

Grizzly **Industrial, Inc.**®

MODEL G0592 10" x 18" Metal Cutting Bandsaw OWNER'S MANUAL



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#PC7789 PRINTED IN TAIWAN

WARNING!

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

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

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

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

WARNING!

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

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

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

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INTRODUCTION

Foreword

We are proud to offer the Model G0592 Metal Cutting Bandsaw. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0592. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0592 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. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

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

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

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

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





MACHINE DATA SHEET

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

MODEL G0592 10" X 18" METAL CUTTING BANDSAW

Product Dimensions:

Weight858 lbs.
Length/Width/Height 74 x 32 x 58 in.
Foot Print (Length/Width)..... 45 x 26 in.

Shipping Dimensions:

TypeWood Slat Crate
Content.....Machine
Weight.....967 lbs.
Length/Width/Height..... 79 x 36 x 49 in.

Electrical:

Switch.....On/Off Located on Saw Bow
Switch Voltage 220V
Cord Length 6 ft.
Cord Gauge 14 gauge
Recommended Breaker Size 20 amp
Plug Yes

Motors:

Main

Type.....TEFC Capacitor Start Induction
Horsepower..... 2 HP
Voltage..... 220V
Prewired 220V
Phase Single
Amps 15A
Speed..... 1720 RPM
Cycle 60 Hz
Number Of Speeds 1
Power Transfer V-Belt Drive
Bearings Shielded and Lubricated

Main Specifications:

Operation Info

Blade Speeds..... 98-394 FPM
Std. Blade Length 132 in.
Head Swivel Right 45°, Left 60°



Cutting Capacities

Angle Cuts	Right 45°, Left 60°
Vise Jaw Depth	7-1/2 in.
Vise Jaw Height	5 in.
Max Capacity Rect. Height At 90°	9-1/2 in.
Max Capacity Rect. Width At 90°	18 in.
Max Capacity Rnd. Width At 90°	10 in.
Max Capacity Rect. Height At 45°	10 in.
Max Capacity Rect. Height At 30°	10 in.
Max Capacity Rect. Width At 30°	14 in.
Max Capacity Rnd. At 30°	10 in.
Max Capacity Rect. Width At 45°	11 in.
Max Capacity Rnd. At 45°	10 in.
Max Capacity Rect. Height At 60°	5 in.
Max Capacity Rect. Width At 60°	8 in.
Max Capacity Rnd. At 60°	8 in.

Construction

Table Construction	Cast Iron
Wheel Construction Upper	Cast Iron
Wheel Construction Lower	Cast Iron
Body Construction	Formed Steel
Base Construction	Cast Iron
Stand Construction	Formed Steel
Wheel Cover Construction	Pre-Formed Steel
Paint	Epoxy

Other

Blade Guides Upper	Ball Bearing
Blade Guides Lower	Ball Bearing
Coolant Capacity	4 gal.

Table Info

Floor To Cutting Area Height	20 in.
------------------------------------	--------

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Grizzly ID Label
Assembly Time	90 minutes

Features:

- Coolant Pump
- Blade Speed Chart
- Variable Speed
- Adjustable Hydraulic Downfeed
- Automatic Shut-off



Identification

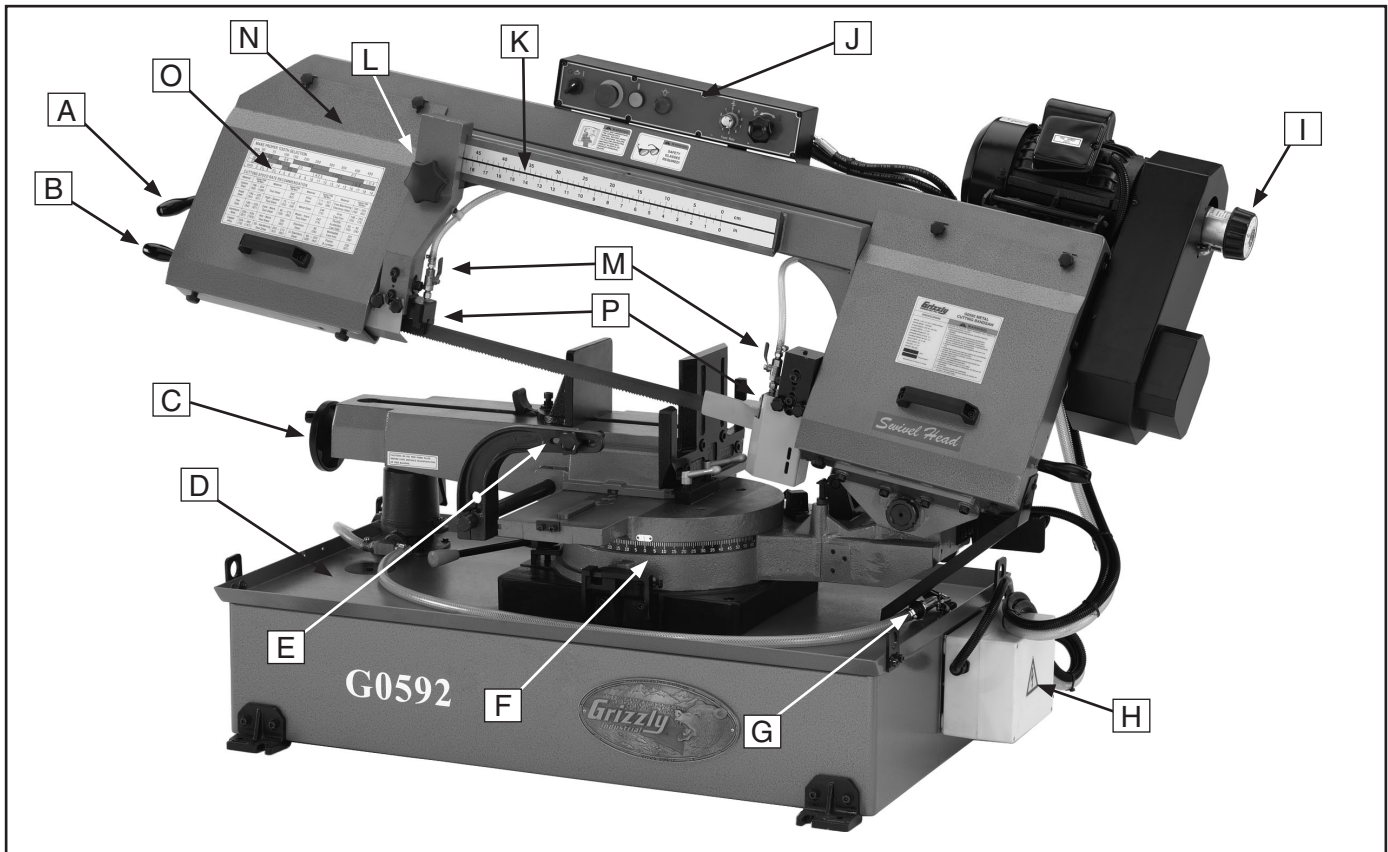


Figure 1. G0592 Machine Identification.

- A. Blade Tension Handle
- B. Lift Handle
- C. Vise Handwheel
- D. Coolant Pan
- E. Work Stop
- F. Rotational Degree Scale
- G. Spray Gun
- H. Electrical Enclosure
- I. Speed Adjustment Knob
- J. Control Panel
- K. Blade Guide Scale
- L. Blade Guide Knob
- M. Coolant Valve Controls
- N. Bow
- O. Speed & Blade Selection Chart
- P. Blade Guides



Control Panel

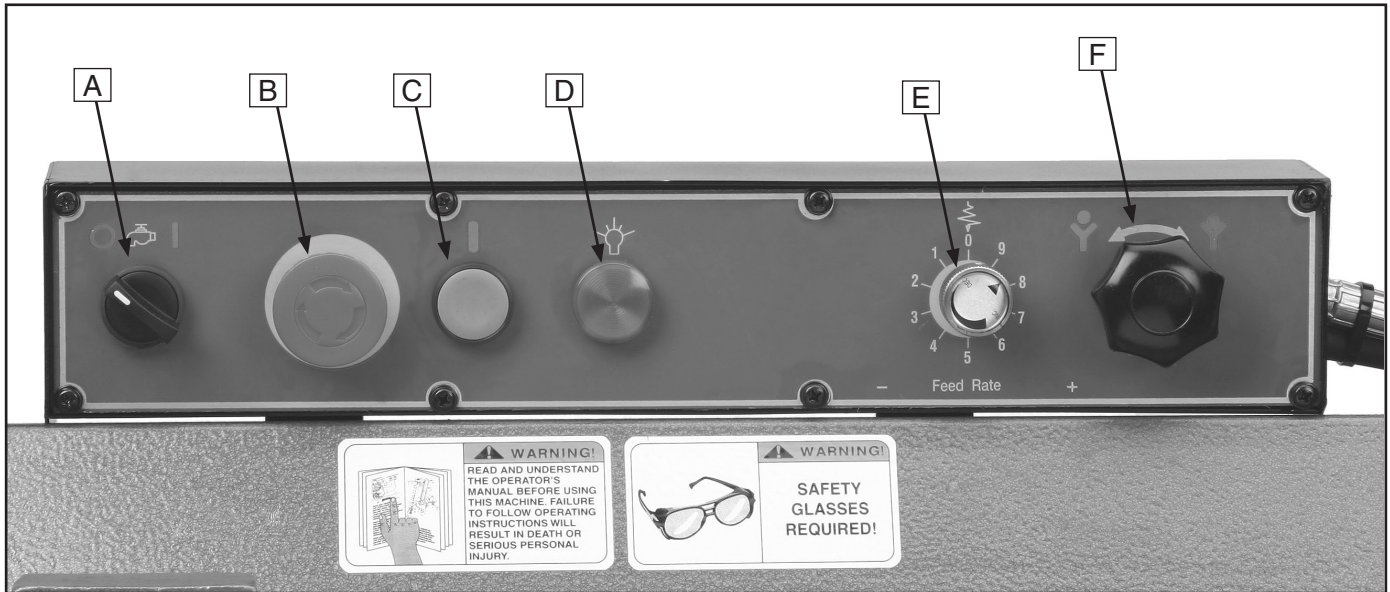


Figure 2. G0592 control panel.

- A. **Coolant Pump Switch:** Turns the coolant pump **ON**.
- B. **EMERGENCY STOP/OFF Button:** Interrupts power to the system and turns the motor **OFF**. Twist the button until it pops out to re-energize the system. Also works as a standard OFF button.

Note: *The bandsaw has an automatic shut-off (limit switch) that turns the machine **OFF** at the completion of the cutting arc.*
- C. **START Button:** Turns the motor **ON** and activates moving parts.
- D. **Power Light:** When lit, indicates that system is energized and machine is ready to operate.
- E. **Feed Rate Dial:** Fine tunes the feed rate by controlling the hydraulic valve. Range is from 1 being slowest to 9 being fastest.
- F. **Feed Control Knob:** Turning the knob to the left lowers the bow at the feed rate you have set. Turning the knob to the right locks the bow in position.

SECTION 1: SAFETY


WARNING

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

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

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.



WARNING

Additional Safety Instructions for Metal Cutting Bandsaws

- 1. BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.
- 2. HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Hands could be crushed in vise or by falling machine components or cut by the blade.
- 3. ENTANGLEMENT HAZARDS.** Do not operate this bandsaw without blade guard in place. Otherwise, loose clothing, jewelry, long hair and work gloves can be drawn into working parts.
- 4. BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Wear gloves to protect hands and safety glasses to protect eyes.
- 5. WORKPIECE HANDLING.** Always support the workpiece with table, vise, or other support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.
- 6. LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall, which could cause serious injury.
- 7. POWER INTERRUPTION.** Unplug machine after power interruption. Machines without magnetic switches can start up after power is restored.
- 8. FIRE HAZARD.** Use EXTREME CAUTION if cutting magnesium. Using the wrong cutting fluid will lead to chip fire and possible explosion.
- 9. CUTTING FLUID SAFETY.** Always follow manufacturer's cutting fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid is a slipping hazard and a toxicity hazard.
- 10. ATTENTION TO WORK AREA.** Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.
- 11. MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the machine **OFF** and the power disconnected to the machine. Wait for all moving parts to come to a complete stop.
- 12. HEARING PROTECTION & HAZARDS.** Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals. Always wear hearing protection.
- 13. HOT SURFACES.** Due to friction, the workpiece, chips, and some machine components can be hot enough to burn you.

WARNING

No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G0592. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



SECTION 2: CIRCUIT REQUIREMENTS

220V Single-Phase

!WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0592 motor draws the following amps under maximum load:

Motor Draw at 220V 15 Amps

Circuit Requirements

We recommend using a dedicated circuit for this machine. You **MUST** connect your machine to a grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

220V Circuit..... 20 Amps

Plug/Receptacle Type

Recommended Plug/Receptacle....NEMA L6-20

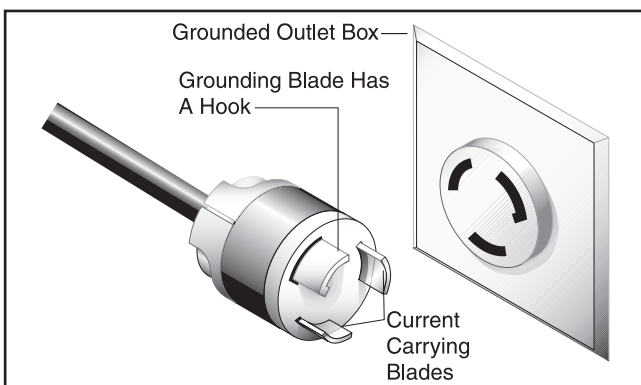
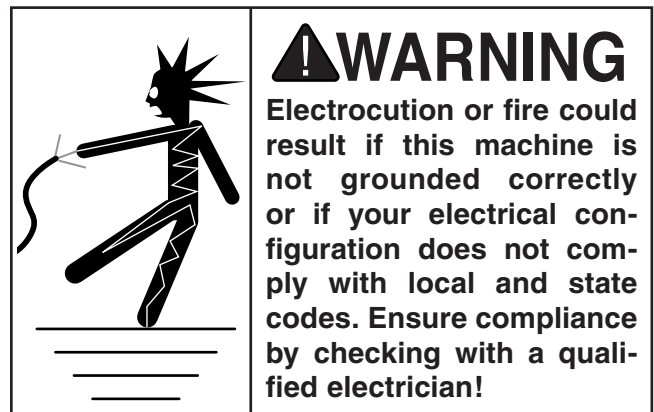


Figure 3. NEMA L6-20 plug and receptacle.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



Extension Cords

We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you find it absolutely necessary to use an extension cord at 220V with your machine:

- Use at least a 12 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.



Inventory

After all the parts have been removed from the crate, you should have the following items:

Box 1: (Figure 4)	Qty
A. Splash Guard	1
B. Lower Chip Tray	1
C. Upper Chip Tray	1
D. Work Stop Rod	1
E. Work Stop Arm	1
F. Work Stop.....	1
G. Leveling Feet.....	4
H. Model G0592 Bandsaw (not shown).....	1

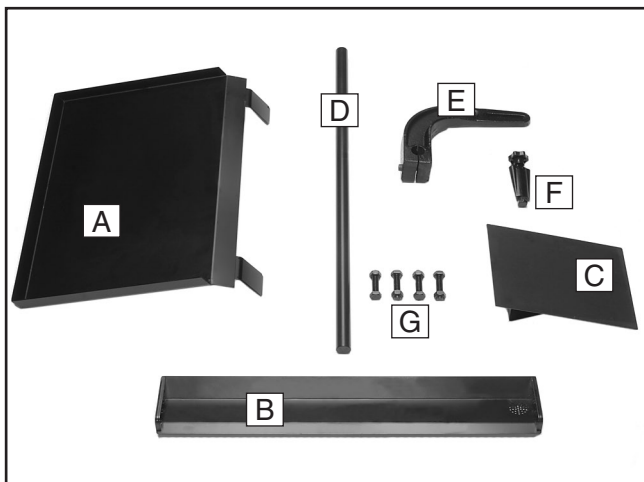


Figure 4. G0592 loose inventory.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

Some hardware/fasteners on the inventory list may arrive pre-installed on the machine. Check these locations before assuming that any items from the inventory list are missing.

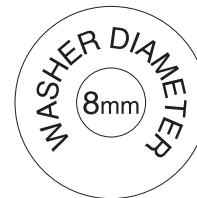
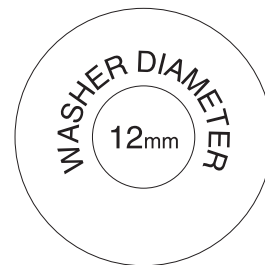
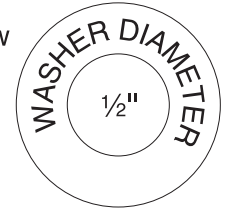
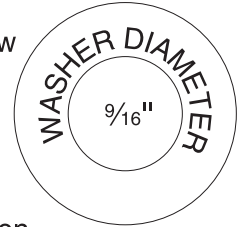
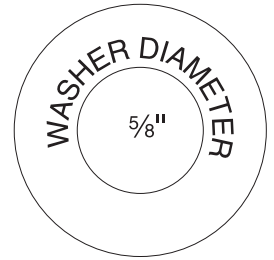
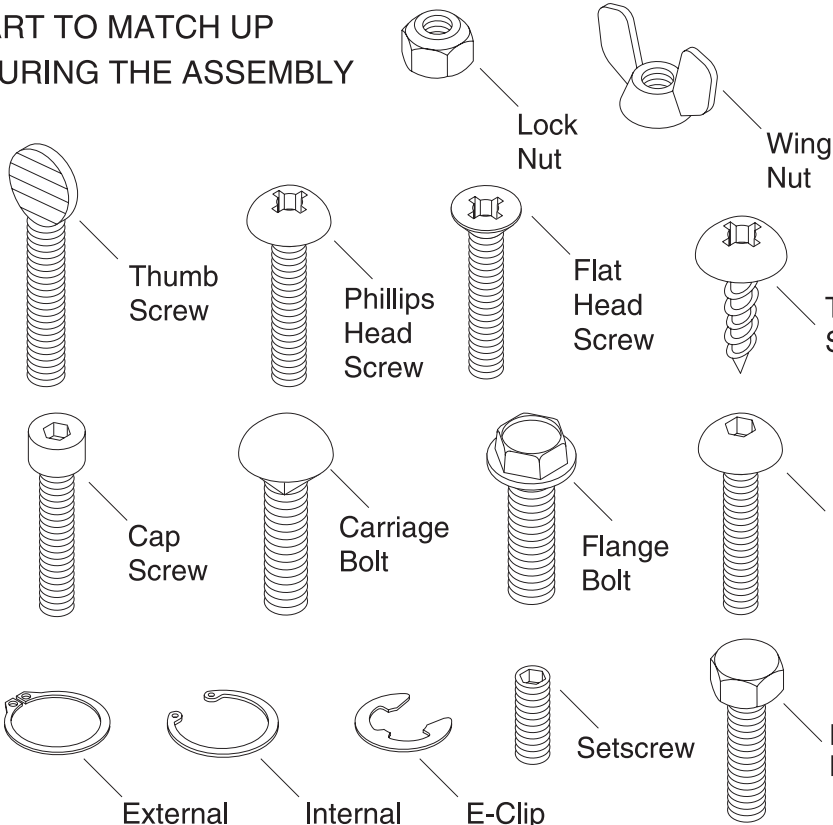


Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

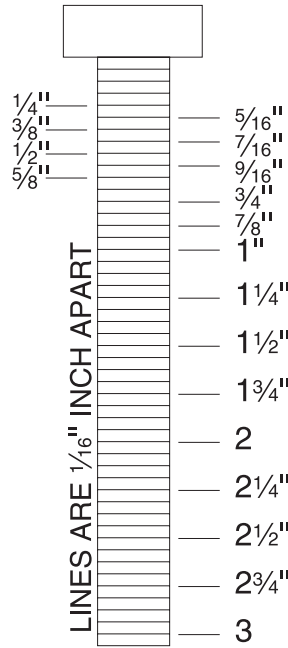
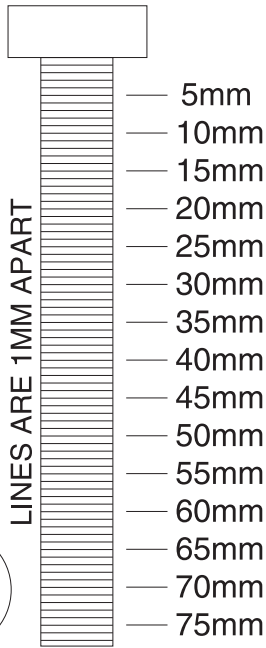
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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



#10

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



WASHERS ARE MEASURED BY THE INSIDE DIAMETER


LINES ARE 1MM APART

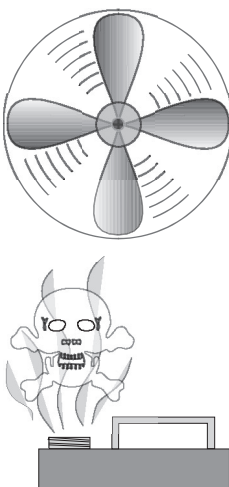
LINES ARE 1/16" INCH APART



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, such as acetone or brake parts cleaner, as they will damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>⚠ WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
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	<p>⚠ CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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Site Considerations

Floor Load

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

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 new machine. See **Figure 5** for the minimum working clearances.

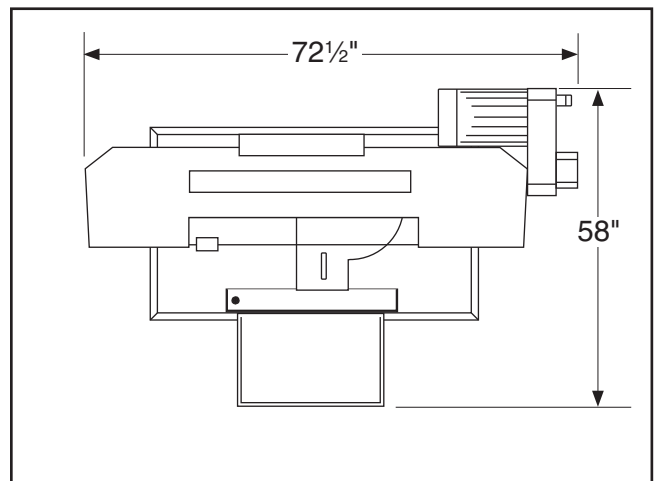
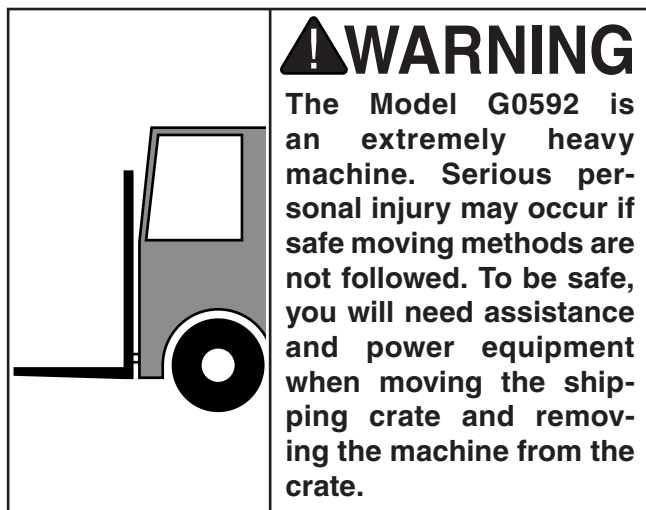


Figure 5. Minimum working clearances.

	<p>⚠ CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
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Moving & Placing Base Unit



Use a forklift and straps rated for the machine weight to lift the machine off the pallet and onto a suitable location (see **Figure 6**).

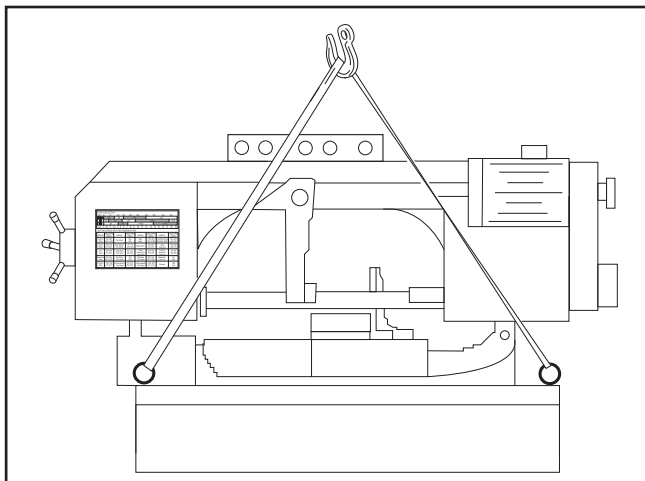


Figure 6. G0592 lifting points.

Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. It will be necessary to level your machine after mounting. If you choose to set your machine on the floor, four M12-1.75 x 50 leveling bolts have been included.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 7**) and anchor studs are two popular methods for anchoring an object to a concrete floor.

NOTICE

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

Using Machine Mounts

Using machine mounts, shown in **Figure 7**, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine.



Figure 7. Typical options for machine mounting.

Shipping Bracket

A bracket has been installed to keep the saw in alignment during shipping. Before using your saw you will need to remove it. Store it for safe keeping, in the event you move your saw to a different location.

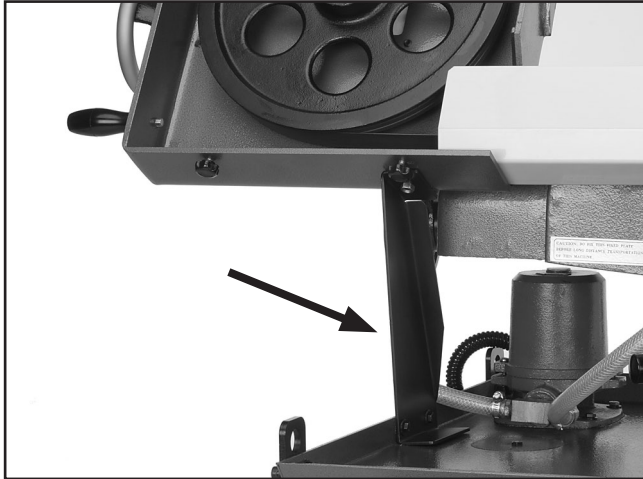


Figure 8. Shipping bracket.

To remove the shipping bracket:

1. Remove the upper hex bolt with a 12mm wrench.
2. Remove the two lower cap screws with a 5mm hex wrench.

Workstop

The workstop on the Model G0592 has three main parts including the workstop rod, arm and workstop. The workstop is easy to adjust and can be set up on either side of the vise.

To install the workstop:

1. Slide the workstop rod in the hole in the base of the vise and tighten the set screw.
2. Slide the arm onto the workstop rod and tighten the set screw.

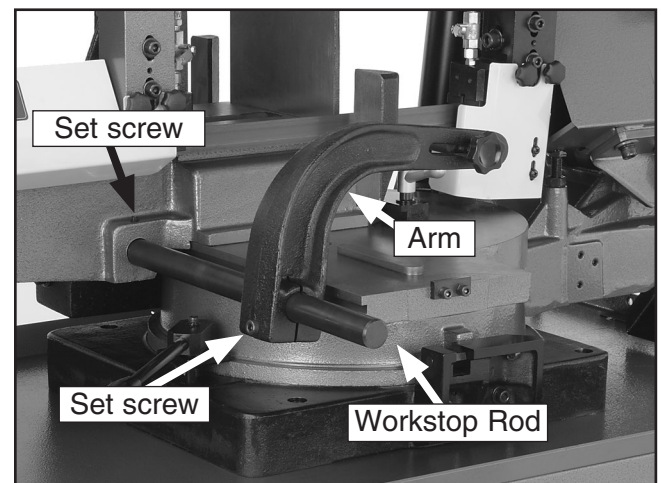


Figure 9. Workstop assembly.

3. Insert the workstop into the arm and secure with the knob.

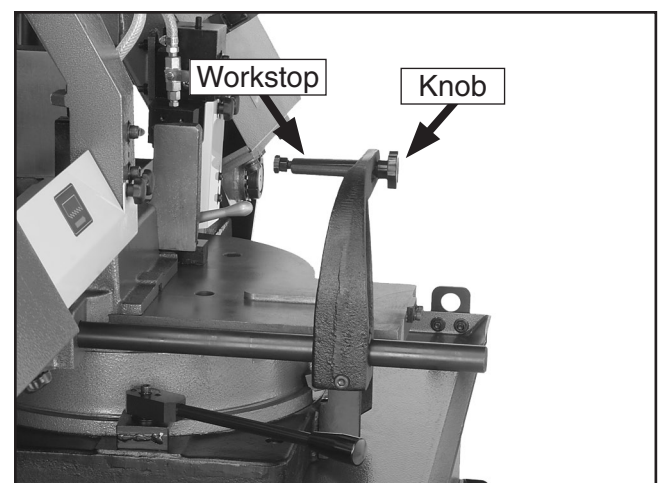


Figure 10. Workstop.

Chip Trays & Splash Guard

Components and Hardware Needed:	Qty
Upper Chip Tray	1
Lower Chip Tray	1
Splash Guard	1

The upper chip tray needs no hardware and rests on the vise and vise base as shown in **Figure 11**.

The lower chip tray rests on the base directly under the upper chip tray. It is not secured so it can be removed for easy clean-up.

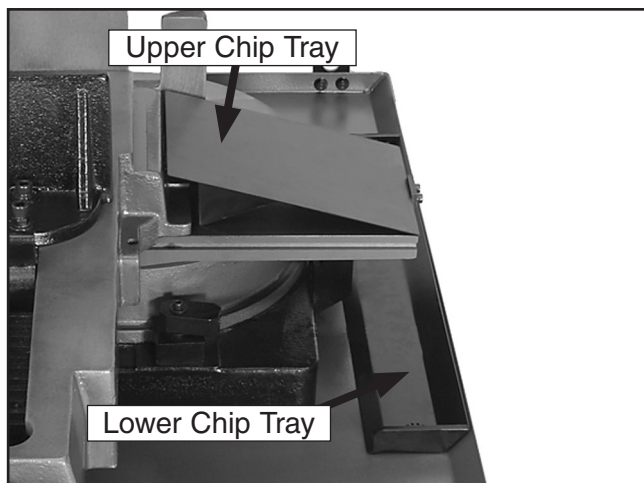


Figure 11. Chip tray set-up.

The splash tray fits over the lip of the base as illustrated in **Figure 12**.

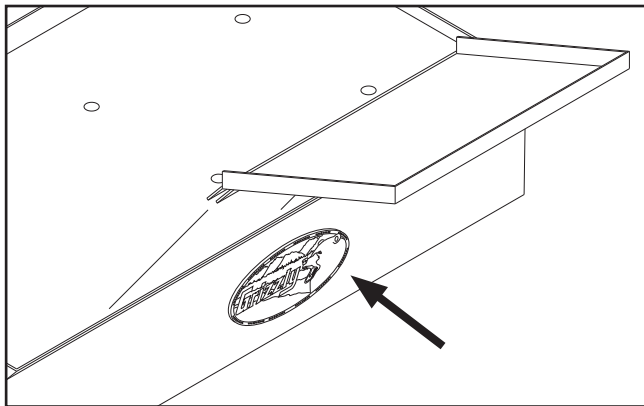


Figure 12. Splash tray installation.

Feed Stop

Depending on how the G0592 was shipped, it may be necessary to adjust the feed stop before the test run. The blade should not make contact with any part of the vise assembly.

To adjust the feed stop bolt:

1. Adjust the feed stop bolt and jam nut (**Figure 13**), so the bandsaw blade teeth are just below the vise table surface when the cut is complete.

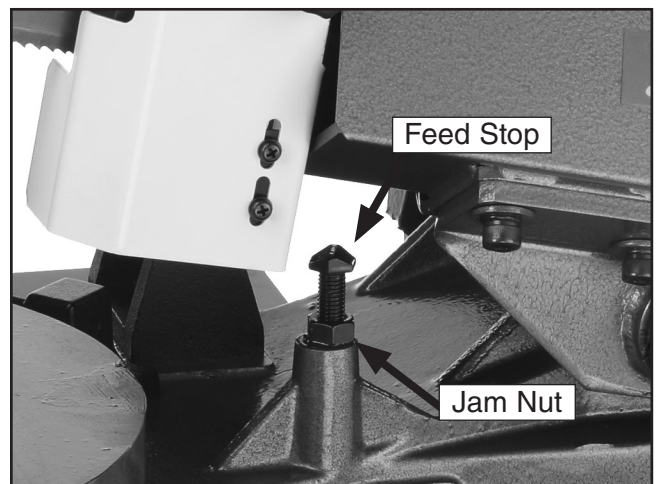


Figure 13. Feed stop.

Recommended Adjustments

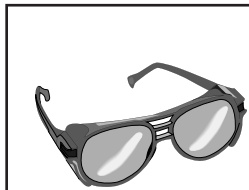
The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure accurate cutting results.

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

Factory adjustments that should be verified:

1. Blade Tracking (**Page 35**).
2. Blade Guide Bearings (**Page 36**).

Test Run



WARNING

Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Put on safety glasses and secure loose clothing or long hair.
4. Connect the bandsaw to power.
5. Raise the bandsaw and close the feed control knob to keep the saw in place.

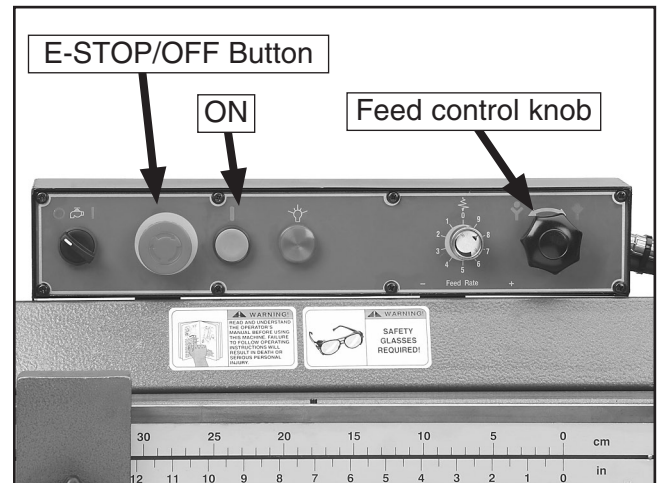


Figure 14. Control panel.

6. Start the bandsaw while keeping your finger near the EMERGENCY STOP/OFF button (**Figure 14**) at all times during the test run. The bandsaw should run smoothly with little or no vibration.

Note: If the EMERGENCY STOP/OFF button is pressed, it needs to be twisted until it pops out or the bandsaw will not start.

—If you suspect any problems, immediately stop the bandsaw and correct before continuing.

—If you need any help with your bandsaw call our Tech Support at (570) 546-9663.

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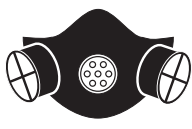


SECTION 4: OPERATIONS

Operation Safety

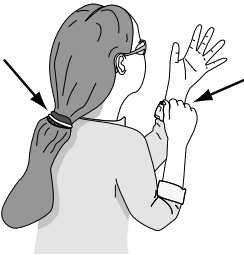
!WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



!WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.



NOTICE

This bandsaw is for trained operators only. **WE STRONGLY RECOMMEND** that you read books, trade magazines, and get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Vise

The vise on the Model G0592 can be positioned for cutting on both sides of the vise. It also has a ratcheting type leadscrew that allows for fast jaw adjustments.

To change vise positions:

1. Remove the chip trays and the splash guard.
2. Raise the bow to the maximum height and lock in place.
3. Loosen the two vise locks at the base of the vise and remove the upper chip tray (see **Figure 15**).

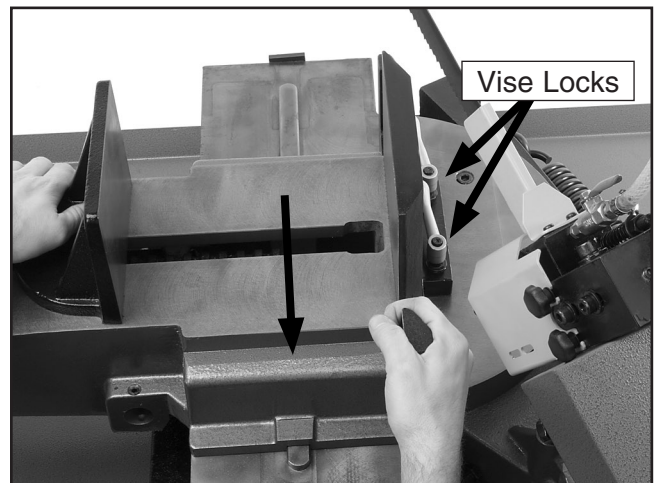


Figure 15. Changing vise positions.

4. Pull the vise all the way to the opposite side of the base and lock it in position (see **Figure 16**).
5. Install the chip trays and splash guards to the new side.

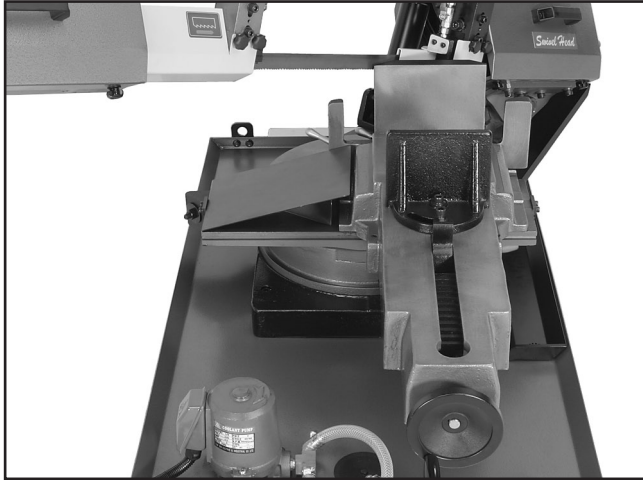


Figure 16. Vise to the right.

⚠ CAUTION

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

The vise jaw width can be quickly adjusted when changing from one sized material to another.

To rapidly change the vise jaw gap:

1. Use the handwheel to relieve any pressure on the vise jaw.
2. Flip the latch up to disengage it from the leadscrew (see **Figure 17**).
3. Pull or push the jaw in the desired direction.
4. Engage the lever with the leadscrew and finish tightening the jaw with the handwheel.

Note: *Figure 18* shows the proper methods for holding different workpiece shapes.



Figure 17. Vise jaw positioning.

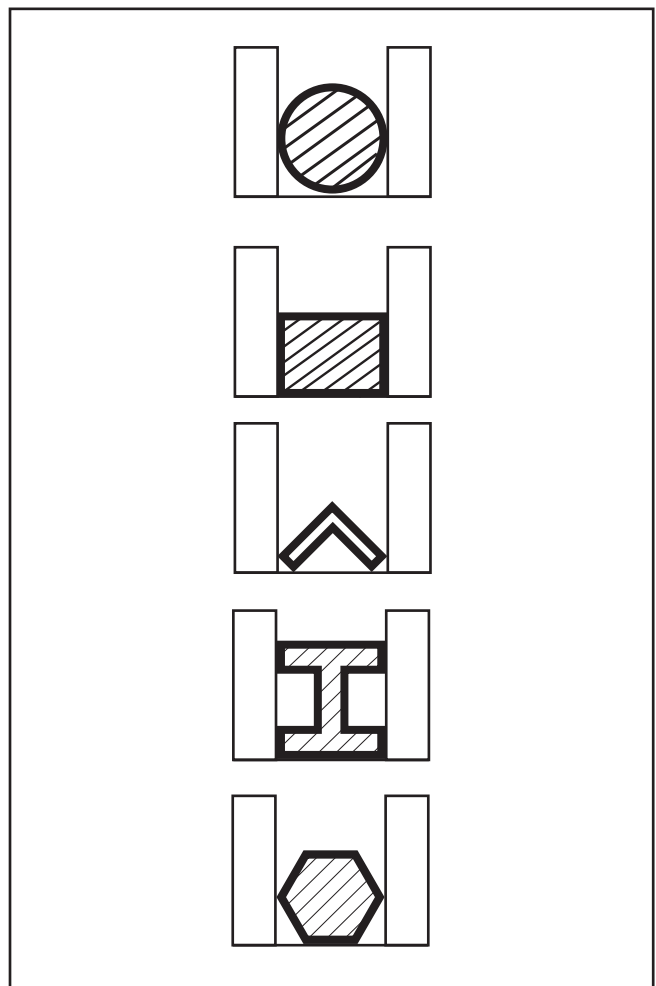


Figure 18. Workholding options by material shape.

Cutting Angle

The G0592 has a locking turret that can be adjusted to 60° clockwise to 45° counterclockwise.

To change the angle:

1. Raise the bow to the highest position and lock in place.
2. Flip the stop out as shown in **Figure 19**.

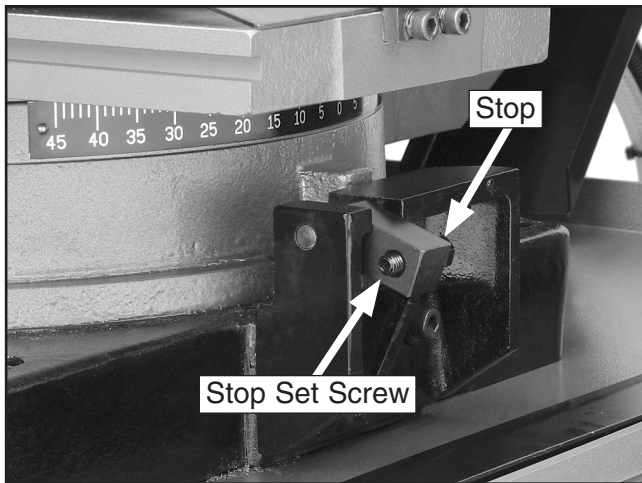


Figure 19. Stop.

3. Loosen the swivel lock lever (**Figure 20**), rotate the turret to the desired angle, then retighten the swivel lock lever.

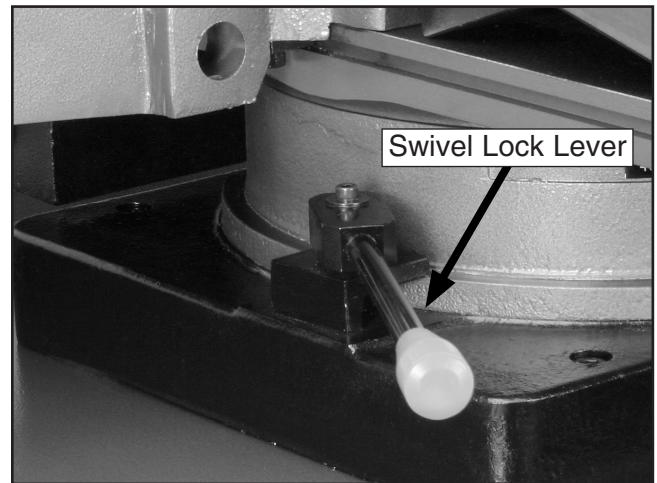


Figure 20. Swivel lock lever.

4. To return to 0°, flip the stop up.

Note: Adjust the set screw on the stop to calibrate the scale to the stop.

Blade Selection

The Model G0592 uses 132" x 1" bandsaw blades.

Selecting the right blade for the job depends on a variety of factors, such as the type of material being cut, hardness of the material, material shape machine capability, and operator technique.

We suggest you do some research for your specific situation so you get the best blade to match your needs.

Grizzly offers a variety of selections that can be found in the current catalog and in **SECTION 5: ACCESSORIES** on **Page 28**.

The chart shown in **Figure 21** is a reproduction of the chart you will find on the blade cover of your G0592. Use it as a rough guideline.

Blade Speed

The Model G0592 has a variable speed control ranging from 98 to 394 feet per minute (FPM).

NOTICE

Only change speeds while the motor is running. Changing speeds when machine is OFF may result in damage to your machine. Always make sure belt guard is in use.

To change blade speeds:

1. Turn the bandsaw **ON** and allow it to come up to speed.
2. Turn the speed adjustment knob (**Figure 23**), clockwise to decrease blade speed and counterclockwise to increase blade speed.

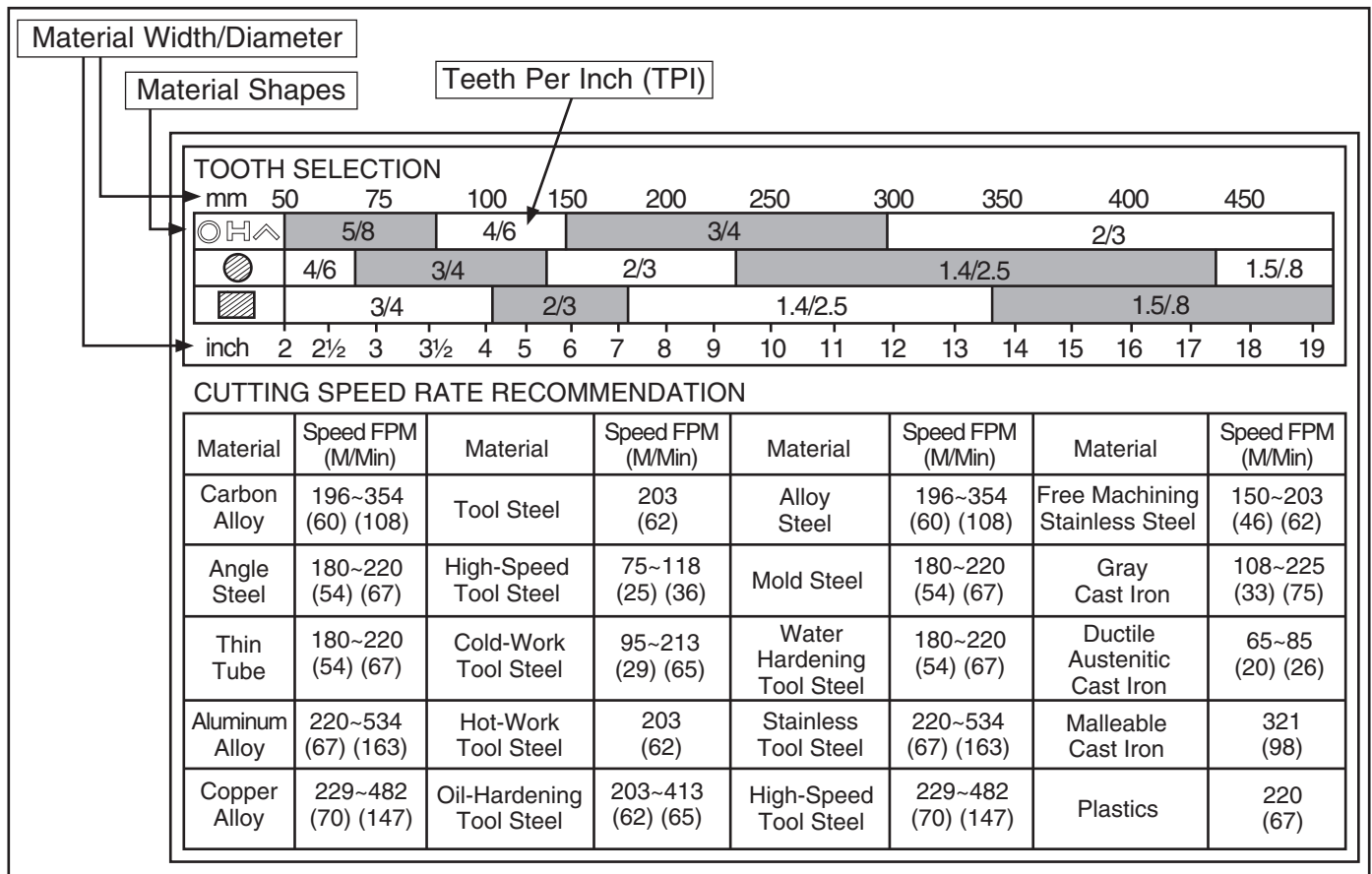


Figure 21. G0592 Blade selection and speed chart.



The table shown in **Figure 22** is a sampling of speed rates for various materials. Use these as a guideline.

Material	Alloy ASTM Number	Blade Speed	
		Ft/Min	Mtrs/Min
Copper Alloys	173,932	314	96
	330,365	284	87
	623,624	264	81
	230,260,272	244	74
	280,264,632,655	244	74
	101,102,110,122,172	234	71
	1751,182,220,510	234	71
	625, 706, 715, 934	234	71
	630	229	70
	811	214	65
Carbon Steels	1117	339	103
	1137	289	88
	1141,1144	279	85
	1141 High Stress	279	85
	1030	329	100
	1008,1015,1020,1025	319	97
	1035	309	94
	1018,1021,1022	299	91
	1026,1513	299	91
	A36 (SHAPES),1040	269	82
	1042,1541	249	76
	1044,1045	219	67
	1060	199	61
1095	184	56	
Nickle	8615, 8620, 8622	239	73
Chrome	4340, E4340, 8630	219	67
Molybdenum	8640	199	61
Alloys	E9310	174	53
Tool Steels	A-6	199	61
	A-2	179	55
	A-10	159	49
	D-2	90	27
	H-11,H-12,H-13	189	58
Stainless Steels	420	189	58
	430	149	46
	410,502	140	43
	414	115	35
	431	95	29
	440C	80	24
	304, 324	120	36
	304L	115	35
	347	110	33
	316, 316L	100	30
416	189	58	

Figure 22. Material speed table.

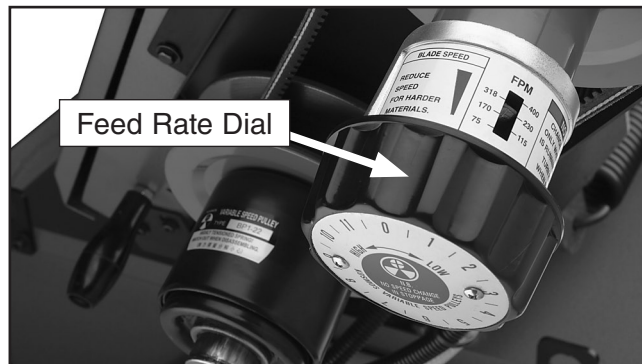


Figure 23. Feed rate dial (shown with guard removed).

Feed Rate

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

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

To set the feed rate:

1. Raise the bow to the highest position.
2. Set the **Feed Rate Dial** to the desired feed rate. Range is from 1 being slowest, to 9 being fastest.
3. Turning the **Feed Control Knob** to the left to lower the bow at the feed rate you have set. Turning the knob to the right locks the bow in position.

- If you get a tightly curled, warm shavings, brown to black in color, you are using too much downward pressure.
- Blue looking chips are from extreme heat with a high band saw speed.
- Thin powder-like chips are from insufficient feed pressure. This will dull your blade rapidly.

- The best cut and feed rate will give you evenly shaped spiraled curls with very little color change, if any at all.



Blade Guides

The rear blade guide should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust the rear blade guide:

1. Loosen the knob shown in **Figure 24** and slide the rear blade guide as close to the workpiece as possible, then tighten the knob.

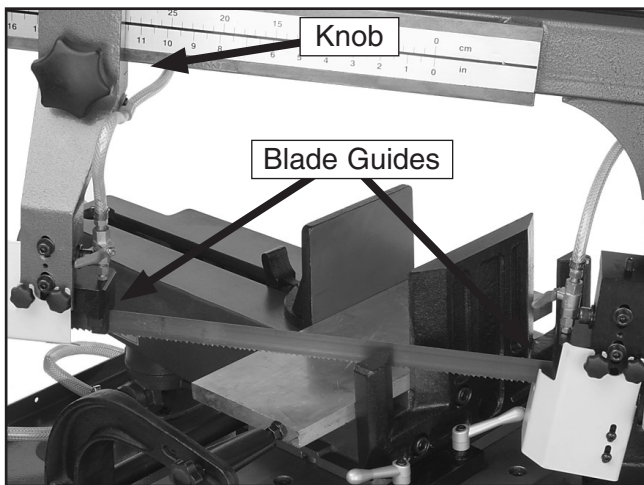


Figure 24. Blade guides.

The front blade guide has a wire brush that makes contact with the blade to help clear away chips and extend blade life (see **Figure 25**).

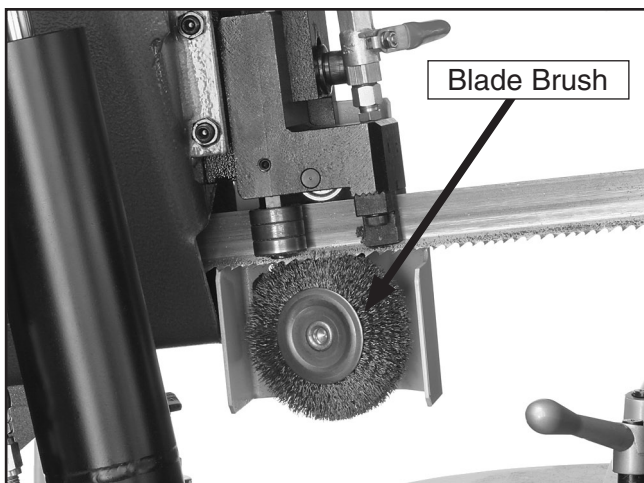



Figure 25. Blade brush.

Coolant System

	<p>!WARNING FIRE HAZARD! DO NOT cut magnesium when using oil-water solutions as a cutting fluid! Always use a cutting fluid intended for magnesium. The water in the solution will cause a magnesium-chip fire.</p>
--	---

This bandsaw has a built-in coolant system that extends the life of your bandsaw blades by lowering the temperature of the blade and workpiece. It also has a convenient spray gun to help you clean the saw at the end of the day.

See **Cutting Fluid** on **Page 27** for additional information.

To use the coolant system:

1. Access the reservoir by removing the front panel (see **Figure 26**).
2. Thoroughly clean and remove any foreign material that may have fallen inside the reservoir during shipping.
3. Fill the reservoir with your chosen cutting fluid solution and replace the front panel.

Continued on next page →

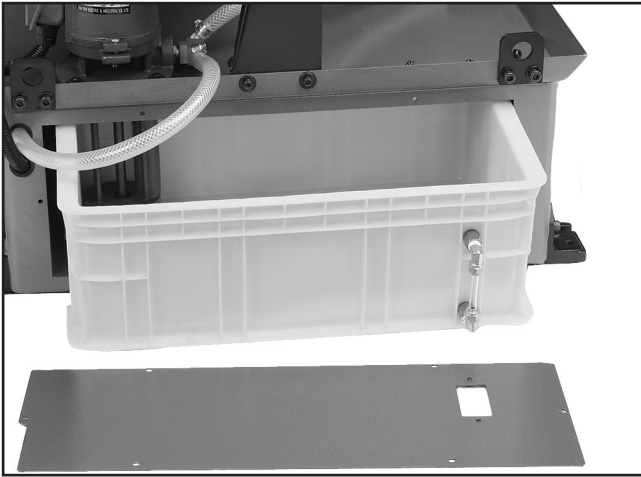


Figure 26. Coolant system reservoir and cover.

- Adjust the valves on the coolant hoses to control the flow of coolant (see **Figure 27**). Make sure that the pressure is not so high that coolant spills on the floor and creates a slipping hazard.

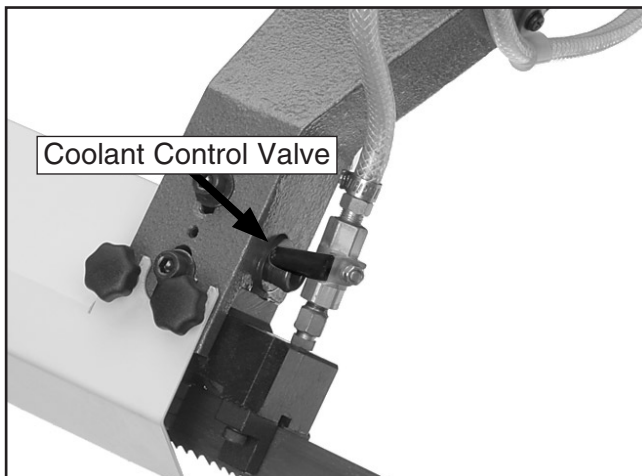


Figure 27. Coolant control valve.

- Turn the coolant pump switch **ON** before making your cut.

NOTICE

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

- Monitor the coolant level frequently to keep the system working properly. **DO NOT** let coolant level fall out of view on the sight glass (see **Figure 28**).

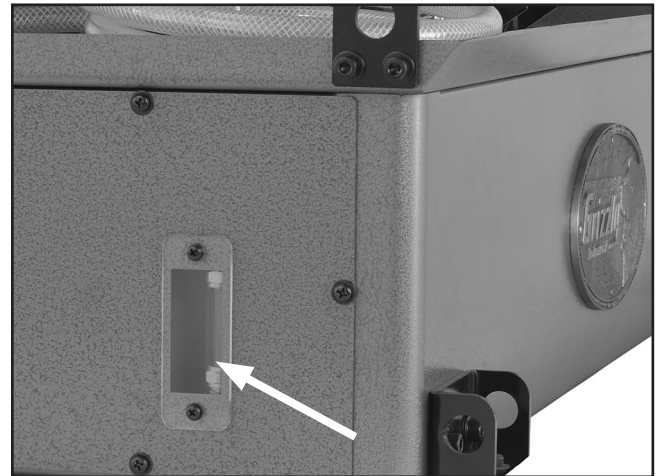


Figure 28. Coolant level sight glass.

To use the spray gun:

- Close the coolant control valves.
- Turn the coolant pump switch **ON**. You are ready to spray.

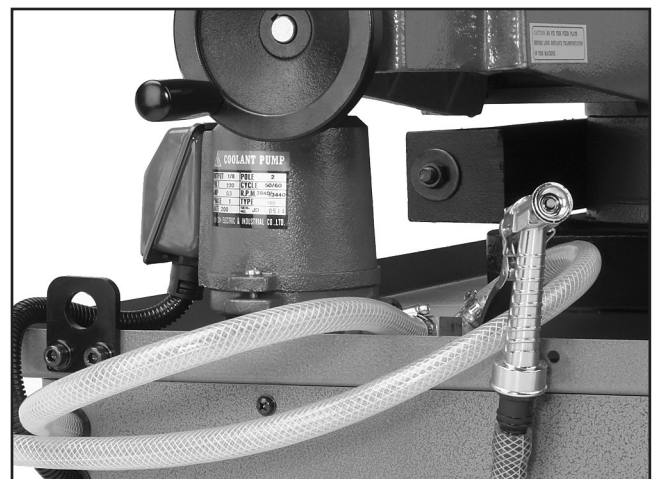
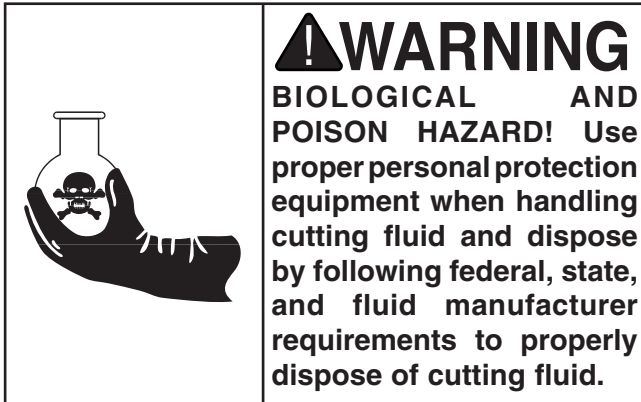


Figure 29. Spray gun.

Cutting Fluid



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

Use the selections below to choose the appropriate cutting fluids:

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

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

Operation Tips

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

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material and use the positive lock to speed production.
- Let the blade reach full speed before engaging the workpiece.
- Never start a cut with the blade in contact with the workpiece and do not start a cut on a sharp edge.
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate.
- Burned chips indicate a need to reduce your blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut, and flag the ends to alert passers-by of potential danger.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

NOTICE

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



SECTION 5: ACCESSORIES

Tool Steel Blades

H2303—132 x 1 x .032 10 TPI Raker

H2304—132 x 1 x .032 14 TPI Raker

Variable Pitch Bi-Metal Blades

H1146—132 x 1 x .032 3-4 Variable Pitch

H1147—132 x 1 x .032 4-6 Variable Pitch

H1148—132 x 1 x .032 5-8 Variable Pitch

H1149—132 x 1 x .032 6-10 Variable Pitch

H1150—132 x 1 x .032 8-12 Variable Pitch

H1151—132 x 1 x .032 10-14 Variable Pitch

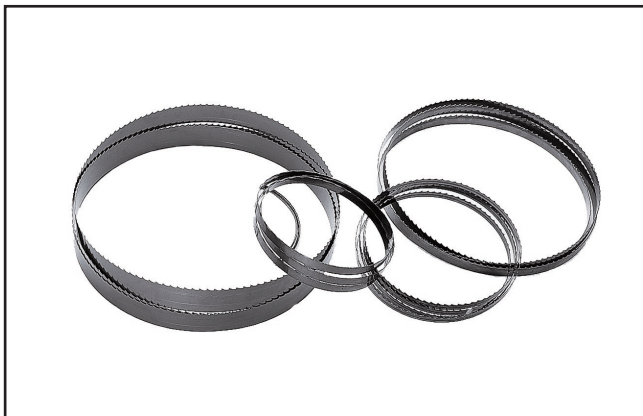


Figure 30. Blades

H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 31. H5408 Blade Tensioning Gauge.

H5405—Lenox® Lube Tube™

Lenox® Lube Tube™ is a stick lubricant designed to prevent heat buildup. Apply it directly to the blade to improve overall blade life and productivity. Can be used on ferrous and non-ferrous metals. Biodegradable, non-toxic, and non-staining 14.5 oz tube.



Figure 32. Lenox® Lube Tube™.

G7897—Machining Fluid

This biostable, soluble oil for heavy-duty machining applications provides stable pH performance, which resists bacteria, fungal growth, rancidity and odors. Can be used in light or heavy machining. Mix with water, 1:21 for general use or 1:11-1:16 for heavy use.



Figure 33. G7897 Machining Fluid.

Call 1-800-523-4777 To Order



G5618—Deburring Tool with Two Blades

G5619—Extra Aluminum Blades

G5620—Extra Brass and Cast Iron Blade

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



Figure 34. G5618 Deburring tool.

H1302—Standard Earmuffs

H4979—Deluxe Twin Cup Hearing Protector

H4977—Work-Tunes Radio Headset Earmuffs

Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 36. Our most popular earmuffs.

G7984—Face Shield

H1298—Dust Sealed Safety Glasses

H1300—UV Blocking, Clear Safety Glasses

H2347—Uvex® Spitfire Safety Glasses

H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

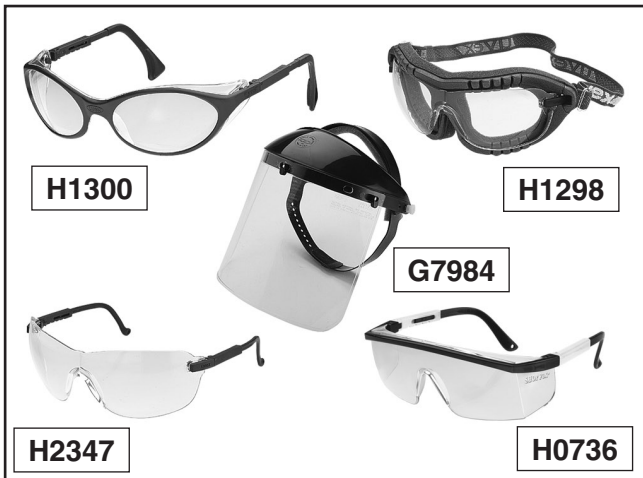


Figure 35. Our most popular safety glasses.

G9256—6" Dial Caliper

G9257—8" Dial Caliper

G9258—12" Dial Caliper

These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display.

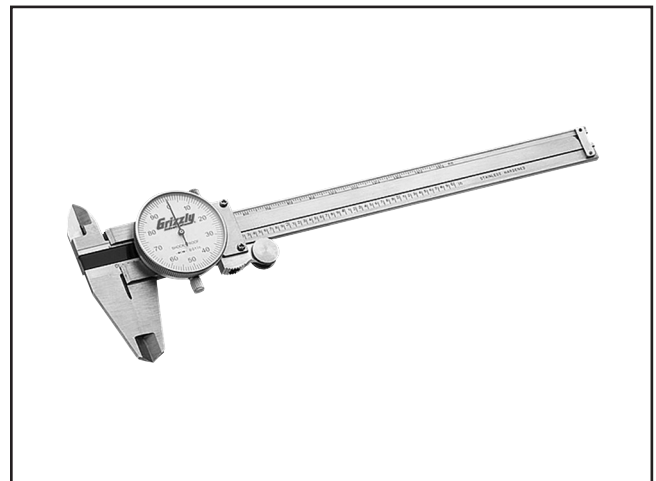
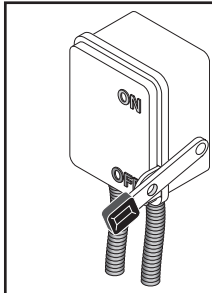


Figure 37. Grizzly® Dial Calipers.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



! WARNING
Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

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

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Clean after each use.
- Proper blade tension.
- Coolant level.

Monthly Check:

- Lubricate vise screw.
- Check gear box fluid level.

Annual Check:

- Change gear box oil (every four months if being used daily).

Cleaning

Cleaning the Model G0592 is relatively easy. After using your bandsaw, remove excess chips by using the spray gun and by sweeping. Then remove chips for recycling.

Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise leadscrew and the grease fittings at the pivot point shown in **Figure 38** with general purpose grease.

All bearings on the Model G0592 are lubricated and sealed for the life of the bearing. No further attention is needed until it is time to replace the bearing.

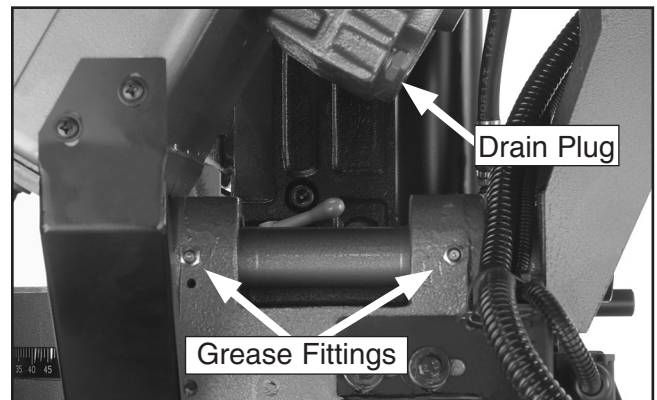


Figure 38. Lubrication points.

The gearbox should be drained and refilled after the first 50 hours of use and then once every four months. Use a high quality, ISO 680 grade synthetic gear oil.

To change the gear oil:

1. Run the bandsaw for ten minutes to warm up the oil in the gearbox.
2. DISCONNECT THE BANDSAW FROM THE POWER SOURCE!
3. Raise the bow to the highest angle and close the feed control knob to lock the bow in position.
4. Drain the gearbox by removing the drain plug shown in **Figure 38**.



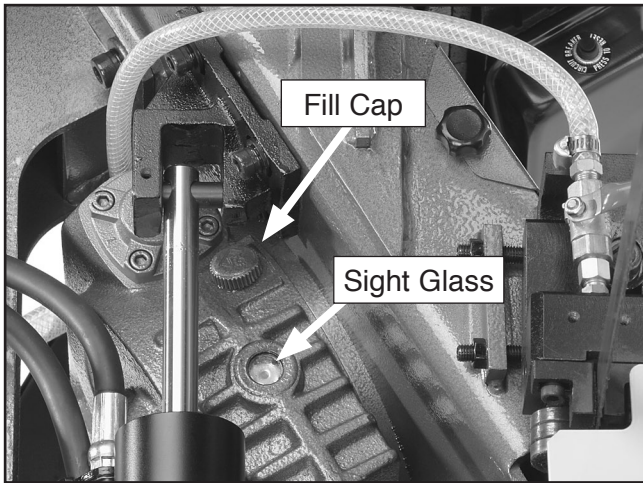


Figure 39. Gear box lubrication.

5. Replace the drain plug, then lower the bow to its lowest position.
6. Open the fill cap and fill the gearbox with oil until you see the oil level reach the halfway point in the sight glass (see **Figure 39**).
7. Tighten the fill plug, connect the machine to power and run the saw for a minute or two—then reinspect the oil level. Add more oil if needed to maintain level at the halfway mark in the sight glass.

8. Lubricate the leadscrew as needed with general purpose grease. Apply a thin layer all along the leadscrew surface (see **Figure 40**).

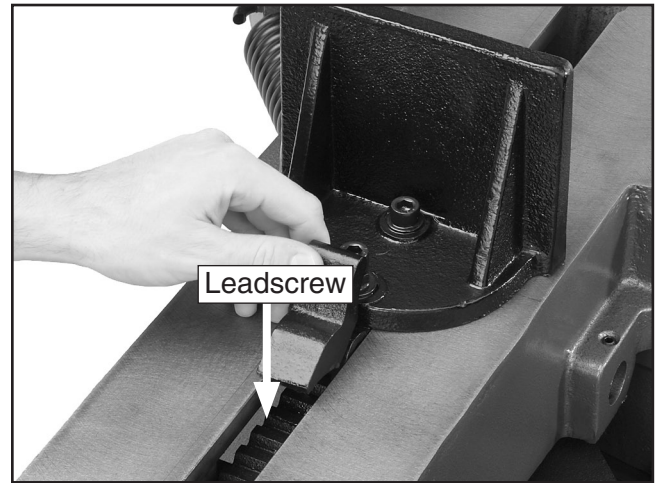
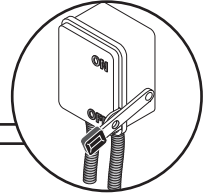


Figure 40. Vise leadscrew lubrication area.

SECTION 7: SERVICE

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

Troubleshooting

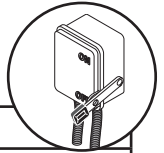


Motor & Electrical

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. E-Stop button pressed. 2. Plug/receptacle is at fault or wired incorrectly. 3. Start capacitor is at fault. 4. Wall fuse/circuit breaker is blown/tripped. 5. Motor connection wired incorrectly. 6. Power supply is at fault/switched OFF. 7. Motor ON/OFF switch is at fault. 8. Wiring is open/has high resistance. 9. Motor is at fault. 	<ol style="list-style-type: none"> 1. Twist E-Stop button until it pops out. 2. Test for good contacts; correct the wiring. 3. Test/replace capacitor if faulty. 4. Ensure correct size for machine load; replace weak breaker. 5. Correct motor wiring connections. 6. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 7. Replace faulty ON/OFF switch. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Test/repair/replace.
Machine stalls or is under-powered.	<ol style="list-style-type: none"> 1. Wrong blade for the workpiece material. 2. Wrong workpiece material. 3. Feed rate/cutting speed too fast for task. 4. Blade is slipping on wheels. 5. Low power supply voltage. 6. Motor bearings are at fault. 7. Plug/receptacle is at fault. 8. Motor connection is wired incorrectly. 9. Motor has overheated. 10. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use blade with correct properties for your type of cutting. 2. Use metal with correct properties for your type of cutting. 3. Decrease feed rate/cutting speed. 4. Adjust blade tracking and tension. 5. Ensure hot lines have correct voltage on all legs. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test for good contacts; correct the wiring. 8. Correct motor wiring connections. 9. Clean off motor, let cool, and reduce workload. 10. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor fan is rubbing on fan cover. 2. Blade is at fault. 3. Gearbox is at fault. 4. Wrong blade for material. 5. Speed is set too slow. 	<ol style="list-style-type: none"> 1. Replace dented fan cover; replace loose/damaged fan. 2. Replace/resharpen blade. 3. Rebuild gearbox for bad gear(s)/bearing(s). 4. Change blade. 5. Adjust speed as required.



Bandsaw Operations



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> Excessive feed rate. The blade TPI is too great, or the material is too coarse. 	<ol style="list-style-type: none"> Refer to Feed Rate on Page 24, or Changing Blade Speed on Page 23, and adjust as required. Refer to Blade Selection on Page 23 and adjust as required.
Blades break often.	<ol style="list-style-type: none"> Blade is not tensioned correctly. The workpiece is loose in the vise. The feed or cut speed is wrong. The blade TPI is too great, or the material is too coarse. The blade is rubbing on the wheel flange. The bandsaw is being started with the blade resting on the workpiece. The guide bearings are misaligned, or the blade is rubbing on the wheel flange. The blade is too thick, or the blades are of low quality. 	<ol style="list-style-type: none"> Check to see that blade is not excessively tight or too loose. Clamp the workpiece tighter, or use a jig to hold the workpiece. Refer to Feed Rate on Page 24, or Changing Blade Speed on Page 23, and adjust as required. Refer to Blade Selection on Page 23, and adjust as required. Refer to Blade Tracking on Page 35, and adjust as required. Start bandsaw and then slowly lower the headstock by setting the feed rate. Refer to Blade Tracking on Page 35, or Blade Guides on Page 25, and adjust as required. Use a higher quality blade.
Blade dulls prematurely.	<ol style="list-style-type: none"> The cutting speed is too fast. The blade TPI is too coarse. The blade feed pressure is too light. The workpiece has hard spots, welds, or scale is on the material. The blade is twisted. The blade is slipping on the wheels. 	<ol style="list-style-type: none"> Refer to Changing Blade Speed on Page 23, and adjust as required. Refer to Blade Selection on Page 23, and adjust as required. Refer to Feed Rate on Page 24, and adjust as required. Increase the feed pressure, and reduce the cutting speed. Replace the blade. Refer to Blade Tension on Page 35, and adjust as required.
Blade wears on one side.	<ol style="list-style-type: none"> The blade guides are worn or mis-adjusted. The blade guide slide bracket is loose. The wheels are out of alignment. 	<ol style="list-style-type: none"> Refer to Blade Guides on Page 25 and replace or adjust. Tighten the blade guide bracket. Refer to Blade Tracking on Page 35, and adjust as required.
Teeth are ripping from the blade.	<ol style="list-style-type: none"> The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. The workpiece is vibrating in the vise. The blade gullets are loading up with chips. 	<ol style="list-style-type: none"> Refer to Blade Selection on Page 23 and decrease the feed pressure. Refer to Feed Rate on Page 24, and adjust as required. Re-clamp the workpiece in the vise, and use a jig if required. Use a coarser-tooth blade.
The cuts are crooked.	<ol style="list-style-type: none"> The feed pressure is too high. The guide bearings are out of adjustment, or too far away from the workpiece. The blade tension is low. The blade is dull. The blade speed is wrong. 	<ol style="list-style-type: none"> Refer to Feed Rate on Page 24, and adjust as required. Refer to Blade Guides on Page 25 and replace or adjust. Refer to Blade Tension on Page 35, and adjust as required. Refer to Blade Change on Page 34 and replace the blade. Refer to Changing Blade Speed on Page 23, and adjust as required.



Blade Change

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

To change the blade on the bandsaw:

1. DISCONNECT THE BANDSAW FROM POWER!
2. Raise the bow of the bandsaw to the highest position, close the feed control knob, and remove the wheel access cover.
3. Slide the blade guard all the way down as shown in **Figure 41**.

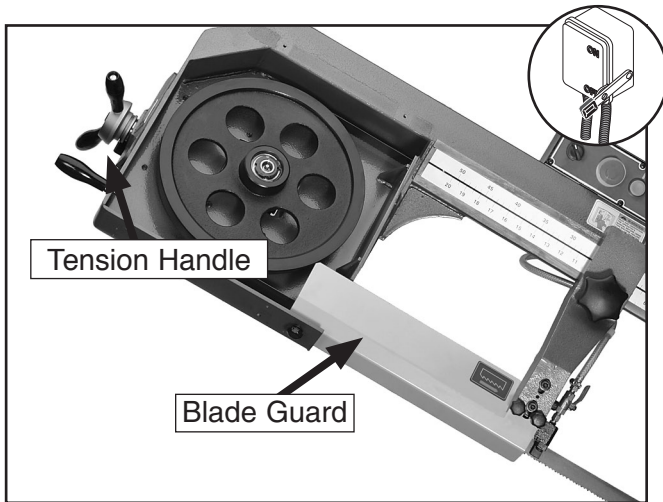


Figure 41. Tension handle and blade.

4. Remove the blade guard and wire wheel from the front of the bandsaw as shown in **Figure 42**.

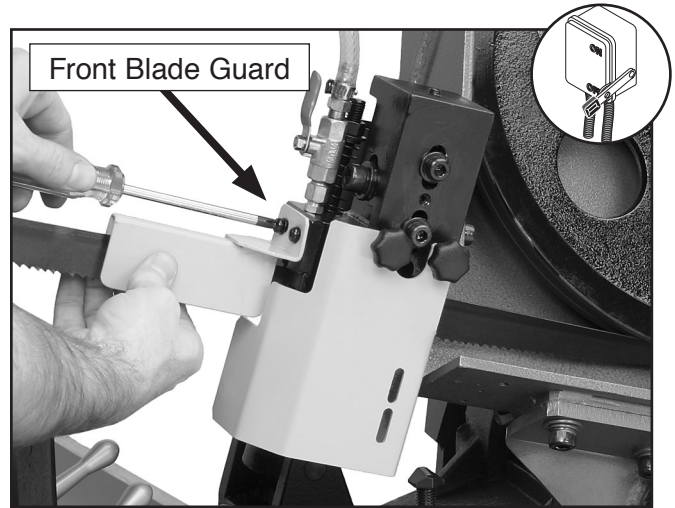


Figure 42. Removing front blade guard.

5. Loosen the blade tension handle in **Figure 41** and slip the blade off of the wheels.
6. Install the new blade through both blade guide bearings, as shown in **Figure 43**, and around the bottom wheel.

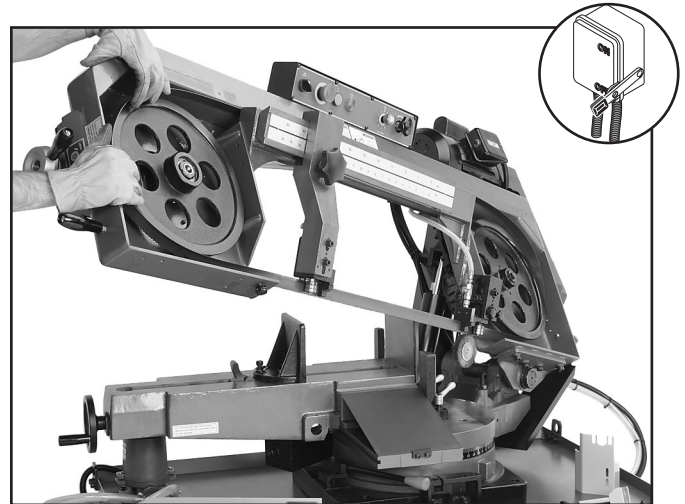


Figure 43. Installing the blade.

7. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

CAUTION

**CUTTING HAZARD! Blades are sharp!
Wear heavy leather gloves when handling
blades to prevent cuts.**

Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 44**, after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

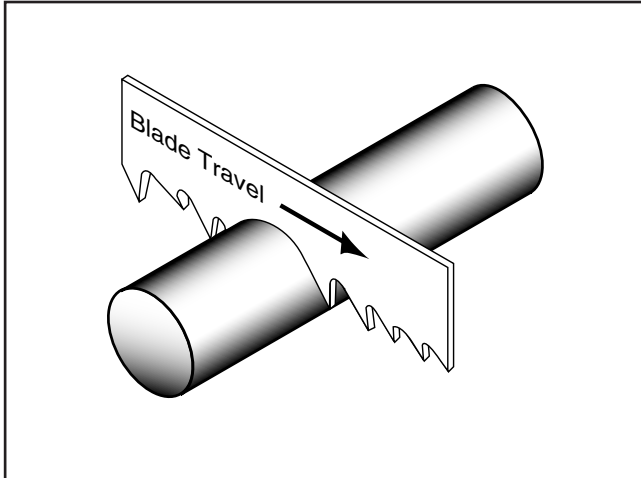


Figure 44. Blade cutting direction.

- When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels.
- Complete the blade change by following the steps in the next section, **Blade Tension & Tracking**.

Blade Tension & Tracking

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting. The Model G0592 features a blade tension indicator to assist you with blade tensioning.

Two major signs that you do not have proper blade tension are: 1) the blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too tight.

NOTICE

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

To tension the blade on the bandsaw:

- Turn the blade tension handle clockwise to tension the blade.
- Use the graduated scale on the blade tension indicator (**Figure 45**) to determine blade tension in PSI.
 - For carbon blades, the blade tension should be 20,000 PSI.
 - For bi-metal blades, like the one supplied with your machine, the blade should be tensioned from 30,000 to 35,000 PSI.
- To fine tune blade tension, use a blade tensioning gauge, like the one found in **SECTION 5: ACCESSORIES** on **Page 28**. Please follow the instructions included with your gauge and the blade manufacturer's recommendations on blade tension.

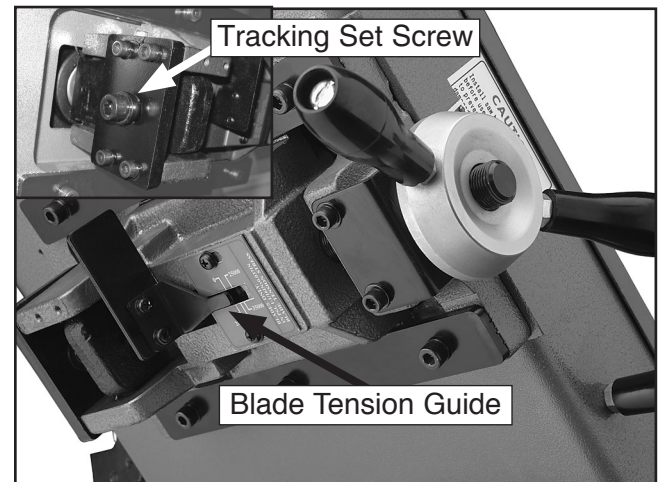


Figure 45. Blade tension guide.

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly. The blade is tracking properly when the back of the blade is lightly touching the flange of both wheels.

To adjust the blade tracking on the bandsaw:

- Turn the tracking set screw (hidden from view) in **Figure 45** until the blade is tracking properly.

Blade Guide Bearings

The blade guide bearings are adjusted at the factory but may need adjustment depending on the use of your bandsaw. Use **Figures 46 & 47** to guide you through the following steps.

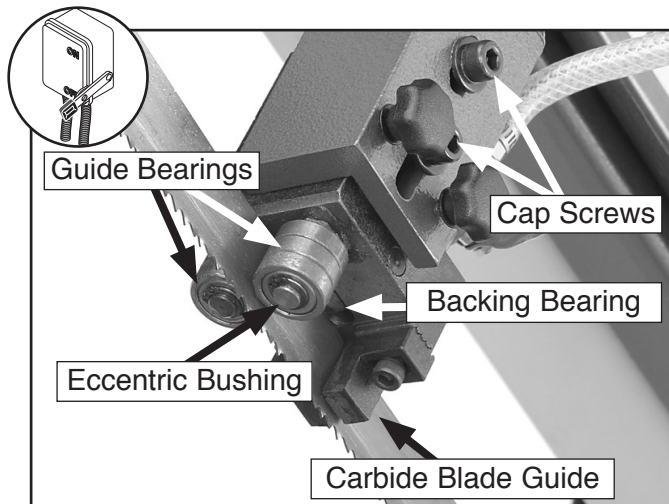


Figure 46. Blade guide adjustments.

To adjust the blade guide bearings:

1. Before making adjustments, make sure the blade is tensioned and tracking correctly.
2. **DISCONNECT THE BANDSAW FROM POWER!**
3. Lower the bow until it makes contact with the horizontal stop.
4. Remove the blade guides.
5. The back of the blade should make light contact with the backing bearing.

—If it does not, loosen the two cap screws shown in **Figure 46**. Lower the blade guide until the back of the blade makes light contact with the backing bearing. Then tighten the two cap screws.

6. Loosen the set screw in **Figure 47** to allow the eccentric bushing to turn.
7. Turn the hex nut on the eccentric shaft to adjust the distance of the guide bearing. The guide bearings and blade should make light contact or have a maximum clearance of 0.002".
8. Adjust the other eccentric blade guide bearing in the same manner.
9. Adjust the carbide blade guides so they make the same contact with the blade as the bearings.

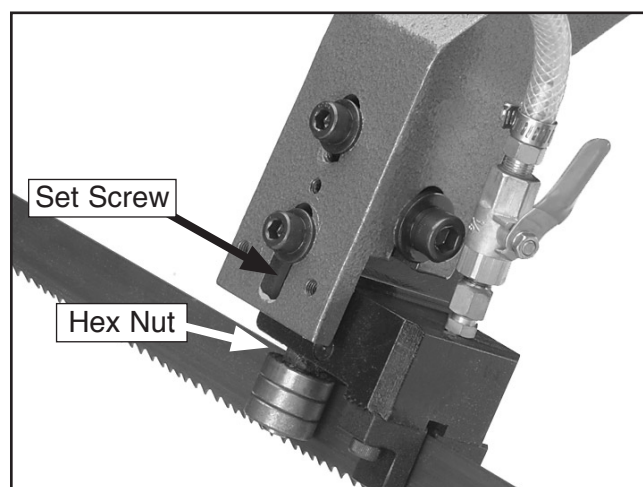


Figure 47. More blade guide adjustments.

Electrical Components

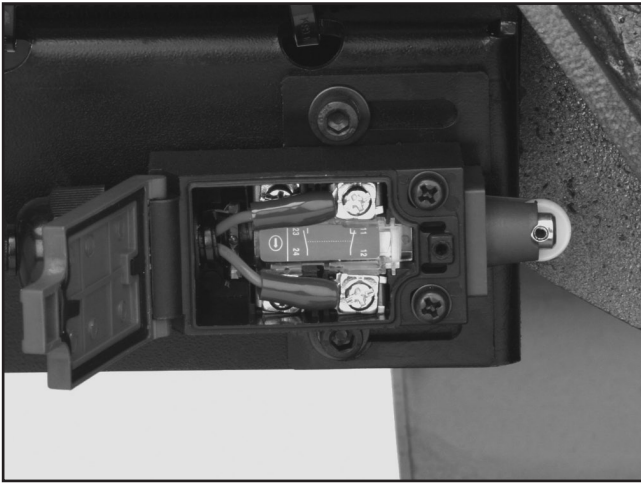


Figure 48. Limit switch.

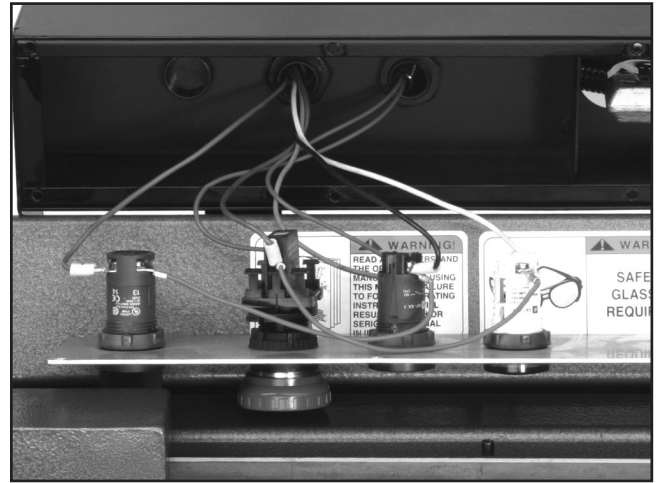


Figure 50. Control panel wiring.



Figure 49. Junction box.



Figure 51. Pump motor wiring.

Electrical Components

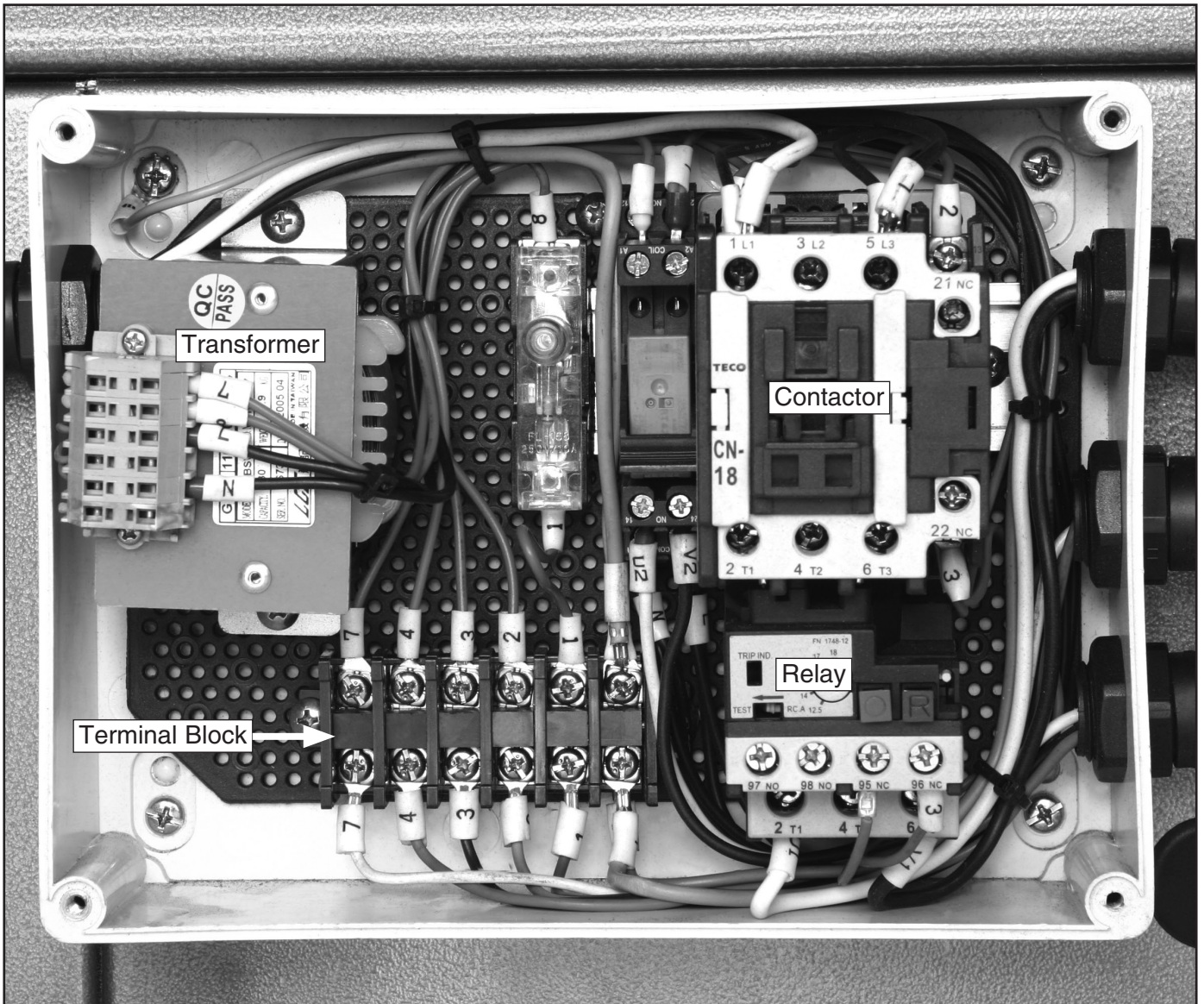
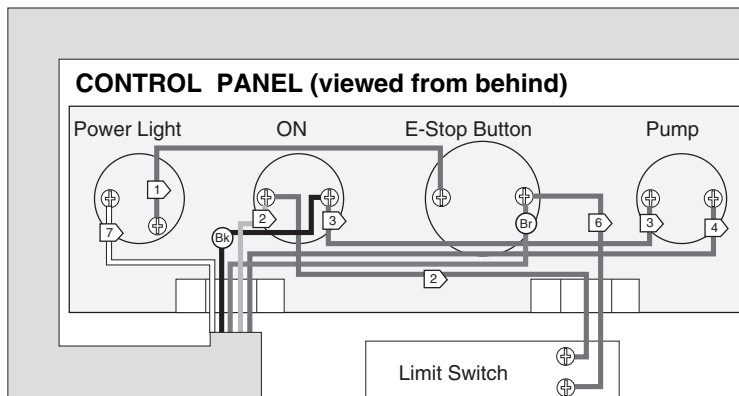
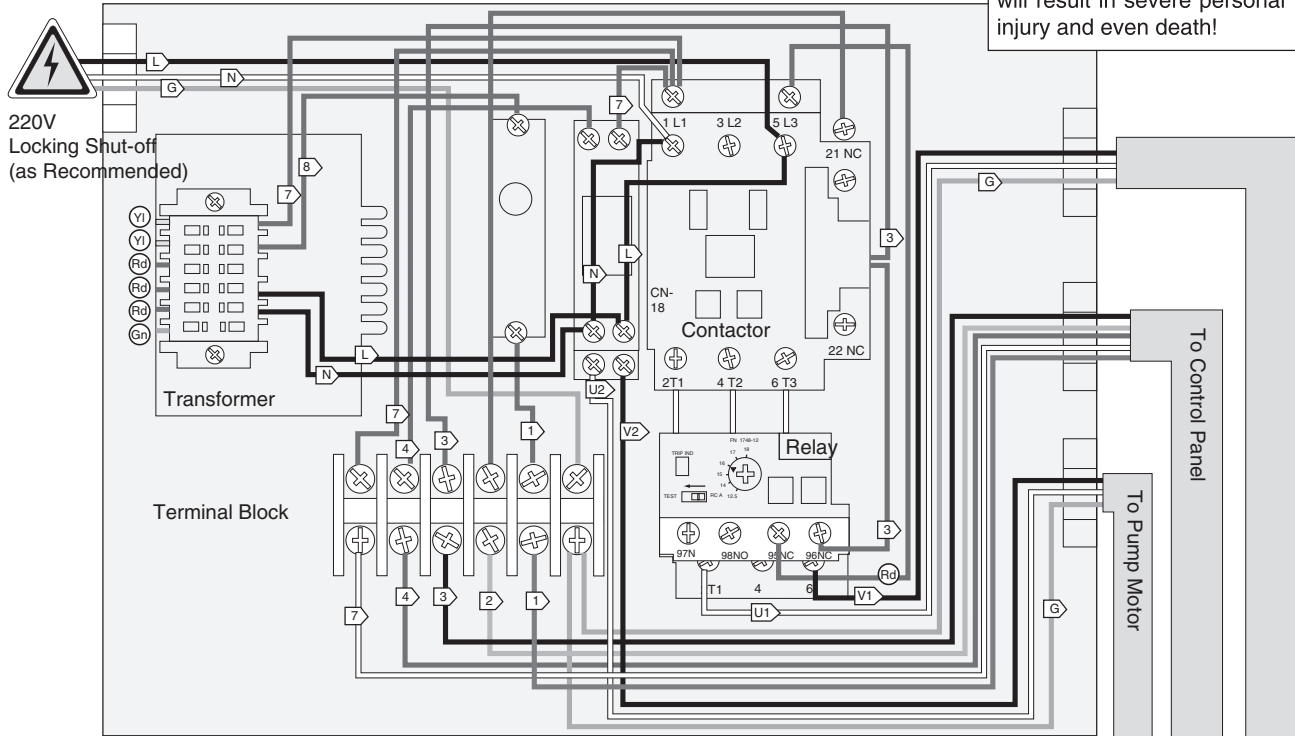


Figure 52. G0592 Contactor & relay electrical box.

Model G0592 220V Wiring Diagram

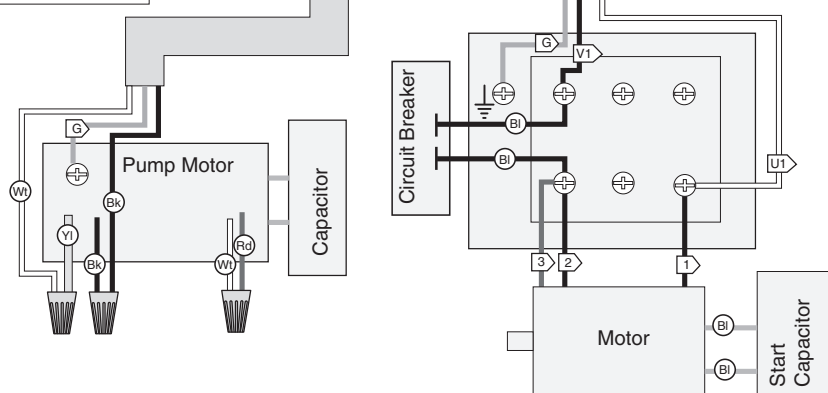


⚠ DANGER
 Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

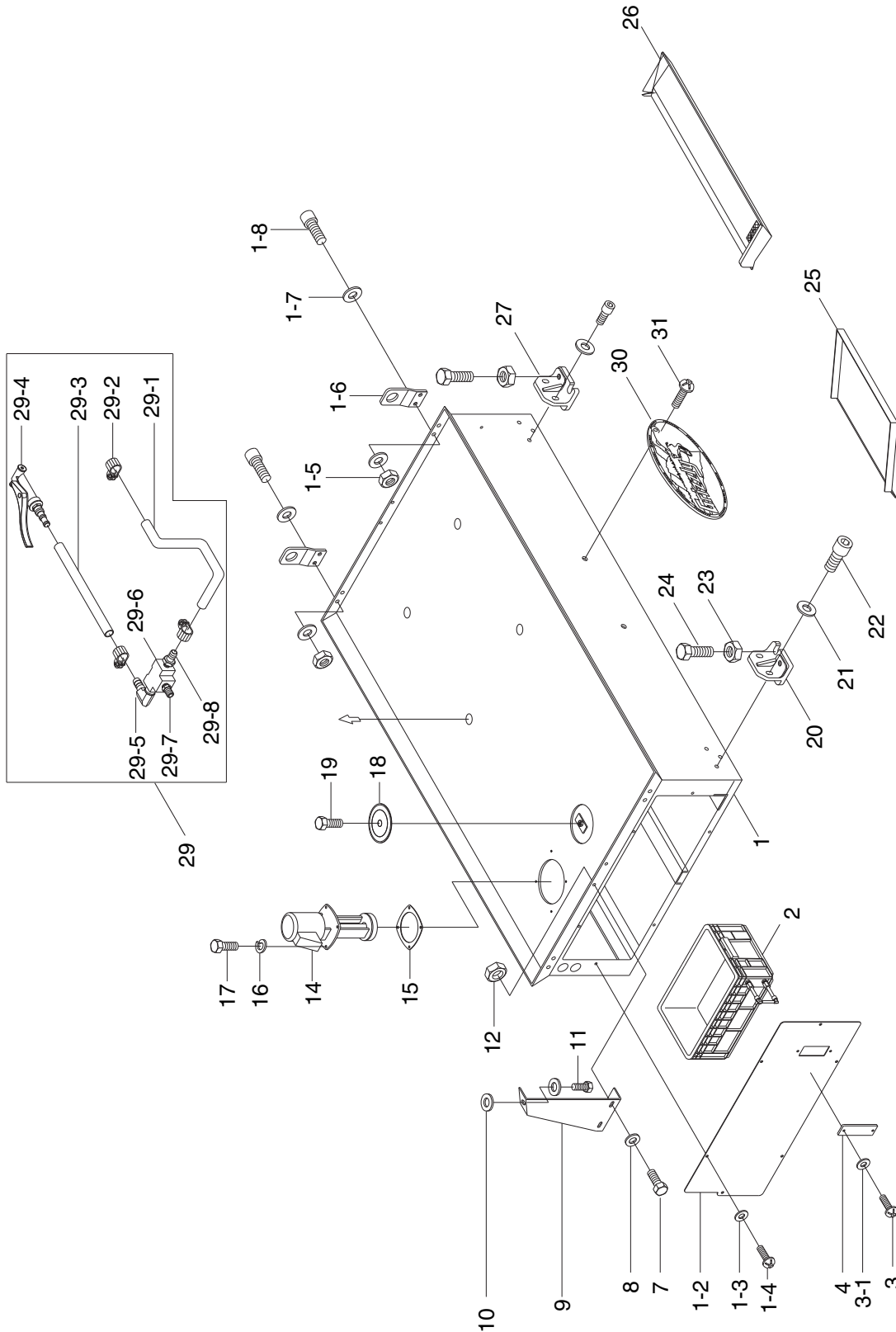


COLOR KEY

BLACK	— Bk —
WHITE	— Wt —
GREEN	— Gr —
RED	— Rd —
YELLOW	— Yl —
BLUE	— Bl —
BROWN	— Br —



Base Parts Breakdown



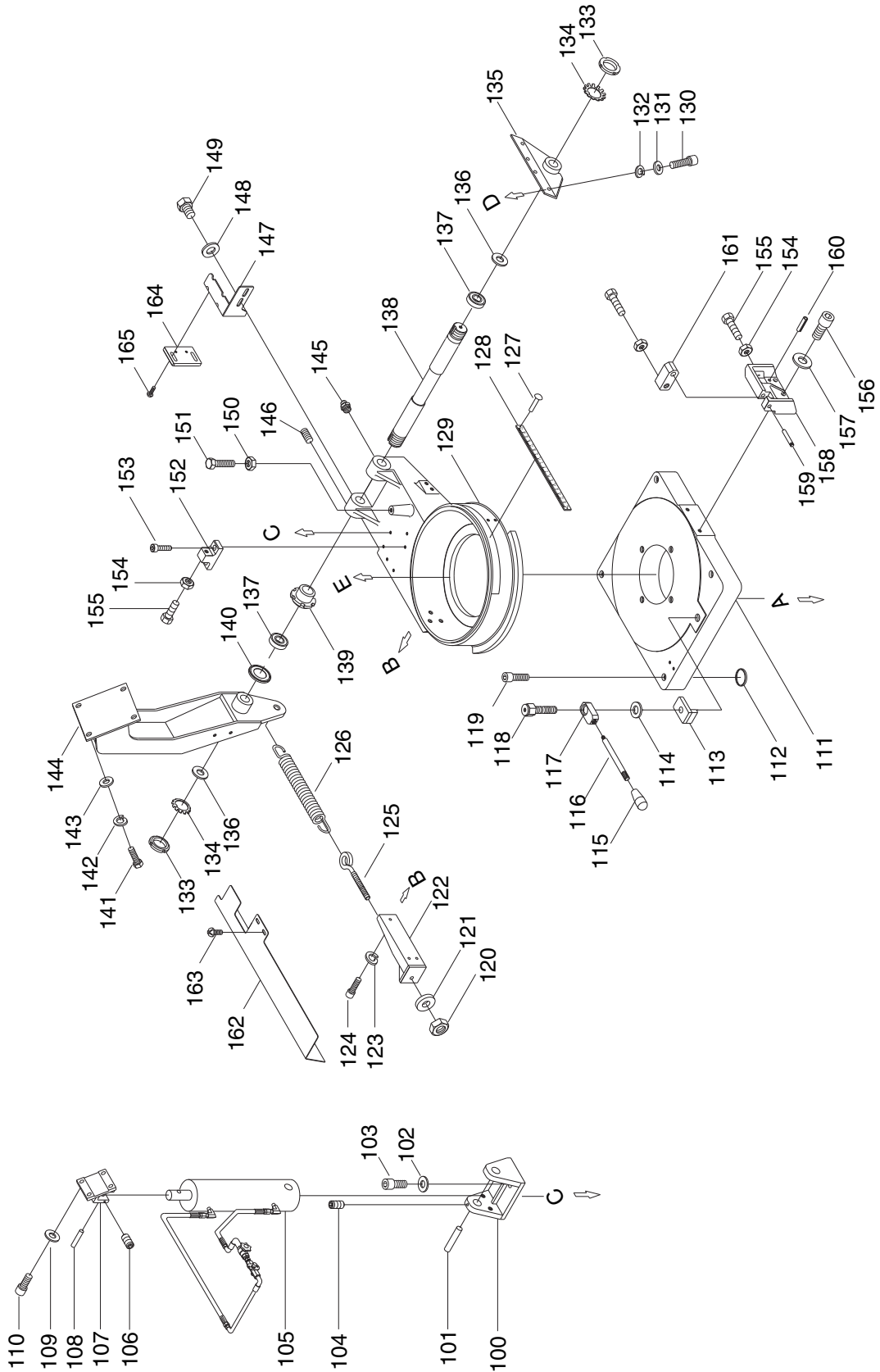
Base Parts List

REF	PART #	DESCRIPTION
1	P0592001	STAND
1-2	P0592001-2	STAND COVER
1-3	PW03M	FLAT WASHER 6MM
1-4	PS68M	PHLP HD SCR M6-1 X 10
1-5	PN03M	HEX NUT M8-1.25
1-6	P0592001-6	HANGER PLATE
1-7	P0592001-7	FENDER WASHER 18MM
1-8	PSB31M	CAP SCREW M8-1.25 X 25
2	P0592002	COOLANT RESERVOIR
3	PS09M	PHLP HD SCR M5-.8 X 10
3-1	PW02M	FLAT WASHER 5MM
4	P0592004	ACRYLIC PLATE
7	PB18M	HEX BOLT M6-1 X 15
8	PW03M	FLAT WASHER 6MM
9	P0592009	SHIPPING BRACKET
10	PW01M	FLAT WASHER 8MM
11	PB09M	HEX BOLT M8-1.25 X 20
12	PN03M	HEX NUT M8-1.25
14	P0592014	COOLANT PUMP 1/8HP 220 1PH
15	P0592015	RUBBER GASKET
16	PLW03M	LOCK WASHER 6MM
17	PB18M	HEX BOLT M6-1 X 15

REF	PART #	DESCRIPTION
18	P0592018	FILTER SCREEN
19	PB04M	HEX BOLT M6-1 X 10
20	P0592020	LOCATING FOOT (LEFT)
21	PW01M	FLAT WASHER 8MM
22	PSB14M	CAP SCREW M8-1.25 X 20
23	PN09M	HEX NUT M12-1.75
24	PB33M	HEX BOLT M12-1.75 X 50
25	P0592025	SPLASH TRAY
26	P0592026	CHIP TRAY
27	P0592027	LOCATING FOOT (RIGHT)
29	P0592029	SPRAY ASSEMBLY
29-1	P0592029-1	HOSE
29-2	P0592029-2	HOSE CLAMP
29-3	P0592029-3	HOSE
29-4	P0592029-4	SPRAY GUN
29-5	P0592029-5	MICRO CONTROL BLOCK
29-6	P0592029-6	STRAIGHT CONNECTOR
29-7	P0592029-7	3-WAY CONNECTOR
29-8	P0592029-8	STRAIGHT CONNECTOR
30	G8589	GRIZZLY LOGO PLATE
31	PS08M	PHLP HD SCR M5-.8 X 12



Swivel Base Parts Breakdown



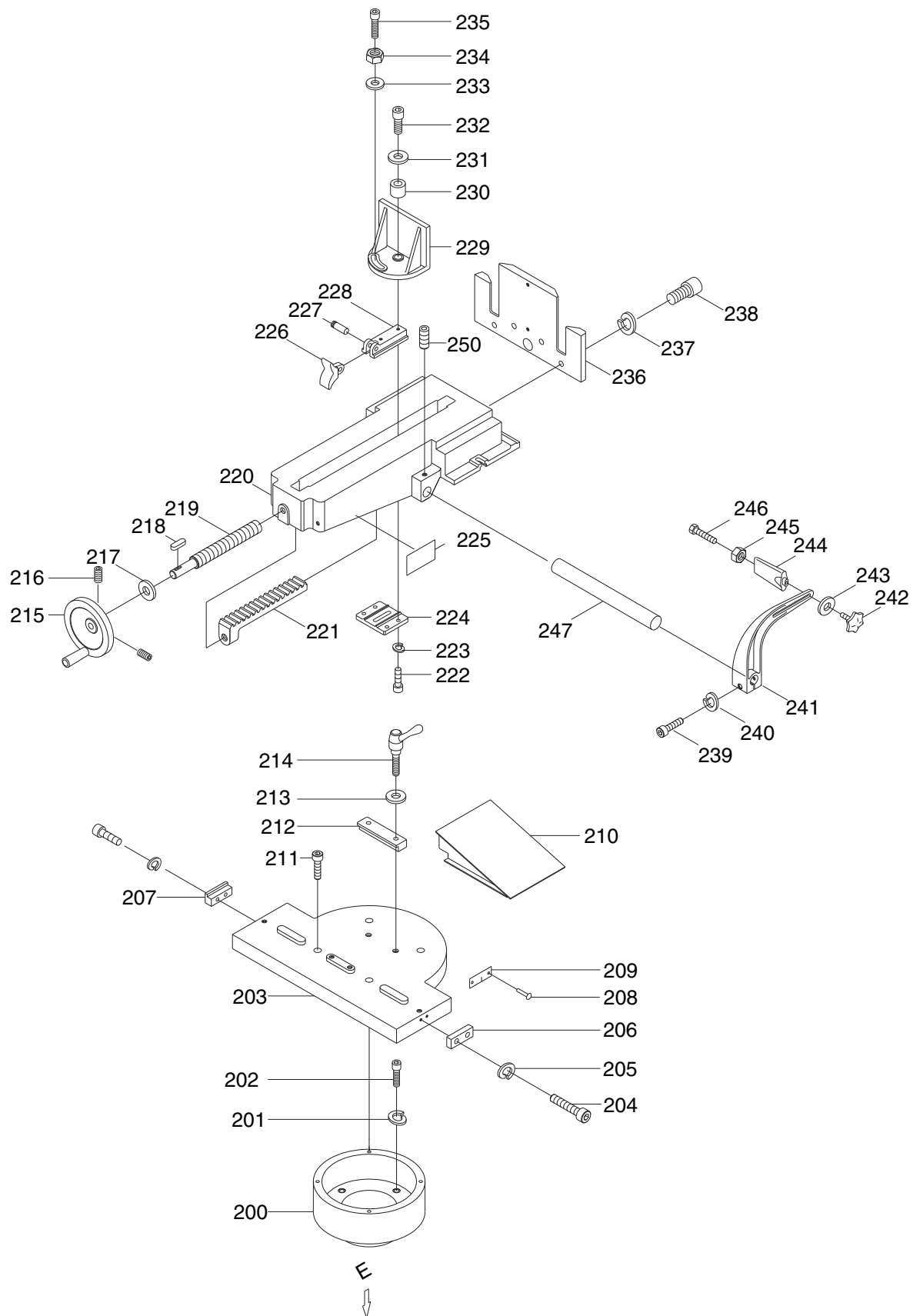
Swivel Base Parts List

REF	PART #	DESCRIPTION
100	P05920100	CYLINDER LOWER SUPPORT
101	P05920101	PIVOT PIN
102	PLW04M	LOCK WASHER 8MM
103	PB09M	HEX BOLT M8-1.25 X 20
104	PSS01M	SET SCREW M6-1 X 10
105	P05920105	CYLINDER ASSEMBLY
106	PSS01M	SET SCREW M6-1 X 10
107	P05920107	CYLINDER UPPER SUPPORT
108	P05920108	PIVOT PIN
109	PW01M	FLAT WASHER 8MM
110	PSB14M	CAP SCREW M8-1.25 X 20
111	P05920111	SWIVEL ARM BASE
112	P05920112	O-RING
113	P05920113	SWIVEL ARM BRACKET
114	PW06M	FLAT WASHER 12MM
115	P05920115	HANDLE
116	P05920116	SCREW ROD
117	P05920117	HUB
118	P05920118	PIVOT BOLT
119	PSB84M	CAP SCREW M10-1.5 X 35
120	PN09M	HEX NUT M12-1.75
121	PW06M	FLAT WASHER 12MM
122	P05920122	FEED SUPPORT
123	PLW04M	LOCK WASHER 8MM
124	PSB31M	CAP SCREW M8-1.25 X 25
125	P05920125	EYE BOLT
126	P05920126	EXTENSION SPRING
127	P05920127	RIVET
128	P05920128	DEGREE SCALE
129	P05920129	UPPER SWIVEL BASE
130	PSB64M	CAP SCREW M10-1.5 X 25
131	PW04M	FLAT WASHER 10MM
132	PLW06M	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
133	P05920133	SPANNER NUT
134	P05920134	EXT. TOOTH WASHER
135	P05920135	BRACKET
136	P05920136	GAP RING
137	P32007	TAPER ROLLER BEARING 32007
138	P05920138	PIVOT SHAFT
139	P05920139	RING
140	P05920140	CHIP COVER
141	PB01M	HEX BOLT M10-1.5 X 30
142	PLW06M	LOCK WASHER 10MM
143	PW04M	FLAT WASHER 10MM
144	P05920144	REAR PIVOT BRACKET
145	P05920145	GREASE FITTING
146	PSS01M	SET SCREW M6-1 X 10
147	P05920147	SWITCH BRACKET
148	PW01M	FLAT WASHER 8MM
149	PB17M	HEX BOLT M8-1.25 X 10
150	PN09M	HEX NUT M12-1.75
151	PB33M	HEX BOLT M12-1.75 X 50
152	P05920152	ANGLE MARGIN
153	PSB14M	CAP SCREW M8-1.25 X 20
154	PN02M	HEX NUT M10-1.5
155	PB31M	HEX BOLT M10-1.5 X 40
156	PSB31M	CAP SCREW M8-1.25 X 25
157	PW01M	FLAT WASHER 8MM
158	P05920158	ANGLE POSITION
159	P05920159	BEARING PIN
160	PRP03M	ROLL PIN 5 X 20
161	P05920161	LOCATING BLOCK
162	P05920162	SPRING COVER
163	PS37M	PHLP HD SCR M6-1 X 6
164	P05920164	SWITCH ADJUSTING BRACKET
165	PB96M	HEX BOLT M5-.8 x 10



Vise Parts Breakdown



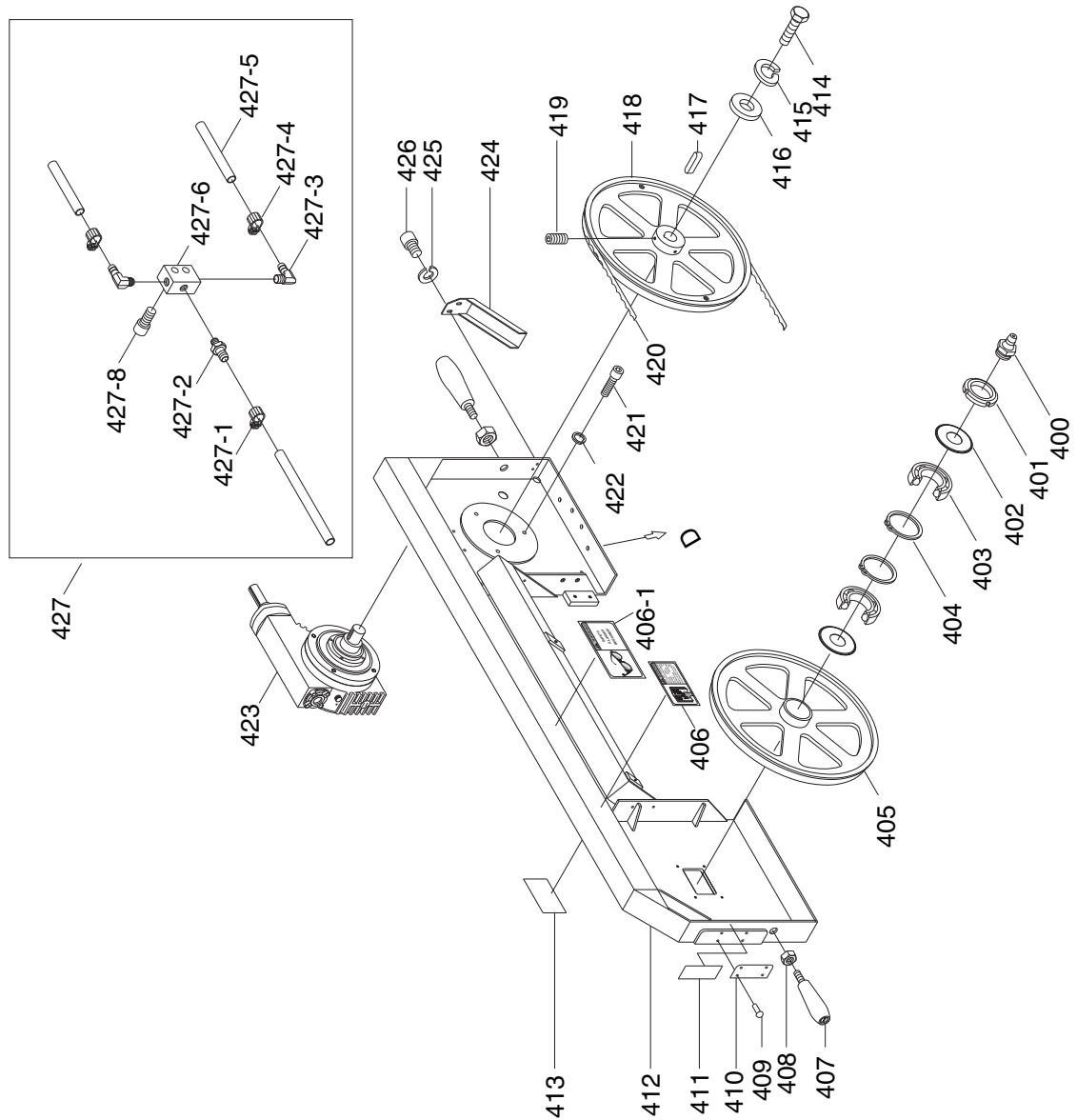
Vise Parts List

REF	PART #	DESCRIPTION
200	P05920200	FIXED SHAFT
201	PLW06M	LOCK WASHER 10MM
202	PSB84M	CAP SCREW M10-1.5 X 35
203	P05920203	SLIDE BASE
204	PSB02M	CAP SCREW M6-1 X 20
205	PLW03M	LOCK WASHER 6MM
206	P05920206	2-WAY LIMIT BLOCK
207	P05920207	2-WAY LIMIT BLOCK
208	P05920208	RIVET
209	P05920209	SCALE
210	P05920210	UPPER CHIP TRAY
211	PSB72M	CAP SCREW M10-1.5 X 30
212	P05920212	FIXED BLOCK
213	P05920213	BUSHING
214	P05920214	KNOB M10-1.5 X 40
215	P05920215	HANDWHEEL
216	PSS01M	SET SCREW M6-1 X 10
217	P05920217	SPECIAL FLAT WASHER 25MM
218	PK20M	KEY 5 X 5 X 15
219	P05920219	LEADSCREW
220	P05920220	WISE BASE
221	P05920221	RACK
222	PSB31M	CAP SCREW M8-1.25 X 25
223	PLW04M	LOCK WASHER 8MM
224	P05920224	RACK SUPPORT

REF	PART #	DESCRIPTION
225	P05920225	NAME PLATE
226	P05920226	RACK HOOK
227	P05920227	SOLID PIN
228	P05920228	BRACKET
229	P05920229	WISE JAW (FRONT)
230	P05920230	BUSHING
231	P05920231	SPECIAL WASHER
232	PSB84M	CAP SCREW M10-1.5 X 35
233	P05920233	SPECIAL WASHER
234	PN02M	HEX NUT M10-1.5
235	PSB47M	CAP SCREW M10-1.5 X 40
236	P05920236	WISE JAW BRACKET(REAR)
237	PLW05M	LOCK WASHER 12MM
238	PSB131M	CAP SCREW M12-1.75 X 45
239	PSB45M	CAP SCREW M8-1.25 X 45
240	PLW04M	LOCK WASHER 8MM
241	P05920241	STOP BLOCK SUPPORT
242	P05920242	WORK STOP KNOB
243	PW03M	FLAT WASHER 6MM
244	P05920244	WORK STOP
245	PN02M	HEX NUT M10-1.5
246	PB01M	HEX BOLT M10-1.5 X 30
247	P05920247	DISTANCE SET ROD
250	PSS09M	SET SCREW M8-1.25 X 20



Bow Parts Breakdown



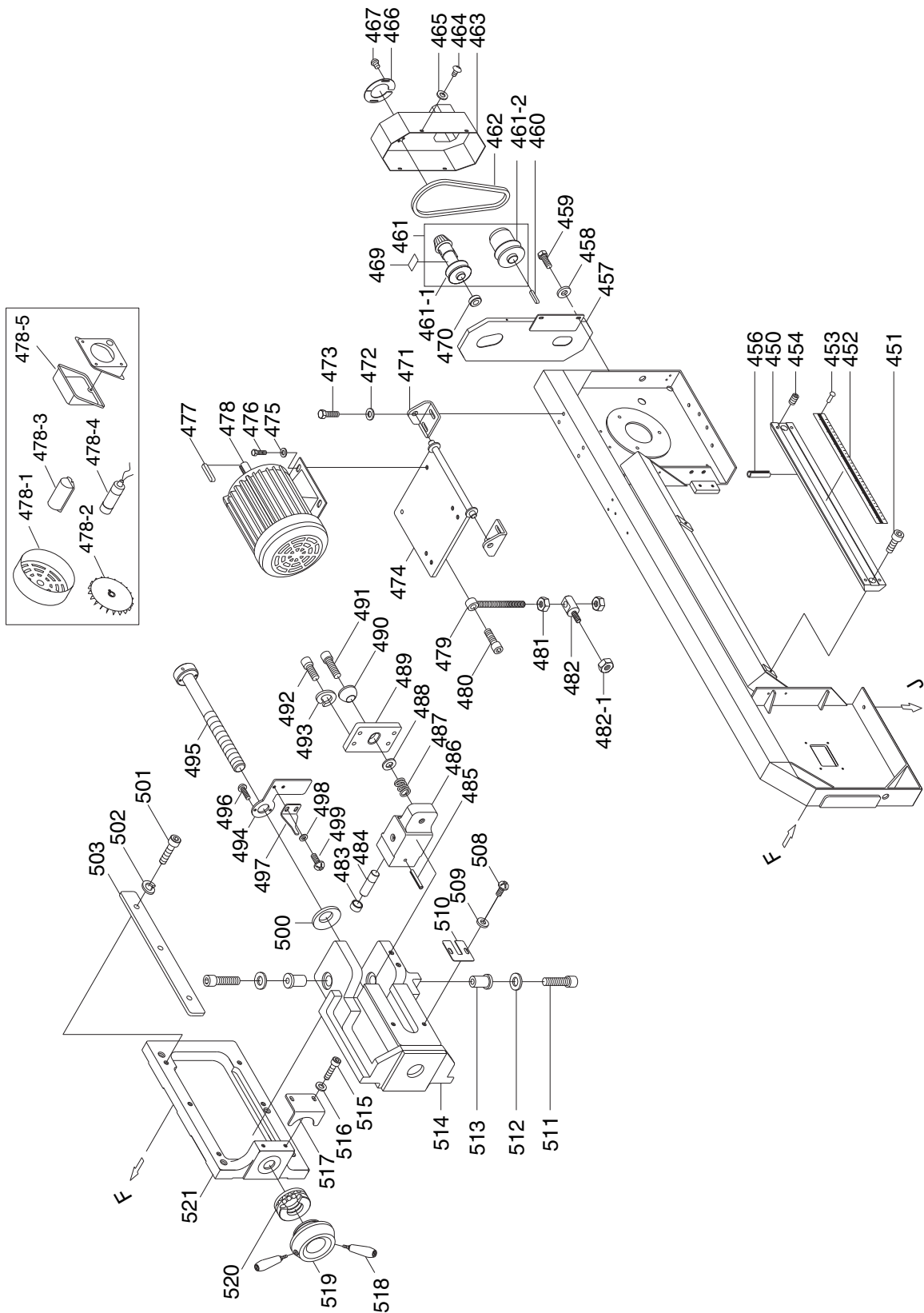
Bow Parts List

REF	PART #	DESCRIPTION
400	P05920400	GREASE FITTING
401	P05920401	SPANNER NUT
402	P05920402	COVER
403	P05920403	BEARING 30205J
404	PR76M	EXT RETAINING RING 52MM
405	P05920405	IDLER WHEEL
406	P05920406	READ MANUAL LABEL
406-1	P05920406-1	SAFETY GLASSES LABEL
407	P05920407	HANDLE
408	PN08	HEX NUT 3/8-16
409	P05920409	RIVET
410	P05920410	LOOSEN TIGHTEN LABEL
411	P05920411	BLADE GUARD LABEL
412	P05920412	BOW FRAME
413	P05920413	TENSION GUAGE PLATE
414	PB32M	HEX BOLT M10-1.5 X 25
415	PLW06M	LOCK WASHER 10MM
416	PW04M	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
417	PK61M	KEY 7 X 7 X 30
418	P05920418	DRIVE WHEEL
419	PSS17M	SET SCREW M8-1.25 X 6
420	P0592420	BLADE 132 X 1 X .032 6/10T
421	PSB61M	CAP SCREW M10-1.5 X 20
422	PLW06M	LOCK WASHER 10MM
423	P05920423	GEAR BOX ASSEMBLY
424	P05920424	SPLASH BOARD
425	P05920425	SPECIAL WASHER
426	PSB04M	CAP SCREW M6-1 X 10
427	P05920427	3-WAY VALVE ASSY
427-1	P05920427-1	HOSE CLAMP
427-2	P05920427-2	STRAIGHT CONNECTOR
427-3	P05920427-3	MICRO CONTROL BLOCK
427-4	P05920427-4	HOSE CLAMP
427-5	P05920427-5	NET TUBE
427-6	P05920427-6	3-WAY VALVE
427-8	PSB07M	CAP SCREW M6-1 X 30



Blade Tension & Motor Parts Breakdown



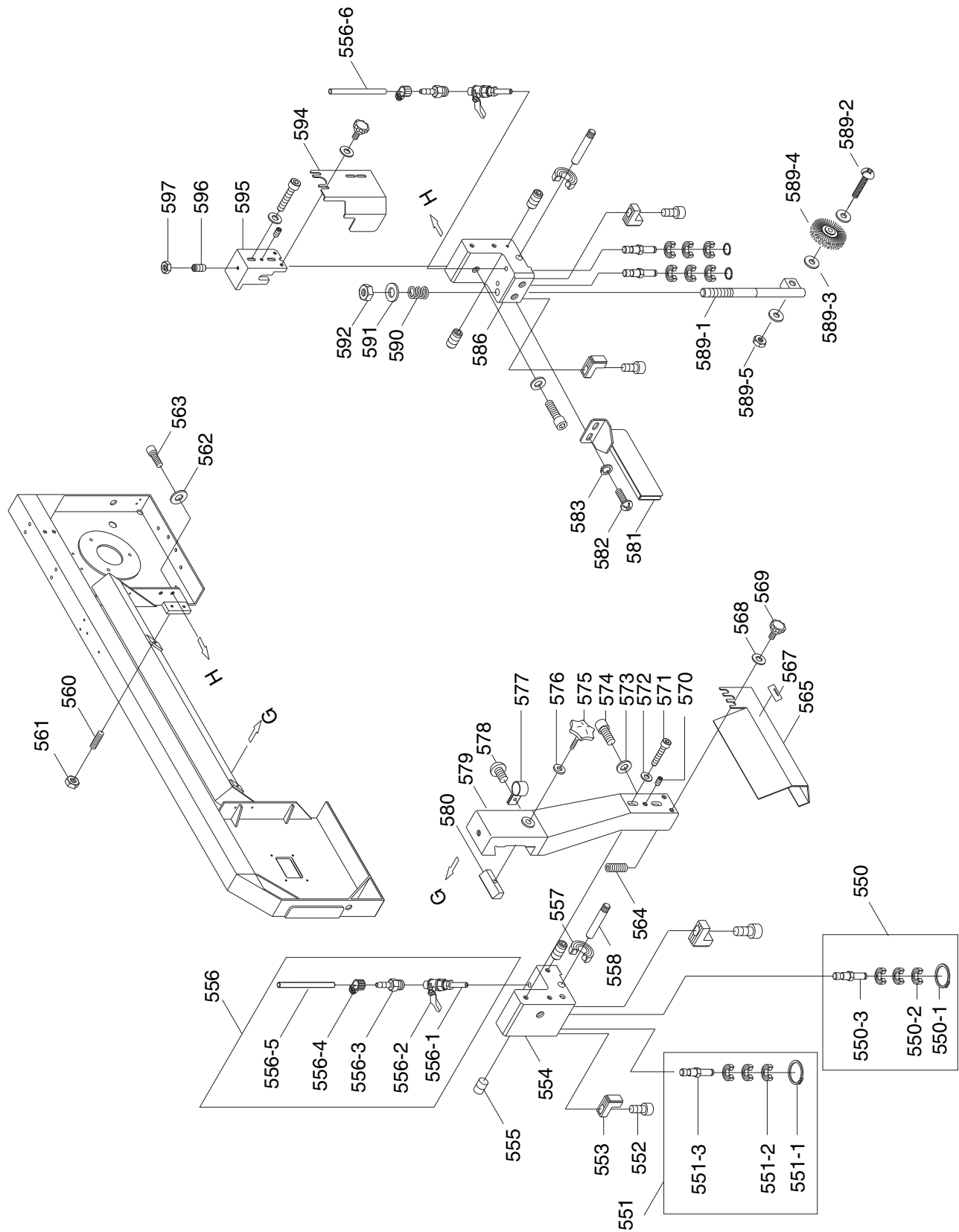
Blade Tension & Motor Parts List

REF	PART #	DESCRIPTION
450	P05920450	COLUMN
451	PSB129M	CAP SCREW M12-1.75 X 20
452	P05920452	SCALE
453	P05920453	RIVET
454	PSS09M	SET SCREW M8-1.25 X 20
456	PRP08M	ROLL PIN 6 X 30
457	P05920457	PULLEY LOWER COVER
458	PW03M	FLAT WASHER 6MM
459	PB04M	HEX BOLT M6-1 X 10
460	PK61M	KEY 7 X 7 X 30
461	P05920461	VARIABLE SPEED PULLEY ASSY
461-1	P05920461-1	VARIABLE SPEED PULLEY
461-2	P05920461-2	SPINDLE PULLEY
462	P05920462	COGGED V-BELT 1422V-360
463	P05920463	MOTOR PULLEY COVER
464	PS09M	PHLP HD SCR M5-.8 X 10
465	PW02M	FLAT WASHER 5MM
466	P05920466	COVER
467	PS45M	PHLP HD SCR M5-.8 X 5
469	P05920469	SPEED LABEL
470	P05920470	WASHER RING
471	P05920471	MOTOR BRACKET
472	PW03M	FLAT WASHER 6MM
473	PB08M	HEX BOLT M6-1 X 20
474	P05920474	MOTOR PLATE
475	PW01M	FLAT WASHER 8MM
476	PB87M	HEX BOLT M8-1.25 X 15
477	PK109M	KEY 7 X 7 X 35
478	P05920478	MOTOR 2HP 220V/ 60HZ 1- PH
478-1	P0592478-1	MOTOR COVER
478-2	P0592478-2	MOTOR FAN
478-3	P0592478-3	CAPACITOR COVER
478-4	P0592478-4	CAPACITOR
478-5	P0592478-5	JUNCTION BOX
479	P05920479	SHAFT
480	PSB71M	CAP SCREW M10-1.5 X 60
481	PN09M	HEX NUT M12-1.75

REF	PART #	DESCRIPTION
482	P05920482	SHAFT
482-1	PN02M	HEX NUT M10-1.5
483	P05920483	BUSHING
484	P05920484	SHAFT
485	PRP08M	ROLL PIN 6 X 30
486	P05920486	BLADE ANGLE ADJ BRACKET
487	P05920487	COMPRESSION SPRING
488	PW04M	FLAT WASHER 10MM
489	P05920489	PLATE
490	P05920490	SPECIAL WASHER
491	PSB134M	CAP SCREW M10-1.5 X 65
492	PSB07M	CAP SCREW M6-1 X 30
493	PLW03M	LOCK WASHER 6MM
494	P05920494	PLATE
495	P05920495	LEAD SCREW
496	PS52M	PHLP HD SCR M4-.7 X 20
497	P05920497	SCALE
498	PW05M	FLAT WASHER 4MM
499	PS38M	PHLP HD SCR M4-.7 X 10
500	P05920500	DISC SPRING
501	PSB12M	CAP SCREW M8-1.25 X 40
502	PLW04M	LOCK WASHER 8MM
503	P05920503	GIB
508	PS05M	PHLP HD SCR M5-.8 X 8
509	PW02M	FLAT WASHER 5MM
510	P05920510	TENSION PLATE
511	PSB06M	CAP SCREW M6-1 X 25
512	PW03M	FLAT WASHER 6MM
513	P05920513	SHAFT BUSHING
514	P05920514	BLADE TENSION SLIDING PLATE
515	PS09M	PHLP HD SCR M5-.8 X 10
516	PW02M	FLAT WASHER 5MM
517	P05920517	BRACKET
518	P05920518	HANDLE
519	P05920519	HANDLE BODY
520	P51204	THRUST BEARING 51204
521	P05920521	ANCHOR BLOCK



Blade Guides Parts Breakdown



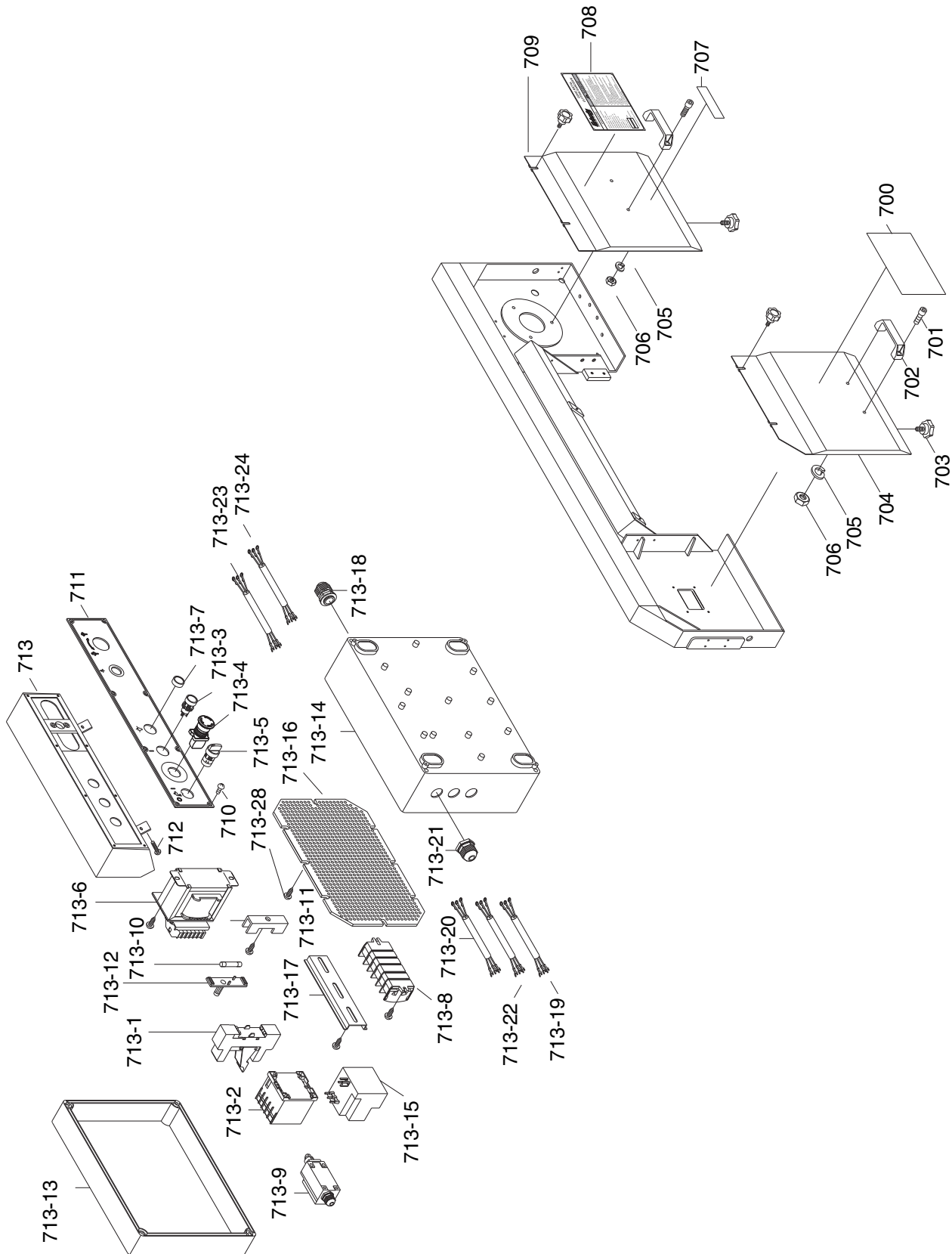
Blade Guides Parts List

REF	PART #	DESCRIPTION
550	P0592550	BEARING SHAFT ASSY
550-1	PR11M	EXT RETAINING RING 25MM
550-2	P609ZZ	BEARING 609ZZ
550-3	P0592550-3	BEARING SHAFT
551	P0592551	ECCENTRIC SHAFT ASSY
551-1	PR45M	INT RETAINING RING 10MM
551-2	P609ZZ	BEARING 609ZZ
551-3	P0592551-3	ECCENTRIC SHAFT
552	PSB02M	CAP SCREW M6-1 X 20
553	P0592553	CARBIDE GUIDE
554	P0592554	BEARING BRACKET LEFT
555	PSS05M	SET SCREW M5-.8 X 10
556	P0592556	VALVE ASSY
556-1	P0592556-1	COPPER TUBE
556-2	P0592556-2	VALVE
556-3	P0592556-3	STRAIGHT CONNECTOR
556-4	P0592556-4	HOSE CLAMP
556-5	P0592556-5	NET TUBE 1/4 X 143CM
556-6	P0592556-6	NET TUBE 1/4 X 63CM
557	P609ZZ	BEARING 609ZZ
558	P0592558	BEARING PIN
560	PSS19M	SET SCREW M8-1.25 X 30
561	PN03M	HEX NUT M8-1.25
562	PW01M	FLAT WASHER 8MM
563	PSB14M	CAP SCREW M8-1.25 X 20
564	PSS28M	SET SCREW M6-1 X 30
565	P0592565	BLADE GUARD FRONT
567	P0592567	LABEL
568	PW03M	FLAT WASHER 6MM
569	P0592569	KNOB M6-1 X 10

REF	PART #	DESCRIPTION
570	PSS01M	SET SCREW M6-1 X 10
571	PSB31M	CAP SCREW M8-1.25 X 25
572	PW01M	FLAT WASHER 8MM
573	PW04M	FLAT WASHER 10MM
574	PSB47M	CAP SCREW M10-1.5 X 40
575	P0592575	BLADE ADJUSTABLE KNOB
576	PW04M	FLAT WASHER 10MM
577	P0592577	HOSE CLAMP
578	PS09M	PHLP HD SCR M5-.8 X 10
579	P0592579	ARM LEFT
580	P0592580	GIB
581	P0592581	BLADE GUARD REAR
582	PS09M	PHLP HD SCR M5-.8 X 10
583	PW02M	FLAT WASHER 5MM
586	P0592586	BLADE ADJUSTER REAR
587	PSS07M	SET SCREW M5-.8 X 5
588	P0592588	COLLAR
589-1	P0592589-1	BRUSH SHAFT
589-2	PS81M	PHLP HD SCR M6-1 X 40
589-3	PW03M	FLAT WASHER 6MM
589-4	P0592589-4	BRUSH
589-5	PN01M	HEX NUT M6-1
590	P0592590	COMPRESSION SPRING
591	PW04M	FLAT WASHER 10MM
592	PN02M	HEX NUT M10-1.5
593	P0592593	BRUSH
594	P0592594	BLADE GUARD REAR
595	P0592595	ARM RIGHT
596	PSS21M	SET SCREW M8-1.25 X 25
597	PN03M	HEX NUT M8-1.25



Electrical Parts Breakdown



Electrical Parts List

REF	PART #	DESCRIPTION
700	P05920700	TOOTH SELECTION LABEL
701	PSB100M	CAP SCREW M8-1.25 X 15
702	P05920702	HANDLE
703	PSB04M	KNOB M6-1 X 10
704	P05920704	BLADE BACK COVER
705	PLW04M	LOCK WASHER 8MM
706	PN03M	HEX NUT M8-1.25
707	P05920707	NAME PLATE
708	P05920708	MACHINE ID LABEL
709	P05920709	BLADE BACK COVER
710	PS09M	PHLP HD SCR M5-.8 X 10
711	P05920711	CONTROL PLATE
712	PS08M	PHLP HD SCR M5-.8 X 12
713	P05920713	CONTROL BOX
713-1	P0592713-1	PUMP RELAY
713-2	P0592713-2	CONTACTOR CN-18
713-3	P0592713-3	ON BUTTON
713-4	P0592713-4	EMERGENCY STOP/OFF SWITCH
713-5	P0592713-5	PUMP ON/OFF SWITCH
713-6	P0592713-6	TRANSFORMER

REF	PART #	DESCRIPTION
713-7	P0592713-7	POWER LIGHT
713-8	P0592713-8	TERMINAL BLOCK
713-9	P0592713-9	LIMIT SWITCH
713-10	P0592713-10	FUSE
713-11	P0592713-11	BRACKET
713-12	P0592713-12	FUSE COVER
713-13	P0592713-13	ENCLOSURE COVER
713-14	P0592713-14	ENCLOSURE
713-15	P0592713-15	RELAY RHN-10/18A
713-16	P0592713-16	PANEL
713-17	P0592713-17	BRACKET
713-18	P0592713-18	STRAIN RELIEF
713-19	P0592713-19	PUMP WIRE HARNESS
713-20	P0592713-20	MOTOR WIRE HARNESS
713-21	P0592713-21	STRAIN RELIEF
713-22	P0592713-22	CNTRL PANEL WIRE HARNESS
713-23	P0592713-23	LIMIT SWITCH WIRE HARNESS
713-24	P0592713-24	POWER WIRE HARNESS
713-28	PS08M	PHLP HD SCR M5-.8 X 12

WARNING

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



WARRANTY AND RETURNS

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

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

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

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

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

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





WARRANTY CARD

Name _____
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 Phone # _____ Email _____ Invoice # _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

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

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

0-2 3-5 6-9 10+

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

Yes No

8. Would you recommend Grizzly Industrial to a friend?

Yes No

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

Note: We never use names more than 3 times.

Yes No

10. Comments: _____

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