adjust tracking.<br>**2.** Adjust wheel alignment. |
| Blade does not cut evenly. | **1.** Blade is not properly tensioned.<br>**2.** Wheels are not coplanar.<br>**3.** Tooth set is uneven.<br>**4.** Teeth are sharper on one side than the other. | **1.** Adjust blade tension.<br>**2.** Adjust wheel alignment.<br>**3.** Skew fence to compensate or replace blade.<br>**4.** Skew fence to compensate or replace blade. |
| Blade slows when cutting. Blade makes a squealing noise, especially on start-up. | **1.** V-belt loose.<br>**2.** V-belt worn out. | **1.** Tighten V-belt.<br>**2.** Replace V-belt. |
| Ticking sound when the saw is running. | Weld contacting support bearing. | Use the G2516 Stone to smooth and round the back of the blade. |
| Blade contacting table insert. | **1.** Excessive side pressure when cutting.<br>**2.** Table improperly adjusted.<br>**3.** Opening in insert too narrow. | **1.** Reduce side pressure.<br>**2.** Adjust table.<br>**3.** File opening in table insert larger. |
| Excessive vibration. | **1.** Rubber pads not installed under stand.<br>**2.** Wheels not coplanar.<br>**3.** Wheel rubber incorrectly installed.<br>**4.** Worn out V-belt.<br>**5.** Bent or worn out blade.<br>**6.** Wheels out of balance. | **1.** Install rubber pads under stand.<br>**2.** Adjust wheel alignment.<br>**3.** Re-install wheel rubber crown.<br>**4.** Replace V-belt.<br>**5.** Replace blade.<br>**6.** Replace wheels. |



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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.

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# WARRANTY CARD

Name _____

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City _____State_____Zip_____

Phone Number_____E-Mail_____FAX_____

**MODEL** _____Serial #_____ Order _____

**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
___World Wide Web

___Other_____

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

___American Woodworker ___Practical Homeowner
___Cabinetmaker ___Shop Notes
___Family Handyman ___Today's Homeowner
___Fine Homebuilding ___WOOD
___Fine Woodworking ___Wooden Boat
___Home Handyman ___Woodshop News
___Journal of Light Construction ___Woodsmith
___Old House Journal ___Woodwork
___Popular Mechanics ___Woodworker
___Popular Science ___Woodworker's Journal
___Popular Woodworking ___Workbench
___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America ___The New Yankee Workshop
___Home Time ___This Old House
___The American Woodworker ___Woodwright's Shop
___Other_____

4. What is your annual household income?

___$20,000-$29,999 ___$60,000-$69,999
___$30,000-$39,999 ___$70,000-$79,999
___$40,000-$49,999 ___$80,000-$89,999
___$50,000-$59,999 ___$90,000 +

5. What is your age group?

___20-29 ___50-59
___30-39 ___60-69
___40-49 ___70 +

6. How long have you been a woodworker?

___0 - 2 Years ___8 - 20 Years
___2 - 8 Years ___20+ Years

7. How would you rank your woodworking skills?

___Simple ___Advanced
___Intermediate ___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor ___Panel Saw
___Band Saw ___Planer
___Drill Press ___Power Feeder
___Drum Sander ___Radial Arm Saw
___Dust Collector ___Shaper
___Horizontal Boring Machine ___Spindle Sander
___Jointer ___Table Saw
___Lathe ___Vacuum Veneer Press
___Mortiser ___Wide Belt Sander
___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander ___6" - 8" Grinder
___5" - 8" Drill Press ___Mini Lathe
___8" Table Saw ___10" - 12" Thickness Planer
___8" - 10" Bandsaw ___Scroll Saw
___Disc/Belt Sander ___Spindle/Belt Sander
___Mini Jointer
___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

_____

_____

_____

13. What machines/supplies would you like Grizzly Industrial to carry?

_____

_____

_____

14. What new accessories would you like Grizzly Industrial to carry?

___Builders Hardware ___Hand Tools
___Fasteners ___Wood Components
___Other_____

15. What other companies do you purchase your tools and supplies from?

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes ___No

19. Comments:_____

_____

_____

_____

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