MODEL G0699
12" SLIDING TABLE SAW
w/SCORING MOTOR
OWNER'S MANUAL

FOR MODELS MANUFACTURED SINCE 6/09 #TS12139 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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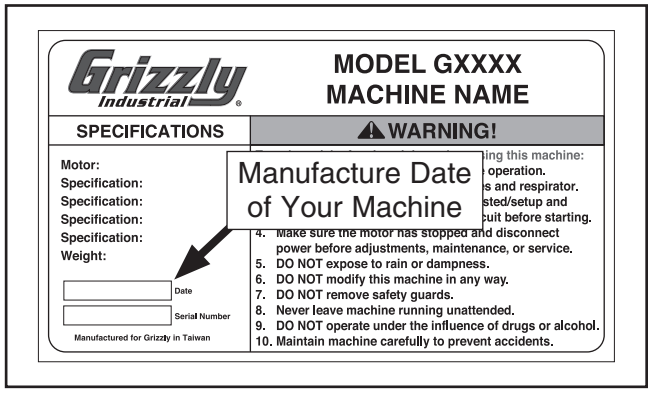
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

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

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

We want your feedback on this manual. If you can take the time, please email or write to us at the address below and tell us how we did:

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

Machine Description

A sliding table saw is primarily used to rip and crosscut sheet stock or panels in a production setting. The sliding table saves time and increases accuracy by removing the burden of sliding large and heavy panels over a stationary table surface. This saw can also be used as a traditional table saw for most types of through-cuts.

The Model G0699 is equipped with a scoring blade, which is a smaller blade located in front of the main blade. It makes a shallow cut in the workpiece in the opposite direction of the main blade, greatly reducing tear-out and chipped edges.

When using the sliding table saw as a traditional table saw, the sliding table is locked in place and the rip fence is then used to guide the workpiece through the cut.

Identification

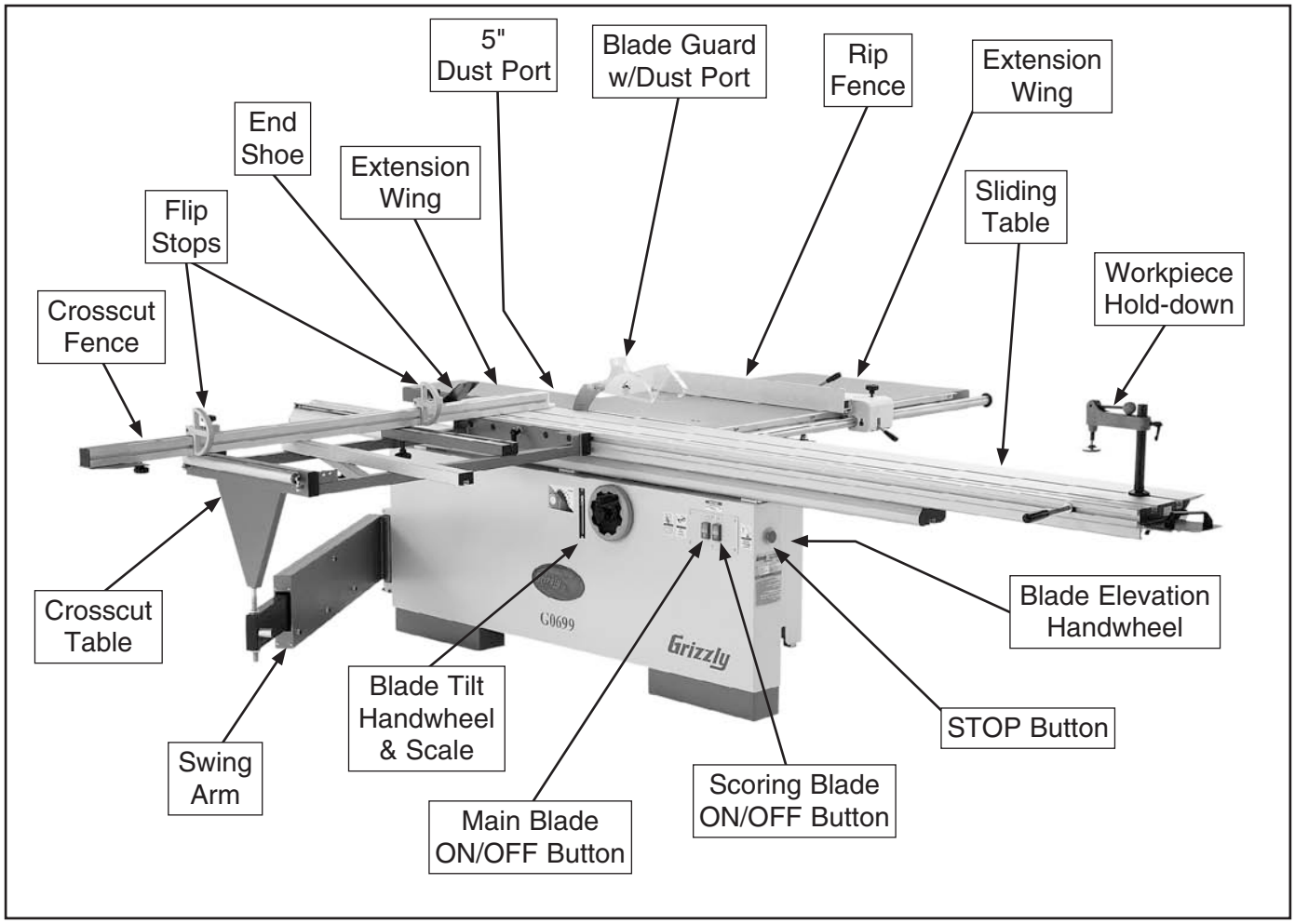
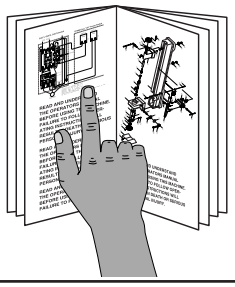


Figure 1. Model G0699 identification.



WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

MACHINE DATA SHEET

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

MODEL G0699 12" SLIDING TABLE SAW W/ SCORING

Product Dimensions:

Weight..... 1219 lbs.
Length/Width/Height..... 139 x 133 x 45 in.
Foot Print (Length/Width)..... 74-1/2 x 35-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Wood
Content..... Machine
Weight..... 1236 lbs.
Length/Width/Height..... 83 x 44. x 44 in.

Carton #2

Type..... Wood
Content..... Sliding Table
Weight..... 275 lbs.
Length/Width/Height..... 132 x 20 x 18 in.

Electrical:

Power Requirement..... 220V/440V, 3-Phase, 60 Hz
Minimum Circuit Size..... 30A @220, 15A @ 440V
Switch..... Magnetic with Thermal Overload Protection
Switch Voltage..... 220V
Plug Included..... No
Recommended Plug/Outlet Type..... L15-30 at 220V, Hardwire Disconnect Switch at 440V

Motors:

Scoring

Type..... TEFC Induction
Horsepower..... 1 HP
Voltage..... 220/440V
Phase..... 3-Phase
Amps..... 3A @220V, 1.5A @440
Speed..... 3450
Cycle..... 60 Hz
Number Of Speeds..... 1
Power Transfer ..... Belt Drive
Bearings..... Shielded and Permanently Sealed

Main

Type..... TEFC Induction
Horsepower..... 7-1/2 HP
Voltage..... 220/440V
Prewired..... 220V
Phase..... 3-Phase
Amps..... 20A @220V, 10A @440V
Speed..... 3450
Cycle..... 60 Hz
Number Of Speeds..... 1
Power Transfer ..... V-Belt
Bearings..... Shielded and Permanently Sealed

Main Specifications:

Operation Information

Main Blade Size	12 in.
Main Arbor Size	1 in.
Scoring Blade Size	4-3/4 in. (120 mm)
Scoring Blade Arbor Size	20 mm
Main Blade Tilt	0-45 deg.
Main Blade Speed	4000 RPM
Scoring Blade Tilt	0-45 deg.
Scoring Blade Speed	8000 RPM

Cutting Capacities

Max Depth Of Cut At 90D	3-5/16 in.
Max Depth Of Cut At 45D	2-3/8 in.
Table With Rip Fence Max Cut Width	49-3/4 in.
Sliding Table With Cross Fence Max Cut Width	126 in.
Sliding Table With Cross Fence Max Cut Length	126 in.
Miter Fence Cut Width At 45D	126 in.

Table Information

Floor To Table Height	36 in.
Table Size Length	21-1/2 in.
Table Size Width	35-1/4 in.
Table Size Thickness	3 in.
Table Size With Ext Wings Length	59 in.
Table Size With Ext Wings Width	35-1/4 in.
Table Size With Ext Wings Thickness	3 in.
Sliding Table Length	126 in.
Sliding Table Width	14 in.

Fence Information

Fence Size Length	73 in.
Fence Size Width	2-3/8 in.

Construction Materials

Table Construction	Cast Iron
Sliding Table Construction	Aluminum
Base Construction	Cast Iron
Body Assembly Construction	Steel
Cabinet Construction	Steel
Trunnions Construction	Cast Iron
Rollers Construction	Steel
Fence Assembly Construction	Extruded Aluminum & Cast Iron
Rails Construction	Hardened Steel
Guard Construction	Plastic
Spindle Bearing Type	Lubricated & Permanently Sealed Ball Bearing
Paint	Powder Coated

Other Related Information

No Of Dust Ports	2
Dust Port Size	2-1/2, 5 in.

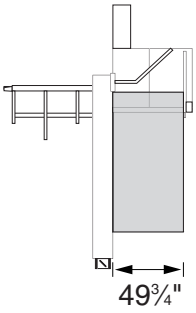
Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine ID Label on Side of Machine
Assembly Time	3 Hours
Sound Rating	82 dB

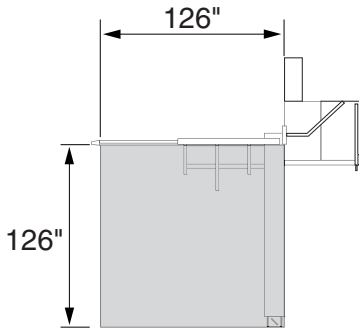
SLIDING TABLE SAW CAPACITIES

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

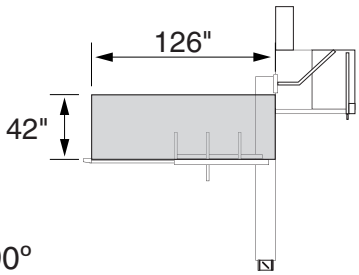
MODEL G0699 12" SLIDING TABLE SAW



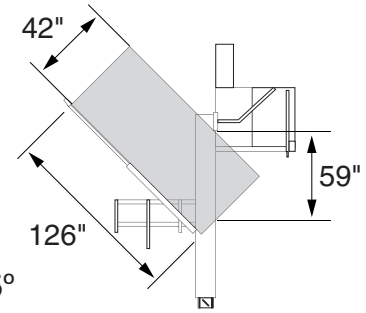
Ripping Width



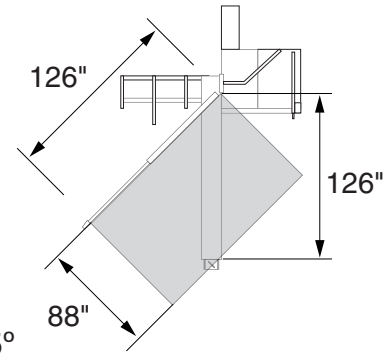
Cross Cut



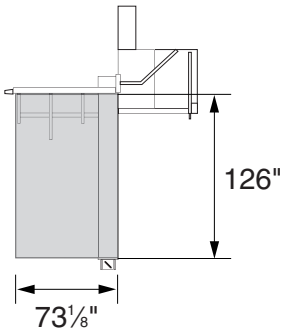
Miter Cut 90°
(push cut)



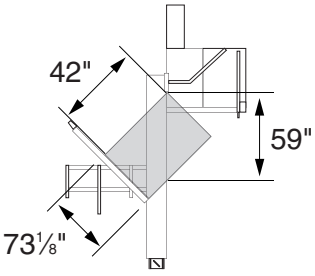
Miter Cut 45°
(push cut)



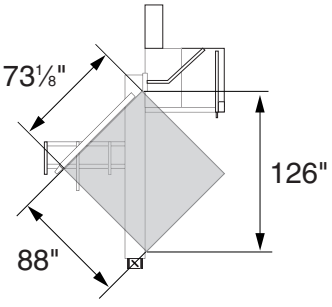
Miter Cut 45°



Cross Cut
(fence not extended)



Miter Cut 45°
(push cut, fence not extended)



Miter Cut 45°
(fence not extended)

SECTION 1: SAFETY

⚠WARNING

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

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

⚠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

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine. Untrained users can be seriously hurt.

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

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

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

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

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

⚠WARNING
Safety Instructions for Machinery

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

INTENDED USE. Only use the machine for its intended purpose and only use recommended accessories. Never stand on machine, modify it for an alternative use, or outfit it with non-approved accessories.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

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

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

REMOVING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

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

DANGEROUS ENVIRONMENTS. Do not use machinery in wet locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well lighted to minimize risk of injury.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

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

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine ***OFF*** and ensure all moving parts completely stop before walking away.

MAINTENANCE & INSPECTION. A machine that is not properly maintained may operate unpredictably. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. Regularly inspect machine for loose bolts, alignment of critical parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or misadjusted parts before operating machine.

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

⚠WARNING
Additional Safety Instructions for Table Saws

SAFETY ACCESSORIES. To prevent kickback, always make sure the riving knife and the blade guard are properly installed during all cutting operations.

KICKBACK. Kickback happens when the workpiece is thrown back toward the operator at a high rate of speed. Until you have a clear understanding of kickback, how it occurs, and how to prevent it, DO NOT operate this table saw!

WORKPIECE CONTROL. If the workpiece should unexpectedly move and bind with the blade, kickback could occur. Always make sure the workpiece is placed in a stable position on the tables and is either supported by the rip fence or the crosscut fence during cutting operations.

PUSH STICKS/BLOCKS. When ripping narrow stock, there is a risk of your hands contacting the spinning blade resulting in serious injury. Always use push sticks/blocks when cutting narrow stock to keep hands clear of the blade.

OPERATOR POSITION. If kickback occurs, the workpiece will be ejected in a path that is in-line with the blade. Never have any part of your body in-line with the cutting path of the blade during operation.

AWKWARD POSITIONS. Avoid awkward body and hand positions where a sudden slip could cause your hands to move into the spinning blade.

RIVING KNIFE ALIGNMENT. If the riving knife is not aligned with the saw blade, the workpiece could bind and cause kickback. Always make sure the riving knife is in proper alignment with the saw blade.

REACHING OVER SAW BLADE. To prevent your hands or arms accidently contacting the spinning blade, never reach behind or over the blade during cutting operations.

USING RIP FENCE WITH CROSSCUT FENCE. When using the rip fence as a stop block for the crosscut fence, the rip fence must be in front of the blade. Otherwise, the workpiece could bind against the rip fence and kickback could occur.

REMOVING WORKPIECES. To avoid accidental contact with the spinning blade, always turn the saw OFF and wait until the blade is completely stopped before removing any part of the workpiece from the table.

BLADE HEIGHT. Make sure the blade is adjusted to the correct height above the workpiece to prevent the blade from aggressively grabbing the workpiece and kicking it back toward the operator.

DAMAGED SAW BLADES. A saw blade that is damaged or bent can cause kickback during operations. If you have any doubt about the condition of the saw blade, DO NOT use it!

⚠WARNING

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

⚠CAUTION

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

Preventing Kickback

Below are steps you must take to avoid the most common causes of kickback:

- Only cut workpieces with at least one smooth and straight edge. DO NOT cut excessively warped, cupped or twisted wood. If the workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, a kickback will likely occur. Always use the rip fence or cross cut fence to support the workpiece.
- Make sure the riving knife is aligned with the blade. A misaligned riving knife can cause the workpiece to catch or bind, increasing the chance of kickback. If you think that your riving knife is not aligned with the blade, check it immediately!
- Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table.
- Always use the riving knife. This device maintains the kerf in the workpiece, reducing the chance of kickback.
- Always keep the blade guard installed and in good working order.
- Feed cuts through to completion. Anytime you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.

⚠WARNING

Statistics show that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward the operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some precautions to help protect yourself if kickback DOES occur:

- Stand to the side of the blade during every cut. If a kickback does occur, the thrown workpiece usually travels directly in front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.
- Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick or push block to keep your hands farther away from the moving blade. If a kickback occurs, these safety devices will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to prevent or slow down kickback.

Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is **VERY** important to us at Grizzly!

ARBOR. Metal shaft extending from the drive mechanism, to which saw blade is mounted.

BEVEL EDGE CUT. Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

BLADE GUARD. Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

CROSSCUT. Cutting operation in which the crosscut fence is used to cut across the grain, or across the shortest width of the workpiece.

DADO BLADE. Blade or set of blades that are used to cut grooves and rabbets.

DADO CUT. Cutting operation that uses a dado blade to cut a flat bottomed groove into the face of the workpiece.

FEATHERBOARD. Safety device used to keep the workpiece against the rip fence and against the table surface.

KERF. The resulting cut or gap in the workpiece after the saw blade passes through during a cutting operation.

KICKBACK. An event in which the workpiece is propelled back towards the operator at a high rate of speed.

PARALLEL. Being an equal distance apart at every point along two given lines or planes. I.e. the rip fence face is parallel to the face of the saw blade.

NON-THROUGHCUT. A sawing operation that requires the removal of the blade guard and riving knife. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock. Deep Non-Through Cuts must be made with multiple, light passes to reduce chance of kickback. Always remember to re-install the blade guard and riving knife after performing a non-through cut.

PERPENDICULAR. Lines or planes that intersect and form right angles (i.e. the blade is perpendicular to the table surface).

PUSH STICK. Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

RABBET. Cutting operation that creates an L-shaped channel along the edge of the workpiece.

RIVING KNIFE. Metal plate located behind the blade. It maintains the kerf opening in the wood when performing a cutting operation.

STRAIGHTEDGE. A tool used to check the flatness, parallelism, or consistency of a surface(s).

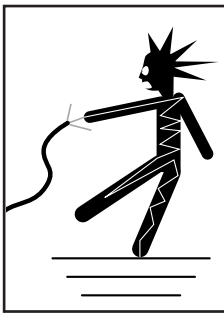
THROUGH CUT. A sawing operation in which the workpiece is completely sawn through.

RIP CUT. Cutting operation in which the rip fence is used to cut with the grain, or across the widest width of the workpiece.

SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.



⚠WARNING

Electrocution, fire, or equipment damage may occur if machine is not correctly grounded and connected to the power supply.

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V ..... 23 Amps
Full-Load Current Rating at 440V .. 11.5 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

Circuit Requirements for 220V

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V/240V
Cycle ..... 60 Hz
Phase 3-Phase
Circuit Rating ..... 30 Amps
Plug/Receptacle ..... NEMA L15-30
Cord ..... 4-Wire, 8 AWG, 300VAC, "S"-Type

Circuit Requirements for 440V

This machine can be converted to operate on a 440V power supply. To do this, follow the **Voltage Conversion** instructions later in this section. The intended 440V circuit must have a verified ground and meet the requirements that follow:

Nominal Voltage 440V/480V
Cycle ..... 60 Hz
Phase 3-Phase
Rated Size ..... 15 Amps
Connection..... Hardwire with Locking Switch

A power supply circuit includes all electrical equipment between the main breaker box or fuse panel in your building and the incoming power connections at the machine. This circuit must be sized to safely handle the full-load current drawn from the machine for an extended period of time.

⚠CAUTION

For your own safety and protection of property, consult a qualified electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*

Grounding Instructions

In the event of certain types of malfunctions or breakdowns, grounding provides a path of least resistance for electric current—in order to reduce the risk of electric shock.

For 220V operation: The power cord and plug specified under "Circuit Requirements for 220V" on the previous page have an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

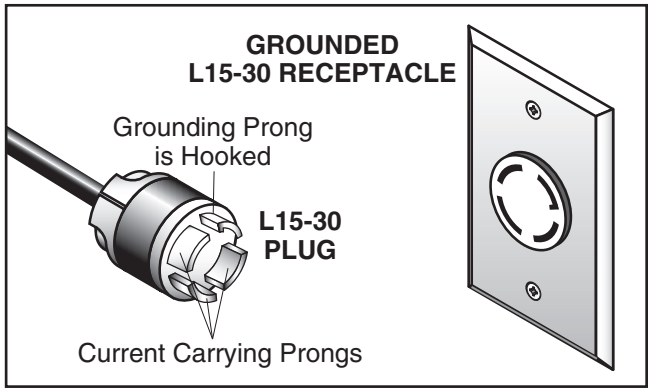


Figure 2. Typical L15-30 plug and receptacle.

For 440V operation: As specified in "Circuit Requirements for 440V" on the previous page, the machine must be hardwired to the power source, using a locking switch as a disconnecting means (see below). This setup must ground the machine to a metal permanent wiring system or a system with an equipment-grounding conductor. Due to the complexity and high voltage involved, this type of installation MUST be done by a qualified electrician.

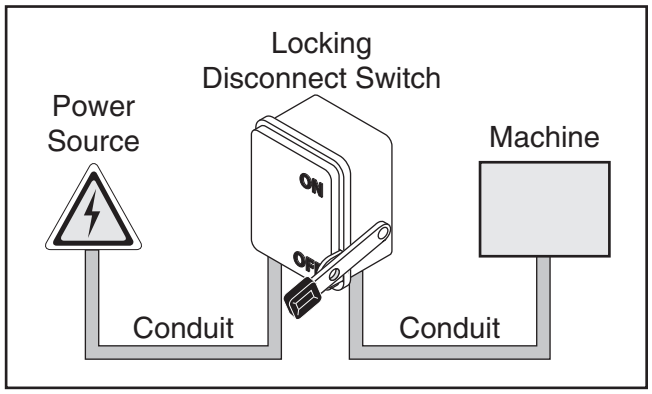


Figure 3. Typical hardwire setup with a locking disconnect switch.

⚠WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded.

If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords (220V Only)

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size .....8 AWG
Maximum Length (Shorter is Better).....50 ft.

440V Conversion

The Model G0699 can be converted for 440V operation. This conversion job consists of disconnecting the saw from the power source, replacing both overload relays, and rewiring the main and scoring blade motors for 440V operation.

Purchase the Model G0699 440V Conversion Kit (Part No. P06991310) that includes the necessary overload relays for this procedure by calling Grizzly Customer Service at (800) 523-4777.

All wiring changes must be inspected by a qualified electrician before the saw is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

To rewire the Model G0699 for 440V operation:

1. DISCONNECT SAW FROM POWER!

2. Remove the electrical panel cover from the back of the frame (see **Figure 4**).

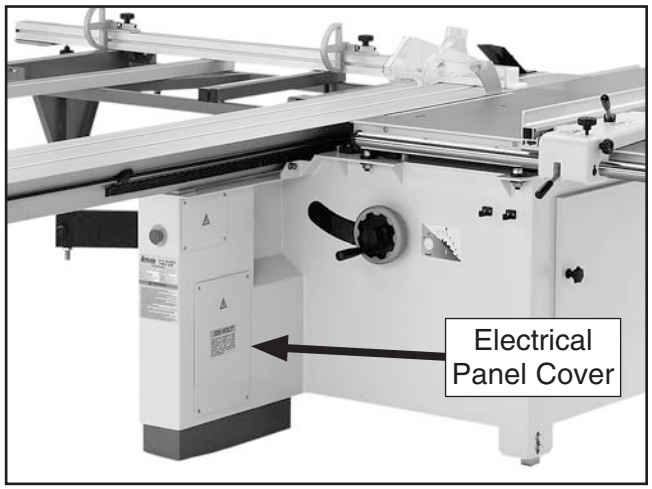


Figure 4. Location of electrical panel cover.

3. Make note of wire locations on both overload relays installed on the electrical panel (see **Figure 5** and refer to **Electrical Cabinet Wiring Diagram** on **Page 73**).

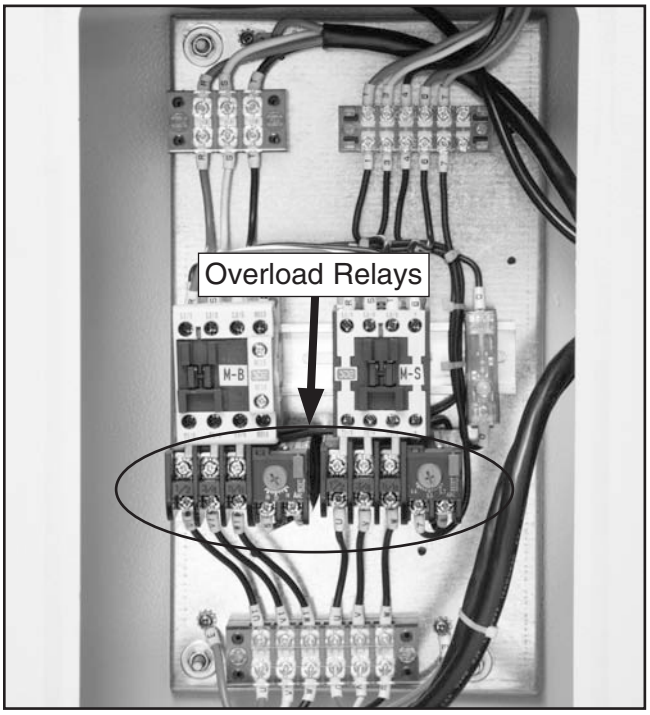


Figure 5. Locations of the overload relays on the electrical panel.

4. Disconnect and remove both overload relays, then replace them with the relays included in the 440V conversation kit.

Note: *Although the two 220V relays look similar, they are not the same models. However, the two 440V relays are the same models and can be installed in either position.*

5. Set the amperage dial on the left relay to 10A and the right relay to 2A.

6. Open the junction boxes on the main and scoring blade motors, then rewire the motors as shown on the diagrams located inside the motor junction box covers.

Note: *When changing the motor wiring for the 440V conversion, refer to the wiring diagrams inside the motor junction box covers, as they will reflect any changes to the motors shipped with the machine. As an aid to understanding these wiring diagrams or if they are missing, refer to the motor wiring diagrams on* ***Page 75****.*

Correcting Phase Polarity

This subsection is only provided for trouble-shooting. If you discover during the test run that the saw will not operate, or that the blades spin backward, the power connections may be wired out-of-phase. Without the proper test equipment to determine the polarity of the power source legs, wiring machinery to 3-phase power may require trial-and-error. Correcting phase polarity is simply a matter of reversing the positions where two of the incoming power source wires are connected at the junction box.

⚠WARNING

If this machine is wired out-of-phase, the blades will spin in the wrong directions. If you attempt a cutting operation with the blades spinning backward, the workpiece could be thrown aggressively from the table during the cutting operation. This could result in death or serious personal injury. You MUST make sure the blades are spinning in the correct directions before attempting any cutting operations. Perform *Step 9* of the test run on *Page 37* to make sure the machine is correctly wired.

To correct phase polarity:

1. DISCONNECT SAW FROM POWER!

2. Remove the power connection junction box cover (see **Figure 6**).

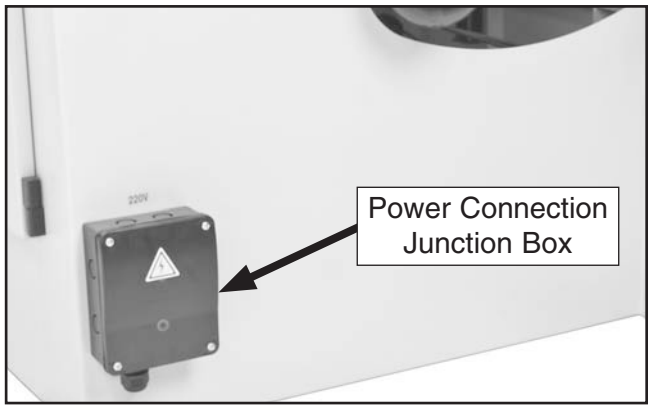


Figure 6. Location of power connection junction box.

3. Swap any two of the hot incoming power connections (see **Figure 7**), then replace the junction box cover.

⚠WARNING

Make sure the incoming ground wire is connected to the right-most terminal post in the power connection junction box to ensure the machine is properly grounded. An ungrounded or improperly grounded machine could cause electrocution.

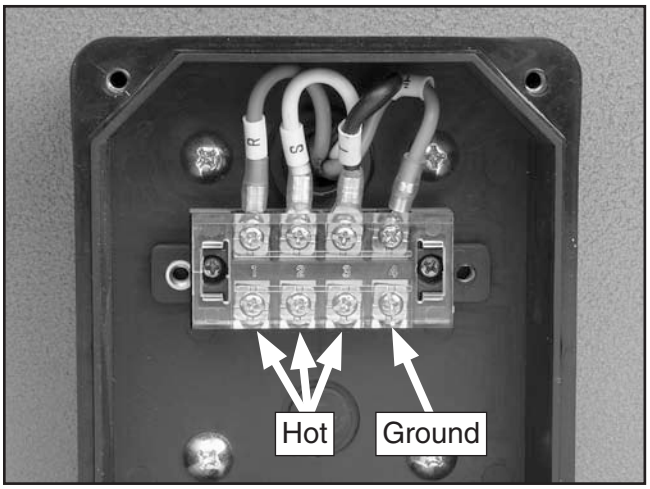
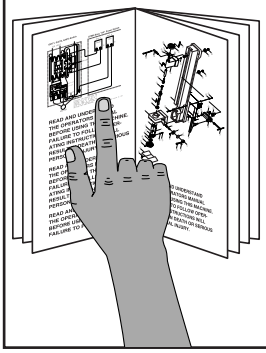


Figure 7. Incoming power connections.

4. Perform **Step 9** of the test run on **Page 37** to confirm that the power connections are correct.

   —If the motors and blades are still rotating in the wrong direction, contact our Tech Support at (570) 546-9663 for assistance.

SECTION 3: SETUP



⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!

⚠WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Needed for Setup

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

Description	Qty
• Additional People	At Least 3
• Safety Glasses	1 Per Person
• Cleaner/Degreaser (**Page 20**)	As Needed
• Disposable Shop Rags	As Needed
• Forklift (Rated for At Least 1500 lbs.)	1
• Saw Blade 12"	1
• Straightedge 3'	1
• Precision Ruler	1
• Felt Tip Pen	1
• Adjustable Carpenter's Square	1
• Feeler Gauge Set	1
• 90° Square	1
• Screwdriver Phillips #2	1
• Hex Wrench 3mm	1
• Hex Wrench 4mm	1
• Hex Wrench 6mm	1
• Hex Wrench 8mm	1
• Wrench 12mm	1
• Dust Collection System	1
• Dust Hose 2½"	1
• Dust Hose 5"	1
• Hose Clamps 5"	2

Unpacking

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

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

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

Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Crate 1: (Figure 8)		**Qty**
A.	Forward Extension Wing	1
B.	Rear Extension Wing	1
C.	Crosscut Table	1
D.	Crosscut Fence	1
E.	Crosscut Table Brace	1
F.	Rip Fence Rail w/Fasteners	1
G.	Rip Fence Scale	1
H.	Rip Fence	1
I.	Rip Fence Body Assembly	1
J.	Blade Guard Assembly	1
K.	Crosscut Fence Flip Stops	2
L.	End Shoe Assembly	1
M.	Push Stick	1
N.	Hold-Down Assembly	1
O.	Riving Knife	1
P.	Dust Hose Support	1
Q.	Tool Box (Not Shown)	1
	—Scoring Arbor Wrench	1
	—Combo Wrench 17/19mm	1
	—Wrench 30mm	1
	—T-Handle Wrench 8mm	1

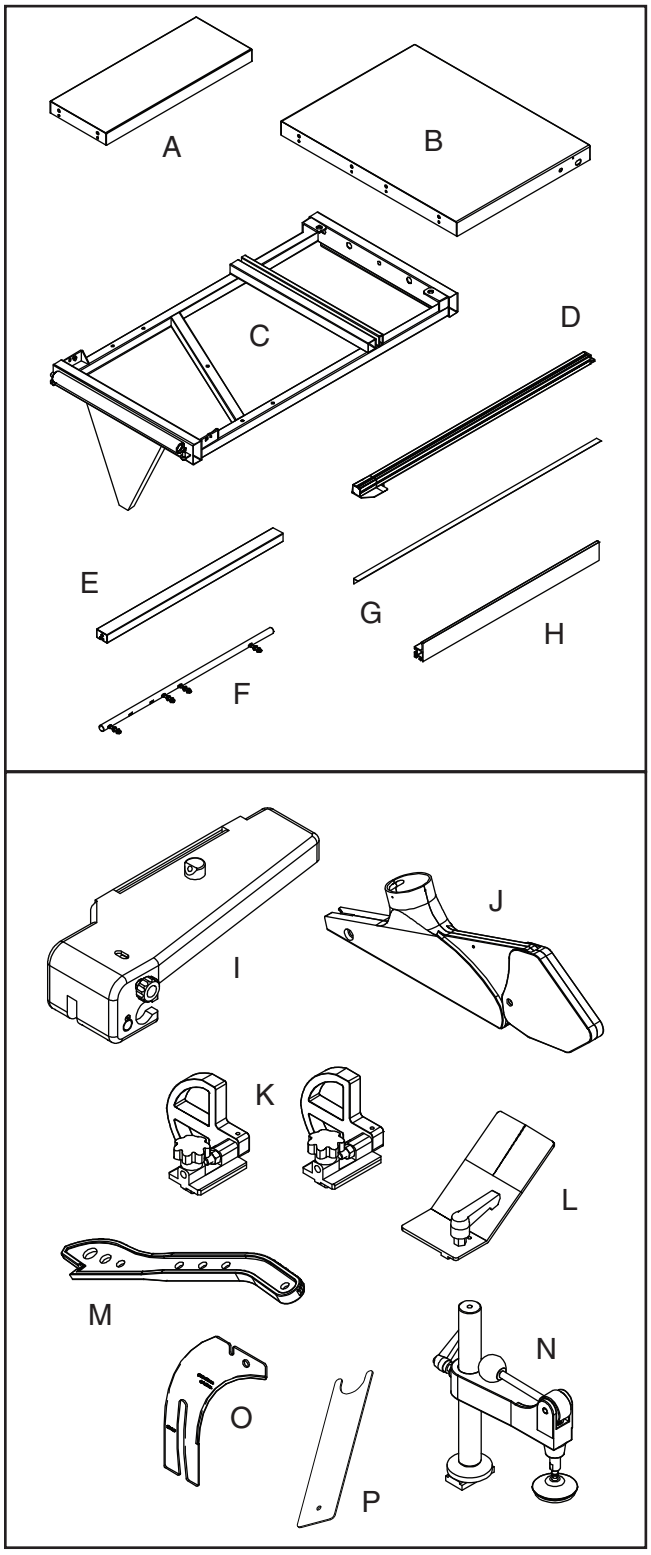


Figure 8. Crate 1 inventory.

Hardware (Not Shown) **Qty**

Blade Guard:
- —Dust Hose Clamps 2-1/2" 2

Sliding Table:
- —T-Bolts M12-1.75 x 60 3
- —Flat Washers 12mm 3
- —Lock Washers 12mm 3
- —Hex Nuts M12-1.75 3
- —Push Handle M12-1.75 x 12 1
- —Flat Washer 12mm 1
- —Nylon Flat Washer 12mm 1
- —T-Nut M12-1.75 1

Rip Fence:
- —Handles M10-1.5 x 12 2
- —Knob M10-1.5 x 70 1
- —Button Head Cap Screws M6-1 x 12 3
- —Flat Washers 6mm 3

Rip Fence Rail:
- —Rip Fence Stop Ring w/Set Screw 1
- —Flat End Cap 1
- —Lock Washer 8mm 1
- —Cap Screw M8-1.25 x 16 1
- —Lock Handle M12-1.75 x 55 1
- —Flat Washer 12mm 1
- —T-Nut Plate M12-1.75 1

Cross Cut Table Brace:
- —T-Nuts M8-1.25 2
- —Fender Washers 8mm 2
- —Knobs M8-1.25 x 50 2

Cross Cut Fence:
- —T-Bolt M8-1.25 x 60 1
- —Fender Washer 8mm 1
- —Knob M8-1.25 1
- —Pivot Stud M8-1.25 x 10 1
- —Fiber Flat Washer 8mm 1
- —T-Nuts M8-1.25 3
- —Knob M8-1.25 x 25 w/Nylon Tip 1
- —Knob M8-1.25 x 50 1
- —Stop Block 1
- —Cap Screw M8-1.25 x 35 1
- —Lock Washer 8mm 1

Wings:
- —Cap Screws M10-1.5 x 25 5
- —Lock Washers 10mm 5
- —Flat Washers 10mm 5
- —Set Screws M10-1.5 x 20 5
- —Hex Nuts M10-1.5 5

Dust Hose Support:
- —Hex Bolt M10-1.5 x 25 1
- —Flat Washers 10mm 2
- —Lock Nut M10-1.5 1

Crate 2: (Figure 9) **Qty**

R. Sliding Table Assembly 1
S. End Handle Assembly 1

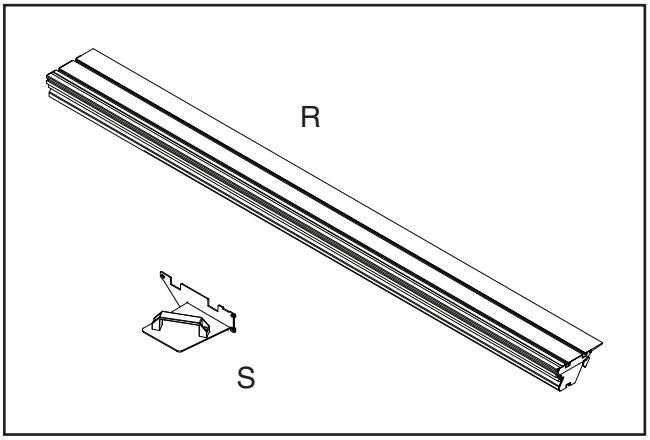
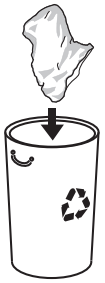


Figure 9. Crate 2 inventory.

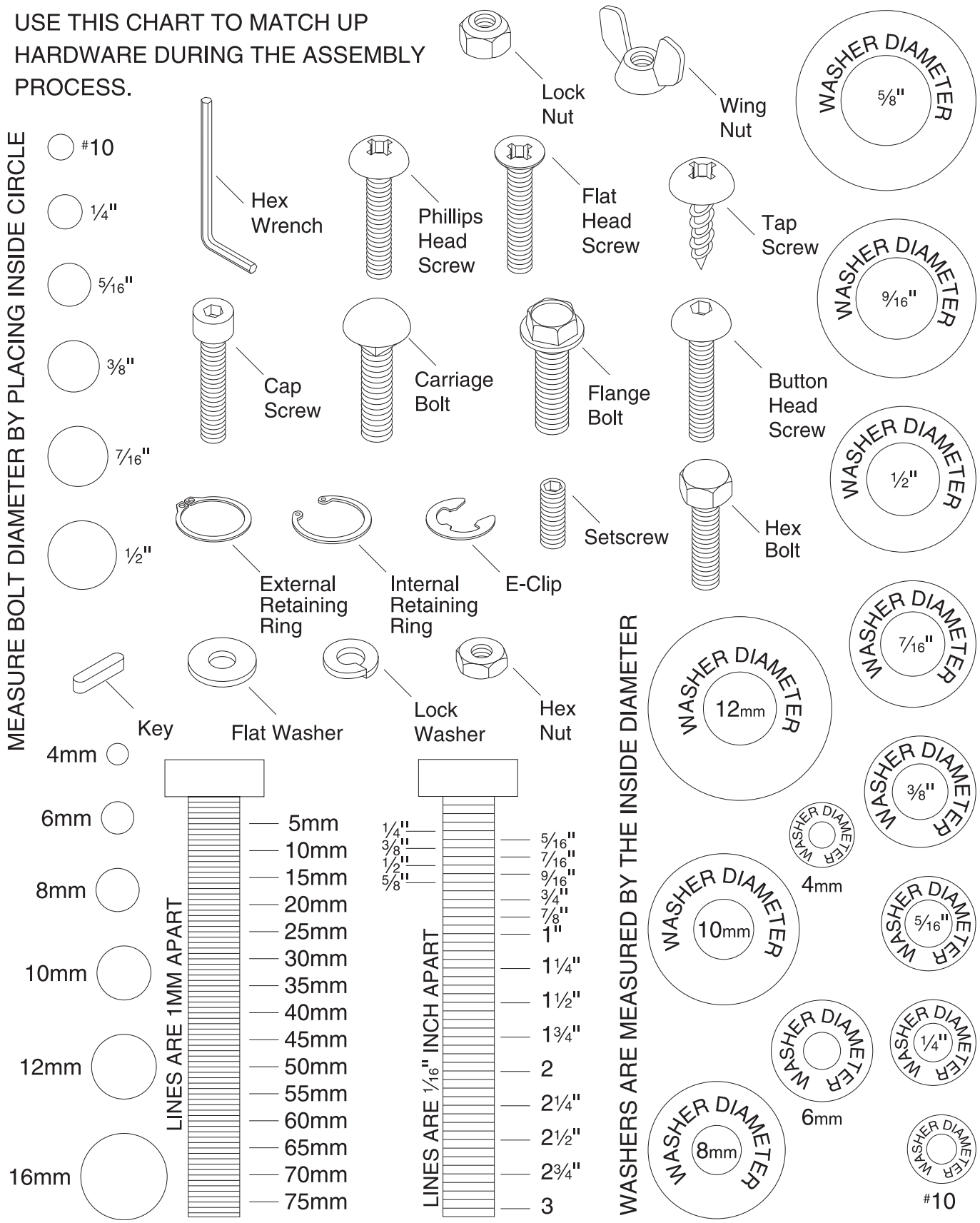


⚠WARNING

SUFFOCATION HAZARD!
Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Hardware Recognition Chart



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage.

This rust preventative has been your machine's close ally and guardian since it left the factory. If your machine arrived to you free of rust, then be thankful that the rust preventative protected it during its journey...and try to stay thankful as you clean it off, because it can be challenging to remove if you are unprepared and impatient.

Plan on spending some time cleaning your machine. The time you spend doing this will reward you with smooth sliding parts and a better appreciation for the proper care of your machine's unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, these instructions walk you through what works well for us.

Before cleaning, gather the following:
- Disposable Rags
- Cleaner/degreaser (see below)
- Safety glasses & disposable gloves

H9692—Orange Power Cleaner & Degreaser
One of the best cleaners we've found for quickly and easily removing rust preventative.

Figure 10. Model H9692 Industrial Orange Power Cleaner/Degreaser.

Note: *In a pinch, automotive degreasers, mineral spirits or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of your paint to make sure they will not damage it.*

⚠WARNING

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

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.

2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner/degreaser and let them soak for few minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily.

   Note: *To clean off thick coats of rust preventative on flat surfaces, such as tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or you may scratch your machine.)*

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

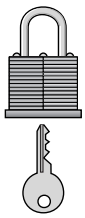
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

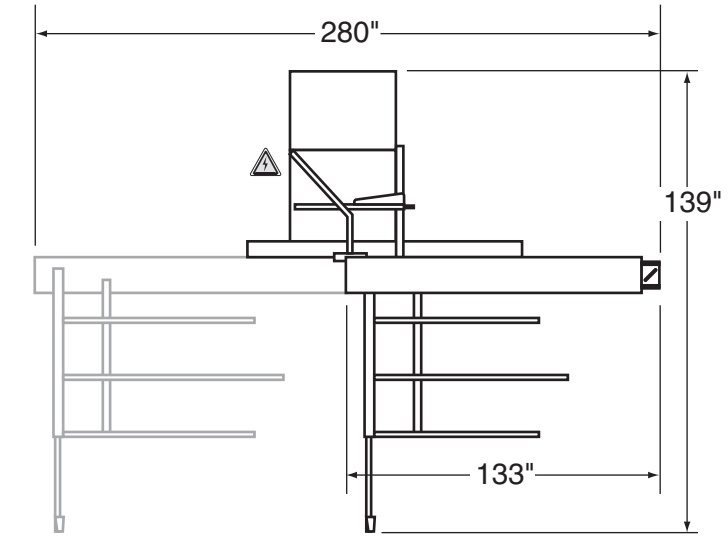
The physical environment where your machine is operated is important for safe operation and the longevity of its components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

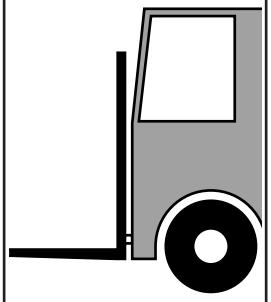
Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.



⚠ = Power Connection (Drawing Not To Scale)

Figure 11. Minimum working clearances.

Lifting & Placing



⚠WARNING

The Model G0699 is a heavy machine. Serious personal injury may occur if safe moving methods are not used. To be safe, get assistance and use power equipment to move the shipping crate and remove the machine from the crate.

To lift and move the machine:

1. After removing the shipping crate from the pallet, move the smaller components and boxes to a safe area.

2. Position the forklift forks completely under the cabinet, as illustrated in **Figure 12**.

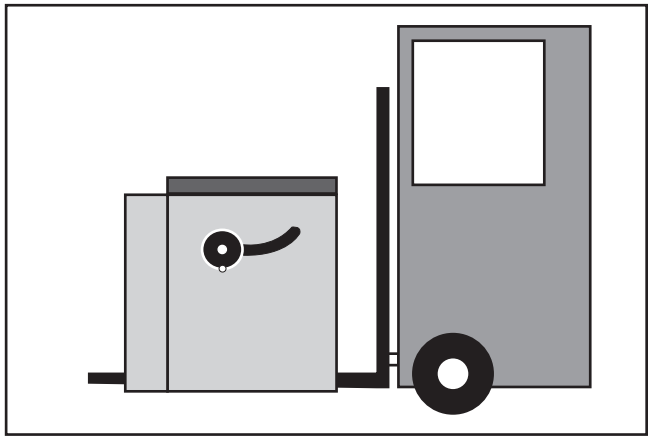


Figure 12. Example of lifting the table saw assembly.

3. With the help of additional people to steady the load, lift the machine enough to clear the pallet and any floor obstacles, then move it to its permanent location.

Assembly & Setup

⚠WARNING

You must successfully complete the assembly and setup of this saw as instructed below before connecting the machine to power. Otherwise, the saw will not operate safely and could cause serious personal injury or machine damage.

⚠CAUTION

Before proceeding with the next steps, wear leather gloves to protect your hands when handling the saw and scoring blades.

To assemble the sliding table saw:

1. Use the elevation handwheel on the right side of the cabinet to raise the main blade arbor all the way up, then open the blade safety cover to expose the blade arbors, as shown in **Figure 13**.

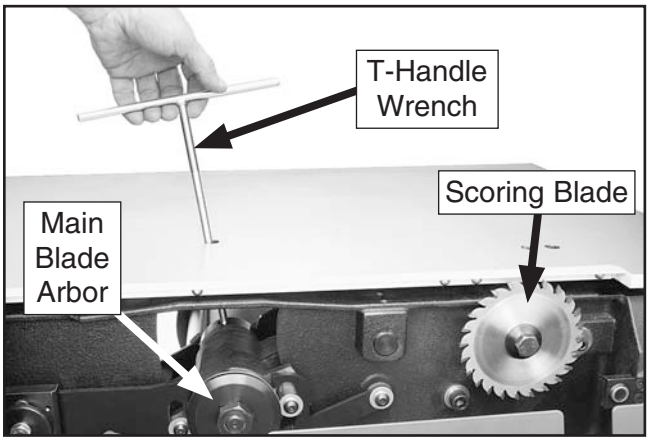


Figure 13. Blade arbors exposed.

2. Insert the provided T-handle wrench through the table top hole shown in **Figure 13** and into one of the holes in the main blade pulley under the table top. This will keep the blade arbor from rotating during the next step.

3. While holding the T-handle wrench with one hand, rotate the arbor nut clockwise to remove it and the flange (see **Figure 14**).

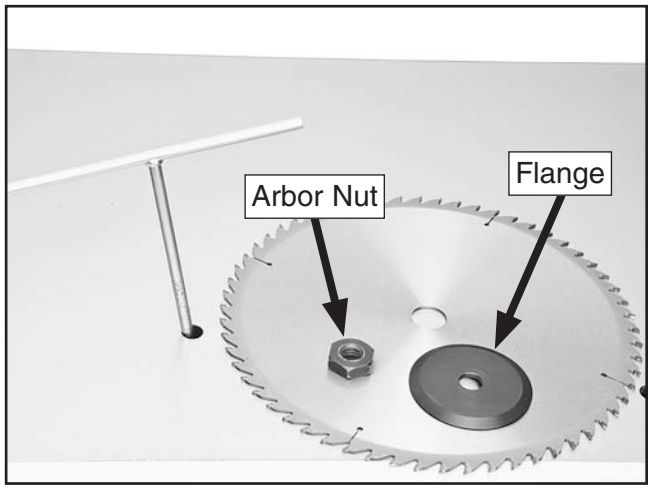


Figure 14. Main blade arbor nut and flange.

4. Slide the saw blade over the arbor with the teeth facing to the right, then re-install the flange and arbor nut while holding the arbor steady with the T-handle wrench, as shown in **Figure 15**.

   The beveled edge of the flange must be facing out and the arbor nut must be fully tightened to safely secure the blade.

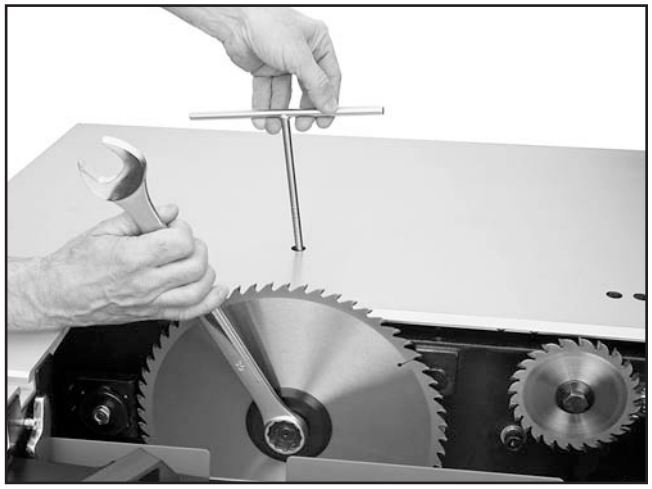


Figure 15. Installing main blade.

5. Loosen the riving knife bolt (see **Figure 16**), position the bottom slot of the knife over the locating pins, then hand tighten the bolt.

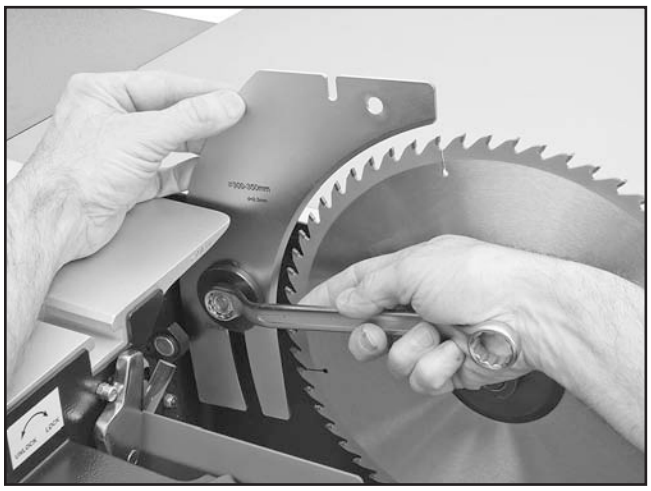


Figure 16. Installing the riving knife.

6. Position the riving knife so that there is an even 3mm distance between it and the blade teeth along its full length.

   Tip: *For a quick spacing gauge, use a 3mm hex wrench to set the correct spacing between the riving knife and the blade, as shown in* ***Figure 17****.*

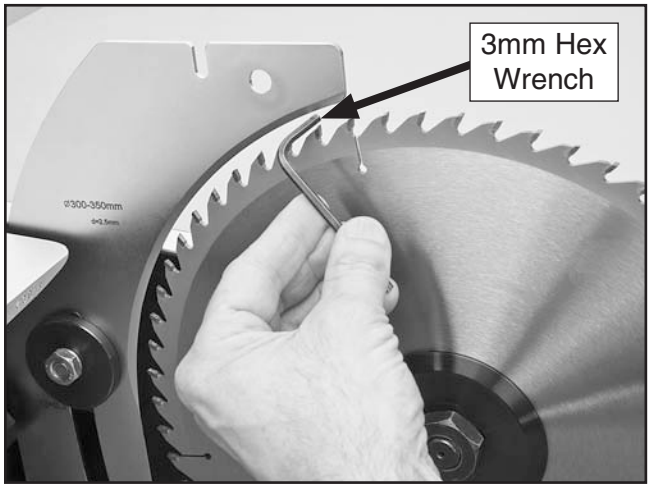


Figure 17. Setting the correct riving knife spacing.

7. Fully tighten the riving knife bolt and re-check its position and spacing. If necessary, repeat **Step 6** until the riving knife is properly positioned.

8. To make sure the scoring blade arbor nut is fully tightened, hold the arbor wrench on the arbor behind the blade and use the wrench on the nut to tighten it clockwise, as shown in **Figure 18**.

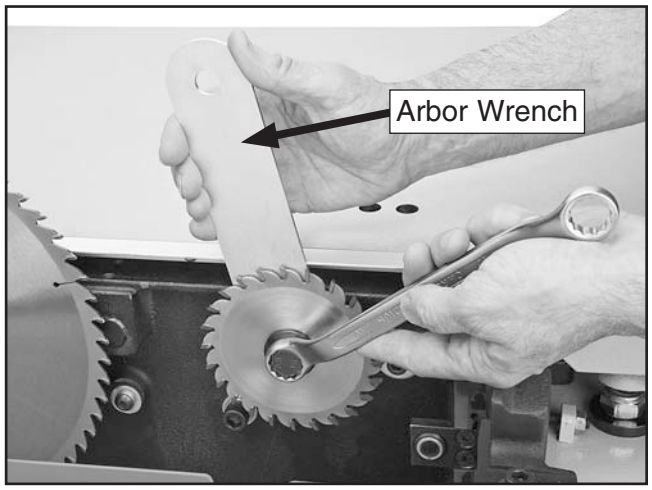


Figure 18. Tightening the scoring blade arbor nut.

9. Close the blade cover and lower the main blade all the way down so that it does not present a hazard during the following steps.

NOTICE

The sliding table is heavy, so you must get help lifting it during the installation process. We recommend two strong people lift the sliding table and an additional person help position the T-bolts into the mounting holes as the table is lowered.

10. Turn the sliding table assembly upside down, as shown in **Figure 19**.

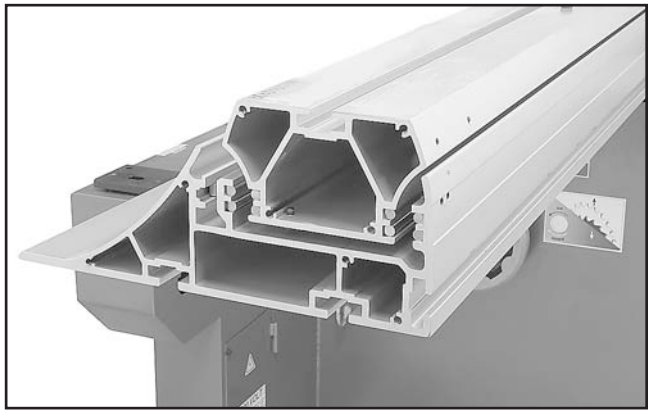


Figure 19. Sliding table saw upside down.

11. Insert the (3) M12-1.75 x 60 T-bolts into the sliding table T-slot, as shown in **Figure 20**, and space them apart the same distance as the mounting holes in the frame top.

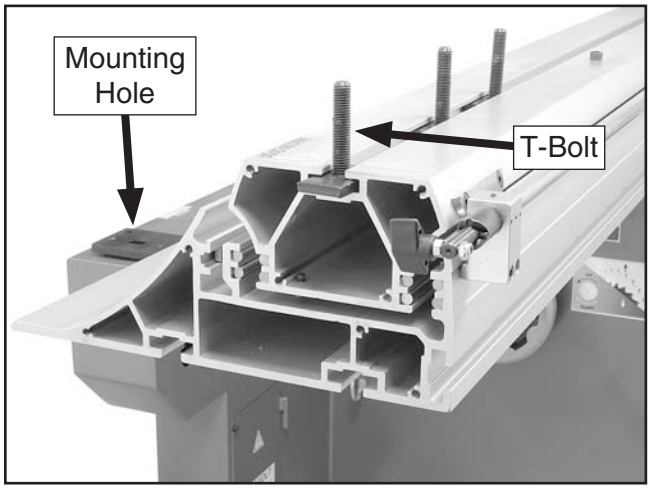


Figure 20. T-bolts inserted into the sliding table T-slot.

12. Have two people turn the sliding table assembly right side up, then have another person guide the T-bolts into the mounting holes as the sliding table is lowered onto the frame.

Important: *As you align the sliding table parallel with the main saw blade in the next steps, the locating cap screw shown in* ***Figure 21*** *must remain against the right side of the frame before securing the sliding table in place. This will correctly position the sliding table with the rest of the machine.*

Figure 21. Sliding table locating cap screw against the right side of the frame.

In the next steps, you will align the sliding table parallel with the table saw. This is necessary to ensure straight cutting operations and to prevent workpieces from binding and kicking back.

13. Move the sliding table all the way back.

14. Tilt the main saw blade to 0° and raise it all the way up.

15. Use the felt tip pen to mark the right blade edge that is even with the table.

16. Use the adjustable square and feeler gauges to measure the distance between the sliding table T-slot and the main saw blade at the mark you made in **Step 15**. This is distance "A" shown in **Figure 22**.

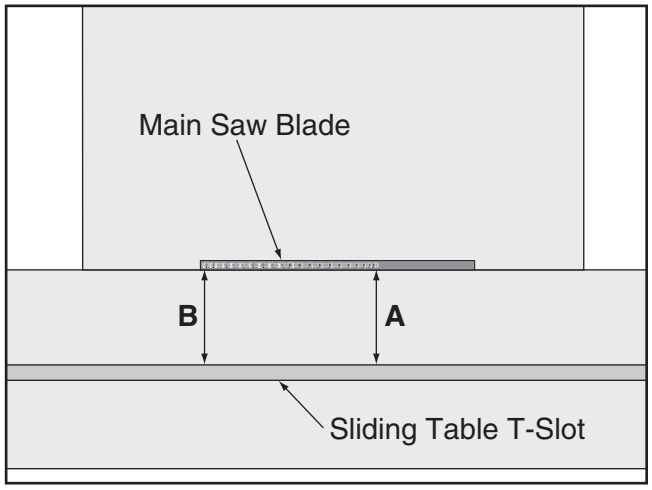


Figure 22. Measuring the distance between sliding table T-slot and main blade.

17. Move the sliding table all the way forward, rotate the saw blade so the mark you made in **Step 15** is at location "B", then take the measurement of "B".

—If the difference is equal to or less than 0.004" between the "A" and "B" measurements, the sliding table parallelism is acceptable. Continue with **Step 21**.

—If the difference between the "A" and "B" measurements is greater than 0.004", the sliding table parallel adjustment bolts need to be re-adjusted. Continue with the next step.

18. Loosen the jam nuts on the sliding table parallel bolts (see **Figure 23**) that are on both sides of the cabinet behind the sliding table, then adjust the bolts in or out in small increments to change the sliding table parallelism to the saw blade.

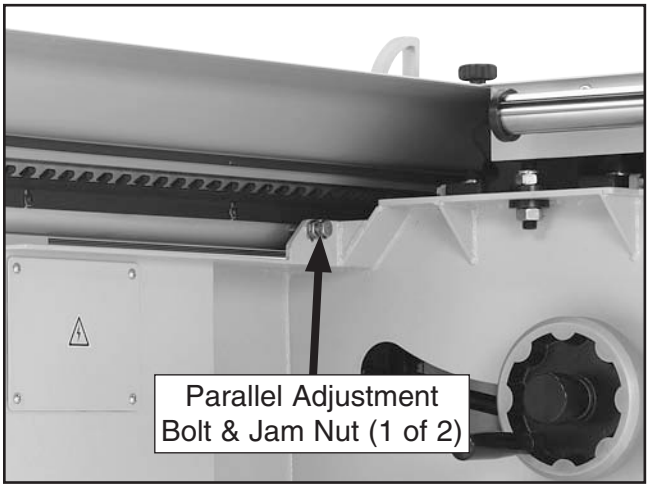


Figure 23. Sliding table parallel adjustment bolt (1 of 2).

19. Make sure the sliding table is against the adjustment bolts, then repeat **Steps 16–17** until the difference between the "A" and "B" measurements is acceptable.

20. Re-tighten the jam nuts.

21. Remove the panels on both sides of the frame to gain access to the forward and rear sliding table T-bolts (see **Figure 24** for the location of the forward access T-bolt).

Figure 24. Location of the forward sliding table T-bolt from the rear of the frame.

22. Locate the middle sliding table T-bolt through the 5" dust chute hole on the forward side of the cabinet, as shown in **Figure 25**.

Figure 25. Location of the middle sliding table T-bolt.

23. Make sure the sliding table is against both parallel adjustment bolts and the locating cap screw shown in **Figure 21** on **Page 24**, then secure the sliding table with (3) M12-1.75 hex nuts, 12mm lock washers, and 12mm flat washers. Replace the forward and rear access panels.

24. Attach the end handle to the right side of the sliding table with the (2) pre-installed M8-1.25 x 16 cap screws, as shown in **Figure 26**.

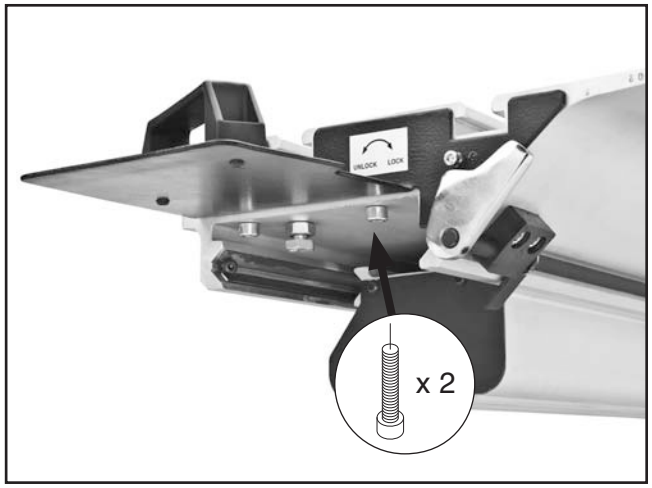


Figure 26. Sliding table end handle attached.

25. Install the sliding table push handle into the front T-slot with a 12mm flat washer, 12mm nylon flat washer, and a M12-1.75 T-nut, as shown in **Figure 27**.

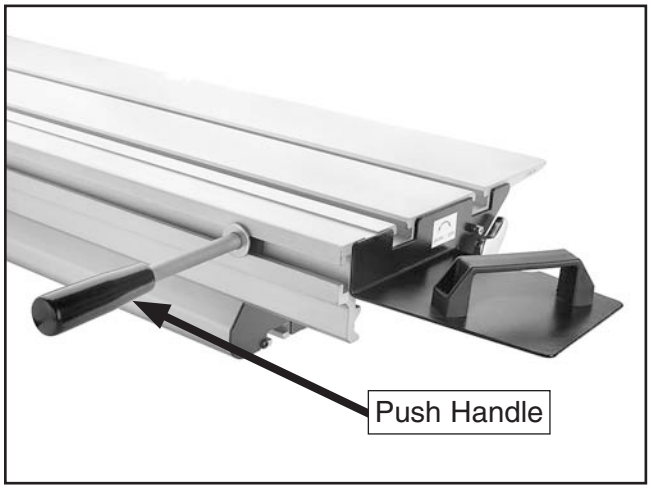


Figure 27. Sliding table push handle installed.

26. With the help of another person to hold the forward extension wing, attach it to the cast iron table with (2) M10-1.5 x 25 cap screws, 10mm lock washers, and 10mm flat washers, as shown in **Figure 28**.

Hand tighten the cap screws for now—they will be fully tightened in a later step.

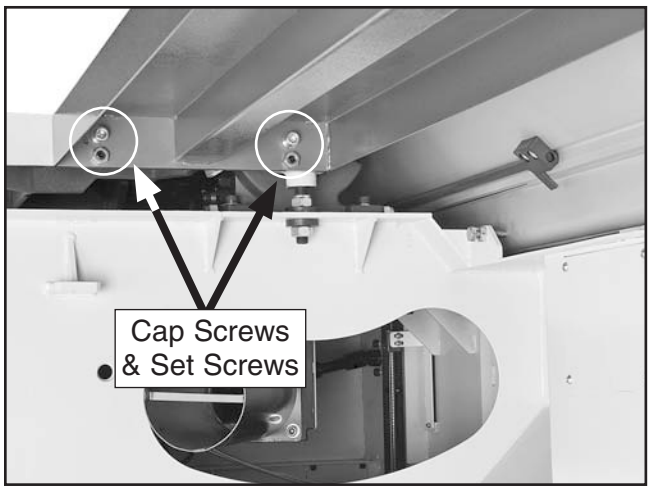


Figure 28. Forward extension wing attached (as viewed under the wing).

27. With the help of two other people to hold the rear extension wing, attach it to the cast iron table with (3) M10-1.5 x 25 cap screws, 10mm lock washers, and 10mm flat washers, as shown in **Figure 29**.

Hand tighten the cap screws for now—they will be fully tightened in a later step.

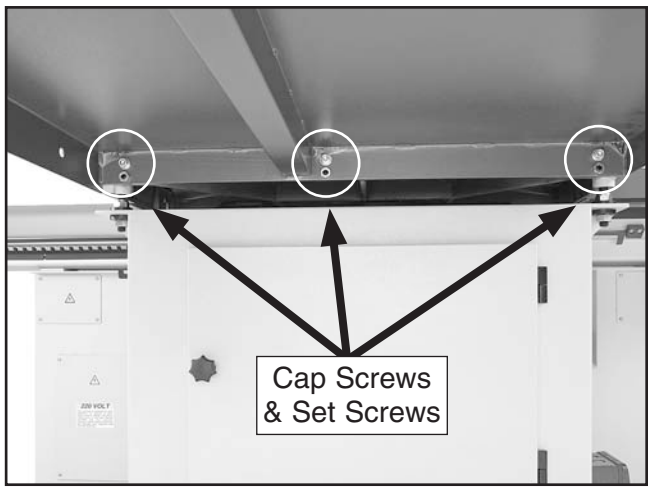


Figure 29. Rear extension wing attached.

28. Thread (5) M10-1.5 x 20 set screws into the threaded holes under each of the extension wing cap screws on both wings (see **Figures 28–29**).

Make sure the set screws do not stick out from the wing mating surface, which would interfere with the leveling process in the next step.

29. Place the straightedge across the cast iron table and an extension wing, then adjust the set screws in or out to make the top surface of the wings even with that of the cast iron table (see **Figure 30**).

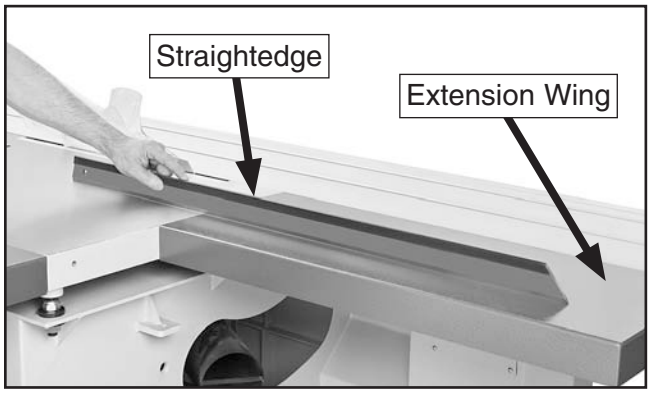


Figure 30. Using a straightedge to make sure the table/wing top surfaces are even.

30. When the top surfaces are even, thread (5) M10-1.5 hex nuts onto the set screws without changing their settings. Fully tighten the hex nuts to secure the set screws in place.

31. Fully tighten the extension wing cap screws, then re-check to make sure the top surfaces remain even.

—If the top surfaces did not remain even after tightening the cap screws, loosen them, then repeat **Steps 29–31** until they remain even.

32. Attach the dust hose support to the left side of the rear extension wing with (1) M10-1.5 x 25 cap screw, (2) 10mm flat washers, and (1) M10-1.5 lock nut, as shown in **Figure 31**.

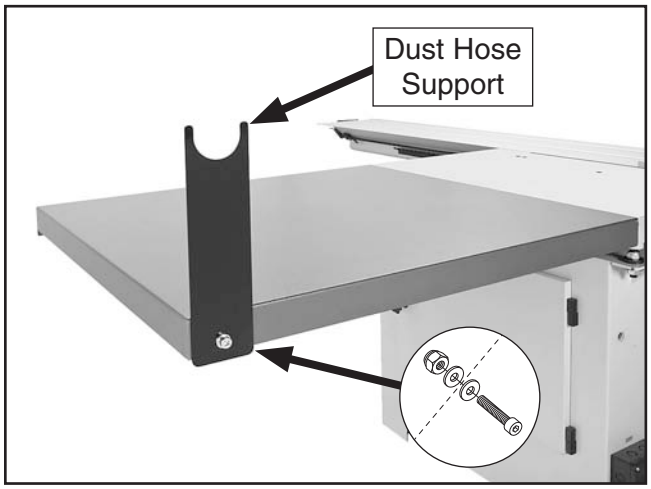


Figure 31. Dust hose support attached.

33. Attach the rip fence scale to the rear side of the cast iron table and rear extension wing with (3) M6-1 x 12 button head cap screws and 6mm flat washers, as shown in **Figure 32**.

Hand-tighten the cap screws for now—they will be fully tightened in a later step.

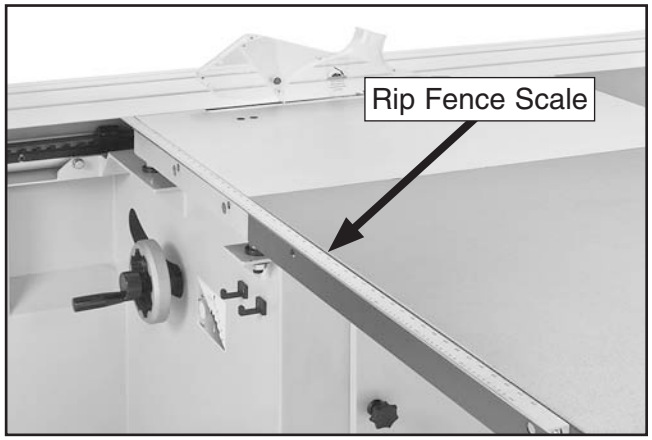


Figure 32. Rip fence scale attached.

34. Remove one hex nut, lock washer, and flat washer from each of the fence rail mounting studs.

35. Install the rip fence rail by inserting the studs into the provided holes in the cast iron table and rear extension wing, as shown in **Figure 33**, then secure them with the hex nuts, lock washers, and flat washers removed in **Step 34**.

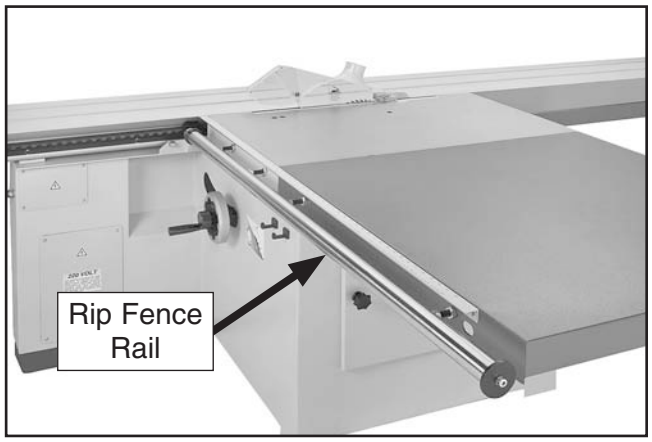


Figure 33. Rip fence rail installed.

36. Slide the rip fence body assembly onto the rip fence rail, then install the two handles and one knob, as shown in **Figure 34**.

You may have to adjust the rip fence rail hex nuts on both sides so that the fence body does not rub against the sides of the table and extension wing.

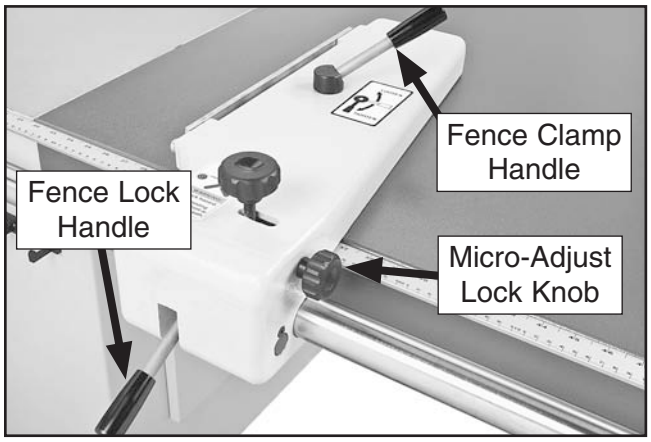


Figure 34. Rip fence body assembly installed.

⚠WARNING

The rip fence stop screws keep the fence from moving forward and slipping off the fence body, which could draw your hands and arms into the spinning blade during operation. Always keep these stop screws properly installed.

37. Remove the rip fence stop screw from the tall side of the rip fence (see **Figure 35**).

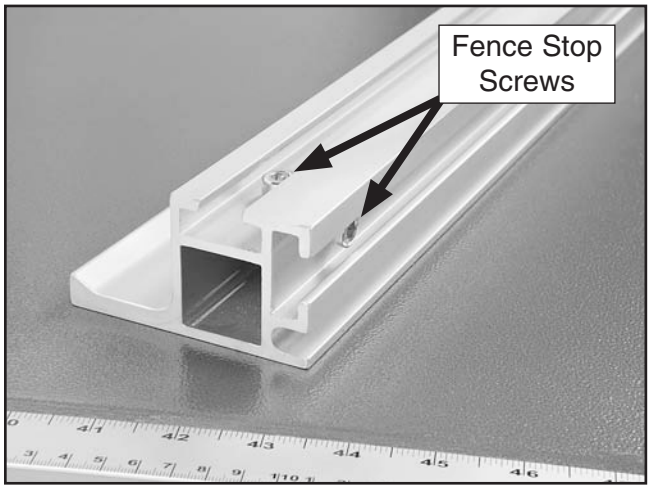


Figure 35. Rip fence stop screws.

38. Loosen the fence clamp handle (see **Figure 36**), then slide the fence onto the T-slot plates and the clamp plate so that the tall side of the fence is facing the blade.

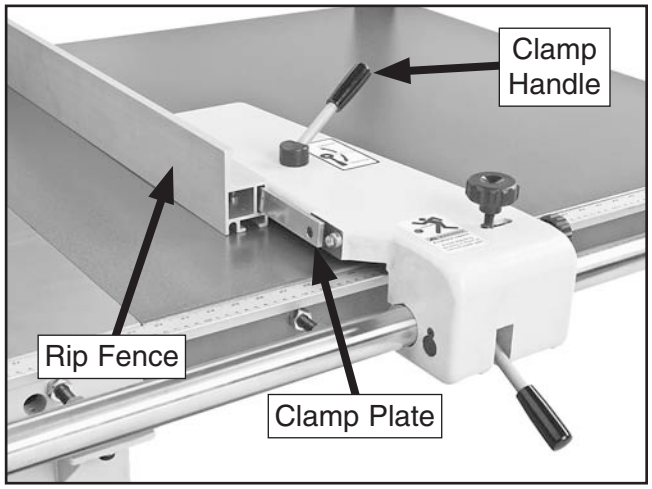


Figure 36. Installing the rip fence.

39. Slide the rip fence toward you, re-install the stop screw that you removed in **Step 27**, move the fence forward until it stops, then tighten the fence clamp handle.

40. Insert the T-handle wrench into the left-hand hole of the two shown in **Figure 37**, engage it with the scoring blade elevation bolt under the table top, and rotate it counterclockwise to lower the scoring blade below the table surface.

Note: *This will keep the scoring blade from interfering with the rip fence alignment process in the next steps.*

Figure 37. Lowering the scoring blade.

41. Raise the main saw blade all the way up, then slide the rip fence against it without pushing on it, as shown in **Figure 38**.

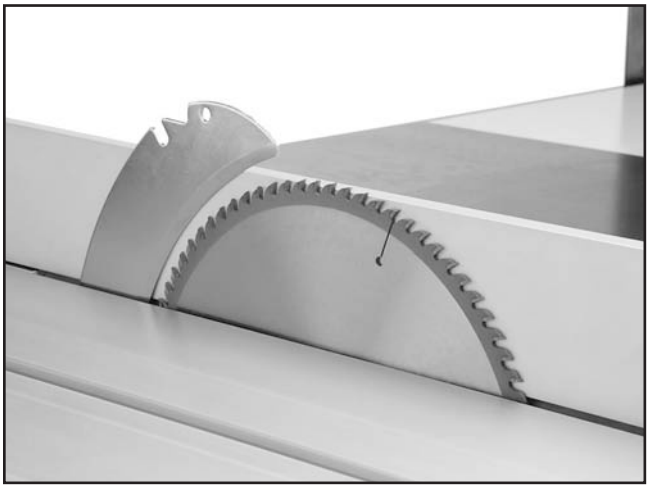


Figure 38. Rip fence against the saw blade.

42. Loosen the fence rail hex nuts on both sides and adjust the rail in or out until the rip fence is even with the saw blade along its full length, then hand-tighten the hex nuts again.

NOTICE

The rip fence body will scratch the table and rear extension wing surfaces if the ride height is not adjusted correctly.

Note: *The goal of the adjustments in the next step is to make the rip fence body ride height as close to and even with the table and extension wing surfaces without touching or scratching them.*

43. Check if the any part of the metal rip fence body rests on the surface of the table.

—If the forward end of the fence body rests on the table, lift the fence up so that you can access the roller adjustment bolt and set screw shown in **Figure 39**. Loosen the set screw, rotate the eccentric adjustment bolt until the roller extends slightly beyond the body, then re-tighten the set screw.

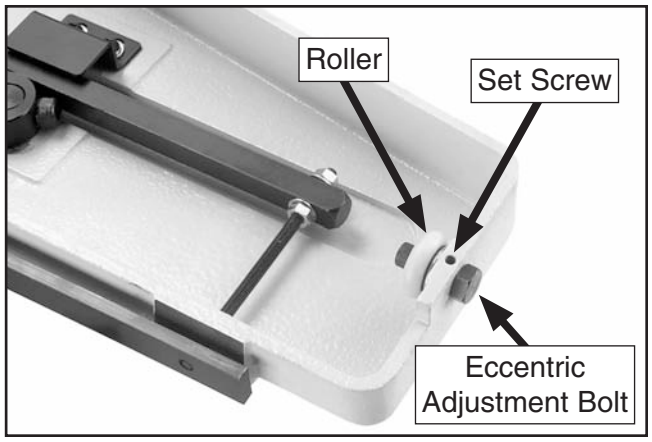


Figure 39. Rip fence body roller controls.

—If the rear end of the fence body rests on the table, adjust the height of the fence rail.

44. If you have not already fully tightened the outer fence rail hex nuts in a previous step, do so now.

45. Make sure the rip fence is still even with the saw blade and the ride height is still correct. If necessary, repeat previous steps to make the rip fence position correct.

46. Move the rip fence up against the saw blade, then position the rip fence scale so that the zero mark is even with face of the rip fence, as shown in **Figure 40.**

Make sure the scale is even with the top surfaces of the table and extension wing, then fully tighten the cap screws that secure the scale in place.

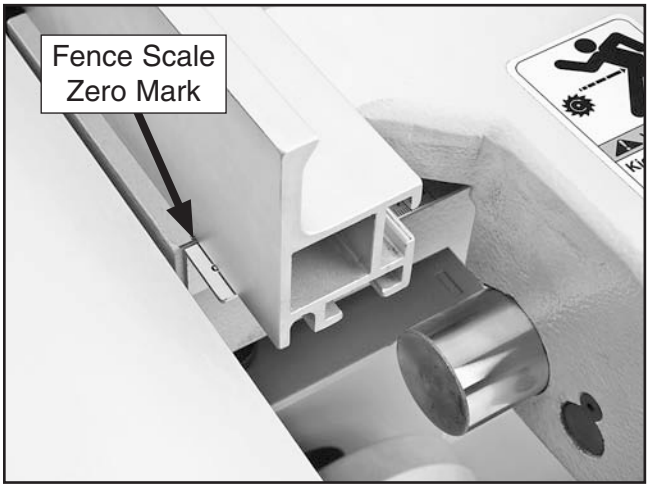


Figure 40. Rip fence scale zero mark even with the rip fence face.

⚠WARNING

When properly positioned, the rail stop ring prevents the rip fence from contacting the saw blade. If this happens during cutting operations, flying metal debris could cause serious personal injury. Always make sure the rail stop ring is secured in the proper position before beginning operations.

47. Back the rip fence away from the saw blade at least ⅛", then slide the fence rail stop ring onto the rail and secure it against the fence body by tightening the pre-installed set screw, as shown in **Figure 41**.

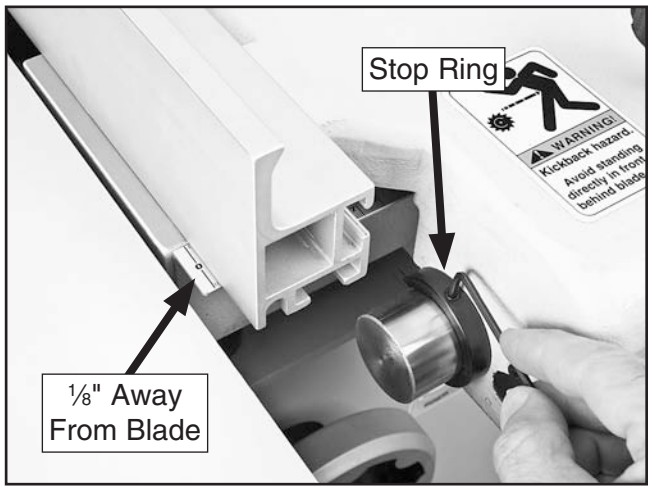


Figure 41. Installing the rip fence stop ring.

48. Attach the flat end cap to the other end of the rail with the M8-1.25 x 16 cap screw and 8mm lock washer, as shown in **Figure 42**.

Note: *The purpose of the end cap is to prevent the rip fence assembly from slipping off the end of the rail.*

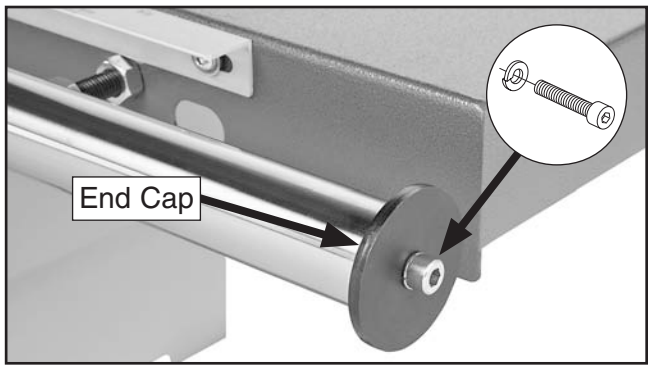


Figure 42. Rip fence rail end cap attached.

The scoring blade has wedge-shaped teeth so that the higher the blade is raised, the wider the scoring kerf will be.

The goal in the next step is to adjust the scoring blade vertical and horizontal positions so that the scoring kerf is the same width as the main saw blade kerf. This procedure requires placing the straightedge on both sides of the blades multiple times as you make adjustments.

49. When positioning the straightedge, place it against teeth at both ends of the main saw blade to obtain an accurate reading of the main saw blade kerf.

—*Horizontal Adjustment:* Insert the T-handle wrench into the right hole shown in **Figure 43**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

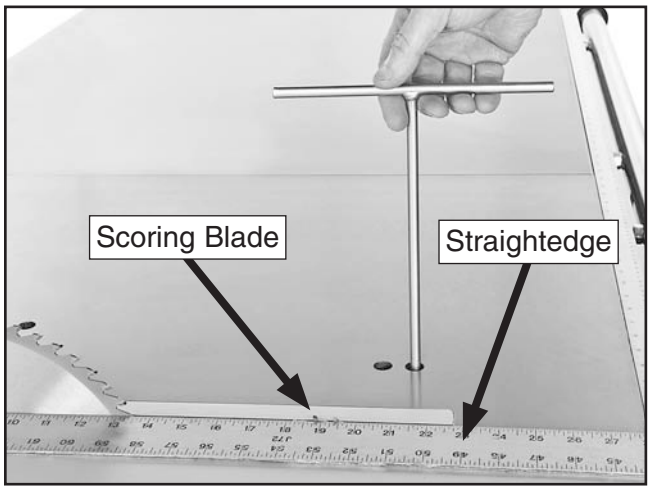


Figure 43. Adjusting the horizontal position of the scoring blade.

—*Vertical Adjustment:* Insert the T-handle wrench into the left hole shown in **Figure 44**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

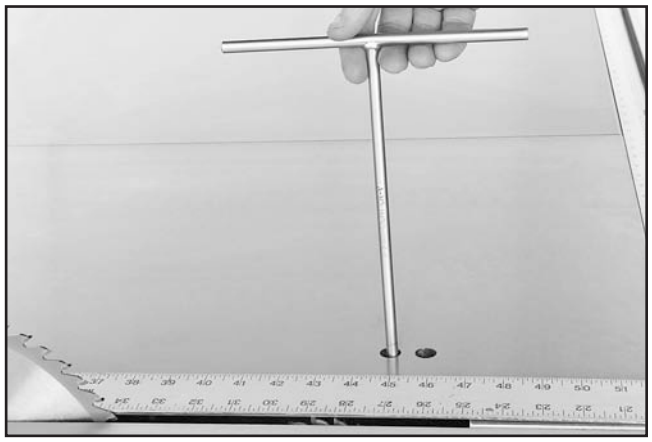


Figure 44. Adjusting the vertical height of the scoring blade.

50. Insert the M12-1.75 x 55 lock handle with a 12mm flat washer through the middle hole of the crosscut table, as shown in **Figure 45**, then loosely thread it into the T-nut plate.

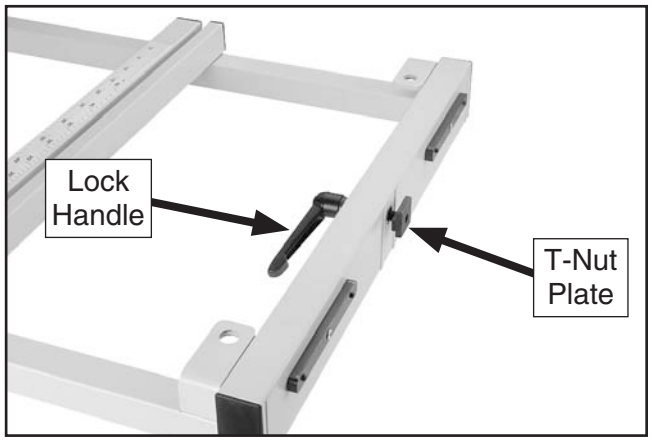


Figure 45. Crosscut lock handle installed.

51. With the help of another person, place the crosscut table on the swing arm pivot pin, as shown in **Figure 46**, then slide the T-plate into the sliding table T-slot.

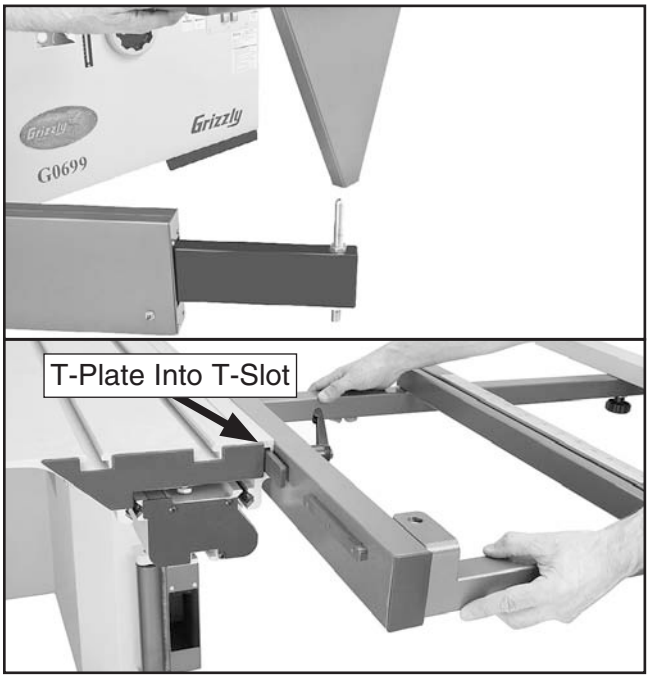


Figure 46. Installing the crosscut table into the sliding table.

52. Position the crosscut table approximately in the middle of the sliding table, then tighten the lock handle to secure it in place.

53. Slide (2) M8-1.25 T-nuts into the crosscut table brace, align the T-nuts with the holes in the crosscut table, then secure the brace with (2) M8-1.25 x 50 knobs and 8mm fender washers, as shown in **Figure 47**.

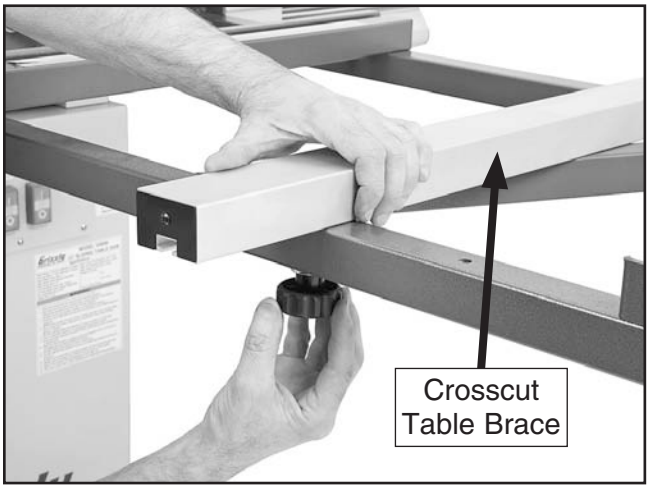


Figure 47. Installing the crosscut table brace.

54. To install the bottom T-slot components of the crosscut fence, lay the fence across the left side of the crosscut table with the polyurethane end block facing the main blade, then do the following:

a) Insert and align an M8-1.25 T-nut with the hole in the slot that is farthest from the saw blade, then thread (1) M8-1.25 x 25 knob with the nylon end through the T-nut and into the fence hole, as shown in Figure 48. This will secure the fence extension in place when fully tightened.

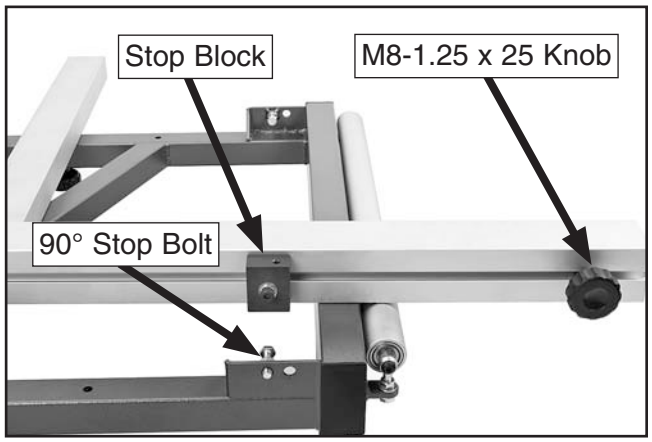


Figure 48. Front end crosscut T-slot components.

b) Align an M8-1.25 T-nut with the 90° stop bolt shown in **Figure 48**, insert (1) M8-1.25 x 35 cap screw with a 8mm lock washer through the stop block, then thread the cap screw into the T-nut.

c) Align the M8-1.25 x 60 T-bolt with the placement position shown in **Figure 49**.

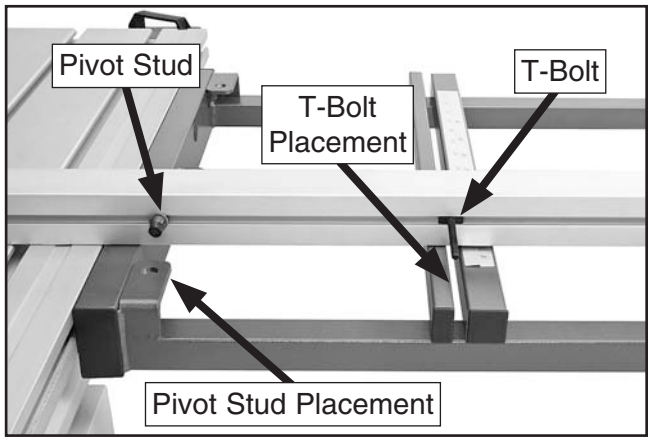


Figure 49. Back end crosscut T-slot components.

d) Align (1) M8-1.25 T-nut with the pivot stud placement position, then hand-tighten the M8-1.25 x 10 pivot stud with the 8mm fiber flat washer into the T-nut, as shown in Figure 49.

55. Turn the crosscut fence over, insert the pivot stud in its placement hole (see **Figure 49**), then slide the fence up to the main saw blade so that polyurethane end block is against the blade.

56. Using the precision ruler against a tooth of the blade, adjust the fence so that the 2" mark on the fence scale is exactly 2" from a blade tooth, as shown in **Figure 50**.

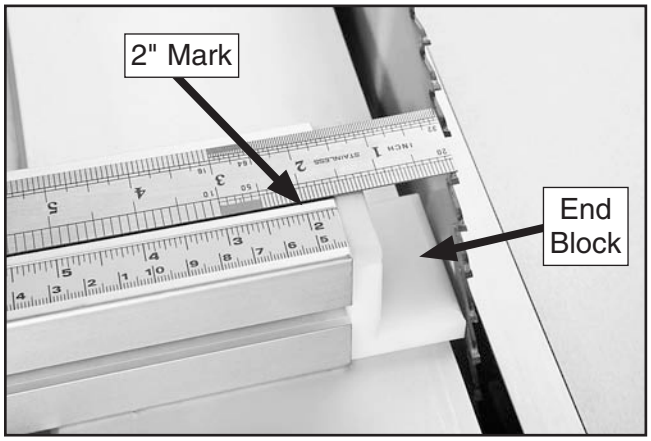


Figure 50. Setting the correct space between the crosscut fence and blade.

57. Carefully lift the crosscut fence up, fully tighten the pivot stud, then re-insert the stud into the hole. Re-check the distance between the scale and blade—if necessary, loosen the stud and repeat **Steps 56–57** until the distance is correct.

58. Slide the crosscut fence against the 90° stop bolt, then secure it in place by tightening the M8-1.25 knob with the 8mm fender washer on the T-bolt, as shown in **Figure 51**.

Note: *Adjusting the crosscut fence in different positions will be discussed in the* ***Operations*** *section later in this manual.*

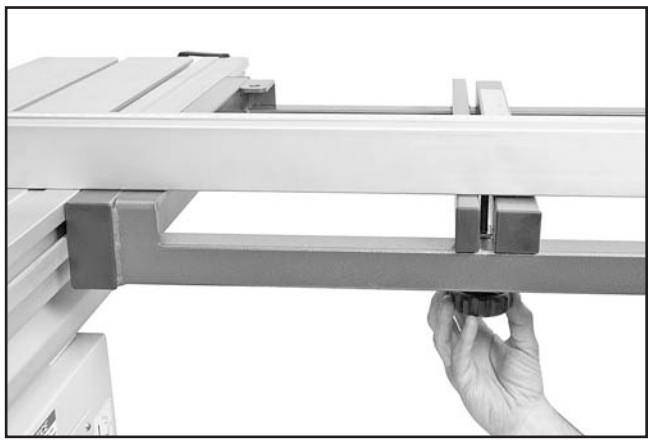


Figure 51. Securing the crosscut fence.

59. Move the crosscut extension fence out so that you can install the flip stop assemblies, as shown in **Figure 52**.

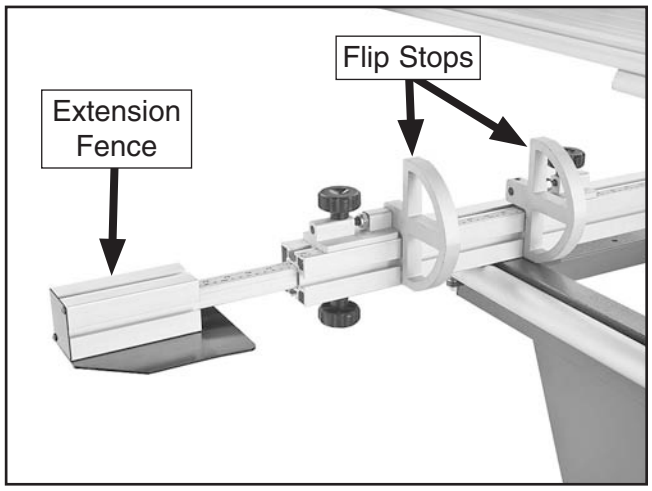


Figure 52. Crosscut flip stops installed.

Dust Collection

⚠CAUTION

DO NOT operate the Model G0699 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Required CFM at 5" Dust Port: 615 CFM
Required CFM at 2½" Dust Port: 150 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect the saw to dust collection system:

1. Secure a 5" dust hose to the port located under the table on the left side with a hose clamp, as shown in **Figure 53**.

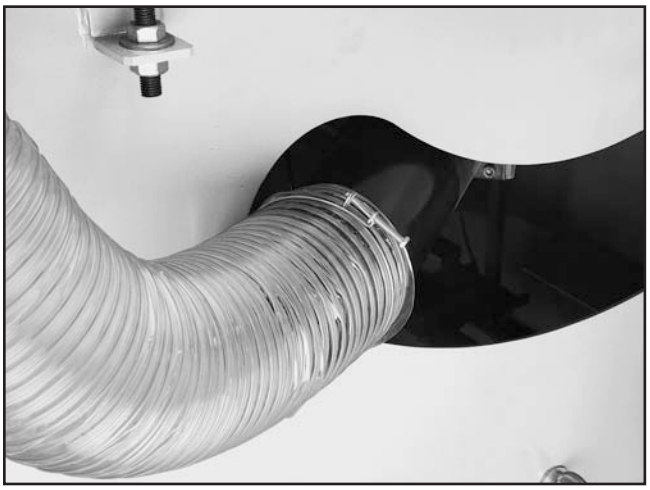


Figure 53. 5" dust port location.

2. Attach the blade guard to the riving knife with the pre-installed cap screw and hex nut, as shown in **Figure 54**, then attach a 2½" dust hose to it with a hose clamp.

Figure 54. Blade guard and 2½" dust hose attached.

3. Run the 2½" dust hose over the hose support, as shown in **Figure 55**.

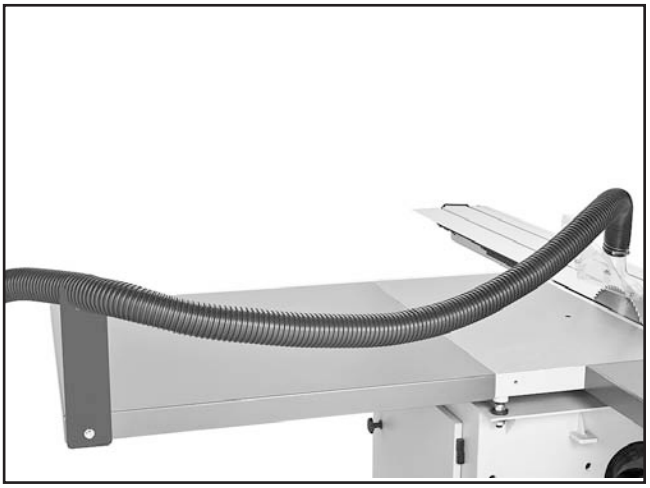


Figure 55. 2½" Dust hose held up by hose support.

4. Tug on all the hose connections to make sure that they are tight and secure.

Power Connection

Before the machine can be connected to the power source, an electrical circuit must be made available that meets the minimum specifications given in the **Circuit Requirements** subsection on **Page 12**. If a power circuit has not been prepared for the machine, do that now. To ensure a safe and code-compliant setup, we strongly recommend that all electrical work be done by a qualified electrician.

NOTICE

The Model G0699 is prewired for 220V. If you plan to operate the machine at 440V, the two overload relays on the electrical panel must be replaced and the motors must be rewired (refer to *440V Conversion* on *Page 14* for detailed instructions).

To connect the saw to the power source:

1. Open the power connection junction box shown in **Figure 56**.

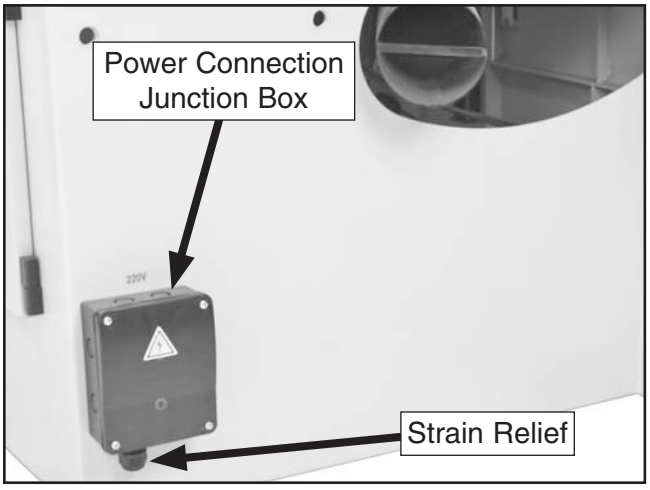


Figure 56. Location of power connection junction box.

2. Feed the incoming power cord through the strain relief at the bottom of the junction box (see **Figure 56**).

3. Make sure there is enough power cord inside the junction box to make the connections with the same amount of slack as the wires connected on top of the terminal bar, then tighten the strain relief around the cord.

4. Tug on the cord with moderate force to make sure it does not move.

   —If the power cord comes loose when you tug on it, re-position it and re-tighten the strain relief. If the strain relief does not adequately secure the cord, then replace it with one that is correctly sized for the cord.

   In the next step, connect the incoming hot wires to the three left terminals and the ground wire to the right-most terminal, as shown in **Figure 57**.

5. Loosen the terminal screw, insert the wires between the terminal plates, then fully tighten the terminal screw. Tug on the wires to make sure that they are secure.

   —If a wire comes loose when you tug on it, repeat this step. If you continue to have difficulty connecting the wires securely, consider using clamp-on ring or spade terminals on the ends of the wires.

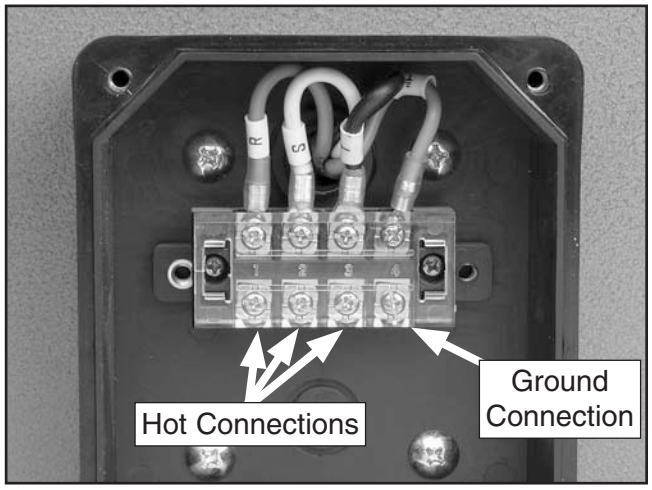


Figure 57. Incoming power connections.

6. Re-install the junction box lid before continuing with the test run.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following:

- The motors power up and run correctly.
- The STOP button safety feature works correctly.
- The blade cover safety switch works correctly.
- The main motor turns the correct direction (machine is not wired out-of-phase).

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 64**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

⚠WARNING

Before starting the saw, 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 features on this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the machine:

1. Make sure you understand the safety instructions at the beginning of the manual and that the machine is set up properly.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Review the power controls shown in **Figure 58**.

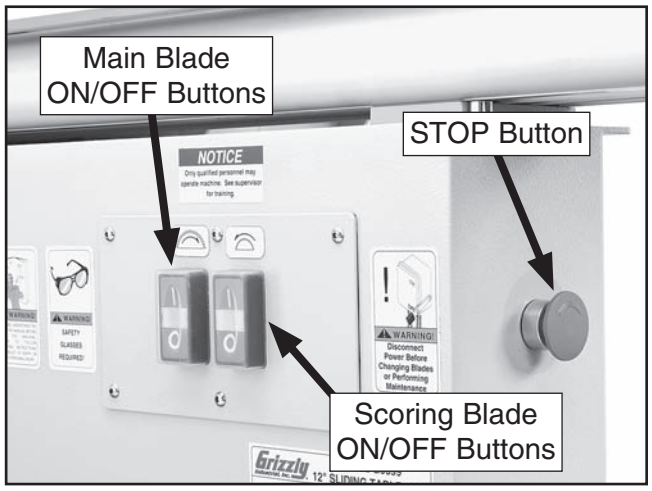


Figure 58. Power controls.

4. Push the STOP button in, then twist it clockwise so it pops out. When the STOP button pops out, the switch is reset and ready for operation (see **Figure 59**).

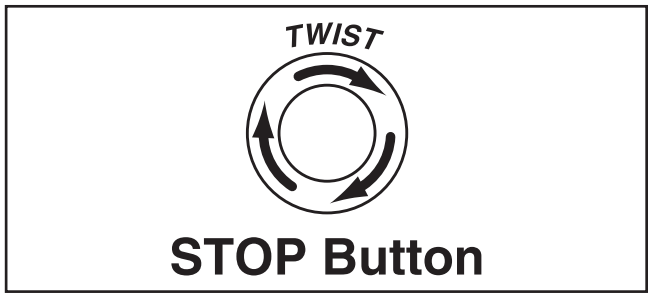


Figure 59. Resetting the STOP button.

5. Verify that the machine is operating correctly by pushing the main and scoring blade ON buttons.

   —When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

   —Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always stop the machine and disconnect it from power before investigating or correcting potential problems.

6. Press the STOP button to stop the machine.

7. WITHOUT resetting the STOP button, press the main blade ON button. The machine should not start.

   —If the machine does not start, the STOP button safety feature is working correctly.

   —If the machine does start (with the STOP button pushed in), turn the main blade motor ***OFF*** and immediately disconnect the power. The STOP button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

8. Reset the STOP button.

9. Verify that the power is not connected out-of-phase by starting/stopping the main blade and determining if the motor and blade turn in the correct direction, using the criteria below:

   —If the main blade turns clockwise (when standing in front of the machine), it is turning in the correct direction (see **Figure 60**).

   —If the main blade turns counterclockwise, it is turning in the wrong direction. Stop the machine, disconnect it from the power source, then refer to **Correcting Phase Polarity** on **Page 15** to correct this condition.

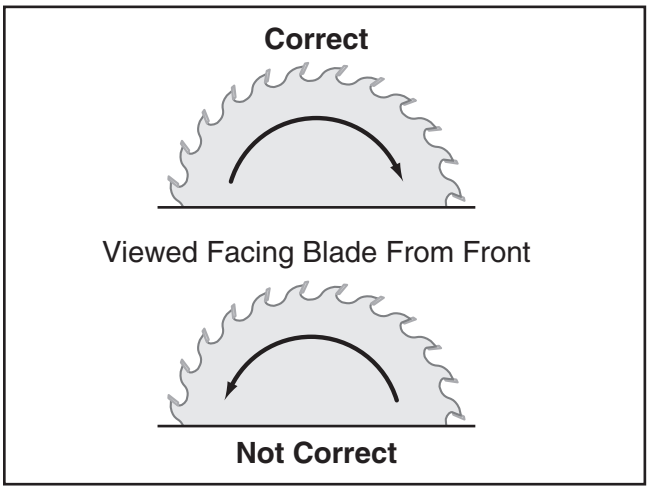


Figure 60. Correct and incorrect rotation directions for the main blade.

10. Push the STOP button, move the sliding table all the way to the left, then carefully open the red blade cover, as shown in **Figure 61**. This activates the blade cover safety switch to prevent the saw from starting while the cover is open.

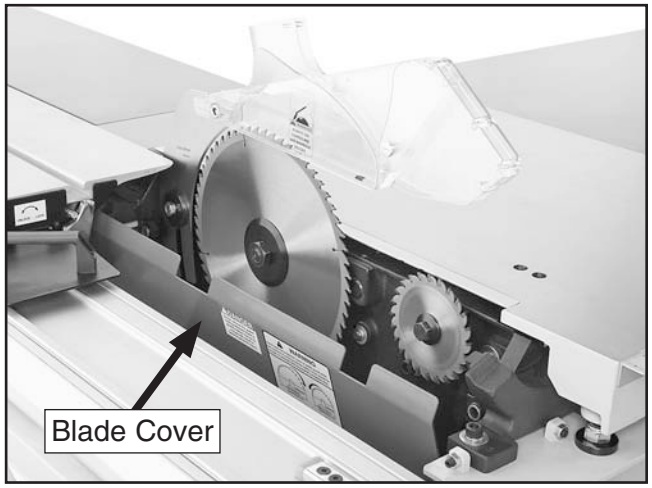


Figure 61. Blade cover open.

11. While staying safely away from the blade, reset the STOP button, then attempt to start the scoring blade.

—If the machine does not start, the blade cover safety switch safety feature is working correctly.

—If the machine does start (with the blade cover open), immediately turn the machine ***OFF*** and disconnect the power. The blade cover safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

12. Push the STOP button, carefully close the blade cover, then move the sliding table back to the center of the machine.

Congratulations! You have completed the assembly, setup, and test run of the saw. Continue with the recommended adjustments in the next section.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory.

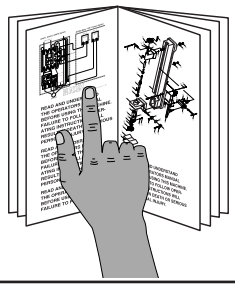
However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

Step-by-step instructions for these adjustments can be found on the referenced page for each item.

Factory adjustments that should be verified:

- Riving knife alignment (**Page 44**)
- Blade tilt calibration (**Page 67**)
- Sliding table parallelism to blade (**Page 68**)
- Crosscut fence 90° to blade (**Page 70**)

SECTION 4: OPERATIONS

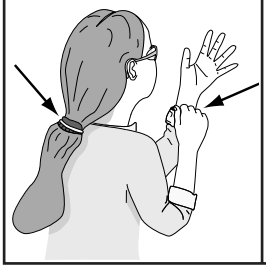


⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

⚠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, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Operation Overview

The purpose of this overview is to provide the novice woodworker with a basic understanding of how the machine is used during a typical operation, so they can more easily understand the controls discussed later in the manual.

Note: *Due to the generic nature of this overview, it is not intended to be an instruction guide for performing actual machine operations. To learn more about specific operations and woodworking techniques, seek training from people experienced with this type of saw, and do additional research outside of this manual by reading "how-to" books, trade magazines, or web sites.*

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

1. Examines the workpiece to make sure it is suitable for cutting.

2. Adjusts the fence.

—If using the rip fence, adjusts it away from the blade the same width of the desired cut, then locks it in place.

—If using the cross cut fence, moves it to correct position on the table to support the workpiece, then locks it in place.

3. Adjusts the blade tilt, if necessary, to the correct angle of the desired cut.

4. Adjusts the blade height approximately ¼" higher than the thickness of the workpiece.

5. Checks the outfeed side of the machine for proper support and clearance to make sure the workpiece can safely pass all the way through the blade without interference from other objects.

6. Wears safety glasses and a respirator, and locates push sticks if needed.

7. Starts the machine.

8. Holds the workpiece firmly and flatly against both the table and fence, and then pushes the workpiece into the blade at a steady and controlled rate until the workpiece moves completely beyond the blade.

   The operator is very careful to keep the workpiece firmly against the table and fence during the entire cut.

9. Stops the machine and removes the workpieces.

Safety Precautions

Your safety is important. The items below are intended to supplement the **SAFETY** section in the front of the manual. But remember, no safety list can cover every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

Please follow these safety precautions EVERY time you use your saw:

- Stand to the side of the blade line-of-cut when performing a cutting operation.
- Turn ***OFF*** the saw and allow the blade to come to a complete stop before removing the cut-off piece.
- Make sure that the riving knife is always aligned with the main blade before cutting!
- Always keep the blade guard properly installed.
- Carefully plan each cutting operation to avoid injuries.
- When you release the sliding table lock, make sure that the lock lever is positioned so that it will not lock the table during a cut.

Machine Controls

Review the control descriptions and **Figures 62–66** to better understand their functions and how to use them.

Main Blade ON/OFF Buttons: Starts and stops the main saw blade.

Scoring Blade ON/OFF Buttons: Starts and stops the scoring blade.

STOP Button: Cuts power to both motors.

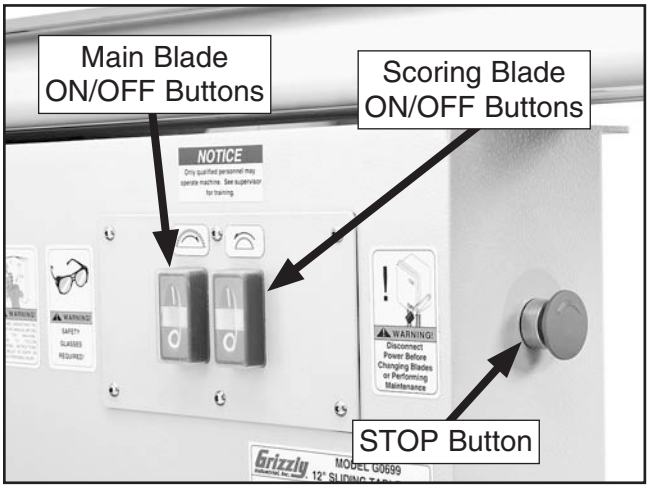


Figure 62. Power controls.

Blade Tilt Handwheel & Lock Knob: Handwheel tilts the blades from 0° to 45°. The lock knob secures the handwheel to prevent it from moving during operation.

Blade Tilt Scale: Displays the degree of blade tilt.

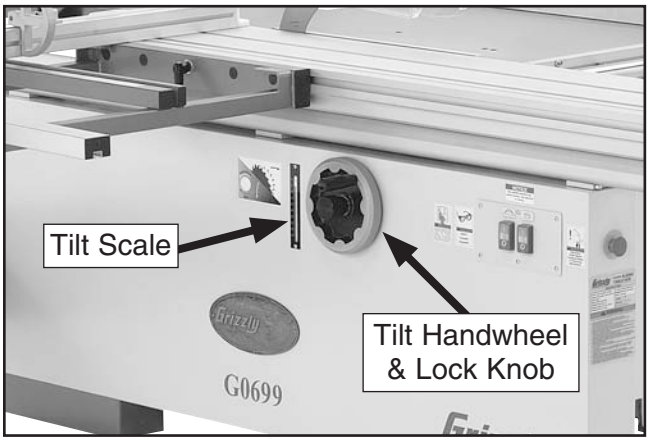


Figure 63. Blade tilt controls.

Blade Elevation Handwheel & Lock Knob: Handwheel raises and lowers the blades. The lock knob secures the handwheel to prevent it from moving during operation.

Figure 64. Blade elevation control.

Sliding Table Lock Lever: Locks the sliding table in position. When rotated to the right, the locking mechanism under the sliding table engages. When the lever is rotated to the left, the lock releases and allows the table to slide freely.

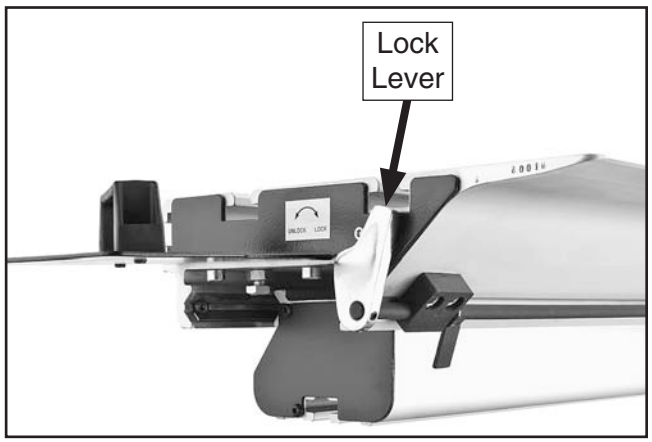


Figure 65. Sliding table locking mechanism.

Rip Fence Clamp Lever: Secures the rip fence to the rip fence body.

Rip Fence Lock Lever: Clamps the rip fence assembly in place on the fence rail.

Micro-Adjust Knob: Provides for fine-tune adjustment for the width-of-cut (the rip fence lock lever must be loose to use this).

Micro-Adjust Lock Knob: Clamps the rip fence assembly to the fence rail and allows the use of the micro-adjust knob.

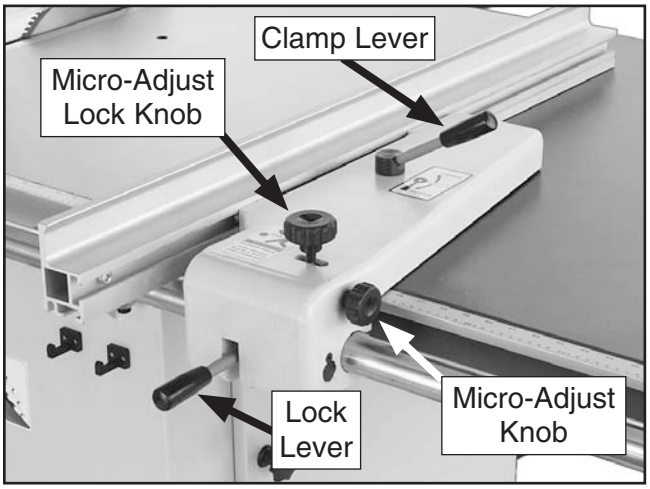


Figure 66. Rip fence controls.

Workpiece Inspection

Some workpieces are not safe to cut or may require modification before they are safe to cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.

- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

Non-Through and Through Cuts

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock. This machine is NOT designed to make non-through cuts. Dado cuts, rabbet cuts, and resawing operations are typical non-through table saw cuts.

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through. Ripping, crosscutting, miter cuts, and angled cuts are all through cutting operations. The riving knife and blade guard must be installed during through cuts.

Read, understand, and follow instructions and safety precautions for each type of cut to reduce the risk of injury.

Safety precautions and instructions for each type of cut are located on the following pages:

- Rip Cuts (**Page 48**)
- Cross Cuts (**Page 50**)
- Miter Cuts (**Page 52**)

Changing Main Blade

The Model G0699 performs best when using high quality, sharp blades. Whenever the main blade starts to get dull, resharpen or replace it with a new blade.

Tools Needed	Qty
Hex Wrench 8mm	1
Wrench 30mm	1
T-Handle Wrench 8mm	1

To change the main blade:

1. DISCONNECT SAW FROM POWER!

2. Adjust the blade tilt to 0° and raise the blade all the way up.

3. Remove the blade guard from the riving knife.

4. Move the sliding table all the way forward to expose the blade cover, lock it in place, then open the blade cover.

5. Insert the provided T-handle wrench through the table top hole shown in **Figure 67** and into one of the holes in the main blade pulley under the table top. This will keep the blade arbor from rotating during the next step.

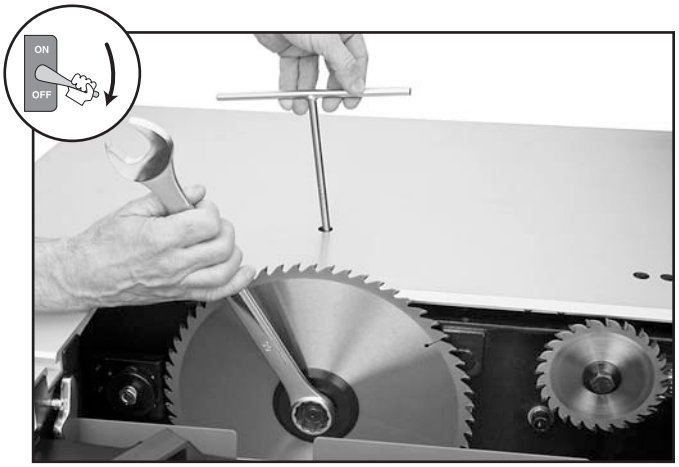


Figure 67. Loosening the main blade arbor nut.

⚠CAUTION

Before proceeding with the next steps, wear leather gloves to protect your hands when handling the saw and scoring blades.

6. While holding the T-handle wrench with one hand, rotate the arbor nut clockwise until you can remove it and the flange (see **Figure 68**).

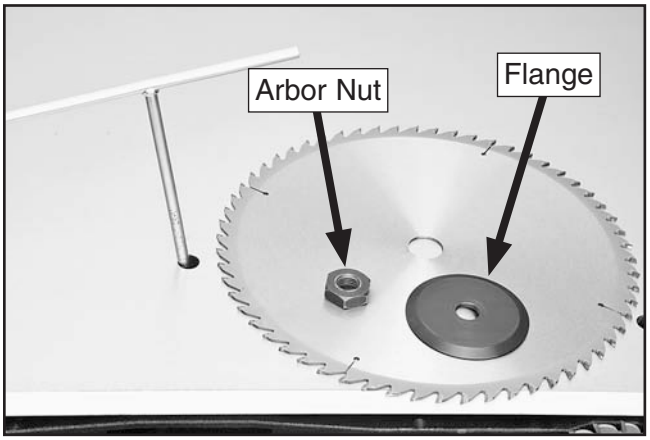


Figure 68. Main blade arbor nut and flange.

7. Remove the existing blade, slide the replacement blade over the arbor with the teeth facing to the right, then re-install the flange with the beveled edge facing out.

8. Thread the arbor nut on counterclockwise and fully tighten it to secure the flange and blade.

9. Re-check the riving knife alignment with the blade, as instructed in the next section.

10. Close the blade cover, re-install the blade guard onto the riving knife, then move the sliding table back to the center of the machine.

Riving Knife Alignment

To be effective, the riving knife must be aligned with the blade. If the riving knife is not aligned with the blade, then the workpiece will be forced sideways during the cut, which will increase the risk of kickback.

⚠WARNING

The riving knife prevents the kerf from closing behind the blade and binding the workpiece, which could cause kickback. You MUST always have the riving knife properly installed and positioned before beginning cutting operations.

Tools Needed	Qty
Hex Wrench 2.5mm	1
Hex Wrench 3mm	1
Hex Wrench 8mm	1
Wrench 17mm	1
Straightedge	1

To align the riving knife:

1. DISCONNECT SAW FROM POWER!

2. Adjust the blade tilt to 0° and raise the blade all the way up.

3. Remove the blade guard from the riving knife.

4. Move the sliding table all the way forward to expose the blade cover, lock it in place, then open the blade cover.

5. Loosen the riving knife hex nut, as shown in **Figure 69**.

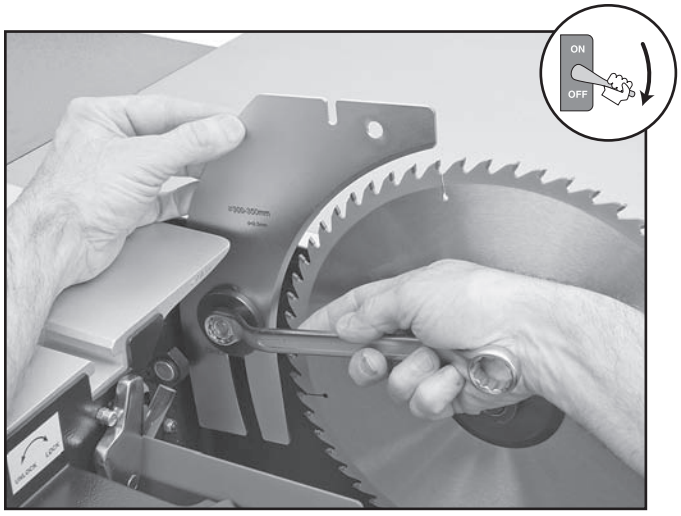


Figure 69. Adjusting the riving knife.

6. Position the riving knife so that there is an even 3mm distance between it and the blade teeth along its full length, then hand-tighten the hex nut to hold it in place during the next steps.

   Tip: *For a quick spacing gauge, use the 3mm hex wrench to set the correct spacing between the riving knife and the blade, as shown in* ***Figure 70****.*

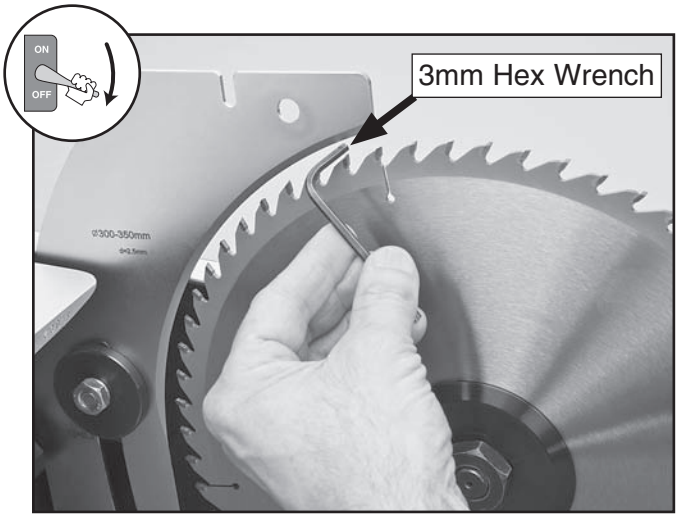


Figure 70. Setting the correct riving knife spacing.

7. Place the straightedge against the top and bottom of the blade and riving knife, as shown in **Figure 71**. The riving knife should be parallel with the blade along its length at both positions and should be in the *Alignment Zone,* as shown in **Figure 72**.

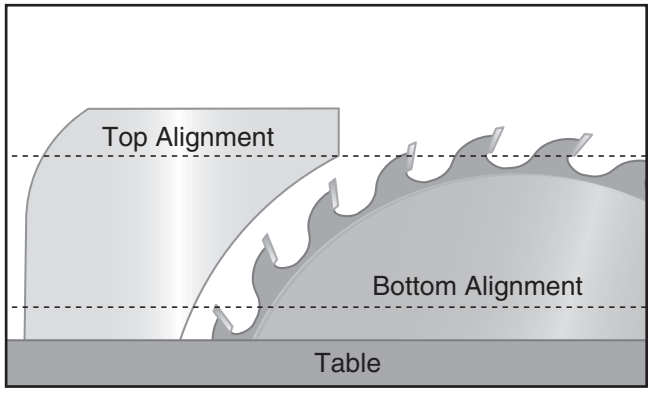


Figure 71. Checking the top and bottom riving knife parallelism with the blade.

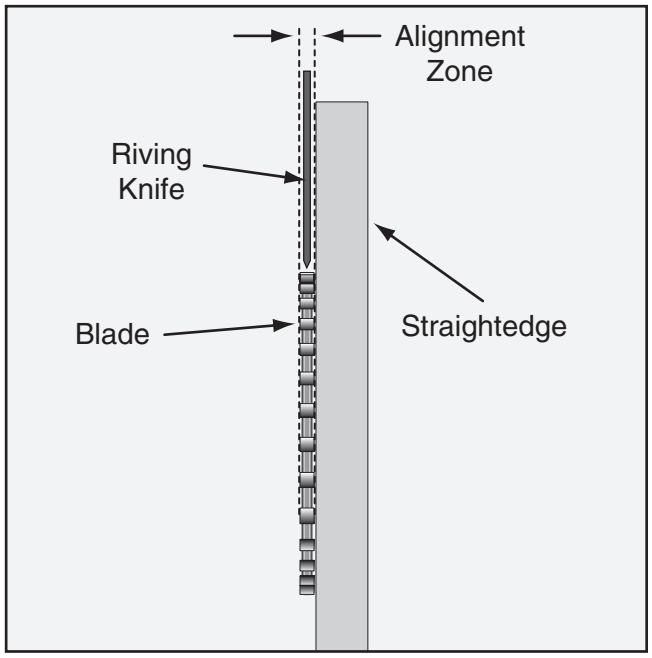


Figure 72. Riving knife alignment zone.

—If the riving knife is parallel with the blade and is in the *Alignment Zone*, then no further adjustments are necessary.

Fully tighten the riving knife bolt, close the blade cover, re-install the blade guard onto the riving knife, then move the sliding table back to the center of the machine.

—If the riving knife is not parallel with the blade or is not in the *Alignment Zone*, then continue with **Step 8**.

8. Loosen the riving knife hex nut, then remove the knife.

9. Study the photo and illustration in **Figure 73**, then adjust the set screws in the riving knife mounting block so that, when re-installed, the riving knife will be parallel with the blade and in the *Alignment Zone*.

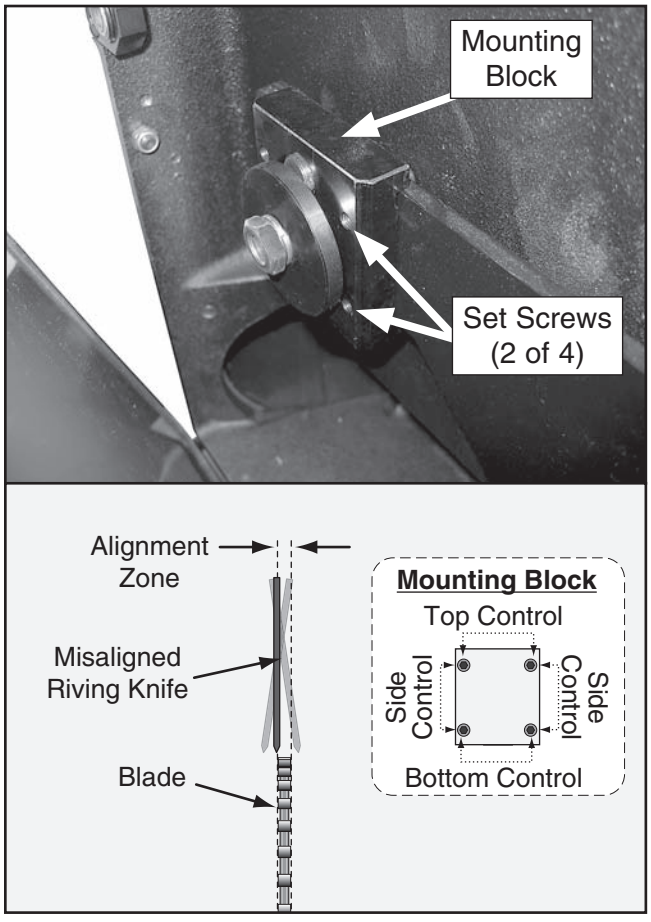


Figure 73. Riving knife mounting block set screws.

10. Re-install the riving knife and repeat **Steps 6–7**.

Adjusting & Replacing Scoring Blade

The scoring blade rotates in the opposite direction from the main blade and makes a shallow cut into the workpiece surface. This prevents workpiece tear-out.

Some replacement scoring blades consist of an inner and outer blade with internal shims. The shims are provided so the scoring blade set can match the kerf thickness of the main blade. **Figure 74** shows a typical scoring blade set with shims.

The scoring blade provided with the Model G0699 has wedge-shaped teeth so that scoring kerf widens as the blade is raised.

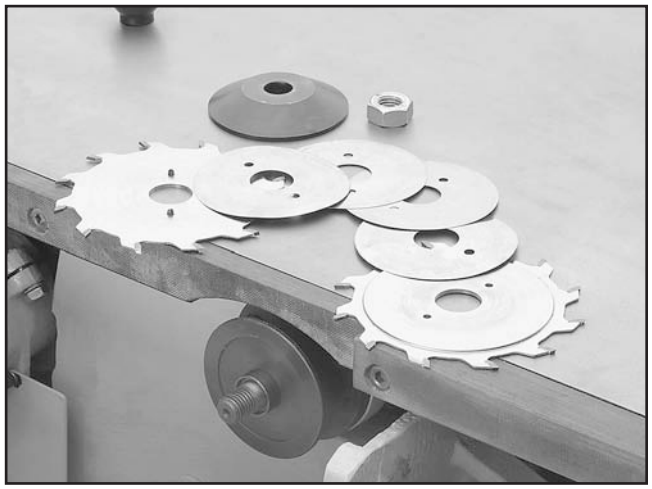


Figure 74. Typical scoring blade set with shims.

NOTICE

To make sure that the scoring blade kerf is the same as the main blade kerf, you will need to adjust the scoring blade as instructed in this procedure whenever the dimensions of the main blade change.

Changing Scoring Blade

Tools Needed	Qty
Hex Wrench 8mm	1
Scoring Blade Arbor Wrench	1
Wrench 19mm	1

To change the scoring blade:

1. DISCONNECT SAW FROM POWER!
2. Adjust the blade tilt to 0° and raise the blade all the way up.
3. Remove the blade guard from the riving knife.
4. Move the sliding table all the way forward to expose the blade cover, lock it in place, then open the blade cover.
5. Place the arbor wrench on the flange behind the scoring blade, then turn the arbor nut counterclockwise until you can remove it and the flange (see **Figure 75**).

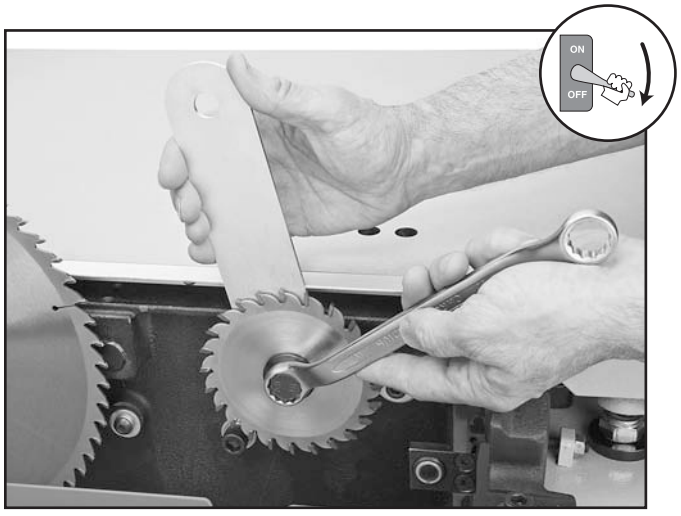


Figure 75. Removing the scoring blade.

6. Replace the scoring blade with the teeth facing the main blade, then re-install the flange and arbor nut. Make sure the nut is fully tightened.

7. Adjust the scoring blade position, as instructed below, then close the blade cover, re-install the blade guard onto the riving knife, and move the sliding table back to the center.

Adjusting Scoring Blade

The goal in this procedure is to adjust the scoring blade vertical and horizontal positions so that the scoring kerf is the same width as the main blade kerf and is aligned with it. This will require placing the straightedge on both sides of the blades multiple times as you make adjustments.

Tools Needed	Qty
Hex Wrench 8mm	1
T-Handle Wrench 8mm	1
Straightedge	1

To adjust the scoring blade position:

1. DISCONNECT SAW FROM POWER!

2. Adjust the blade tilt to 0° and raise the blade all the way up.

3. Remove the blade guard from the riving knife.

4. Move the sliding table all the way forward to expose the red blade cover, lock it in place, then open the blade cover.

5. When positioning the straightedge, place it against teeth on both sides of the main saw blade to obtain an accurate reading of the main saw blade kerf.

   —*Horizontal Adjustment:* Insert the T-handle wrench into the right hole shown in **Figure 76**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

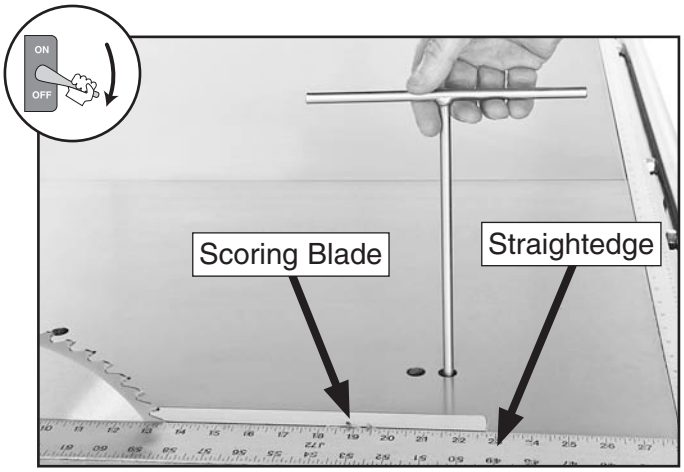


Figure 76. Adjusting the horizontal position of the scoring blade.

   —*Vertical Adjustment:* Insert the T-handle wrench into the left hole shown in **Figure 77**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

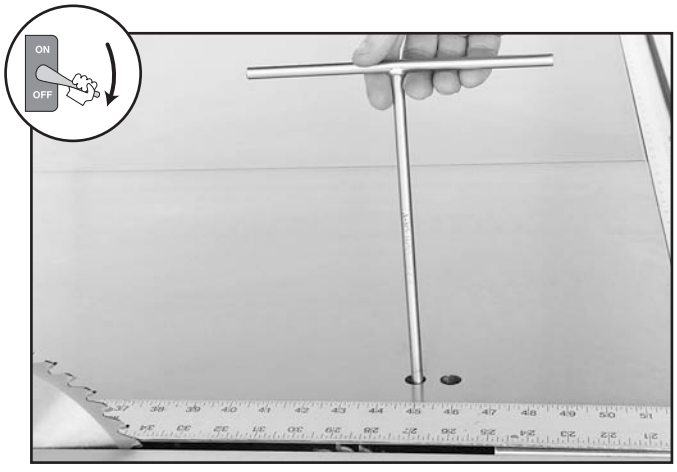


Figure 77. Adjusting the vertical height of the scoring blade.

6. Close the blade cover, re-install the blade guard onto the riving knife, and move the sliding table back to the center.

Rip Cutting

The Model G0699 has the capability of rip cutting full-size panels, as shown in **Figure 78**. The sliding table saves time and increases accuracy by removing the burden of sliding a large and heavy panel over a stationary table surface.

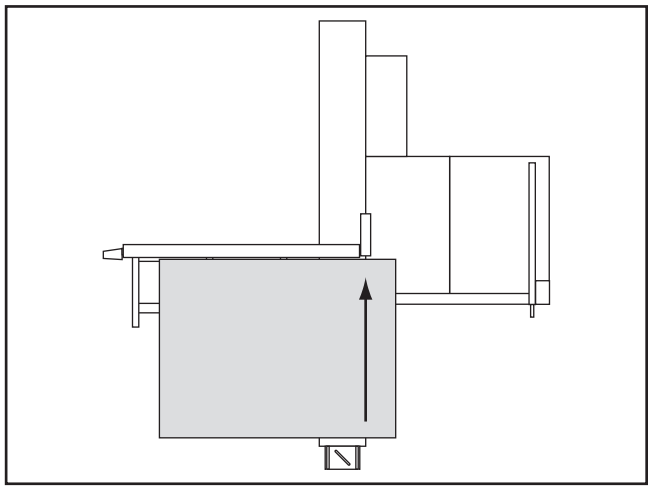


Figure 78. Example of full panel rip cutting.

This saw also has the capability of rip cutting smaller workpieces, using the machine as a traditional table saw, as shown in **Figure 79**. Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade with the use of the rip fence.

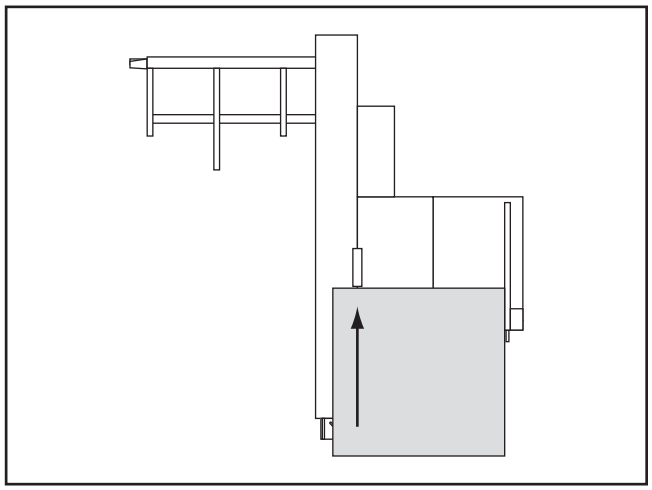


Figure 79. Example of using the rip fence with smaller workpieces.

⚠WARNING

Use the hold-down and the end shoe to hold down the workpiece ends to prevent it from raising up, which could cause kickback.

Rip Cutting With Sliding Table

1. DISCONNECT SAW FROM POWER!

2. Make sure the 90° stop bolt is properly adjusted, as instructed in the **Squaring Crosscut Fence to Blade** on **Page 70**.

3. Loosen the crosscut fence pivot stud under the crosscut fence, insert it into its hole in the crosscut table, then rotate the fence against the 90° stop bolt.

   Note: *The fence can be mounted in the forward or rear position, depending on the size of the workpiece and which position will provide the safest operation.*

4. Use a precision ruler against a tooth of the blade, then adjust the fence so that the 2" mark on the fence scale is exactly 2" from the blade tooth, as shown in **Figure 80**.

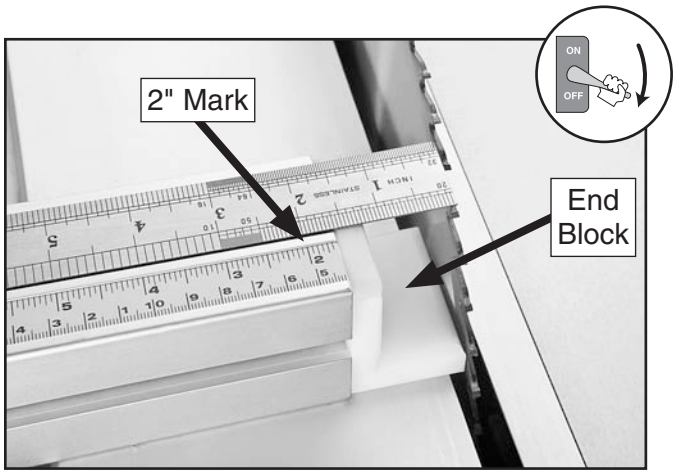


Figure 80. Setting the correct space between the crosscut fence and blade for rip cutting.

5. Carefully lift the crosscut fence up, fully tighten the pivot stud, then re-insert the stud into the hole. Re-check the spacing between the end block and blade—if necessary, loosen the stud and repeat **Steps 3–5** until the spacing is correct.

6. Set a flip stop to the desired width-of-cut.

7. Load the workpiece onto the sliding and crosscut tables.

8. Install the hold-down into the sliding table T-slot and use it to secure the workpiece to the sliding table. The set up should look similar to **Figure 78** on the previous page.

9. Take all the necessary safety precautions, connect the saw to power, then perform the cutting operation.

Rip Cutting With Rip Fence

1. DISCONNECT SAW FROM POWER!

2. Move the sliding table forward out of the way, then lock it place.

3. The rip fence can be installed in the vertical position for thicker workpieces, or in the horizontal position for smaller workpieces (see **Figure 81**).

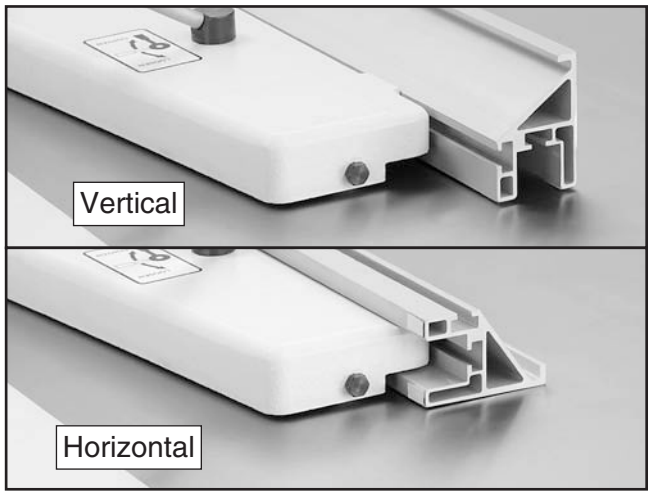


Figure 81. Rip fence positions.

4. Loosen the rip fence clamp handle, position the leading edge of the fence so it is even with the center of the main saw blade, as shown in **Figure 82**, then re-tighten the clamp handle.

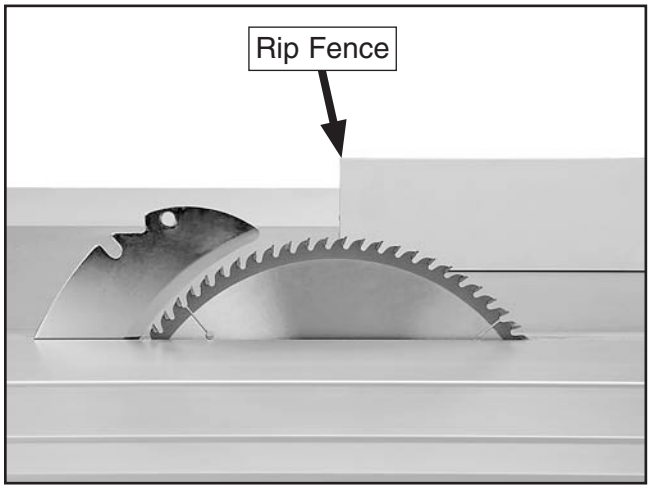


Figure 82. Rip fence properly positioned to the main saw blade (blade guard removed for clarity).

5. Lift the fence lock lever and position the rip fence to the approximate width-of-cut (see **Figure 83**).

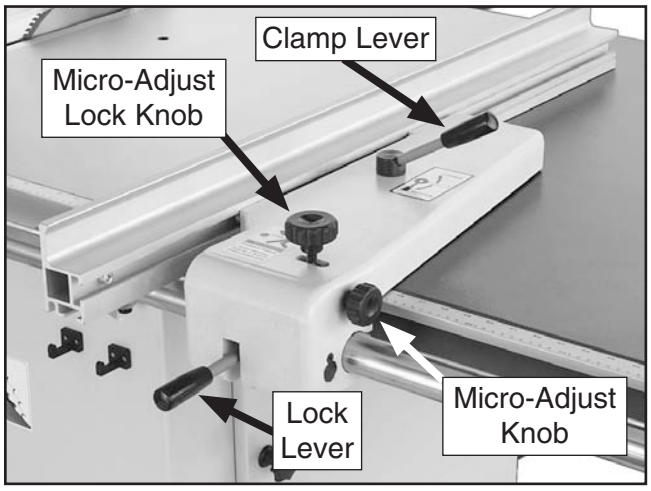


Figure 83. Rip fence controls.

6. Tighten the micro-adjust lock knob, then turn the micro adjust knob to fine tune the desired width-of-cut.

7. Push the lock lever down to lock the fence assembly in place, connect the saw to power, then perform the cutting operation.

Crosscutting

The Model G0699 crosscuts full size panels with the fence in the forward or rear position. However, it is easier to load full size panels with the crosscut fence mounted in the forward position, as shown in **Figure 84**.

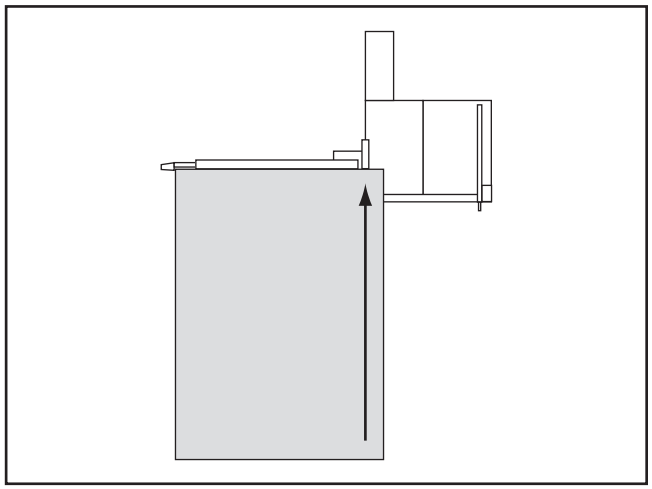


Figure 84. Crosscut fence mounted forward to handle full size panel.

Mounting the crosscut fence in the rear position provides greater stability for crosscutting smaller panels, as shown in **Figure 85**.

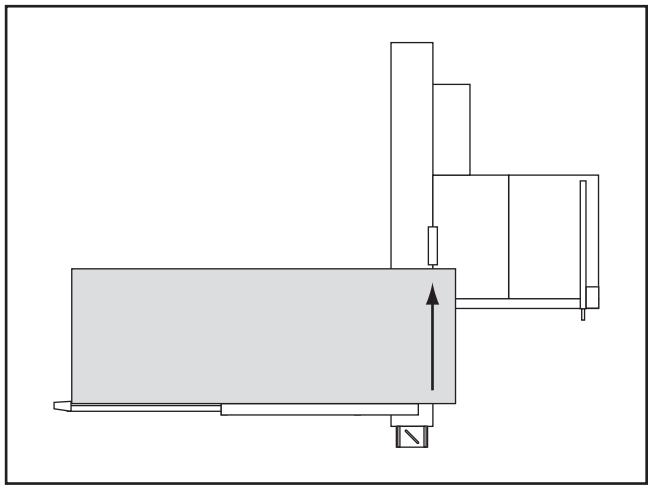


Figure 85. Crosscut fence mounted in the rear position for smaller panels.

When setup properly, this table saw also has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge, as shown in **Figure 86**.

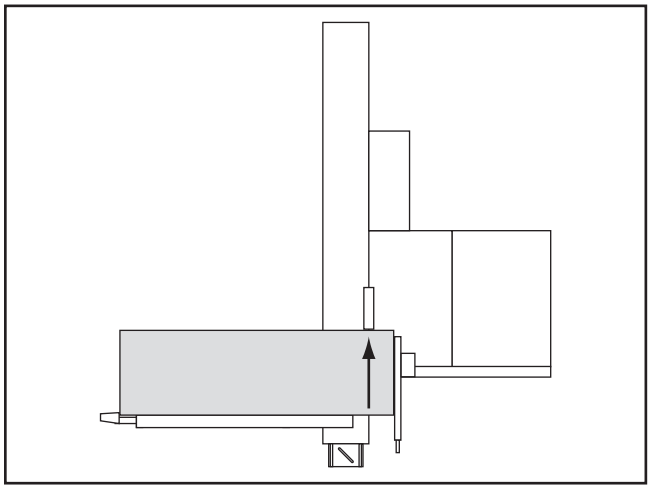


Figure 86. Crosscutting using the rip fence as a cut off gauge.

Crosscutting Full Size Panels

1. DISCONNECT SAW FROM POWER!

2. Make sure the forward 90° stop bolt is properly adjusted, as instructed in the **Squaring Crosscut Fence to Blade** on **Page 70**.

3. Loosen the crosscut fence pivot stud under the crosscut fence, install the fence in the forward position, as indicated in **Figure 87**, then rotate the fence against the 90° stop bolt.

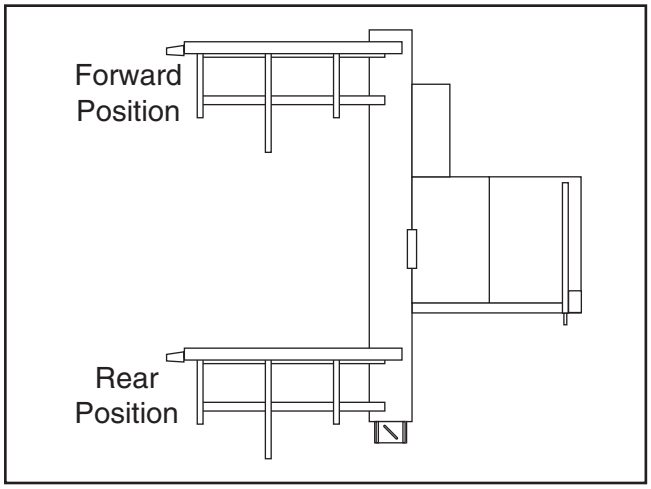


Figure 87. Forward and rear crosscut fence mounting positions.

4. Use a precision ruler against a tooth of the blade, then adjust the fence so that the 2" mark on the fence scale is exactly 2" from the blade tooth, as shown in **Figure 88**.

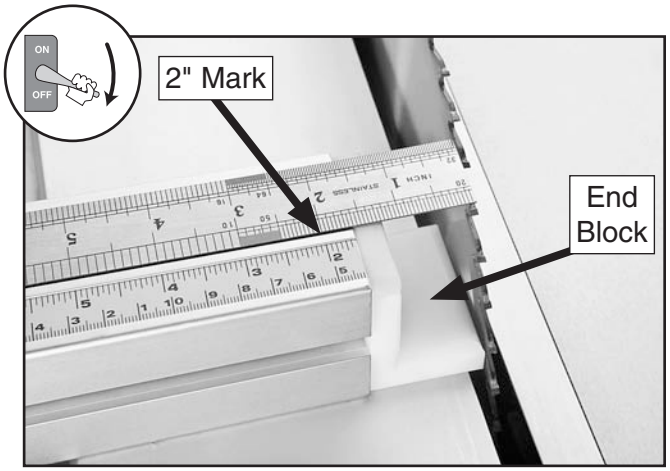


Figure 88. Setting the correct space between the crosscut fence and blade for rip cutting.

5. Carefully lift the crosscut fence up, fully tighten the pivot stud, then re-insert the stud into the hole. Re-check the spacing between the end block and blade—if necessary, loosen the stud and repeat **Steps 3–5** until the spacing is correct.

6. Set either crosscut fence flip stop to the desired width-of-cut.

   Note: *Extend the crosscut fence slide if the workpiece is more than 74".*

7. Load the workpiece onto the table saw. The set up should look similar to **Figure 84** on the previous page.

8. Once all the necessary safety precautions have been taken, then perform the cutting operation.

Crosscutting Smaller Panels

Follow the same steps in the **Crosscutting Full Size Panels** subsection on **Page 50**, but mount the crosscut fence in the rear position, as indicated in **Figure 87** on the previous page. Then, load the workpiece so your setup looks similar to **Figure 85** on the previous page.

Crosscutting Using Rip Fence as a Cut-Off Gauge

1. Follow the same steps in the **Crosscutting Full Size Panels** subsection on **Page 50**, but mount the crosscut fence in the rear position, as indicated in **Figure 87** on the previous page.

⚠WARNING

When using the rip fence with the crosscut fence, the rip fence must be positioned behind the front edge of the blade to prevent the workpiece from binding and causing a kickback hazard.

2. Position the rip fence for the desired width-of-cut, then slide the leading end of the rip fence behind the front edge of the main blade, as shown in **Figure 89**.

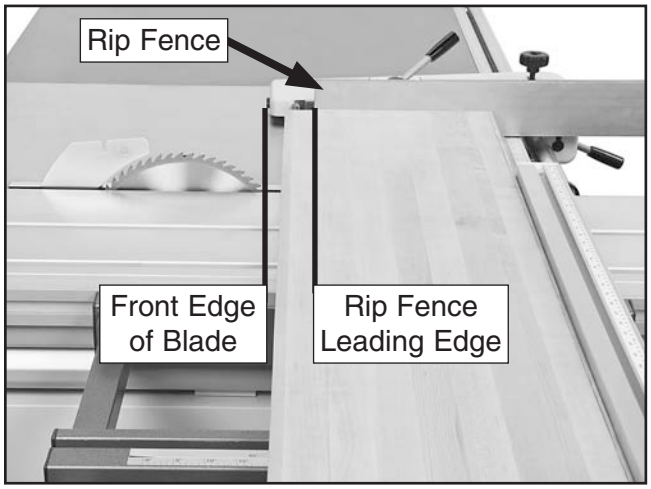


Figure 89. Proper rip fence position when using it as a cut-off gauge.

3. Take all the necessary safety precautions, connect the saw to power, then perform the cutting operation.

Miter Cutting

The crosscut fence can be positioned for miter cuts from 0° to 135°. The miter scale on top of the crosscut table has a resolution of 1".

To perform a miter cut:

1. DISCONNECT SAW FROM POWER!

2. Position the crosscut table to provide the greatest amount of workpiece support, then lock it in place.

3. Install the crosscut fence onto the crosscut table in the position that will allow for the desired angle of cut.

—For miter cuts from 0° to 90°, insert the fence pivot stud into the rear hole and angle the fence forward, as shown in **Figure 90**.

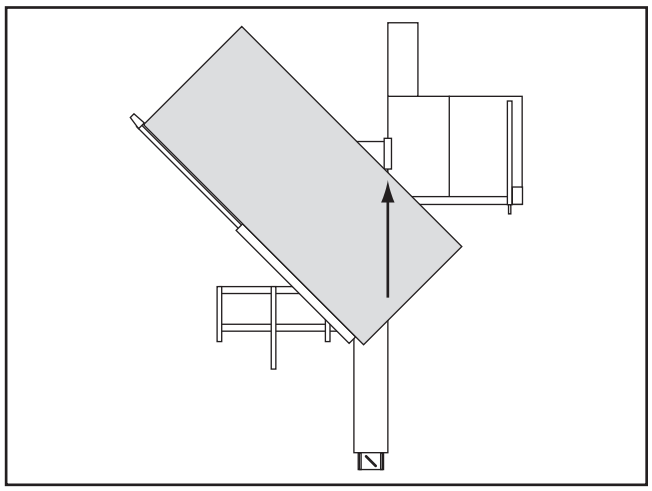


Figure 90. Crosscut fence positioned for miter cuts from 0° to 90°.

—For miter cuts from 90° to 135°, insert the fence pivot stud into the forward hole and angle the fence to the rear, as shown in **Figure 91**.

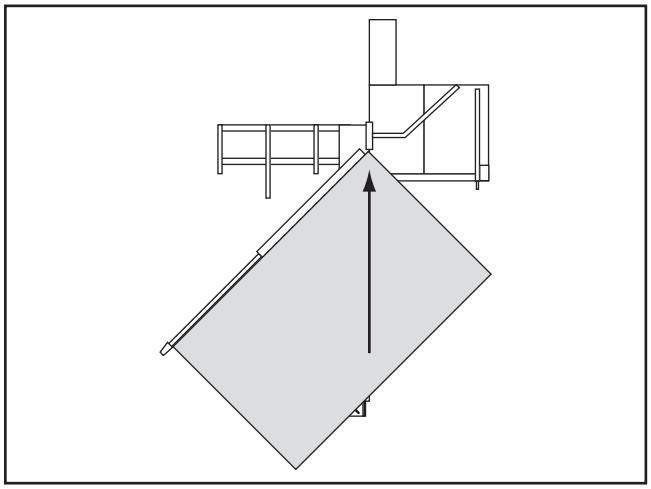


Figure 91. Crosscut fence positioned for miter cuts from 90° to 135°.

4. Rotate the fence to the desired angle of cut, make sure the fence end block is clear of the blade so that it will not be cut during the operation, then use the fence lock knob to secure the fence in place.

5. Position the flip stop for the desired width-of-cut, then load the workpiece onto the table. The set up should look similar to **Figures 90–91**.

6. Once all the necessary safety precautions have been taken, connect the saw to power, then perform the cutting operation.

SECTION 5: ACCESSORIES

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 92. Recommended products for protecting unpainted cast iron/steel part on machinery.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 93. Half-mask respirator with disposable cartridge filters.

G4173—Baby Power Feeder 110V
G4176—¼ HP Power Feeder 110V
G4179—½ HP Power Feeder 220V
G4181—1 HP Power Feeder 220V
Installing a power feeder on your table saw will make repetitive cuts much easier and safer. Can be installed on nearly any table saw. Easy to adjust wherever needed, including out of the way when not needed! A must for any production shop.

Figure 94. G4179 Power Feeder.

⚠WARNING

Using accessories or attachments not recommended for this machine could cause the machine to function differently than intended, which may increase the risk of serious personal injury. Only use recommended accessories for this machine.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

Cyclone Dust Collectors
G0440—2 HP, 1354 CFM @ 2.5" SP
G0441—3 HP, 1654 CFM @ 2.0" SP
G0443—1½ HP, 1025 CFM @ 2.6" SP
Cyclone action separates the heavy dust particles from the fine particles and drops them into the steel drum. Any remaining fine dust travels past the impeller and is then trapped by a cartridge filter made of spun-bond polyester that filters 99.9% of particles from 0.2–2.0 microns in size. The cartridge filter is pleated to provide a large surface area for efficient air movement and a clear plastic bag collect the fine cake that shakes off the filter for consistent dust collector performance. Casters mounted to the steel drum also make disposal of the larger chips and dust as easy as it gets.

Figure 96. Model G0440 Cyclone Dust Collector.

T23037—Scoring Blade Replacement

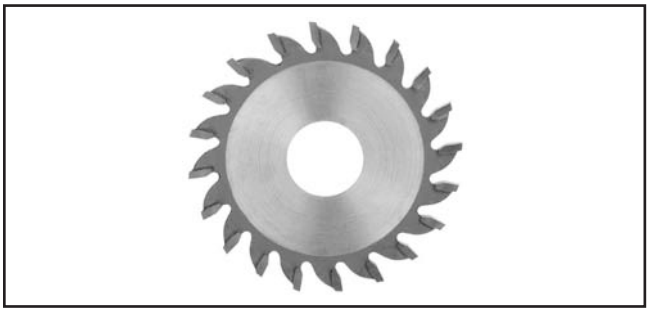


Figure 95. Model T23037 Scoring Blade

G7581—Superbar™
G7582—Master Plate
The miter slot mounted Superbar™ will align, tune and calibrate your table saw to within ±0.001 in just minutes. Replace your table saw blade when calibrating the double disk ground Master Plate for a precision measurement, with no run out!

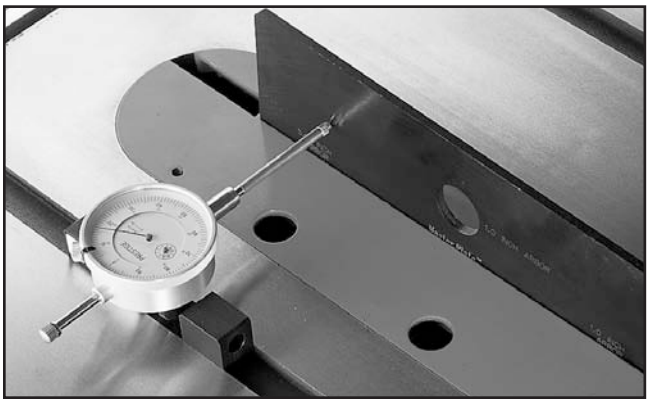


Figure 97. Superbar™ and Master Plate.

H8029—5 Piece Safety Kit
This kit has four essential jigs. Includes two push blocks, push stick, featherboard and combination saw and router gauge. Featherboard fits ⅜" x ¾" miter slots. Made of high visibility yellow plastic.

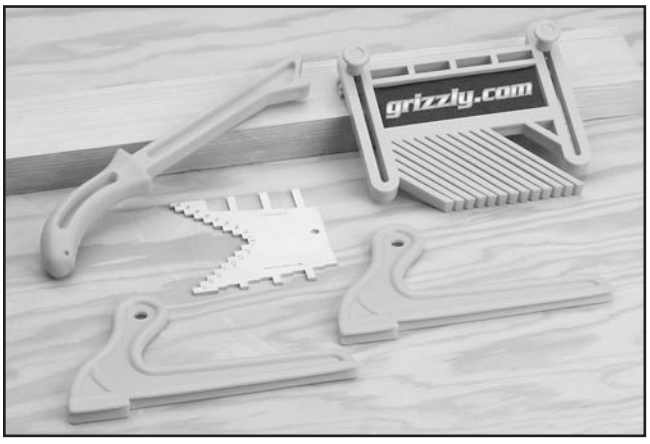


Figure 98. H8029 5 Piece Safety Kit.

SECTION 6: SHOP-MADE SAFETY ACCESSORIES

Safety devices such as push sticks, featherboards, and push blocks can be made easily and inexpensively. They increase safety by keeping hands a safe distance from the blade when feeding workpieces into the blade.

Push Sticks

Push sticks are particularly useful when cutting small or narrow workpieces. They provide added leverage, enabling the operator to keep the workpiece firmly supported against the fence and table. At the same time, the push stick keeps the operator's hands safely away from the saw blade. A push stick is included with your table saw. To make additional push sticks, refer to the template in **Figure 99** for construction details.

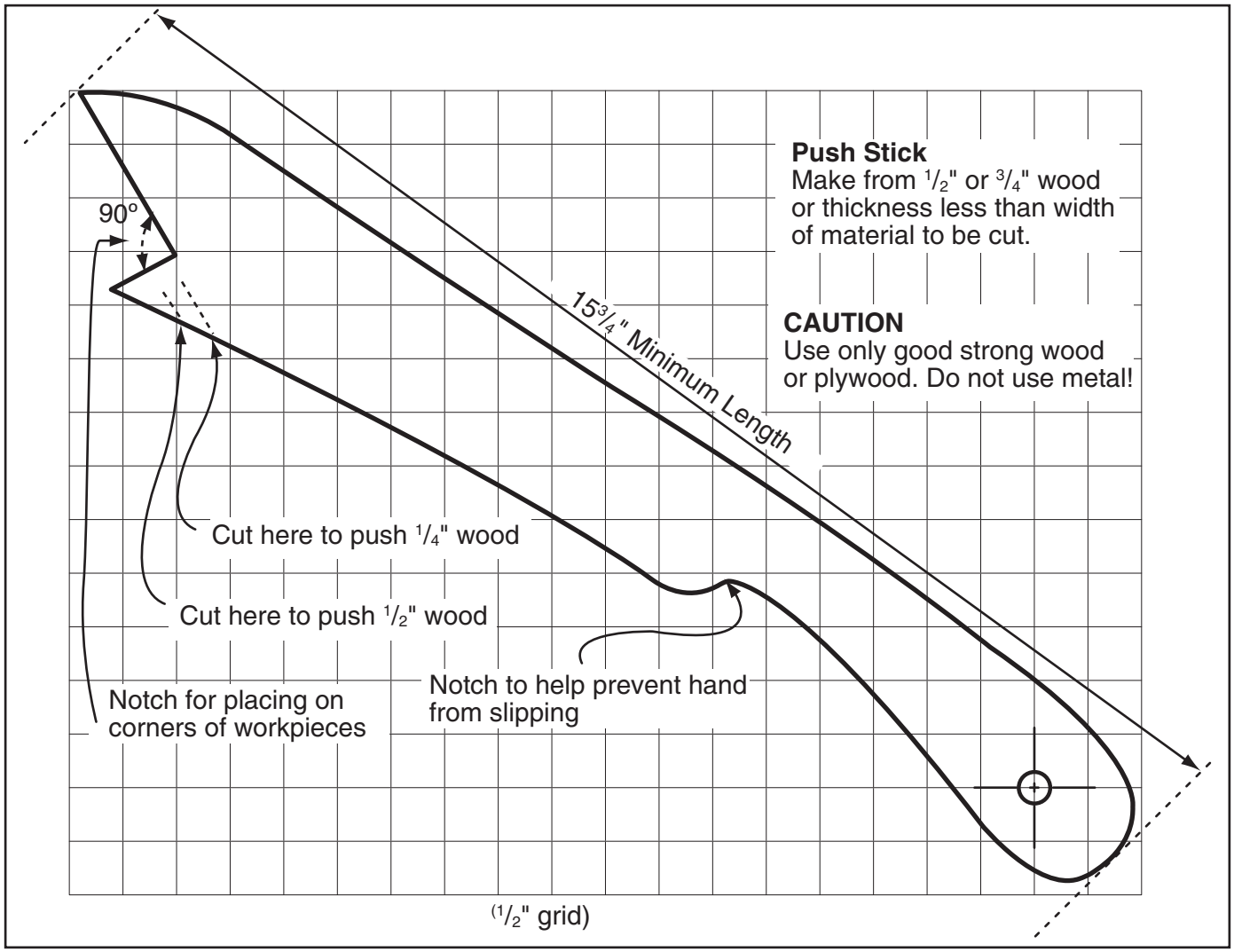


Figure 99. Template for a shop-made push stick (shown at 70% of full size).

Push sticks should be made of plywood or hard wood and can be made in a variety of shapes and sizes. Avoid making push sticks out of material that may break under pressure (soft wood or particle board) or out of material that may damage the blade during accidental contact (metal).

The push stick must be at least 15¾" long. The pattern for making a basic push stick, such as the one shown in **Figure 99**, can be laid out on a piece of wood and cut out using a bandsaw, jig saw, or scroll saw. Sand the handle area and edges to increase comfort and safety.

Using a Push Stick

Figure 100 shows an example of push sticks used to feed and support a workpiece.

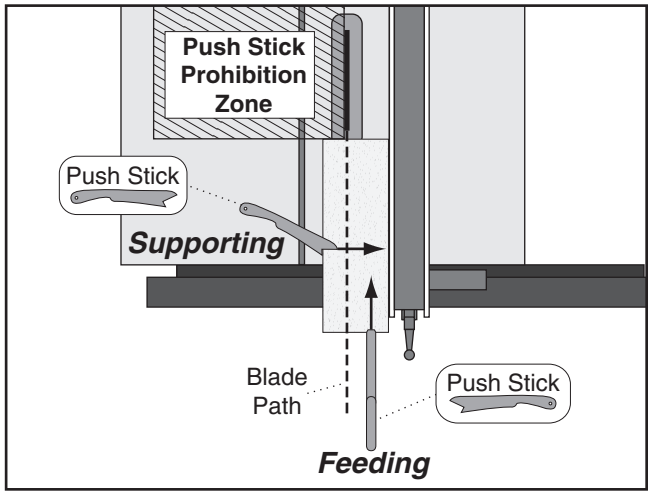


Figure 100. Example of shop-made push stick used to rip narrow stock.

Feeding: Place the notched end of the push stick against the end of the workpiece and out of the blade path. Use steady downward and forward pressure to push the workpiece into the blade.

Supporting: A second push stick may also be used with the other hand to apply sideways pressure on the workpiece to keep it held firmly against the fence while starting the cut. When using a push stick in this manner, do not apply pressure to the workpiece against or behind the blade (see "Push Stick Prohibition Zone" in **Figure 100**). Otherwise, pressure from the push stick will increase the risk of kickback.

Push Block

A push block can be used in place of a push stick for feeding work during rip cuts. These devices help keep the operator's hands safely away from the saw blade while providing firm control over stock during operation. We describe two types of push blocks in this sub-section: 1) an independent device, and 2) a push block paired with an auxiliary fence for cutting very narrow or very thin workpieces.

Making a Push Block

To make your own push block, refer to the template in **Figure 102** for construction details.

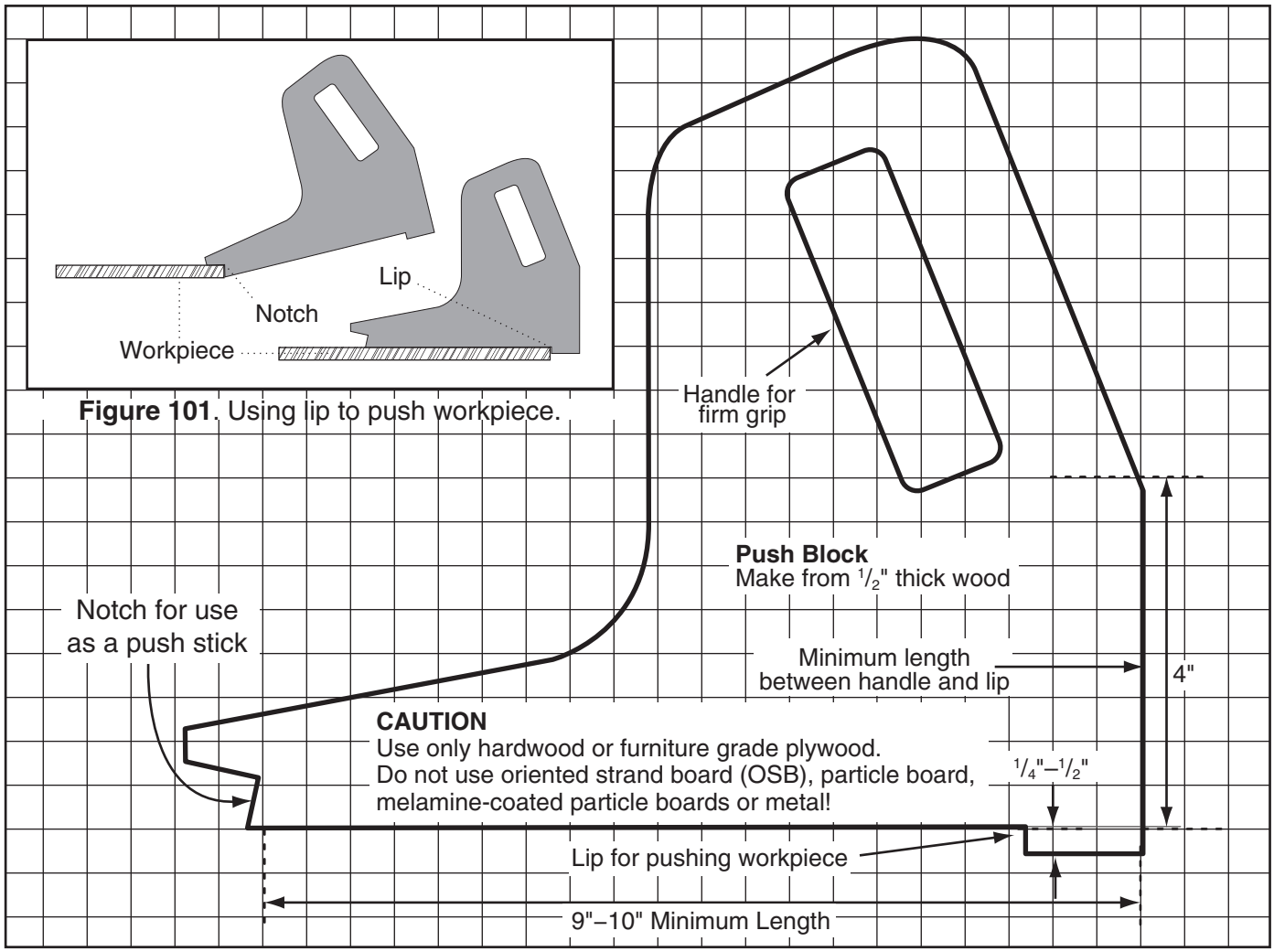


Figure 101. Using lip to push workpiece.

Figure 102. Template for a shop-made push block (shown at 50% of full size).

Push blocks must be made using natural wood or furniture grade plywood. The push block must be at least 9"–10" long and the bottom of the handle must be at least 4" above the lip. The pattern for making a basic push block, shown in **Figure 102**, can be laid out on a piece of wood or cut out using a bandsaw, jig saw, or scroll saw. Sand the handle area and edges to increase comfort and safety.

Using a Push Block

1. Place the lip of the push block (**Figure 102, Page 57**) against the end of the workpiece, and use steady downward and forward pressure to push the workpiece into the blade. Use a push stick to apply sideways pressure on the workpiece to keep it held firmly against the fence, as shown in the example of **Figure 103**).

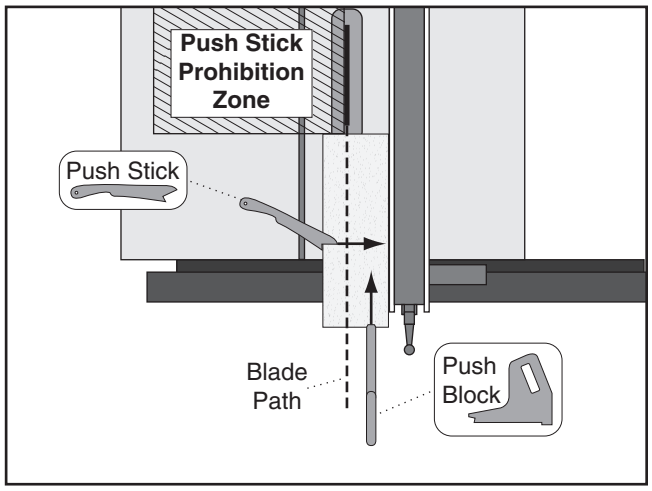


Figure 103. Example of using a push block to feed a workpiece into the blade.

2. As the workpiece nears the end of the cut, release the push stick just before the blade, (see **Figure 101**).

3. Use steady downward and forward pressure to push the workpiece the rest of the way through the blade.

Making a Narrow-Rip Push Block for an Auxiliary Fence

1. Cut a piece of ½" thick plywood 6" by 39½", and cut a piece of ¾" thick hardwood 3" by 39½", as shown in **Figure 104.**

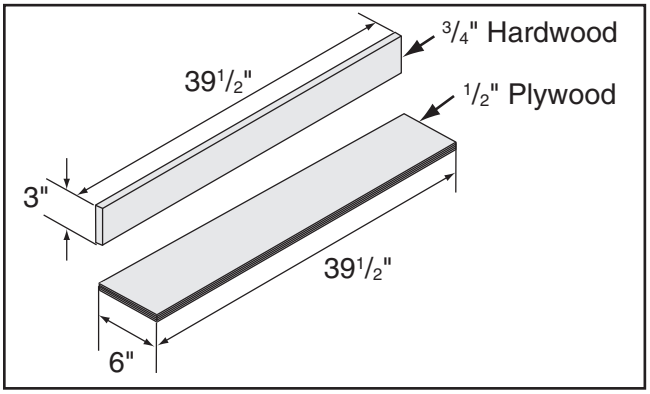


Figure 104. Auxiliary fence dimensions.

Note: *We recommend cutting the hardwood board oversize, then jointing and planing it to the correct size to make sure the board is square and flat.*

Only use furniture-grade plywood or kiln-dried hardwood to prevent warping.

2. Pre-drill and countersink eight pilot holes ⅜" in from the edge of the 6" wide board, as shown in **Figure 105**, for the wood screws that will attach the boards together in next step.

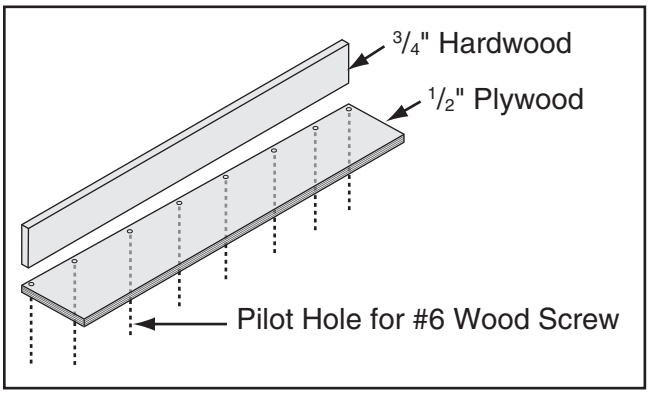


Figure 105. Location of pilot holes.

3. Fasten the 6" and 3" wide boards with eight #6 x ¼" wood screws through the holes you drilled in **Step 2**; the fence should look like the one shown in **Figure 106**.

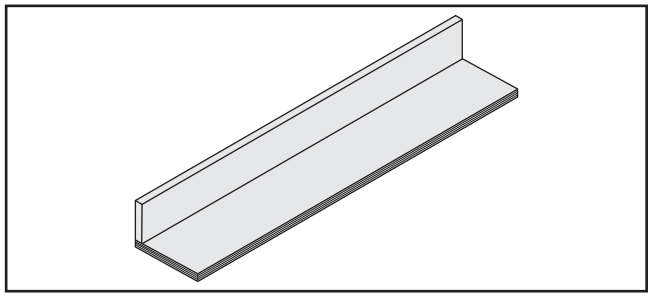


Figure 106. Auxiliary fence complete.

4. Cut a piece of plywood 15" long and 5¼" wide for the base of a push block, then cut off a strip ⅜" wide by 12½" long (see **Figure 107**).

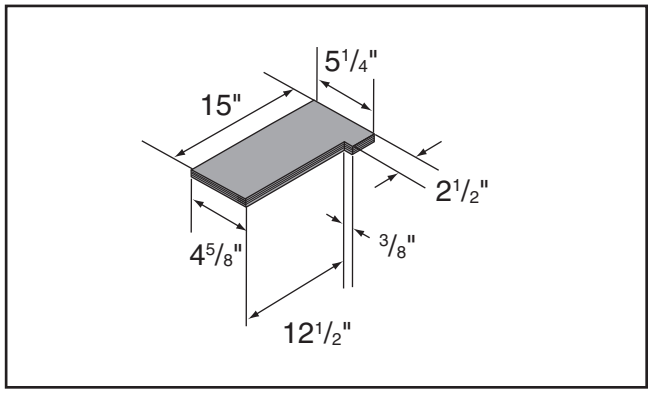


Figure 107. Push block base pattern.

5. Cut a piece of ½" plywood 10" long by 5"–9" high for the handle, then cut it to the desired final shape.

6. Pre-drill and countersink three holes through the bottom center of the base, then attach the handle to the base with #6 x ¼" wood screws (see **Figure 108**).

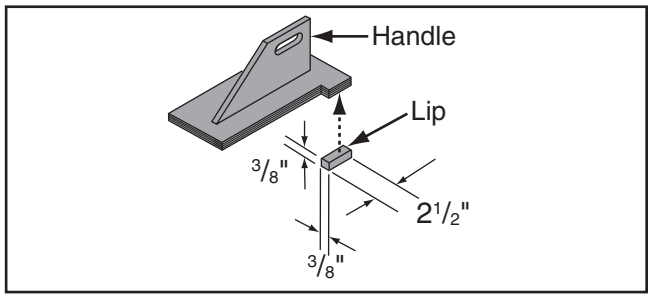


Figure 108. Push block and lip.

7. Make a lip from scrap wood that is approximately 2½ x ⅜" x ⅜", then fasten this piece to the bottom of the base, as shown in **Figure 108**.

Tip: *Try using cyanoacrylate type wood glue or small wood screws to secure the lip to the push block base*.

Using the Auxiliary Fence and Push Block

1. Place the auxiliary fence on the table and clamp it to the fence at both ends, then adjust the distance between the auxiliary fence and the blade—this determines how wide the workpiece will be ripped (see the example in **Figure 109**).

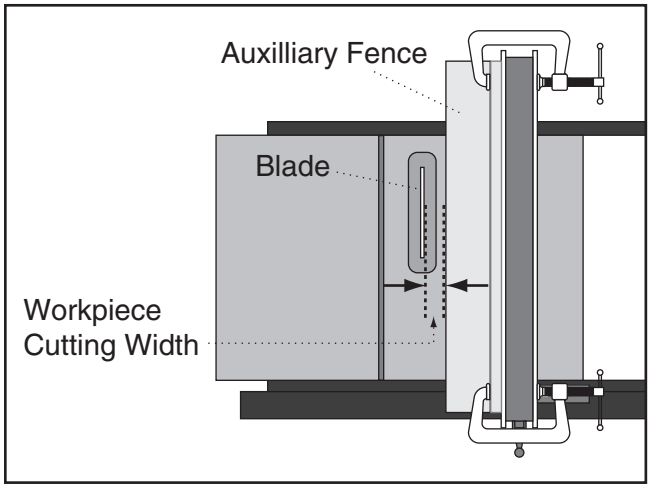


Figure 109. Example of adjusting ripping distance between blade and auxiliary fence.

⚠WARNING

Keep the riving knife and blade guard properly installed during cutting operations. Failure to do this present amputation hazards!

2. Place the workpiece 1" in front of the blade and evenly against the table and the auxiliary fence.

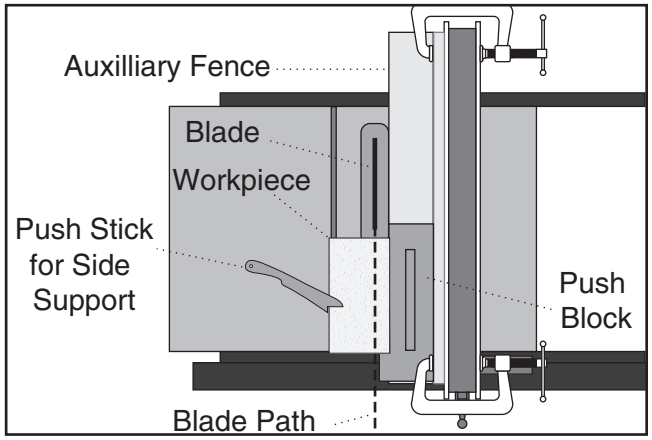


Figure 110. Push block in position to push workpiece through blade.

3. Turn the saw ***ON***, then begin ripping the workpiece using a push stick for side support.

As the workpiece nears the end of the cut, place the push block on the auxiliary fence with the lip directly behind the workpiece, then release the push stick just before it is even with the blade (see the example in **Figure 111**).

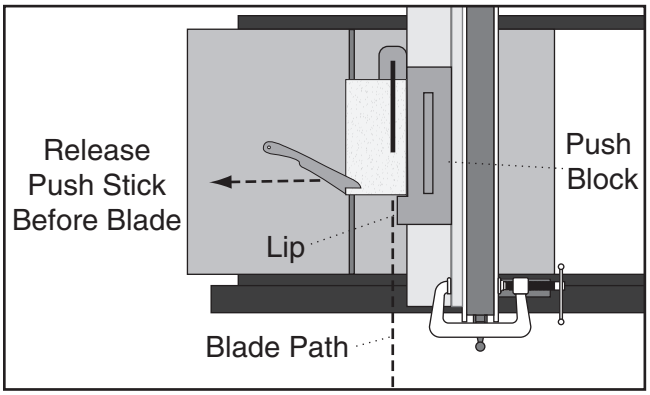
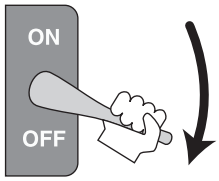


Figure 111. Example of ripping with push block.

WARNING

Turn the saw *OFF* and allow the blade to come to a complete stop before removing the cut-off piece. Failure to follow this warning could result in serious personal injury.

SECTION 7: 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.

Ongoing Check:
- Loose mounting bolts.
- Damaged saw blades.
- Worn or damaged switches or wires.
- Any other unsafe condition.

Weekly Maintenance:
- Clean sliding table surface and grooves
- Clean and lubricate sliding table ways (**Page 63**)
- Clean cast iron saw table
- Clean the rip fence assembly

Monthly Check:
- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Every 6-12 Weeks:
- Lubricate tilt and elevation trunnions (**Page 62**)
- Lubricate tilt and elevation leadscrews (**Page 63**)

Cleaning

Cleaning the Model G0699 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 53** for more details).

Lubrication

Other than the lubrication points covered in this section, all other bearings are internally lubricated and sealed at the factory. Simply leave them alone unless they need to be replaced.

Although it is not necessary to remove the table to complete the lubrication tasks for the trunnions and leadscrews, to do so makes it easier to access these areas for proper inspection, cleaning, and lubrication.

Important: *Take care not to get any lubrication on the drive V-belts to prevent slippage and damage. If you do, replace them.*

Removing Main Table

Tools Needed	Qty
Hex Wrench 4mm	1
Hex Wrench 6mm	1
Hex Wrench 8mm	1
Wrench 19mm	1
Wrench 24mm	1

To remove the table:

1. DISCONNECT SAW FROM POWER!

2. Remove the rip fence assembly, rip fence rail, rip fence scale, and both extensions wings from the cast iron table.

3. Move the sliding table all the way forward and lock it in place.

4. Remove the four hex nuts and spacers from the bottom of the studs that secure the cast iron table to the cabinet (see **Figure 112**).

   Important: *The position of the four upper lock nuts were set at the factory so that the cast iron table is square with the saw blade from side to side and back to front. DO NOT change the position of these lock nuts (see **Figure 112**). Otherwise, you will have to perform the time consuming procedure of bringing the table back to square with the blade.*

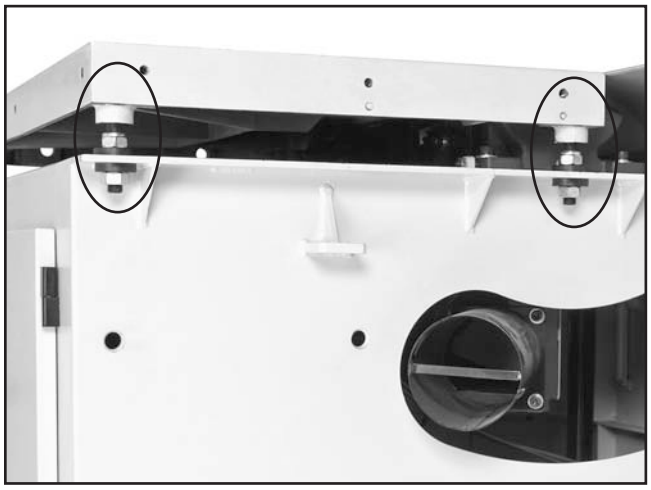


Figure 112. Main table mounting fasteners.

5. With the help of another person for lifting, remove the table from the cabinet and place it in a safe location.

6. Remove the four spacers from the top of the cabinet.

Trunnions

The tilt and elevation trunnions (see **Figure 113**) are curved cast iron surfaces that allow the heavy motors, arbor assemblies, and blades to tilt and change elevation.

It will be necessary to use the tilt and elevation handwheels to gain access to the full lengths of the trunnion sliding surfaces. Use mineral spirits and shop rags to clean away the grime and debris, then apply a thin coat of multi-purpose grease to the full length of the trunnions. Move the trunnions through their full range of movement several times to evenly distribute the grease.

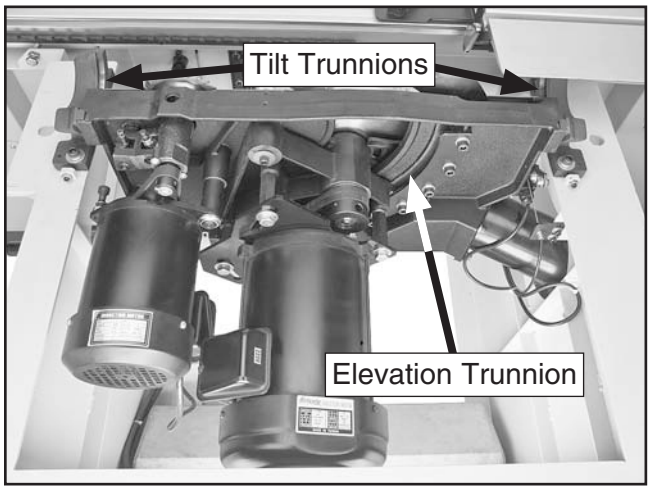


Figure 113. Locations of the trunnions.

Leadscrews

Use mineral spirits and shop rages to clean away grime and debris from the full lengths of the tilt and elevation leadscrews (see **Figures 114–115**). Then, apply a thin coat of light machine oil (see **Accessories** on **Page 53**) to their full lengths with a shop rag. Move the leadscrews through their full range of movement several times to evenly distribute the oil.

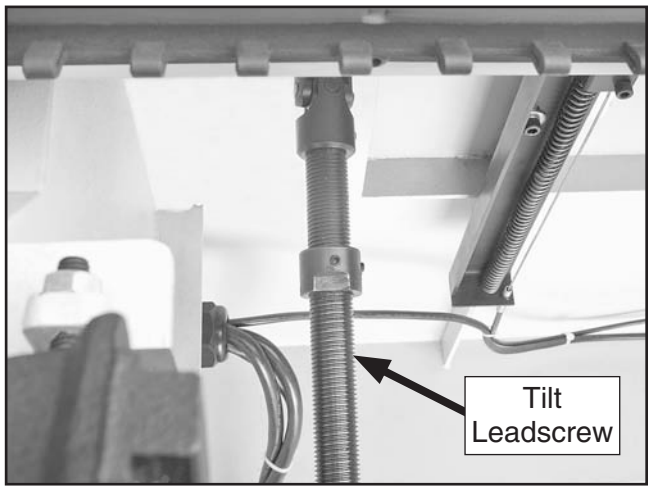


Figure 114. Tilt leadscrew (viewed through the gap between the sliding table and cabinet).

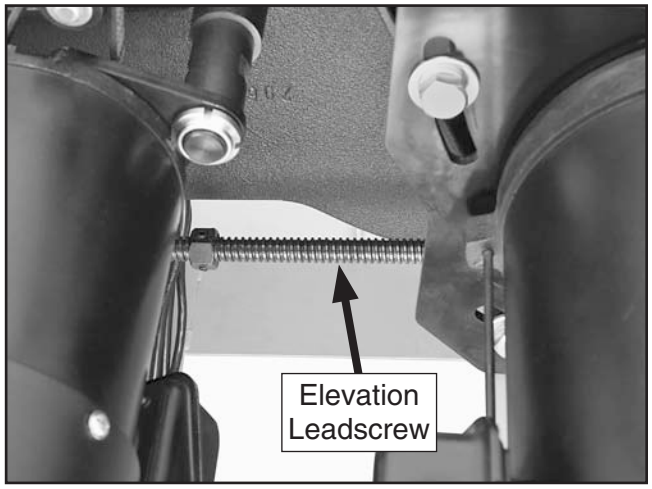


Figure 115. Elevation leadscrew (viewed between the motors).

Sliding Table Ways

There are steel ways (see **Figure 116**) on both sides of the sliding table that fit between the top and the base and allow these parts to slide past each other. Clean the ways with mineral spirits and shop rags, then apply a thin coat of light machine oil with a shop rag. Move the sliding table through its full range of movement several times to evenly distribute the oil.

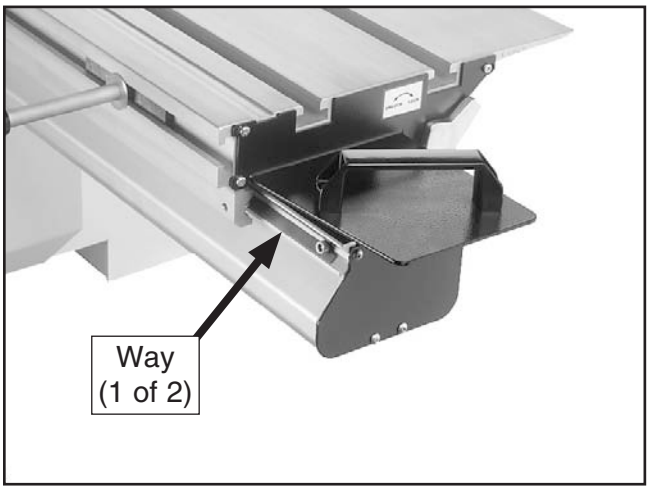


Figure 116. Sliding table way (1 of 2).

Replacing Main Table

Replace the main table in the reverse steps from which it was removed.

Before re-tightening the mounting hex nuts, use a straightedge to adjust the table position so that the leading edge of the blade gap is parallel to saw blade, as illustrated in **Figure 117**.

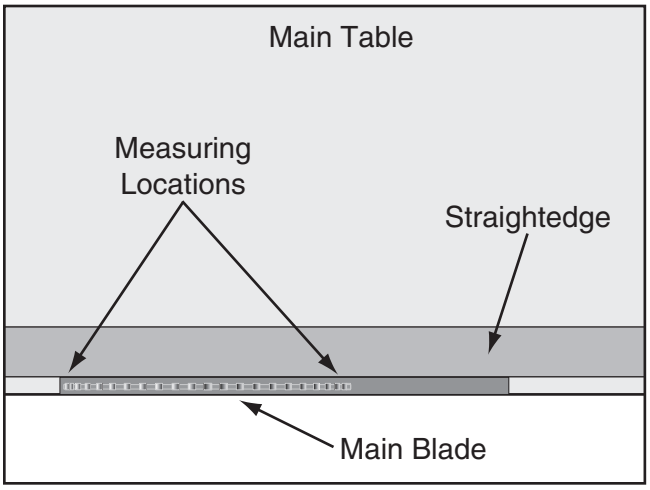
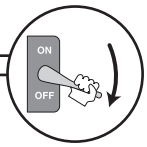


Figure 117. Measuring locations for squaring the main table to the blade.

SECTION 8: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. STOP push-button is engaged/faulty. 2. Power supply switched OFF or is at fault. 3. Blade cover limit switch engaged/at fault. 4. Motor connection wired incorrectly. 5. Thermal overload relay has tripped. 6. Wall fuse/circuit breaker is blown/tripped. 7. Contactor not getting energized/has burnt contacts. 8. Wiring is open/has high resistance. 9. Motor ON/OFF switch is at fault. 10. Motor is at fault.	1. Rotate clockwise slightly until it pops out/replace it. 2. Ensure power supply is switch on; ensure power supply has the correct voltage. 3. Move blade cover to the working position; replace faulty limit switch. 4. Correct motor wiring connections. 5. Turn amperage dial to 110% of motor full-load amperage and push the reset pin. Replace if tripped multiple times (weak relay). 6. Ensure circuit size is suitable for this machine; replace weak breaker; check wiring at machine. 7. Test for power on all legs and contactor operation. Replace unit if faulty. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Replace faulty ON/OFF switch. 10. Test/repair/replace.
Machine stalls or is overloaded.	1. Feed rate/cutting speed too fast for task. 2. Workpiece material is not suitable for this machine. 3. Belt(s) slipping. 4. Motor connection is wired incorrectly. 5. Motor bearings are at fault. 6. Motor is at fault.	1. Decrease feed rate/cutting speed. 2. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece (see **Page 42**). 3. Replace bad belt (if V-belts, replace as matched set, align pulleys, and re-tension (see **Page 66**). 4. Correct motor wiring connections. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Test/repair/replace.

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. Blade is at fault. 3. Belt(s) worn or loose. 4. Pulley is loose. 5. Motor mount loose/broken. 6. Machine is sits unevenly. 7. Arbor pulley is loose. 8. Motor fan is rubbing on fan cover. 9. Arbor bearings are at fault. 10. Motor bearings are at fault.	1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Re-tension (see **Page 66**). Replace is necessary. 4. Realign/replace shaft, pulley, setscrew, and key as required. 5. Tighten/replace. 6. Relocate/shim machine. 7. Retighten/replace arbor pulley with shaft and thread locking liquid. 8. Reposition fan cover; replace if damaged; replace loose/damaged fan. 9. Replace arbor housing bearings; replace arbor. 10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Main blade runs counterclockwise.	1. Two of the incoming power wires are reversed.	1. Swap any two hot wires in the main power junction box (**Page 15**).

Operation

Symptom	Possible Cause	Possible Solution
Workpiece has burned edges, binds, or kicks back.	1. Sliding table or rip fence is not parallel to blade. 2. Riving knife is not aligned with the blade. 3. Blade is warped or damaged.	1. Make sliding table or rip fence parallel to the blade (**Pages 68 & 71**). 2. Shim the riving knife to align it with the main blade. 3. Replace the blade.
Workpiece has chip out on the bottom edge.	1. Scoring blade kerf does not match the main blade.	1. Properly adjust the scoring blade to the main blade (**Page 47**).
Sliding table saw does not cut square.	1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Crosscut fence is not perpendicular to the blade.	1. Make sliding table parallel to the blade (**Page 68**). 2. Adjust the rip fence parallel to blade (**Page 29**). 3. Adjust the 90° stop bolts so that the fence is perpendicular to the blade (**Page 70**).
Rip fence hits table top when sliding across table.	1. Rip fence rail is too low. 2. Rip fence roller is too low.	1. Raise the rip fence rail (**Page 71**). 2. Adjust the rip fence roller (**Page 71**).
Blade does not reach 90˚, or blade does not reach 45˚.	1. Blade stop bolts are out of adjustment.	1. Adjust the stop bolts (**Page 67**).
The rip fence scale is not accurate.	1. The rip fence scale is out of calibration or was not set up correctly.	1. Adjust the rip fence scale (**Page 71**).
Tilt or elevation handwheels difficult to turn.	1. Lock knob is tight. 2. Gears caked with dust.	1. Release the lock knob. 2. Clean out dust and grease the gears.

Belt Service

To ensure the efficient transfer of power from the motors to the blade arbors, the drive belts must be in good condition and properly tensioned. As the belts wear with normal use, they will stretch and need to be re-tensioned. If the belts show signs of cracking, fraying, or damage, replace them.

Although it is not necessary, removing the cast iron table from the cabinet could make most belt servicing tasks safer and easier. Refer to the **Removing Main Table** subsection on **Page 62** and the **Replacing Main Table** on **Page 63** for detailed instructions.

Note: *Replace the main motor V-belts as a matched set so that they will wear evenly.*

Main Motor V-Belts

1. DISCONNECT SAW FROM POWER!

2. Loosen the three mounting hex bolts shown in **Figure 118** to allow the motor to rotate.

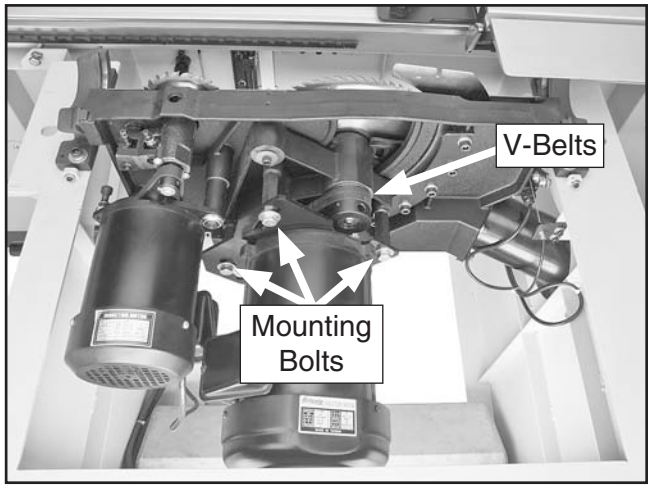


Figure 118. Locations of main motor mounting bolts (cast iron table removed).

3. If the V-belts need replacing, lift the motor up to release the tension, roll the old V-belts off the pulleys, then install the new V-belts as a matched set.

4. Adjust the motor until there is approximately ¼" deflection when you use moderate pressure between the pulleys, as illustrated in **Figure 119**, then re-tighten the motor mounting bolts.

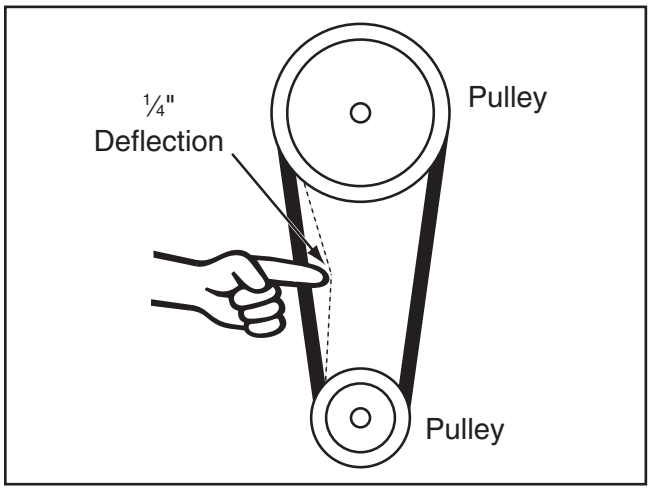


Figure 119. Testing for the correct amount of belt tension.

Scoring Motor Ribbed V-Belt

The scoring motor ribbed V-belt is automatically correctly tensioned by a spring that puts downward pressure on the motor.

To replace the scoring motor ribbed V-belt:

1. DISCONNECT SAW FROM POWER!

2. Lift up on the scoring motor, roll the old V-belt off the pulleys (see **Figure 120**).

   Note: *It takes considerable upward pressure against the spring to raise the motor.*

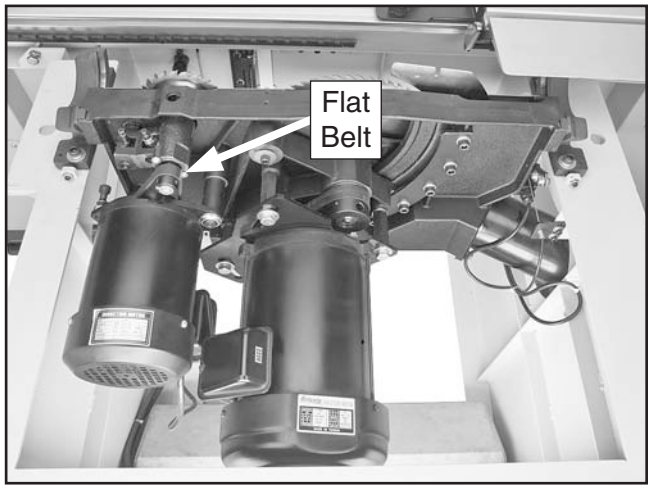


Figure 120. Scoring motor flat belt.

3. Make sure all of the ribs of the V-belt are seated in the grooves of the pulleys as you install the new V-belt.

Calibrating Blade Tilt

The blade tilt stop nuts were correctly calibrated at the factory, but can be re-calibrated if they change position during the life of the machine.

Tools Needed	Qty
Hex Wrench 2.5mm	1
90° Square	1
45° Square	1

To calibrate the tilt stop nuts:

1. DISCONNECT SAW FROM POWER!

2. Raise the main blade all the way up and tilt it all the way toward the 0° mark until it stops. This moves the leadscrew clamp up against the 0° stop nut and the blade perpendicular to the table.

3. Place the 90° square flat on the table and against the main blade.

   —If the main blade is not 90° to the table, reach through the rear door, loosen the two set screws on the 0° tilt stop nut (see **Figure 121**), then adjust the stop nut until you can move the blade so that it is 90° to the table. Re-tighten the set screws on the stop nut.

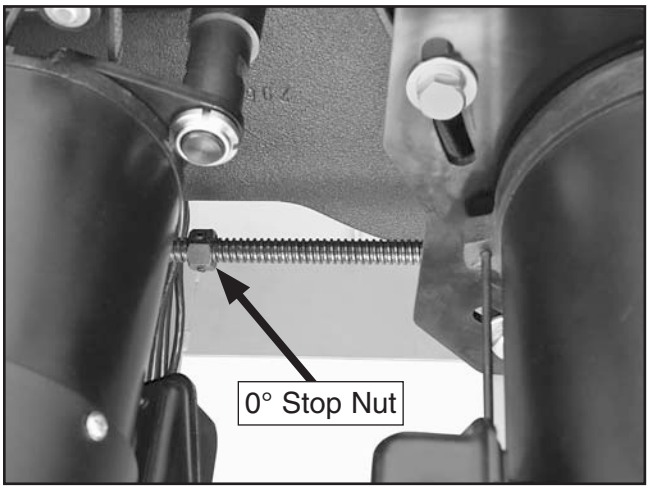


Figure 121. Tilt leadscrew 0° stop nut (viewed between the motors).

4. Move the sliding table all the way forward and lock it in place.

5. Tilt the main blade all the way to the 45° mark, then place the 45° square against the blade and table.

   —If the blade is not 45° to the table, reach through the gap between the main table and sliding table base (see **Figure 122**), loosen the two set screws on the 45° stop nut, then adjust the nut on the leadscrew until you can move the blade to be 45° to the main table. Re-tighten the set screws on the stop nut.

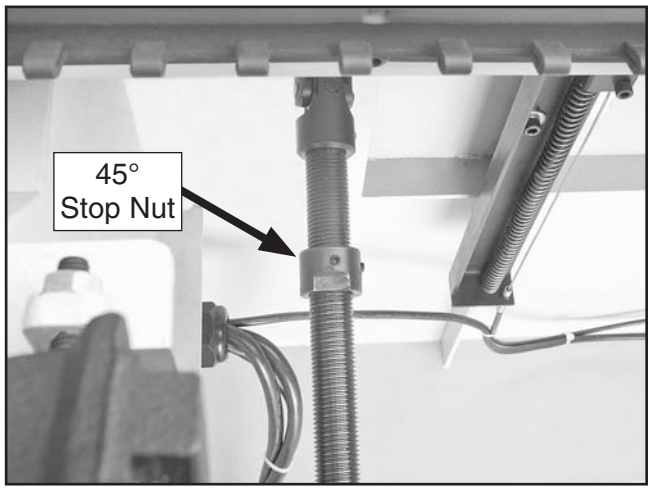


Figure 122. Tilt leadscrew 45° stop nut (viewed with main table removed for clarity).

Adjusting Sliding Table Parallelism

If the cuts are not square when using the sliding table, the table may not be parallel to the main blade. Making sure that the sliding table is parallel to the blade is necessary to ensure straight cutting operations and to prevent the workpiece from binding and kicking back.

Tools Needed	Qty
Felt Tip Pen	1
Adjustable Square	1
Wrench 17mm	1
Wrench 19mm	1

To check and adjust the sliding table parallelism:

1. DISCONNECT SAW FROM POWER!

2. Move the sliding table all the way back.

3. Move the main saw blade to 0° and raise it all the way up.

4. Use the felt tip pen to make a mark on the right blade edge that is even with the table.

5. Use the adjustable square to measure the distance from the sliding table T-slot and the main saw blade at the mark you made in **Step 4**. This is distance "A" shown in **Figure 123**.

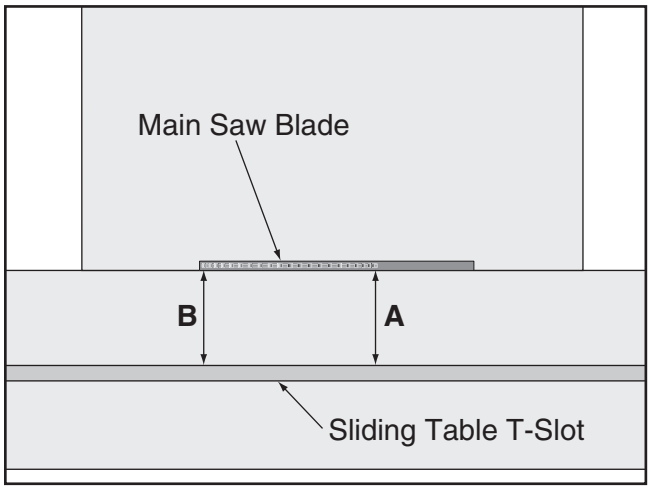


Figure 123. Measuring the distance between sliding table T-slot and main blade.

6. Move the sliding table all the way forward, rotate the saw blade so the mark you made in **Step 15** is at location "B", then take the measurement of "B".

   —If the difference is equal to or less than 0.004" between the "A" and "B" measurements, the sliding table parallelism to the saw blade is acceptable and adjustment is necessary.

   —If the difference between the "A" and "B" measurements is greater than 0.004", the sliding table parallel adjustment bolts need to be re-adjusted. Continue with the next step.

7. Loosen the three sliding table mounting hex nuts that hold the sliding table in place.

   Note: *Access two of the hex nuts by removing the access panels on both sides of the frame, and the middle hex nut through the 5" dust port gap in the cabinet side.*

8. Loosen the jam nuts on the sliding table parallel adjustment bolts (see **Figure 124**) that are on both sides of the frame behind the sliding table, then adjust the bolts in or out in small increments to change the parallel relationship of the sliding table to the saw blade.

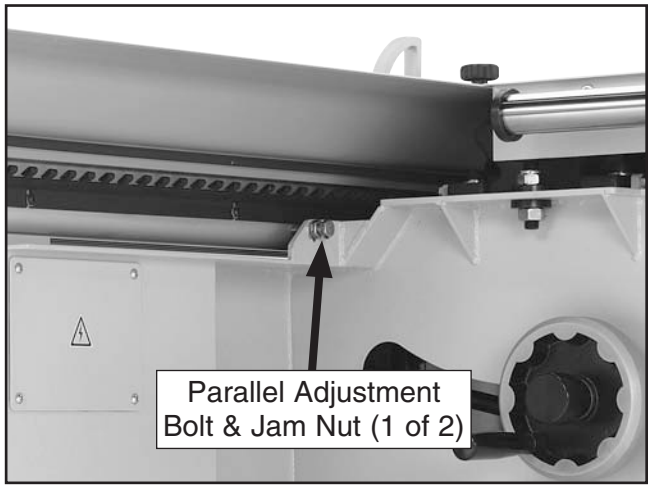


Figure 124. Sliding table parallel adjustment bolt (1 of 2).

9. Make sure the sliding table is up against the adjustment bolts, then repeat **Steps 5, 6** and **8** until the difference between the "A" and "B" measurements is acceptable.

10. Re-tighten the jam nuts on the adjustment bolts.

11. Make sure the sliding table is against both adjustment bolts, then re-tighten the mounting hex nuts to secure the table in place.

Adjusting Sliding Table Ways

The sliding table ways are steel rails that are on both sides of the sliding table base. The ball bearings of the sliding table top ride on these ways when you move the table.

The sliding table base features multiple adjustment bolts along its full length (see **Figure 125**) that control the pressure that the ways apply to the ball bearings. These bolts were properly set at the factory and should not need further adjustment over the life of the machine.

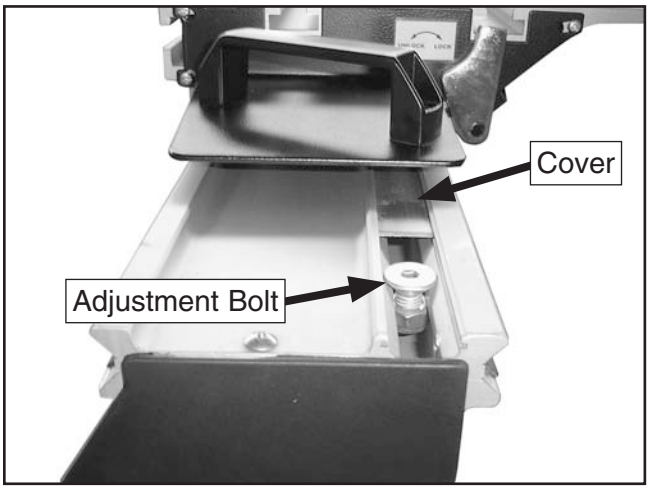


Figure 125. Sliding table way adjustment bolt.

If you choose to re-adjust the adjustment bolts, keep in mind that properly completing this procedure is a matter of trial-and-error by making small adjustments, moving the sliding table, then making additional adjustments. Ultimately, the table must move easily without any slop along its full range of movement.

Turning the adjustment bolts *clockwise* increases the outward pressure applied to the ways. This reduces table movement slop, which increases accuracy, but makes it harder to slide the table.

Turning the adjustment bolts *counterclockwise* decreases the outward pressure applied to the ways. This increases table movement slop, which reduces accuracy, but makes it easier to slide the table.

Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with this fence will be square. This procedure is done by using a piece of scrap plywood as a test piece and making five test cuts, then adjusting the 90° stop bolts on both ends of the crosscut table (see **Figure 126**).

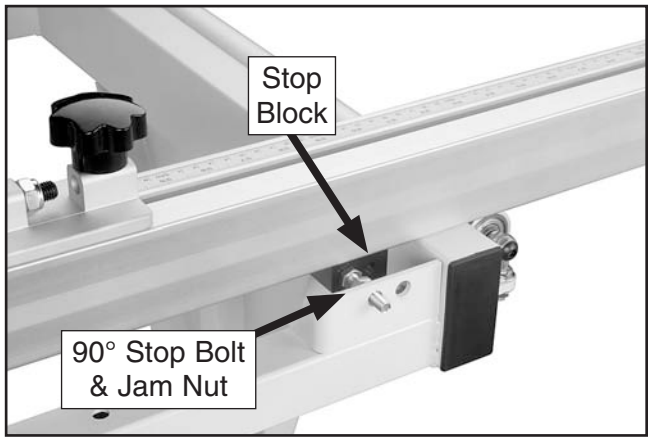


Figure 126. Crosscut fence stop block and 90° stop bolt.

Tool Needed	**Qty**
Wrench 13mm	1

To adjust the 90° stop bolts:

1. Make sure the sliding table is parallel to the main saw blade (see the **Sliding Table Parallel Adjustment** procedure on **Page 68** for detailed instructions).

2. Prepare the test piece by cutting it to a dimension of 32" x 32", then number all four sides, as illustrated in **Figure 127**.

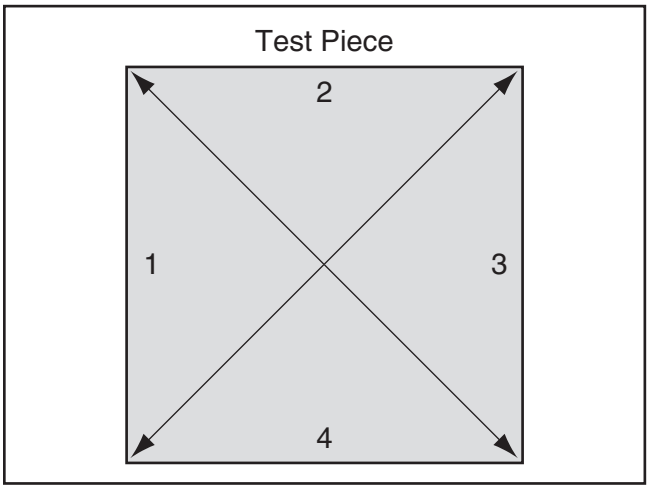


Figure 127. Crosscut fence adjustment test piece.

3. Move the crosscut fence stop block against one of the 90° stop bolts, then use the fence to cut ½" off each side of the test piece, then cut side 1 again—five cuts total.

4. Measure the test piece diagonally from corner to corner, as illustrated in **Figure 127**.

   —If both measurements are within 1/16" of each other, then no further adjustments are necessary.

   —If both measurements are not within 1/16" of each other, then the stop bolt needs to be adjusted. Proceed to the next step.

5. Loosen the 90° stop bolt jam nut, adjust the bolt in or out, repeat **Steps 3–4** until the diagonal measurements are within 1/16" of each other, then tighten the stop bolt jam nut.

6. Repeat **Steps 3–5** with the other 90° stop bolt.

Rip Fence Adjustments

There are three adjustments that affect the accuracy and operation of the rip fence: 1) Height above the table, 2) parallelism to the blade, and 3) rip fence scale position. If your cuts are not square when using the rip fence, check these adjustments.

Height Above Table

The rip fence and body should ride as close to the table surface as possible without touching it and with an even gap along the length. This is accomplished by adjusting the rip fence rail and the roller at the end of the fence body.

Tools Needed	Qty
Hex Wrench 2.5mm	1
Wrench 17mm	1
Wrench 19mm	1

To adjust the rip fence height above the table:

1. Observe the gap between the fence body and the table along the entire length.

   —If the near end of the fence body is too low, loosen the hex nuts that secure the rail, raise the rail until the fence body gap is even, then re-tighten the rail hex nuts.

   —If the far end of the fence body is too low, pull the body up from the table, loosen the set screw shown in **Figure 128**, then turn the eccentric adjustment bolt to rotate the roller and extend it out from the body.

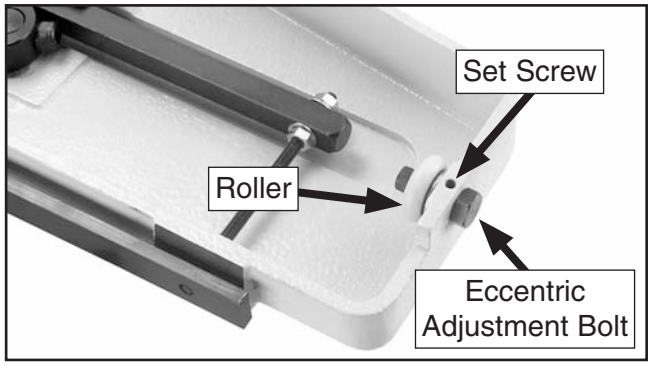


Figure 128. Rip fence body roller controls.

Parallelism To Blade

Tool Needed	Qty
Wrench 19mm	1

To adjust the rip fence parallel to the main blade:

1. DISCONNECT SAW FROM POWER!

2. Raise the main blade all the way up and bring the tilt to 0°.

3. Slide the rip fence against the main blade and check if it touches both ends of the blade evenly.

   —If the rip fence does not touch both ends of the blade evenly, loosen the rail hex nuts and adjust one end in or out until the rip fence is parallel with the blade, then re-tighten the hex nuts.

Calibrating Rip Fence Scale

Tool Needed	Qty
Phillips Screwdriver #2	1

To calibrate the rip fence scale:

1. DISCONNECT SAW FROM POWER!

2. Make sure the rip fence is parallel to the main blade, then move it against the blade so that it just touches the teeth.

3. Observe the reading on the scale underneath the rip fence (see **Figure 129**).

   —If the scale reading is not zero, loosen the screws that secure it to the table, adjust it so that it does read zero, then re-tighten the screws to secure the setting.

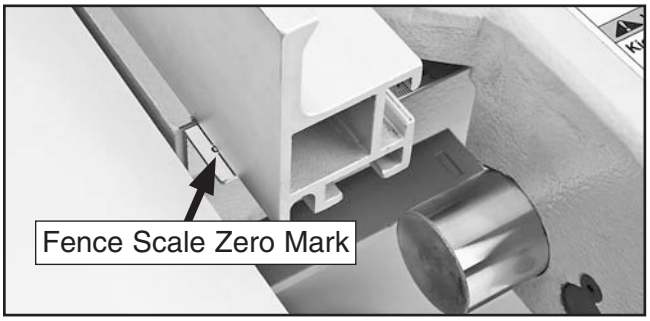


Figure 129. Rip fence scale zero mark.

SECTION 9: WIRING & ELECTRICAL

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠WARNING
Wiring Safety Instructions

1. **SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

2. **MODIFICATIONS.** Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

3. **WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

4. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

5. **WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

7. **CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

8. **EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

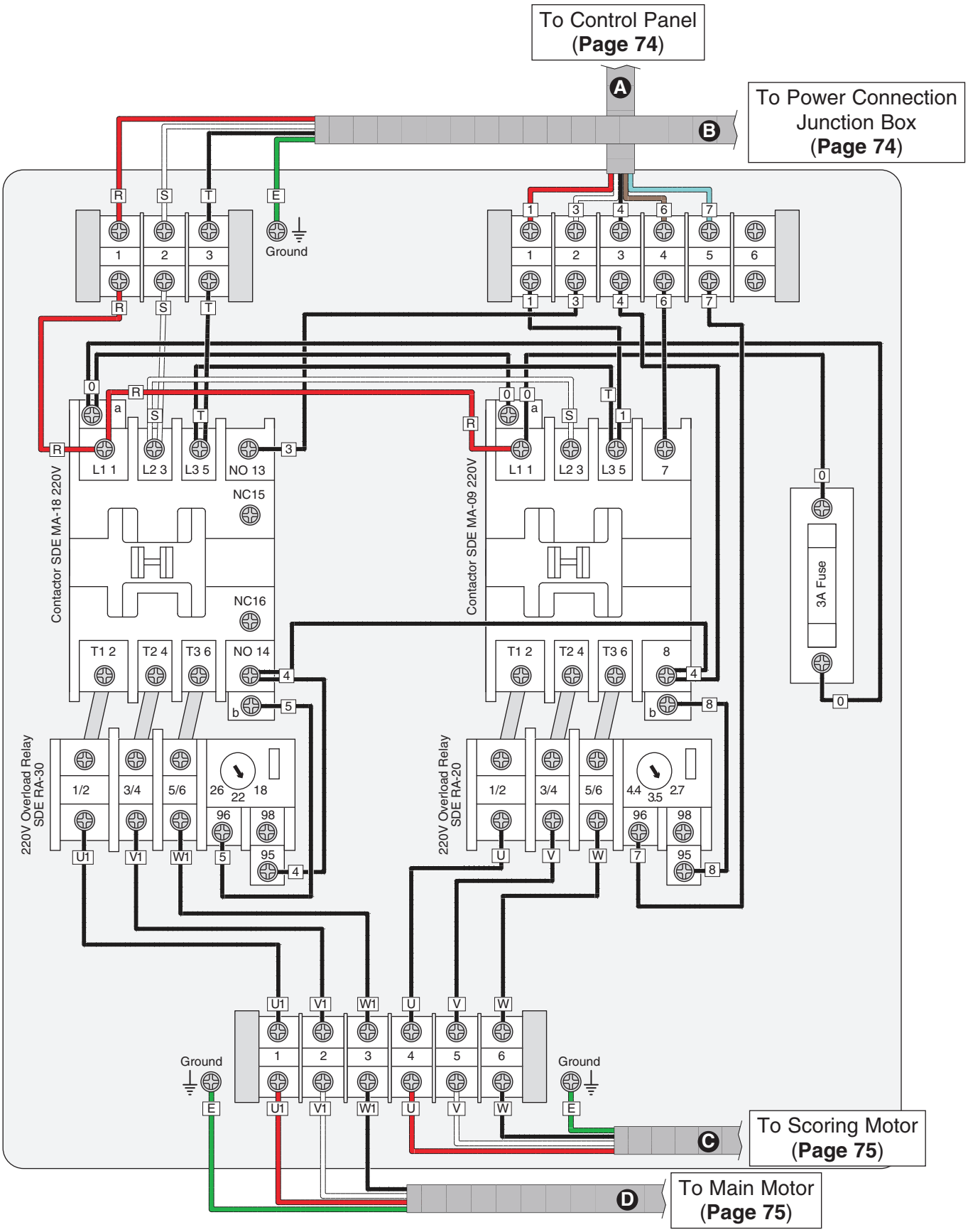
NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

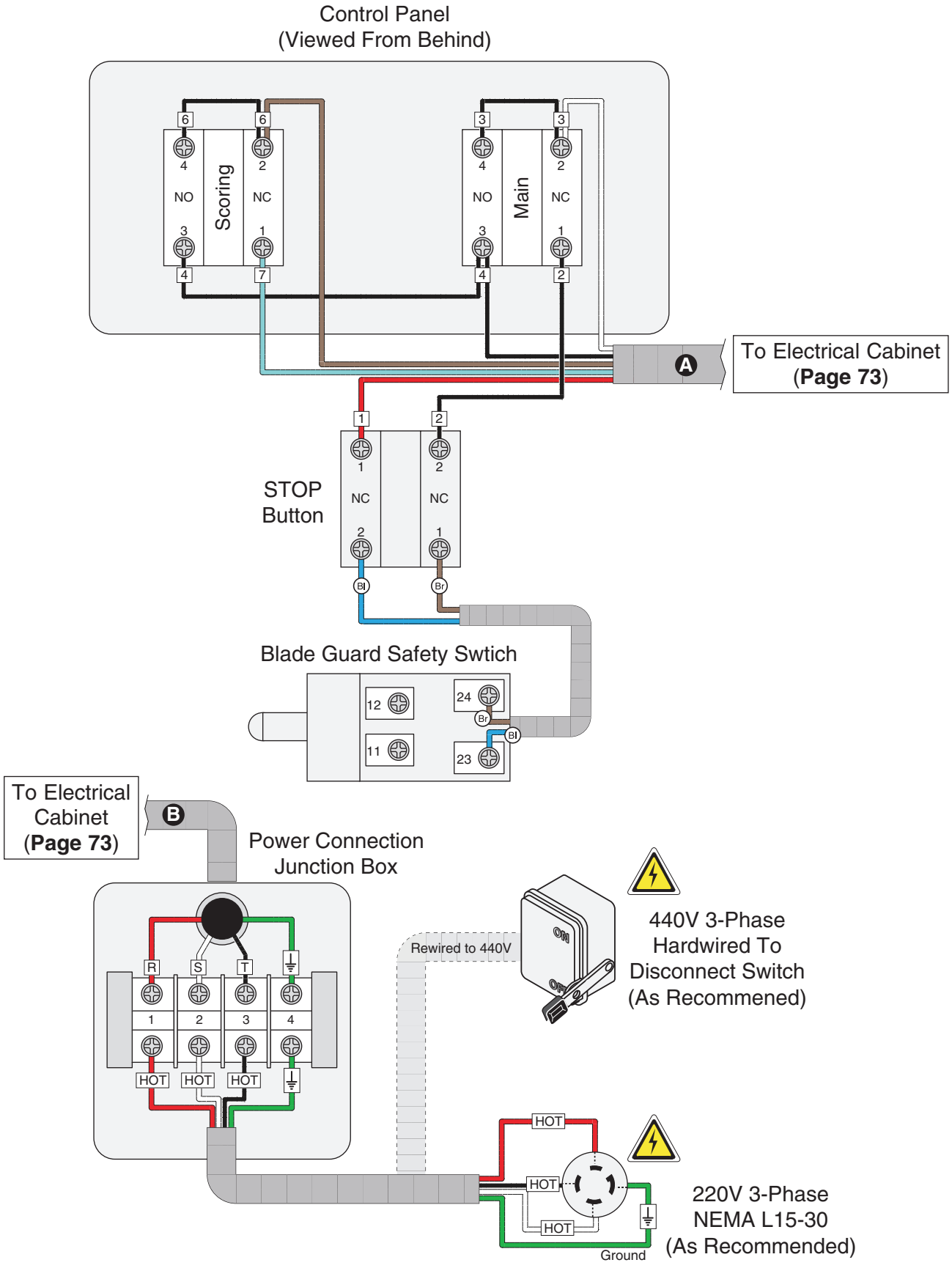
BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Electrical Cabinet Wiring Diagram (220V Components Shown)



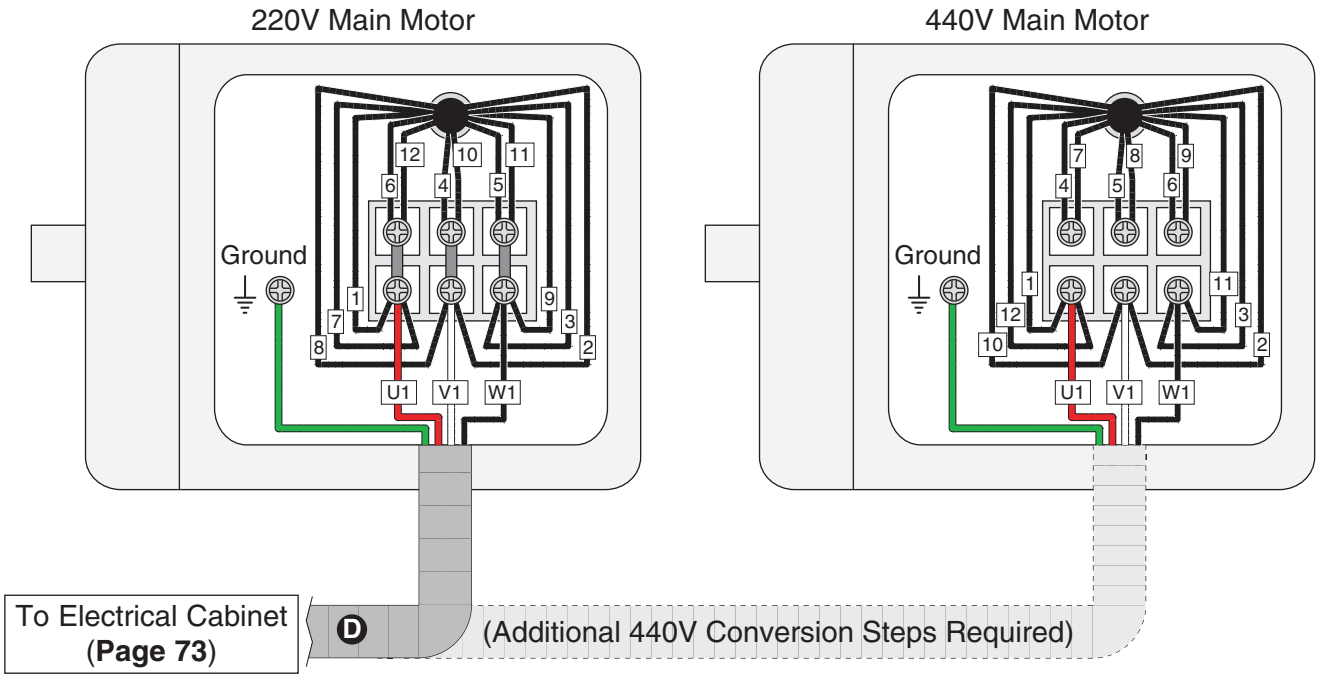
READ ELECTRICAL SAFETY ON PAGE 72!

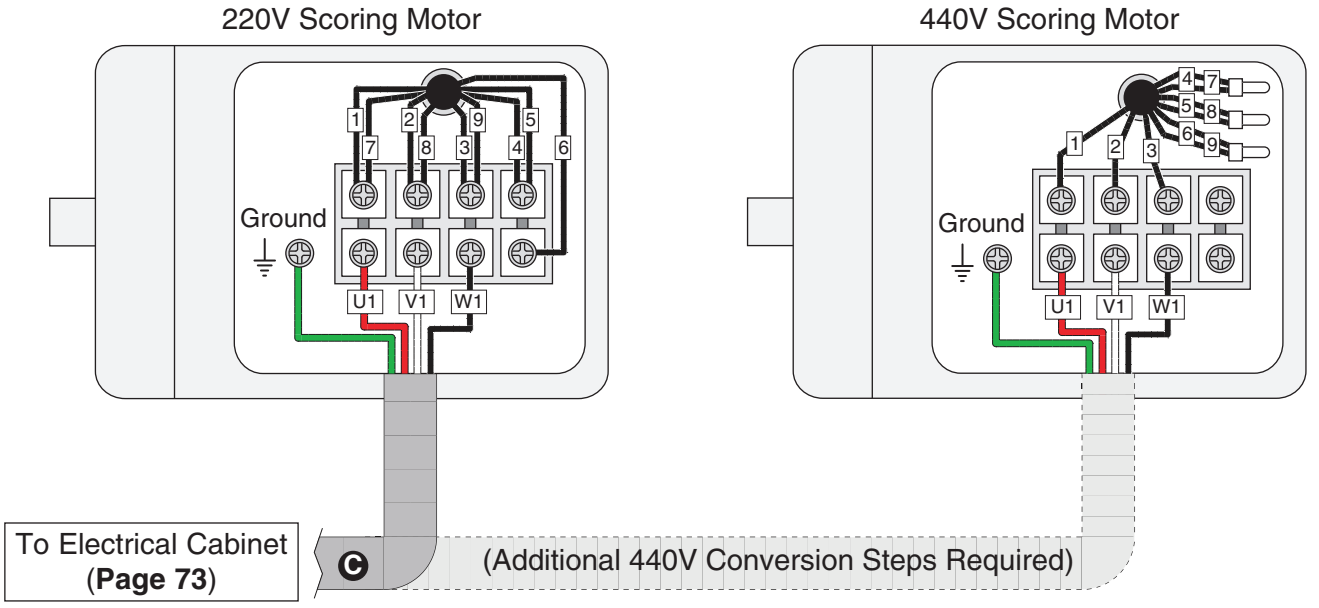
Control Panel, Guard Switch, & Power Connection Junction Box Wiring Diagrams



READ ELECTRICAL SAFETY ON PAGE 72!

Main & Scoring Motor Wiring Diagrams





READ ELECTRICAL SAFETY ON PAGE 72!

Electrical Component Photographs

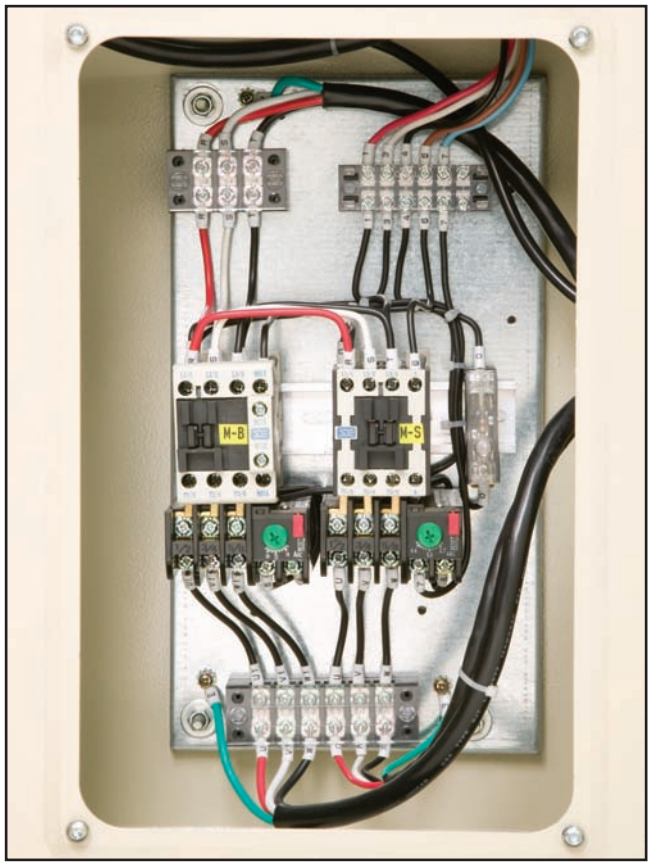


Figure 130. Electrical panel wiring.

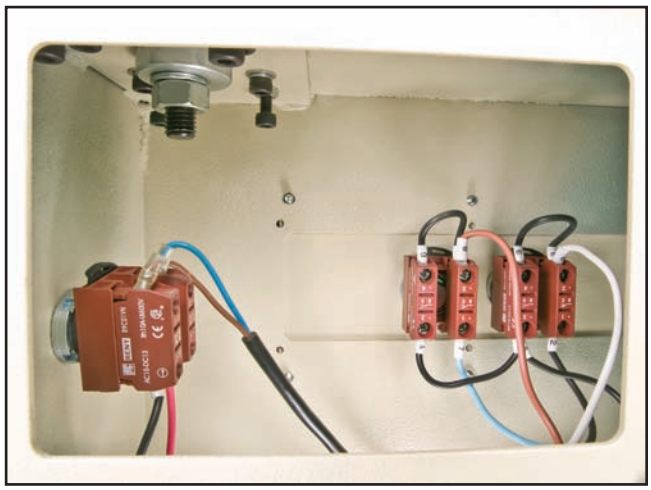


Figure 131. Control panel wiring.

Figure 132. Main motor wiring.

Figure 133. Scoring motor wiring.

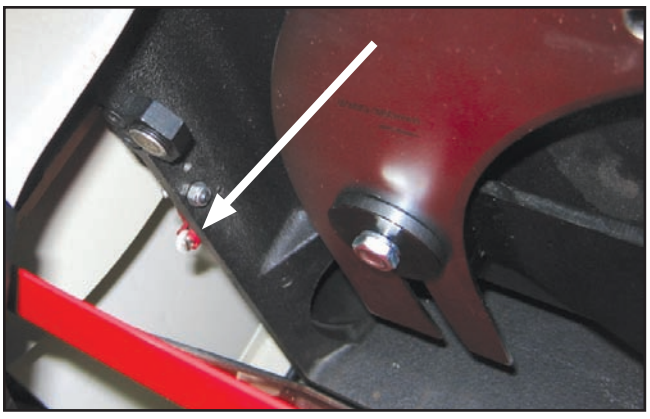
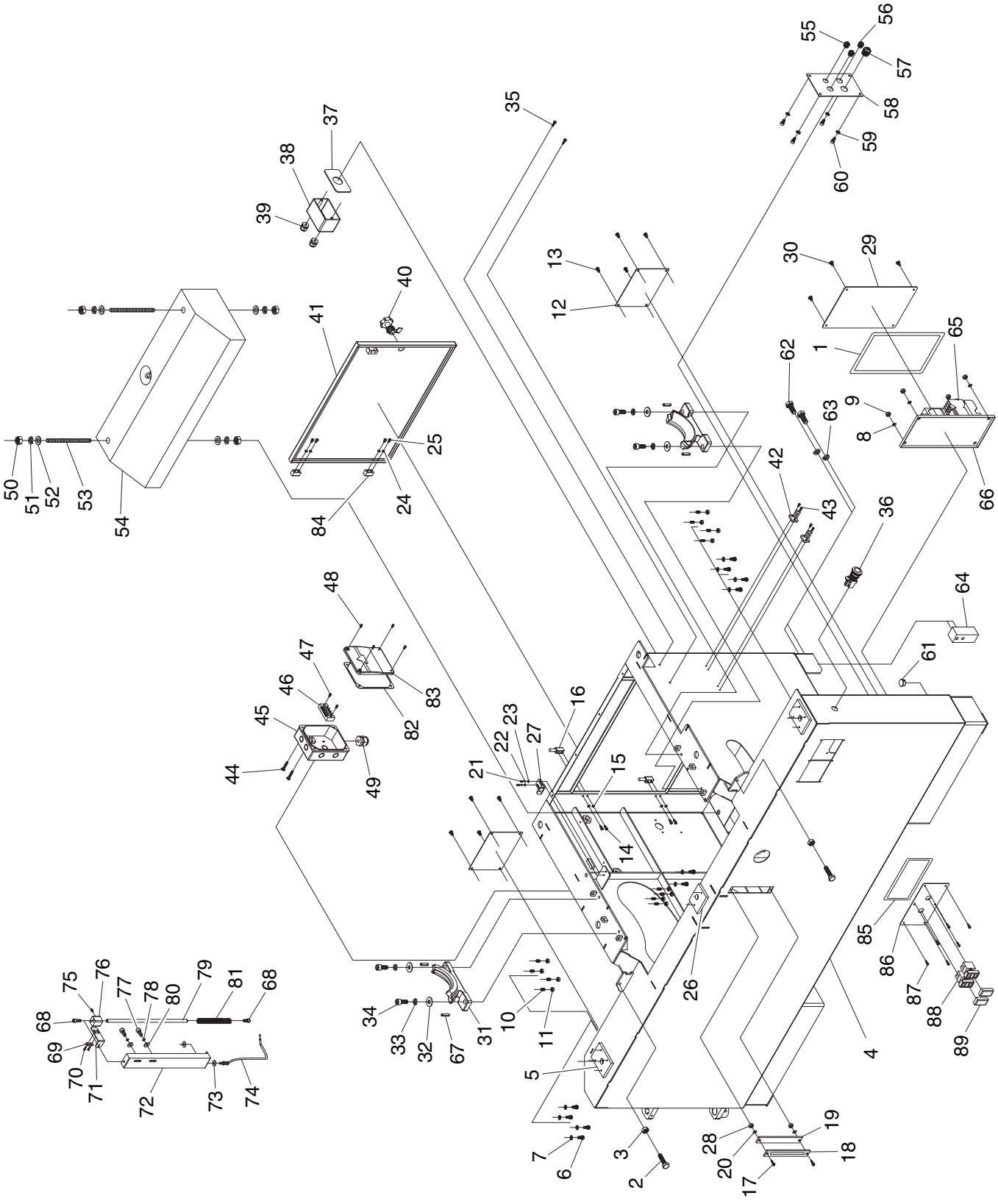


Figure 134. Blade guard safety switch.

READ ELECTRICAL SAFETY ON PAGE 72!

SECTION 10: PARTS

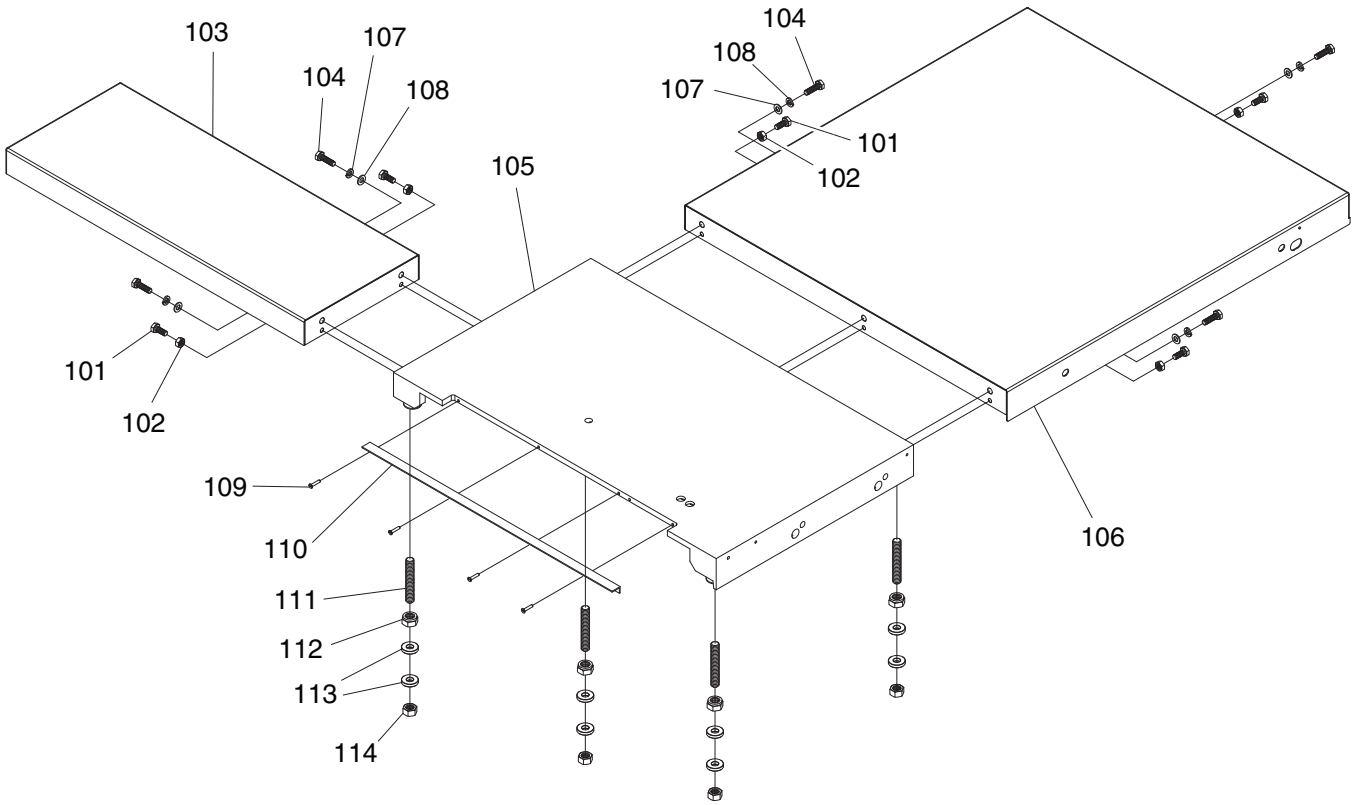
Cabinet Body



Cabinet Body Parts List

REF	PART #	DESCRIPTION
1	P06990001	ELECTRICAL PANEL GASKET
2	PB31M	HEX BOLT M10-1.5 X 40
3	PN02M	HEX NUT M10-1.5
4	P06990004	MACHINE FRAME
5	P06990005	TABLE SIDE MOUNTING PLATE
6	PCAP26M	CAP SCREW M6-1 X 12
7	PLW03M	LOCK WASHER 6MM
8	PW03M	FLAT WASHER 6MM
9	PFN02M	FLANGE NUT M6-1
10	PSS25M	SET SCREW M6-1 X 20
11	PN01M	HEX NUT M6-1
12	P06990012	FRAME REAR ACCESS PANEL
13	PBHS09M	BUTTON HD CAP SCR M6-1 X 12
14	PCAP33M	CAP SCREW M5-.8 X 12
15	PLW01M	LOCK WASHER 5MM
16	P06990016	DOOR HINGE
17	PS52M	PHLP HD SCR M4-.7 X 20
18	P06990018	TILT SCALE COVER
19	P06990019	TILT SCALE
20	PW05M	FLAT WASHER 4MM
21	PCAP03M	CAP SCREW M5-.8 X 8
22	PLW03M	LOCK WASHER 6MM
23	PW03M	FLAT WASHER 6MM
24	PCAP03M	CAP SCREW M5-.8 X 8
25	PLW01M	LOCK WASHER 5MM
26	P06990026	TABLE MIDDLE MOUNTING PLATE
27	P06990027	SUPPORT BRACE
28	PN04M	HEX NUT M4-.7
29	P06990029	ELECTRICAL PANEL COVER
30	PBHS11M	BUTTON HD CAP SCR M6-1 X 10
31	P06990031	BLADE TILT TRUNNION
32	PW04M	FLAT WASHER 10MM
33	PLW06M	LOCK WASHER 10MM
34	PCAP84M	CAP SCREW M10-1.5 X 35
35	PHTEK17M	TAP SCREW M5 X 20
36	P06990036	STOP BUTTON
37	P06990037	SWITCH BOX GASKET
38	P06990038	SWITCH BOX
39	P06990039	STRAIN RELIEF
40	P06990040	DOOR LOCK
41	P06990041	DOOR
42	P06990042	HANGER
43	PHTEK17M	TAP SCREW M5 X 20
44	PBHS05M	BUTTON HD CAP SCR M6-1 X 20
45	P06990045	JUNCTION BOX
46	P06990046	TERMINAL BLOCK 4P
47	PS05M	PHLP HD SCR M5-.8 X 8
48	PBHS06M	BUTTON HD CAP SCR M5-.8 X 12
49	P06990049	STRAIN RELIEF PG20
50	PN09M	HEX NUT M12-1.75
51	PLW05M	LOCK WASHER 12MM
52	PW06M	FLAT WASHER 12MM
53	P06990053	ALL-THREAD STUD M12-1.75 X 185
54	P06990054	CONCRETE BLOCK
55	P06990055	STRAIN RELIEF PG11
56	P06990049	STRAIN RELIEF PG20
57	P06990057	STRAIN RELIEF MGB25
58	P06990058	CORD PLATE
59	PLW03M	LOCK WASHER 6MM
60	PCAP26M	CAP SCREW M6-1 X 12
61	P06990061	PLUG
62	PB25M	HEX BOLT M12-1.75 X 25
63	PLW05M	LOCK WASHER 12MM
64	P06990064	BLOCK
65	P06990065	ELECTRICAL PANEL ASSEMBLY
66	P06990066	ELECTRICAL BACK PANEL
67	PRP93M	ROLL PIN 6 X 25
68	PCAP50M	CAP SCREW M5-.8 X 10
69	PW02M	FLAT WASHER 5MM
70	PS09M	PHLP HD SCR M5-.8 X 10
71	P06990071	POINTER
72	P06990072	TILT SCALE BRACKET
73	PW03M	FLAT WASHER 6MM
74	P06990074	STEEL WIRE
75	PSS05M	SET SCREW M5-.8 X 10
76	P06990076	POINTER BRACKET
77	PCAP26M	CAP SCREW M6-1 X 12
78	PLW03M	LOCK WASHER 6MM
79	P06990079	SHAFT
80	PW03M	FLAT WASHER 6MM
81	P06990081	COMPRESSION SPRING
82	P06990082	JUNCTION BOX GASKET
83	P06990083	JUNCTION BOX COVER
84	P06990084	DOOR HINGE BLOCK
85	P06990085	CONTROL PANEL GASKET
86	P06990086	CONTROL PANEL
87	PSBHS35M	BUTTON HD CAP SCR M5-.8 X 10
88	P06990088	ON/OFF BUTTON SWITCH
89	P06990089	BUTTON SWITCH DUST COVER

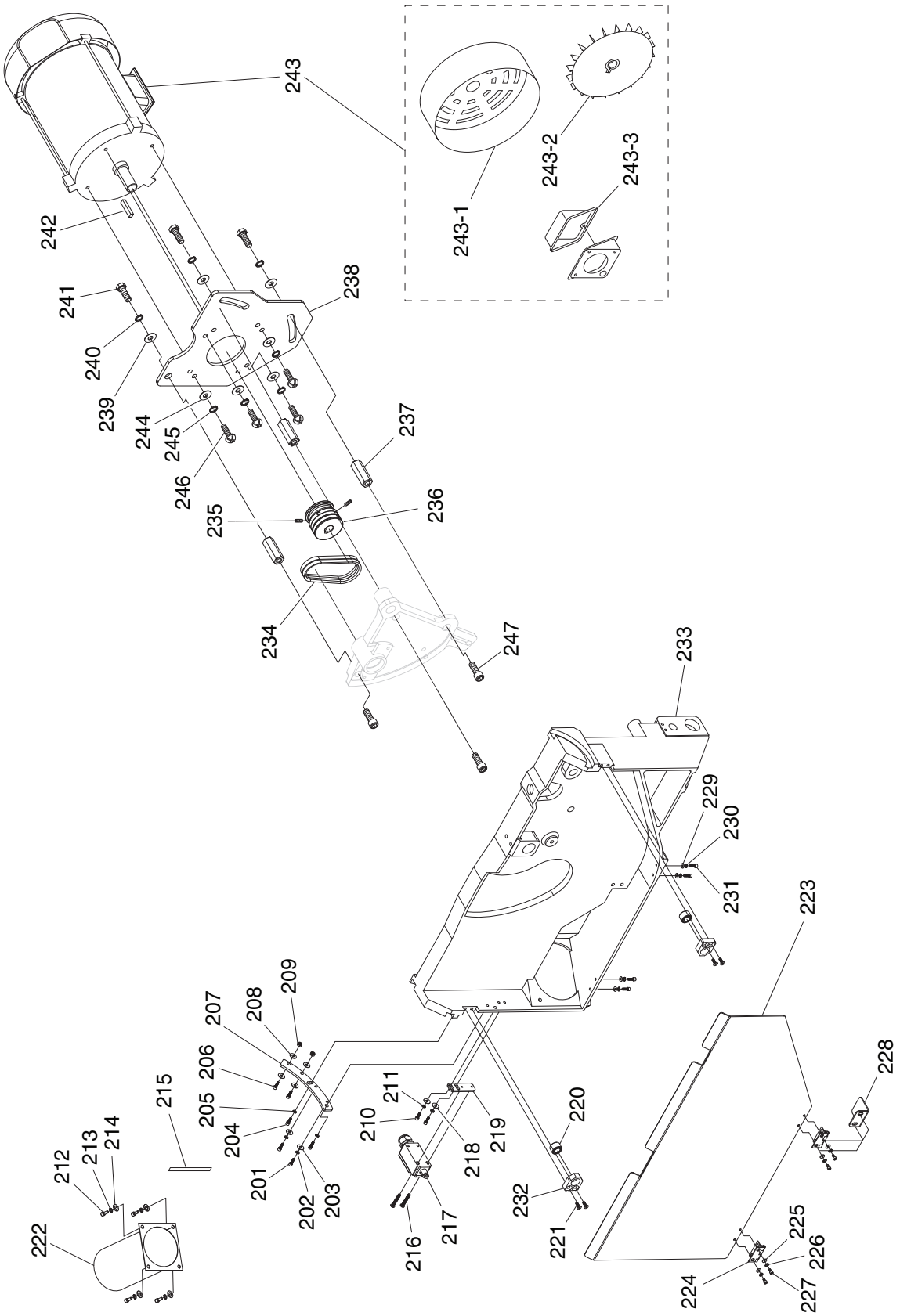
Tables



REF	PART #	DESCRIPTION
101	PB32M	HEX BOLT M10-1.5 X 25
102	PN02M	HEX NUT M10-1.5
103	P06990103	LEFT EXTENSION WING
104	PB32M	HEX BOLT M10-1.5 X 25
105	P06990105	SAW TABLE
106	P06990106	REAR EXTENSION WING
107	PW04M	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
108	PLW06M	LOCK WASHER 10MM
109	PBHS09M	BUTTON HD CAP SCR M6-1 X 12
110	P06990110	SAW TABLE ANGLE INSERT
111	P06990111	ALL-THREAD STUD M16-2 X 100
112	PLN07M	LOCK NUT M16-2
113	P06990113	TABLE MOUNT SPACER 16MM
114	PN13M	HEX NUT M16-2

Main Blade Trunnion & Motor

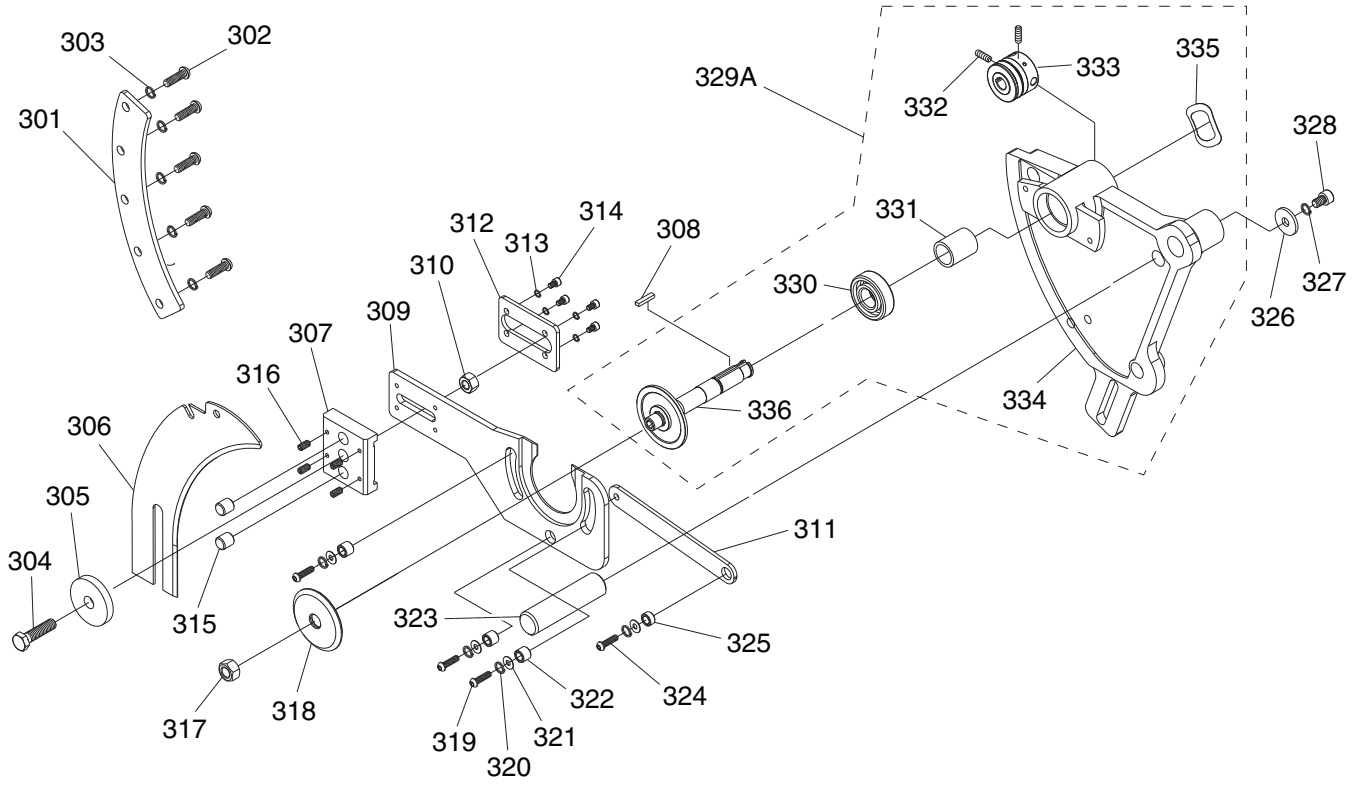


Main Blade Trunnion & Motor Parts List

REF	PART #	DESCRIPTION
201	PCAP03M	CAP SCREW M5-.8 X 8
202	PLW01M	LOCK WASHER 5MM
203	PW02M	FLAT WASHER 5MM
204	PCAP26M	CAP SCREW M6-1 X 12
205	PLW03M	LOCK WASHER 6MM
206	PCAP24M	CAP SCREW M5-.8 X 16
207	P06990207	ANGLE PLATE
208	PW02M	FLAT WASHER 5MM
209	PLN02M	LOCK NUT M5-.8
210	PCAP33M	CAP SCREW M5-.8 X 12
211	PLW01M	LOCK WASHER 5MM
212	PCAP58M	CAP SCREW M8-1.25 X 12
213	PLW04M	LOCK WASHER 8MM
214	PW01M	FLAT WASHER 8MM
215	P06990215	CUSHION STRIP
216	PS25M	PHLP HD SCR M4-.7 X 35
217	P06990217	BLADE COVER SAFETY SWITCH
218	PW02M	FLAT WASHER 5MM
219	P06990219	SWITCH BRACKET
220	P06990220	BLADE COVER MAGNET
221	PFH55M	FLAT HD CAP SCR M6-1 X 20
222	P06990222	DUST PORT
223	P06990223	BLADE COVER
224	P06990224	BLADE COVER DOOR HINGE
225	PW02M	FLAT WASHER 5MM

REF	PART #	DESCRIPTION
226	PLW01M	LOCK WASHER 5MM
227	PCAP03M	CAP SCREW M5-.8 X 8
228	P06990228	HINGE BRACKET
229	PW02M	FLAT WASHER 5MM
230	PLW01M	LOCK WASHER 5MM
231	PCAP50M	CAP SCREW M5-.8 X 10
232	P06990232	MAGNET HOLDER
233	P06990233	ELEVATION TRUNNION
234	PVM16	V-BELT M16 3L160
235	PSS16M	SET SCREW M8-1.25 X 10
236	P06990236	MAIN BLADE MOTOR PULLEY
237	P06990237	SPACER
238	P06990238	MAIN BLADE MOUNTING PLATE
239	P06990239	MOTOR MOUNT FLAT WASHER 12MM
240	PLW05M	LOCK WASHER 12MM
241	PB25M	HEX BOLT M12-1.75 X 25
242	PK152M	KEY 8 X 7 X 40
243	P06990243	MAIN MOTOR 7-1/2HP 220/440V 3PH
243-1	P06990243-1	MAIN MOTOR FAN COVER
243-2	P06990243-2	MAIN MOTOR FAN
243-3	P06990243-3	MAIN MOTOR JUNCTION BOX
244	PW01M	FLAT WASHER 8MM
245	PLW04M	LOCK WASHER 8MM
246	PB09M	HEX BOLT M8-1.25 X 20
247	PCAP77M	CAP SCREW M12-1.75 X 30

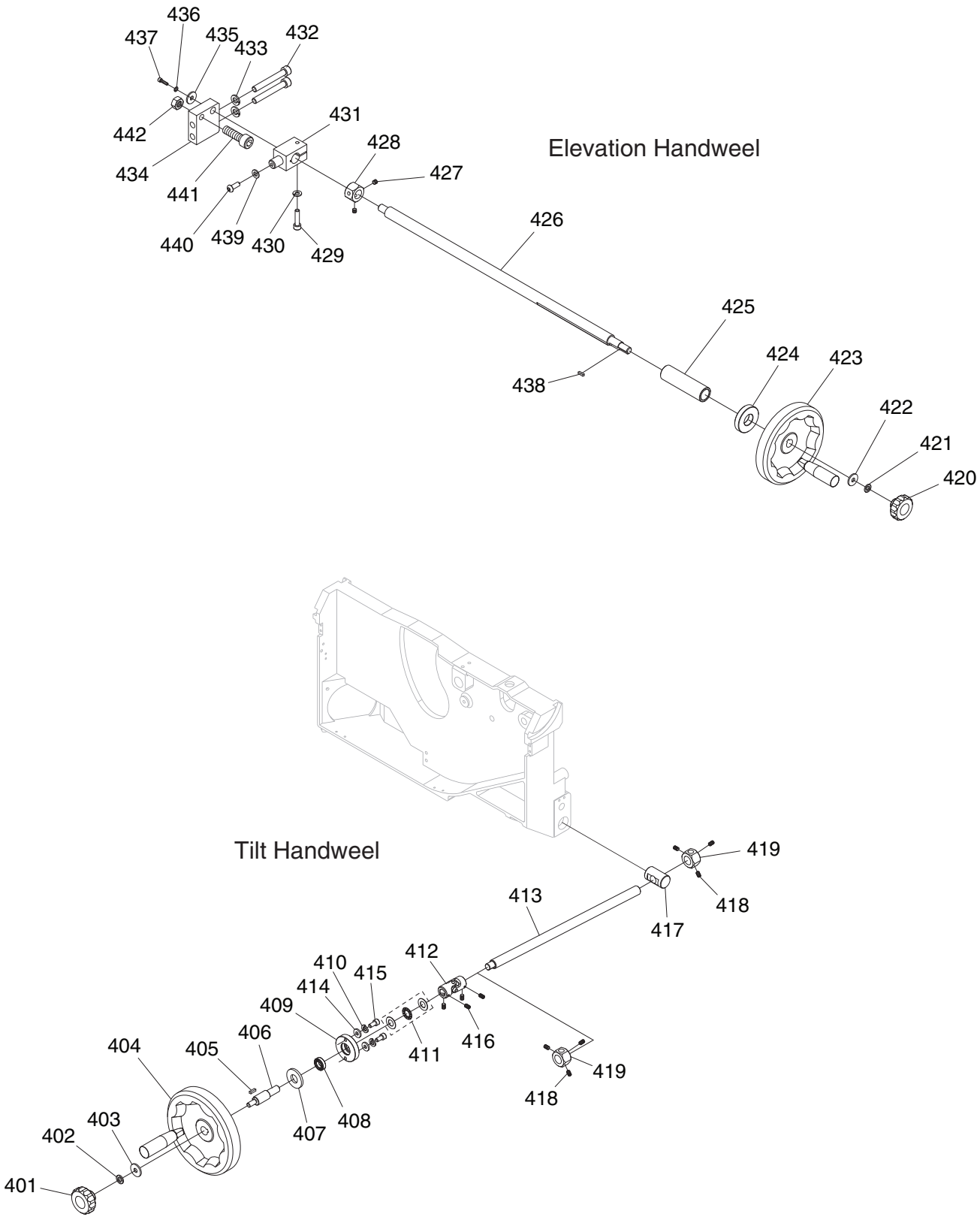
Main Blade Arbor



REF	PART #	DESCRIPTION
301	P06990301	GIB
302	PBHS10M	BUTTON HD CAP SCR M10-1.5 X 25
303	PLW06M	LOCK WASHER 10MM
304	PB31M	HEX BOLT M10-1.5 X 40
305	P06990305	RIVING KNIFE FLAT WASHER 10MM
306	P06990306	RIVING KNIFE
307	P06990307	FRONT RIVING KNIFE BRACKET
308	PK34M	KEY 5 X 5 X 20
309	P06990309	BRACKET
310	PN09M	HEX NUT M12-1.75
311	P06990311	PIVOT LINK
312	P06990312	REAR RIVING KNIFE BRACKET
313	PLW01M	LOCK WASHER 5MM
314	PBHS06M	BUTTON HD CAP SCR M5-.8 X 12
315	P06990315	ALIGNMENT PIN
316	PSS05M	SET SCREW M5-.8 X 10
317	PN13M	HEX NUT M16-2
318	P06990318	MAIN BLADE ARBOR FLANGE

REF	PART #	DESCRIPTION
319	PBHS03M	BUTTON HD CAP SCR M8-1.25 X 16
320	PLW04M	LOCK WASHER 8MM
321	PW01M	FLAT WASHER 8MM
322	P06990322	BUSHING
323	P06990323	ARBOR HOUSING PIVOT SHAFT
324	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
325	P06990325	BUSHING
326	P06990326	PIVOT SHAFT FLAT WASHER
327	PLW04M	LOCK WASHER 8MM
328	PCAP14M	CAP SCREW M8-1.25 X 20
329	P06990329	ARBOR-HOUSING ASSEMBLY
330	P6206LLB	BALL BEARING 6206 LLB
331	P06990331	SPACER
332	PSS03M	SET SCREW M6-1 X 8
333	P06990333	ARBOR PULLEY
334	P06990334	ARBOR HOUSING
335	P06990335	WAVE WASHER
336	P06990336	MAIN BLADE ARBOR

Tilt & Elevation Handwheels

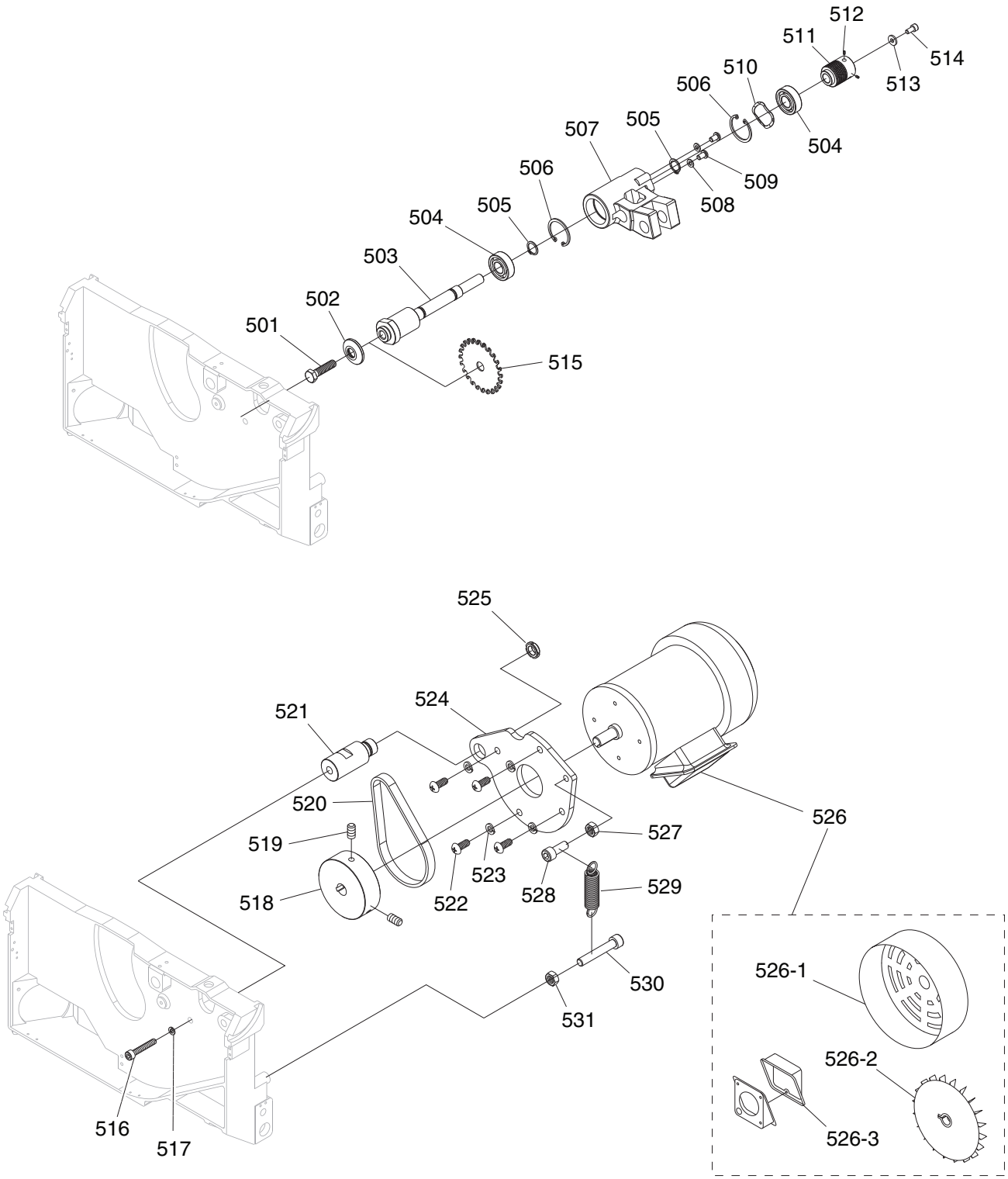


Tilt & Elevation Handwheels Parts List

REF	PART #	DESCRIPTION
401	P06990401	LOCK KNOB M10-1.5
402	PW04M	FLAT WASHER 10MM
403	P06990403	HANDWHEEL FLAT WASHER 10MM
404	P06990404	TILT HANDWHEEL ASSEMBLY
405	PK25M	KEY 7 X 7 X 20
406	P06990406	HANDWHEEL SHAFT
407	P06990407	BEARING WASHER
408	P6902ZZ	BALL BEARING 6902 ZZ
409	P06990409	BEARING SEAT
410	PLW04M	LOCK WASHER 8MM
411	P06990411	THRUST BEARING NTB1528 AS
412	P06990412	UNIVERSAL JOINT
413	P06990413	TILT LEADSCREW
414	PW01M	FLAT WASHER 8MM
415	PCAP14M	CAP SCREW M8-1.25 X 20
416	PSS02M	SET SCREW M6-1 X 6
417	P06990417	TRUNNION CONNECTOR
418	PSS02M	SET SCREW M6-1 X 6
419	P06990419	TILT LEADSCREW NUT
420	P06990401	LOCK KNOB M10-1.5
421	PW04M	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
422	P06990403	HANDWHEEL FLAT WASHER 10MM
423	P06990423	ELEVATION HANDWHEEL ASSEMBLY
424	P06990424	BEARING WASHER
425	P06990425	LEADSCREW SLEEVE
426	P06990426	ELEVATION LEADSCREW
427	PSS02M	SET SCREW M6-1 X 6
428	P06990428	ELEVATION LEADSCREW NUT
429	PCAP06M	CAP SCREW M6-1 X 25
430	PLW03M	LOCK WASHER 6MM
431	P06990431	ELEVATION LEADSCREW CLAMP
432	PCAP35M	CAP SCREW M8-1.25 X 60
433	PLW04M	LOCK WASHER 8MM
434	P06990434	LEADSCREW BRACKET
435	PW03M	FLAT WASHER 6MM
436	PLW03M	LOCK WASHER 6MM
437	PCAP26M	CAP SCREW M6-1 X 12
438	PK34M	KEY 5 X 5 X 20
439	PW03M	FLAT WASHER 6MM
440	PCAP04M	CAP SCREW M6-1 X 10
441	PCAP84M	CAP SCREW M10-1.5 X 35
442	PN02M	HEX NUT M10-1.5

Scoring Blade Arbor & Motor

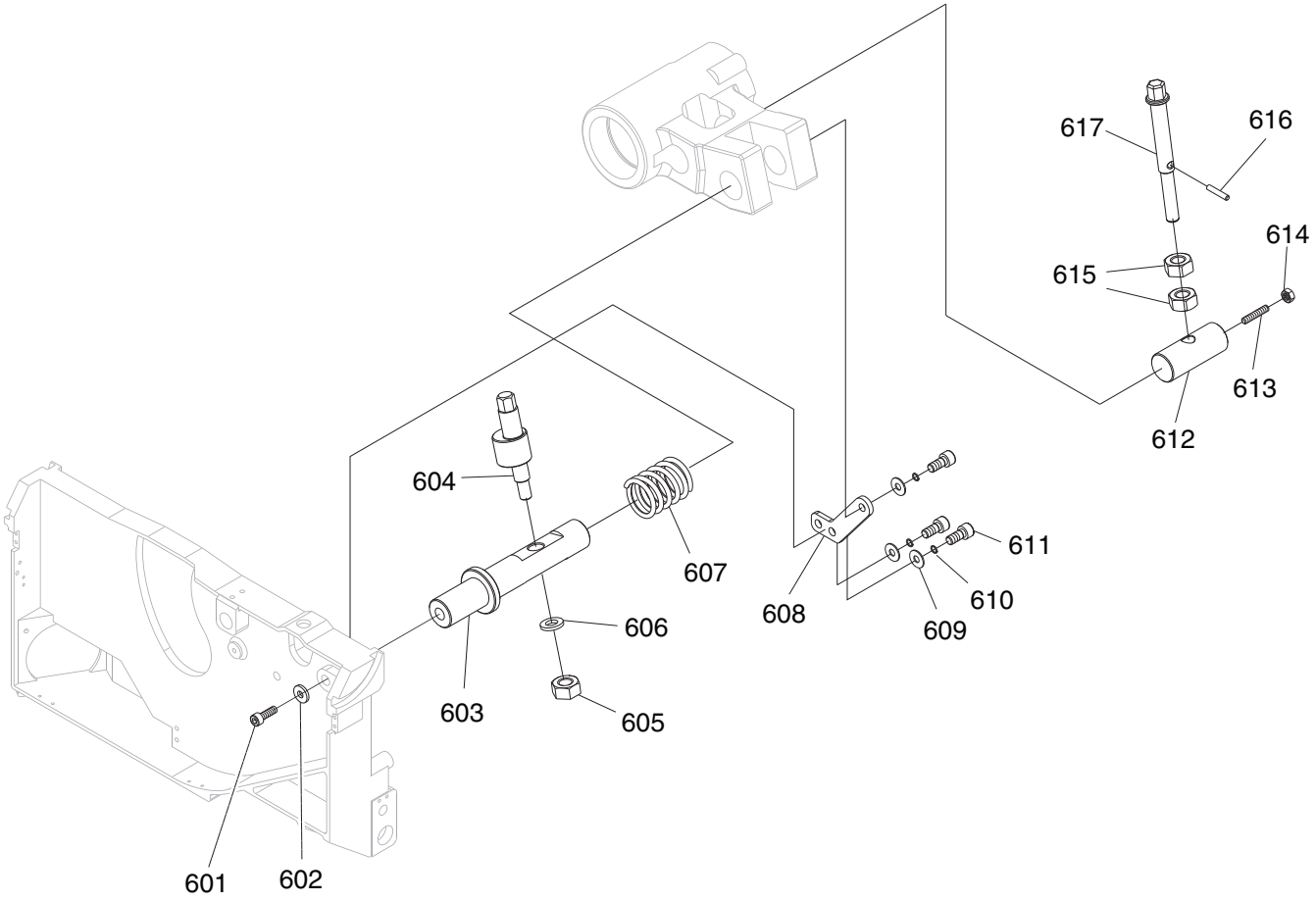


Scoring Blade Arbor & Motor Parts List

REF	PART #	DESCRIPTION
501	PB49M	HEX BOLT M12-1.75 X 20
502	P06990502	SCORING BLADE ARBOR FLANGE
503	P06990503	SCORING BLADE ARBOR
504	P6202LLB	BALL BEARING 6202LLB
505	PR05M	EXT RETAINING RING 15MM
506	PR21M	INT RETAINING RING 35MM
507	P06990507	ARBOR HOUSING
508	PW03M	FLAT WASHER 6MM
509	PFH11M	FLAT HD SCR M8-1.25 X 15
510	P06990510	WAVE WASHER 26MM
511	P06990511	SCORING BLADE PULLEY
512	PSS02M	SET SCREW M6-1 X 6
513	P06990513	PULLEY FLAT WASHER 16MM
514	P06990514	HEX BOLT M6-1 X 16 LH
515	T23037	SCORING BLADE 20T
516	PCAP149M	CAP SCREW M12-1.75 X 100
517	PLW05M	LOCK WASHER 12MM

REF	PART #	DESCRIPTION
518	P06990518	SCORING MOTOR PULLEY
519	PSS25M	SET SCREW M6-1 X 20
520	P06990520	RIBBED FLAT BELT 140J7
521	P06990521	PIVOT SHAFT
522	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
523	PLW04M	LOCK WASHER 8MM
524	P06990524	SCORING MOTOR MOUNTING PLATE
525	P06990525	SPANNER NUT
526	P06990526	SCORING MOTOR 1HP 220/440V 3PH
526-1	P06990526-1	SCORING MOTOR FAN COVER
526-2	P06990526-2	SCORING MOTOR FAN
526-3	P06990526-3	SCORING MOTOR JUNCTION BOX
527	PN02M	HEX NUT M10-1.5
528	PB56M	CAP SCREW M10-1.5 X 20
529	P06990529	TENSION SPRING
530	PCAP143M	CAP SCREW M10-1.5 X 50
531	PN02M	HEX NUT M10-1.5

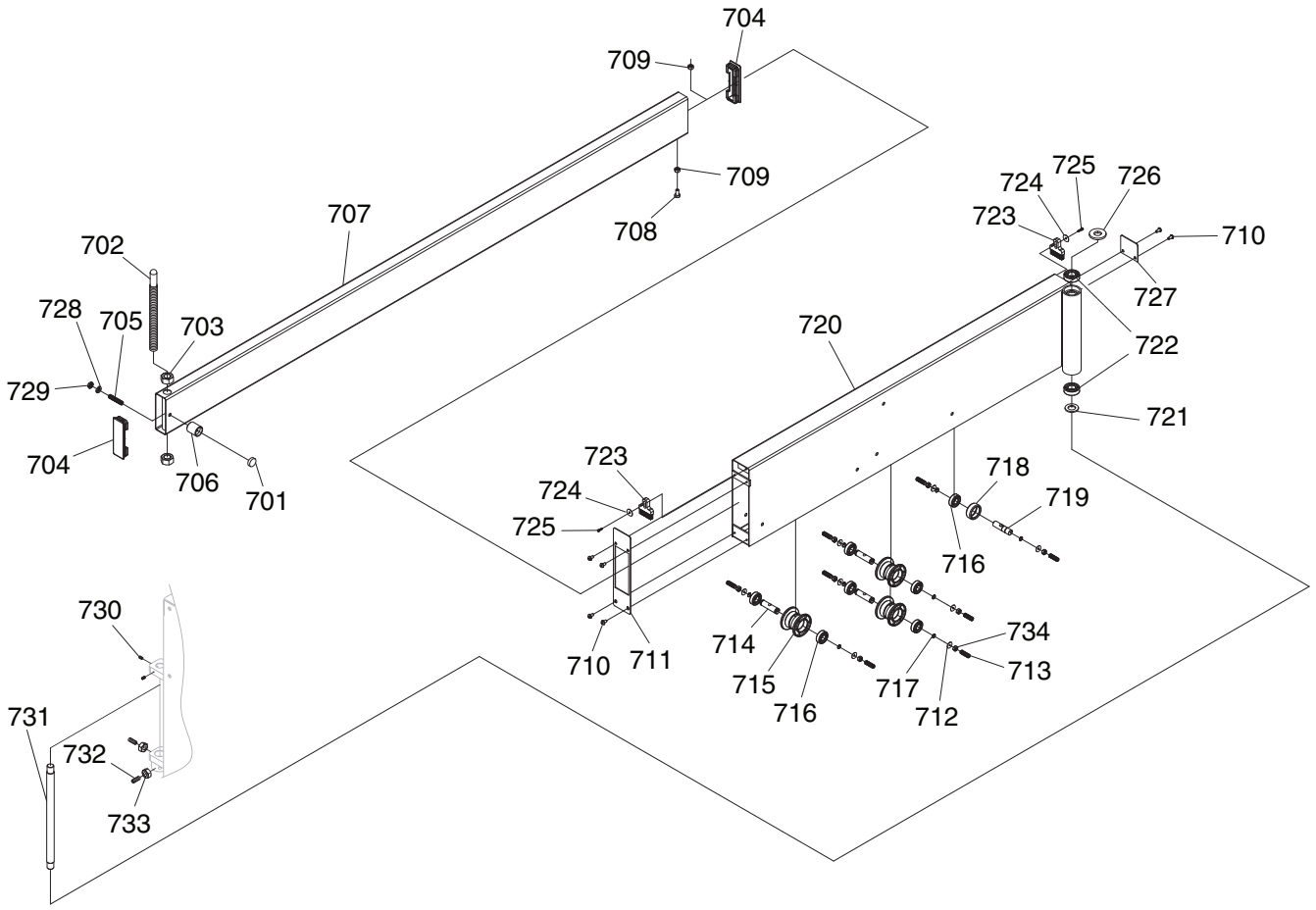
Scoring Blade Adjustment System



REF	PART #	DESCRIPTION
601	PCAP14M	CAP SCREW M8-1.25 X 20
602	PW01M	FLAT WASHER 8MM
603	P06990603	HORIZONTAL ADJUSTMENT SHAFT
604	P06990604	ECCENTRIC SHAFT
605	PLN03M	LOCK NUT M6-1
606	PW03M	FLAT WASHER 6MM
607	P06990607	COMPRESSION SPRING
608	P06990608	PIVOT ARM
609	PW03M	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
610	PLW03M	LOCK WASHER 6MM
611	PCAP01M	CAP SCREW M6-1 X 16
612	P06990612	VERTICAL ADJUSTMENT SHAFT
613	PSS28M	SET SCREW M6-1 X 30
614	PN01M	HEX NUT M6-1
615	PN03M	HEX NUT M8-1.25
616	PRP61M	ROLL PIN 3 X 12
617	P06990617	VERTICAL ADJUSTMENT BOLT

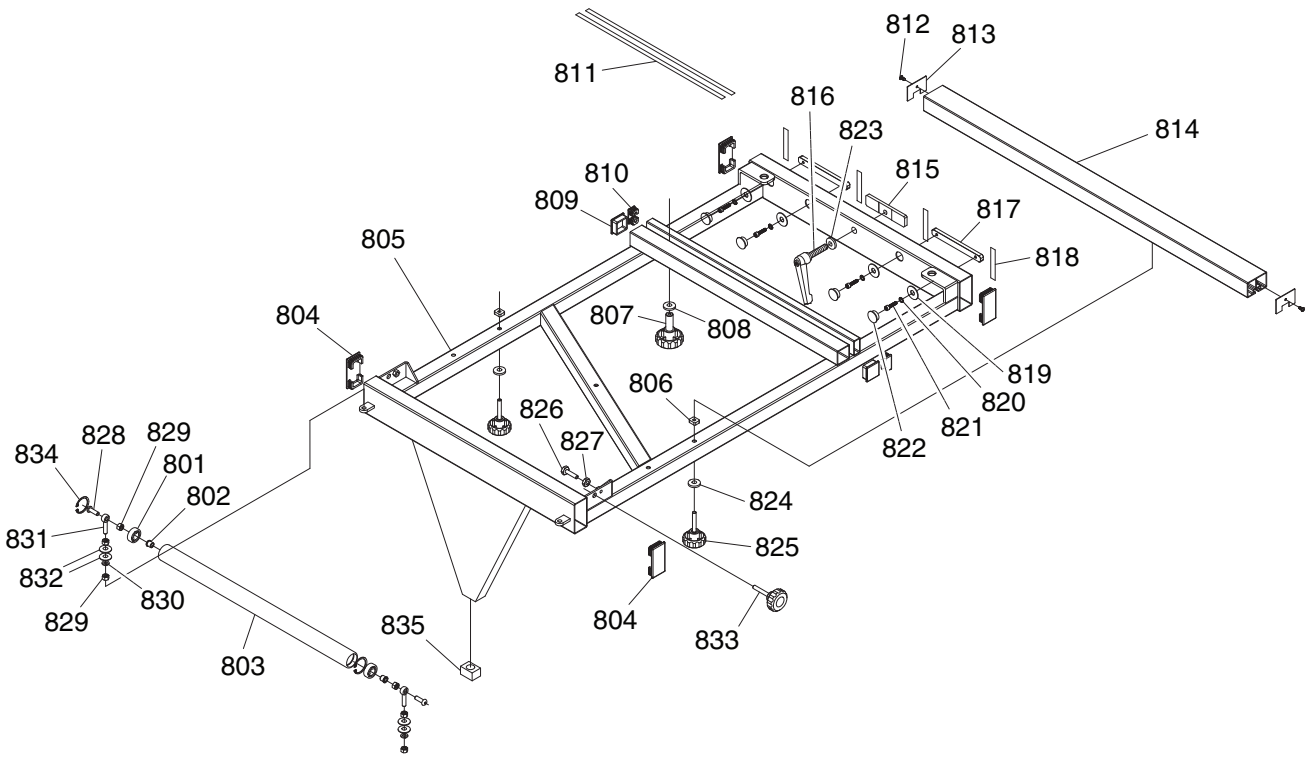
Swing Arm



REF	PART #	DESCRIPTION
701	P06990701	SWING ARM MAGNET
702	P06990702	CROSSCUT PIVOT STUD M20-2.5
703	PN28M	HEX NUT M20-2.5
704	P06990704	END PLUG 40 X 120MM
705	PSS74M	SET SCREW M8-1.25 X 35
706	P06990706	MAGNET HOLDER
707	P06990707	SLIDING TUBE
708	PB09M	HEX BOLT M8-1.25 X 20
709	PN03M	HEX NUT M8-1.25
710	PBHS11M	BUTTON HD CAP SCR M6-1 X 10
711	P06990711	SWING ARM END PLATE
712	PW01M	FLAT WASHER 8MM
713	PSS21M	SET SCREW M8-1.25 X 25
714	P06990714	ROLLER AXLE
715	P06990715	ROLLER
716	P6202ZZ	BALL BEARING 6202ZZ
717	PR05M	EXT RETAINING RING 15MM

REF	PART #	DESCRIPTION
718	P06990718	BEARING SPACER
719	P06990719	BEARING SHAFT
720	P06990720	SWING ARM
721	P06990721	BEARING WASHER
722	P6004ZZ	BALL BEARING 6004ZZ
723	P06990723	BRUSH
724	PW03M	FLAT WASHER 6MM
725	PCAP02M	CAP SCREW M6-1 X 20
726	PW13M	FLAT WASHER 20MM
727	P06990727	BRUSH COVER
728	PLW04M	LOCK WASHER 8MM
729	PN03M	HEX NUT M8-1.25
730	PSS04M	SET SCREW M6-1 X 12
731	P06990731	SWING ARM PIVOT SHAFT
732	PSS10M	SET SCREW M10-1.5 X 20
733	PN02M	HEX NUT M10-1.5
734	PN03M	HEX NUT M8-1.25

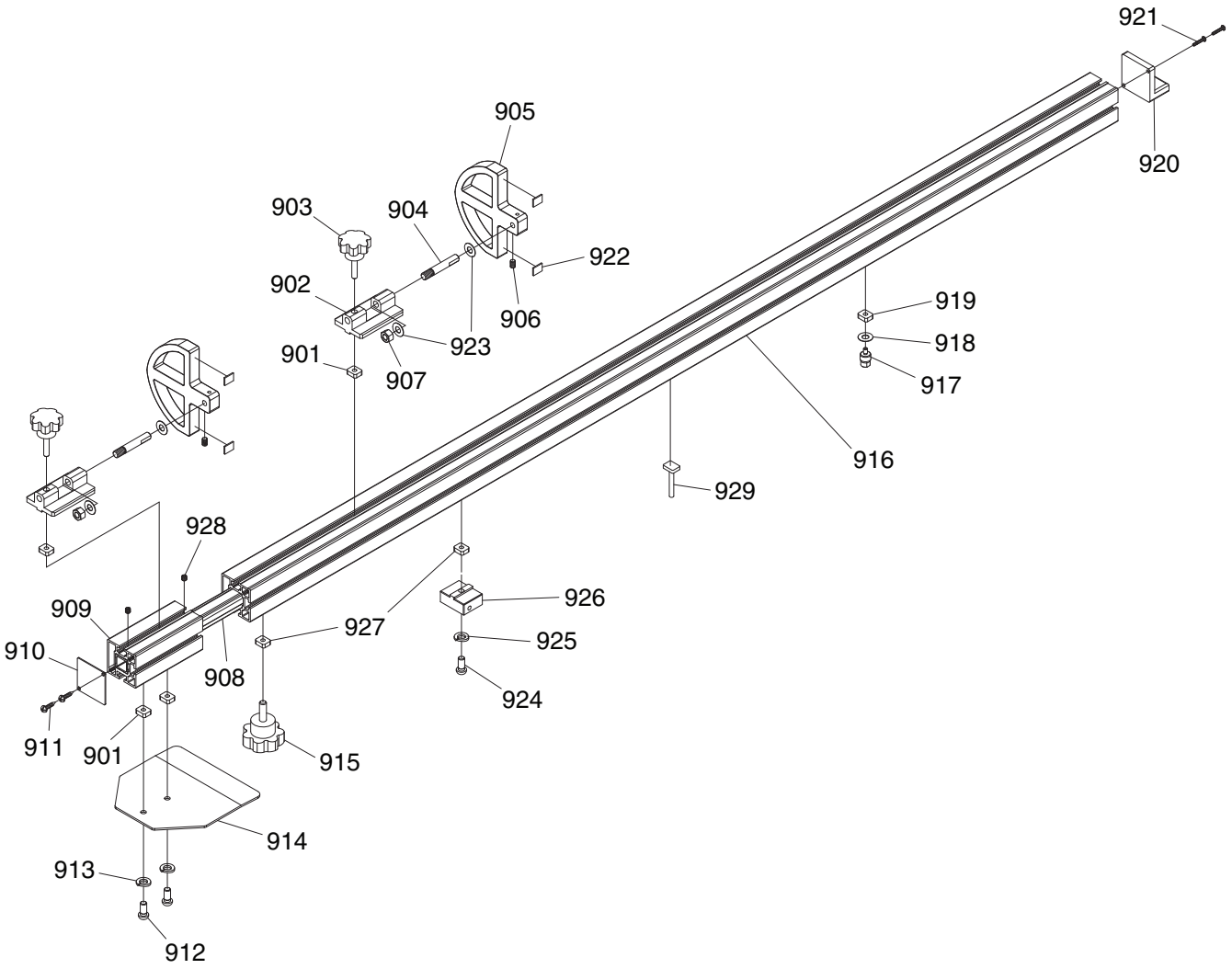
Crosscut Table



REF	PART #	DESCRIPTION
801	P6201ZZ	BALL BEARING 6201ZZ
802	P06990802	SPACER
803	P06990803	ROLLER
804	P06990804	LARGE FRAME END PLUG
805	P06990805	CROSSCUT TABLE FRAME
806	P06990806	T-NUT M8-1.25
807	P06990807	KNOB BOLT M8-1.25 X 25
808	PWF08M	FENDER WASHER 8MM
809	P06990809	MEDIUM FRAME END PLUG
810	P06990810	SMALL FRAME END PLUG
811	P06990811	ANGLE SCALE ASSEMBLY
812	PHTEK7	TAP SCREW #8 X 3/8
813	P06990813	BRACE END PLUG
814	P06990814	CROSSCUT TABLE BRACE
815	P06990815	LOCK T-BAR
816	P06990816	LOCK LEVER ASSEMBLY
817	P06990817	SLIDE T-BAR
818	P06990818	CUSHION

REF	PART #	DESCRIPTION
819	PW03M	FLAT WASHER 6MM
820	PLW03M	LOCK WASHER 6MM
821	PCAP115M	BUTTON HD CAP SCR M6-1 X 16
822	P06990822	PLUG
823	PW06M	FLAT WASHER 12MM
824	PWF08M	FENDER WASHER 8MM
825	P06990825	KNOB BOLT M8-1.25 X 50
826	PB26M	HEX BOLT M8-1.25 X 30
827	PN03M	HEX NUT M8-1.25
828	PBHS23M	BUTTON HD CAP SCR M8-1.25 X 25
829	PN03M	HEX NUT M8-1.25
830	PLW04M	LOCK WASHER 8MM
831	P06990831	ROLLER EYE BOLT M8-1.25 X 40
832	PW01M	FLAT WASHER 8MM
833	P06990825	KNOB BOLT M8-1.25 X 50
834	PR29M	INT RETAINING RING 32MM
835	P06990835	PIVOT BLOCK

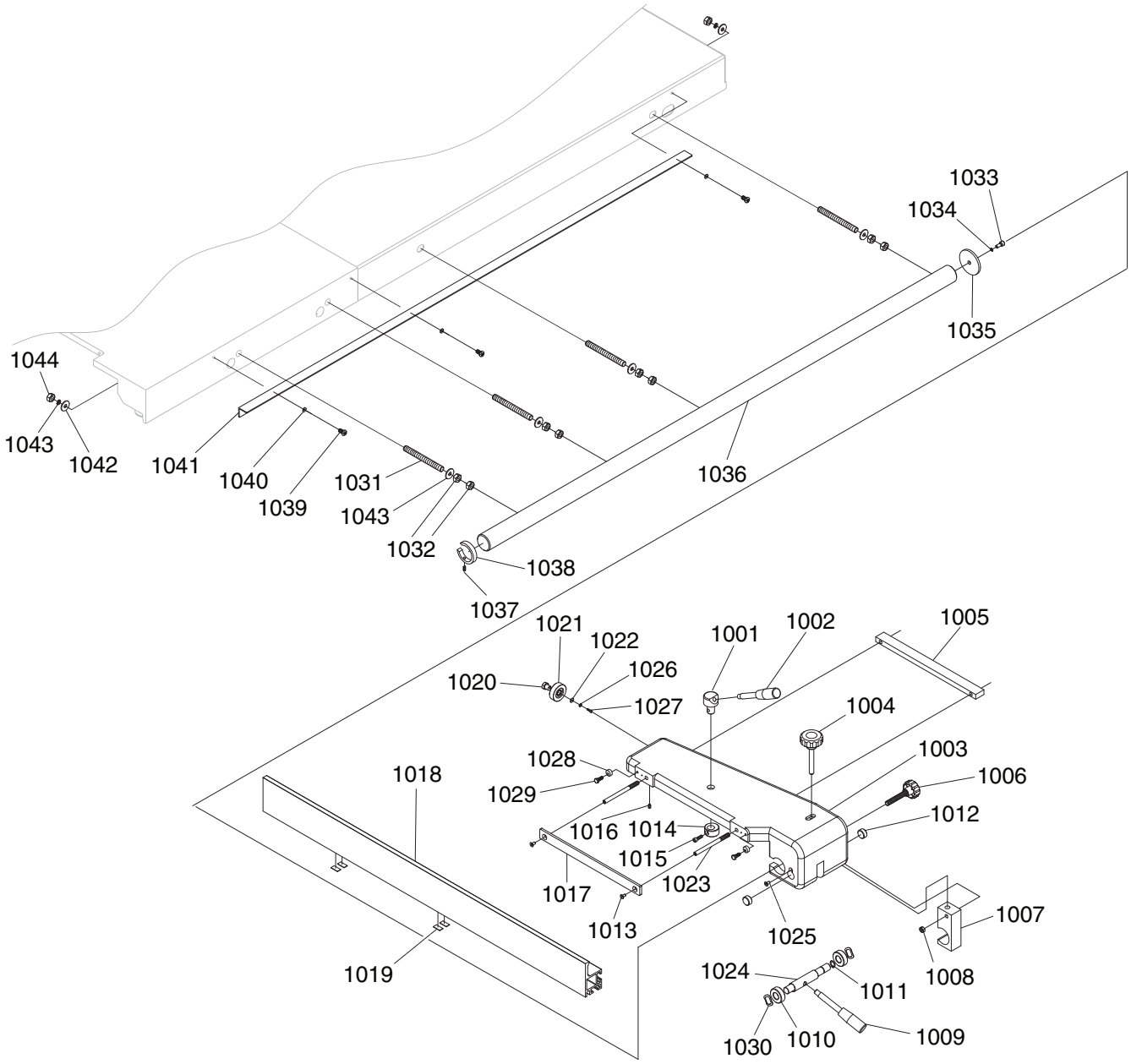
Crosscut Fence



REF	PART #	DESCRIPTION
901	P06990806	T-NUT M8-1.25
902	P06990902	STOP BRACKET
903	P06990903	KNOB BOLT M8-1.25 X 40
904	P06990904	FLIP STOP PIVOT SHAFT
905	P06990905	FLIP STOP
906	PSS16M	SET SCREW M8-1.25 X 10
907	PLN05M	LOCK NUT M10-1.5
908	P06990908	EXTENSION CONNECTOR
909	P06990909	EXTENSION FENCE
910	P06990910	EXTENSION FENCE END PLATE
911	PHTEK15M	TAP SCREW M4 X 10
912	PBHS03M	BUTTON HD CAP SCR M8-1.25 X 16
913	PLW04M	LOCK WASHER 8MM
914	P06990914	SUPPORT PLATE
915	P06990807	KNOB BOLT M8-1.25 X 25

REF	PART #	DESCRIPTION
916	P06990916	CROSSCUT FENCE
917	P06990917	PIVOT SHAFT
918	P06990918	FIBER FLAT WASHER 10MM
919	P06990806	T-NUT M8-1.25
920	P06990920	POLYURETHANE FENCE END PIECE
921	PS38M	PHLP HD SCR M4-.7 X 10
922	P06990922	NYLON PAD
923	P06990923	FIBER FLAT WASHER
924	PCAP40M	CAP SCREW M8-1.25 X 35
925	PLW04M	LOCK WASHER 8MM
926	P06990926	T-BLOCK
927	P06990806	T-NUT M8-1.25
928	PSS02M	SET SCREW M6-1 X 6
929	P06990929	T-BOLT M8-1.25 X 60

Rip Fence

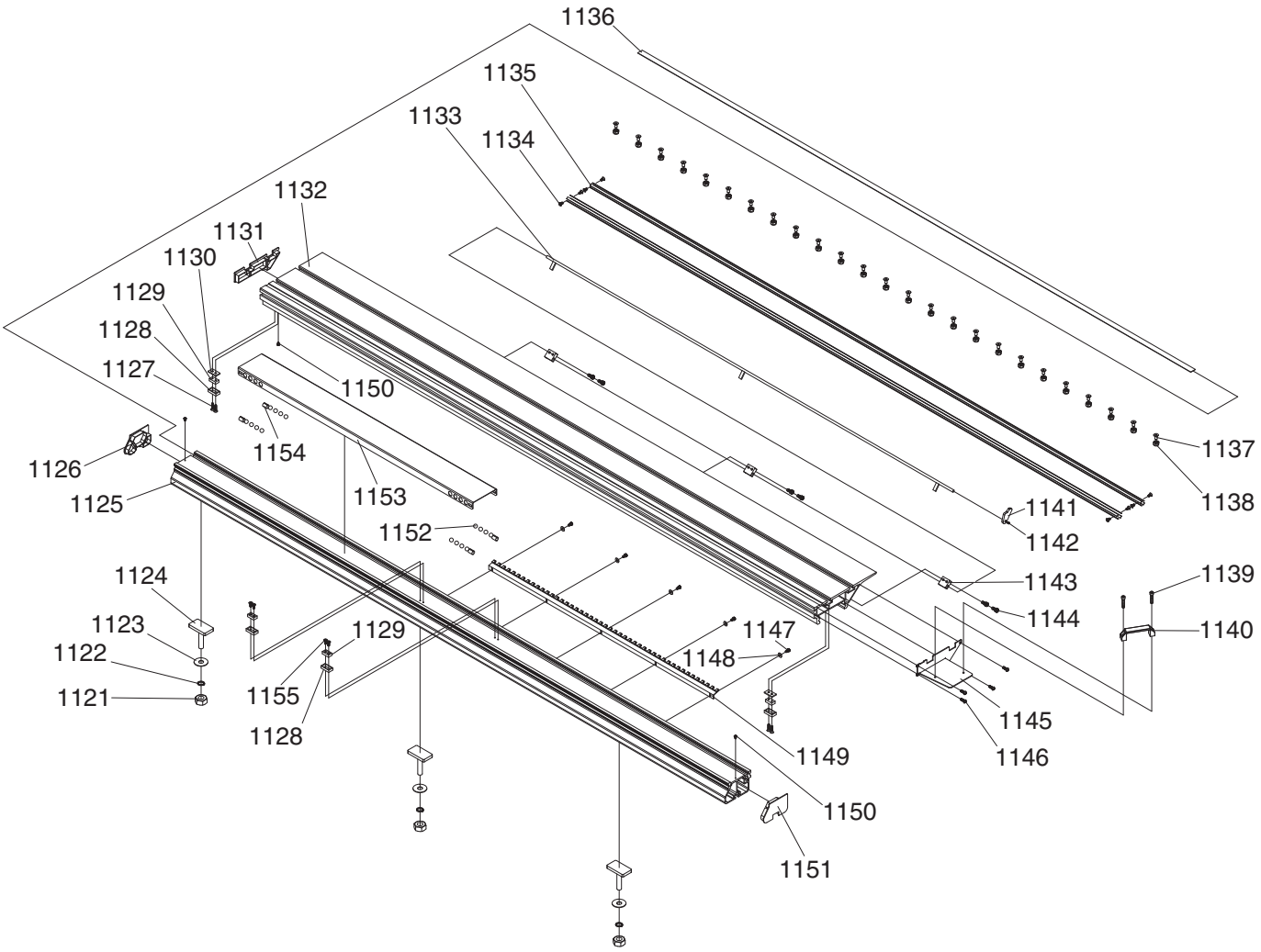


Rip Fence Parts List

REF	PART #	DESCRIPTION
1001	P06991001	FENCE SLIDE LOCK KNOB
1002	P06991002	LOCK KNOB HANDLE
1003	P06991003	RIP FENCE CASTING
1004	P06991004	KNOB BOLT M10-1.25 X 70
1005	P06991005	CASTING SUPPORT BAR
1006	P06991006	MICRO-ADJUST KNOB BOLT
1007	P06991007	FENCE RAIL BRACKET
1008	PLN05M	LOCK NUT M10-1.5
1009	P06991009	LOCK-DOWN HANDLE
1010	P06991010	SHAFT BUSHING
1011	PR05M	EXT RETAINING RING 15MM
1012	P06991012	CASTING PLUG
1013	PFH05M	FLAT HD SCR M5-.8 X 12
1014	P06991014	CLAMP LOCK CAM
1015	PCAP11M	CAP SCREW M8-1.25 X 16
1016	PSS05M	SET SCREW M5-.8 X 10
1017	P06991017	CLAMP PLATE
1018	P06991018	RIP FENCE
1019	P06991019	BEARING PAD
1020	P06991020	ECCENTRIC HEX HEAD SHAFT
1021	P06991021	NYLON ROLLER
1022	PW03M	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
1023	P06991023	ECCENTRIC SHAFT
1024	P06991024	LOCK-DOWN SHAFT
1025	PFH30M	FLAT HD SCR M5-.8 X 8
1026	PLW03M	LOCK WASHER 6MM
1027	PCAP04M	CAP SCREW M6-1 X 10
1028	P06991028	ECCENTRIC RING
1029	PB83M	HEX BOLT M6-1 X 16
1030	P06991030	WAVE WASHER 24MM
1031	P06991031	ALL-THREAD STUD M12-1.75 X 115
1032	PN09M	HEX NUT M12-1.75
1033	PCAP11M	CAP SCREW M8-1.25 X 16
1034	PLW04M	LOCK WASHER 8MM
1035	P06991035	RIP FENCE RAIL END PLATE
1036	P06991036	RIP FENCE RAIL
1037	PSS01M	SET SCREW M6-1 X 10
1038	P06991038	RIP FENCE STOP RING
1039	PCAP115M	BUTTON HD CAP SCR M6-1 X 16
1040	PW03M	FLAT WASHER 6MM
1041	P06991041	RIP FENCE SCALE
1042	PW06M	FLAT WASHER 12MM
1043	PLW05M	LOCK WASHER 12MM
1044	PN09M	HEX NUT M12-1.75

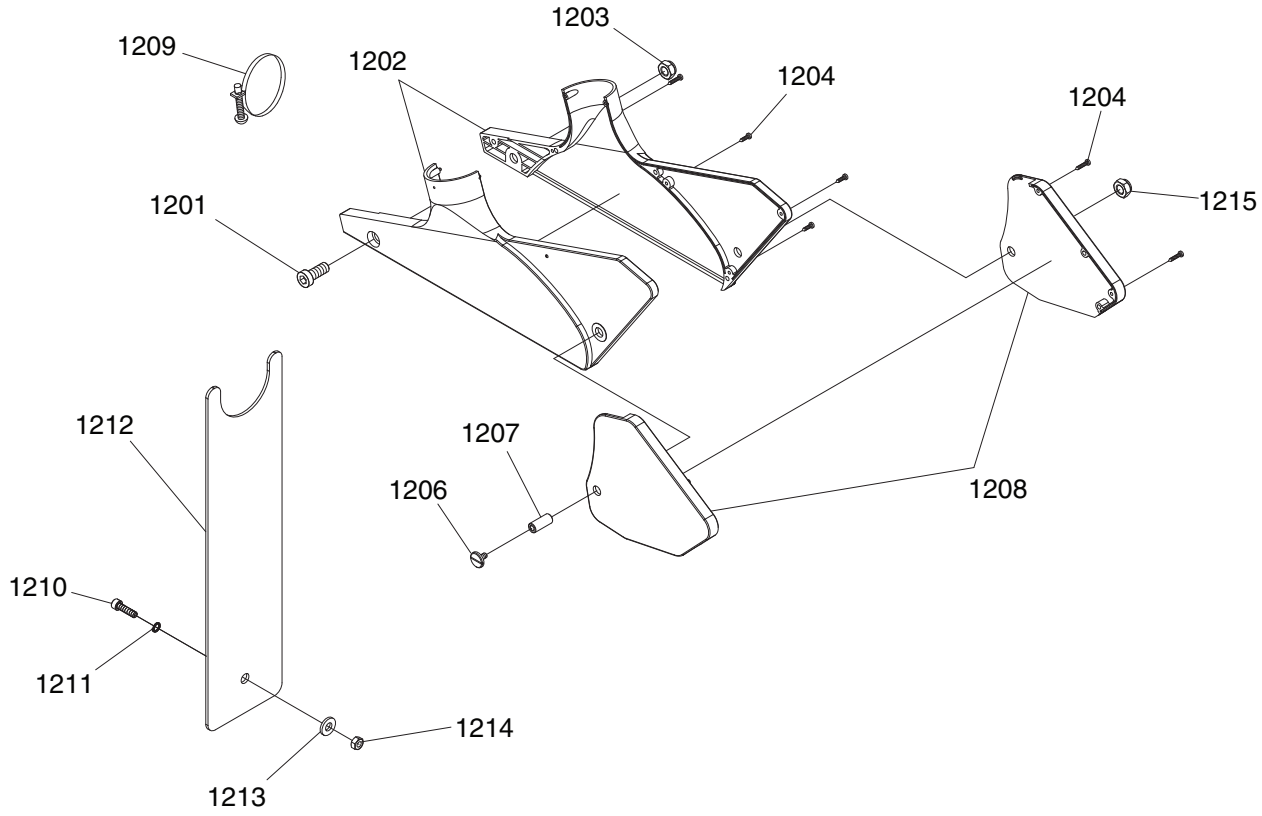
Sliding Table



REF	PART #	DESCRIPTION
1121	PN09M	HEX NUT M12-1.75
1122	PLW05M	LOCK WASHER 12MM
1123	PW06M	FLAT WASHER 12MM
1124	P04931224	T-BOLT M12-1.75 X 40
1125	P04931225	SLIDING TABLE BASE 3200MM
1126	P04931226	BASE LEFT SIDE COVER
1127	PFH26M	FLAT HD SCR M6-1 X 30
1128	P04931228	RUBBER BLOCK
1129	P04931229	LOCATE BLOCK
1130	P04931230	BLOCK PLATE
1131	P04931231	SLIDING TABLE LEFT SIDE COVER
1132	P04931232	SLIDING TABLE 3200MM
1133	P04931233	LOCK ROD
1134	PFH43M	FLAT HD SCR M6-1 X 10
1135	P04931235	SLIDING TABLE WAY
1136	P04931236	COVER STRIP
1137	PFH75M	FLAT HD CAP SCR M10-1.5 X 20
1138	PLN05M	LOCK NUT M10-1.5

REF	PART #	DESCRIPTION
1139	PCAP58M	CAP SCREW M8-1.25 X 12
1140	P04931240	HANDLE
1141	P04931241	LOCK ROD LEVER
1142	PSS31M	SET SCREW M5-.8 X 8
1143	P04931243	GUIDE BLOCK
1144	PCAP11M	CAP SCREW M8-1.25 X 16
1145	P04931245	HANDLE PLATE
1146	PBHS06M	BUTTON HD CAP SCR M5-.8 X 12
1147	PCAP04M	CAP SCREW M6-1 X 10
1148	PW03M	FLAT WASHER 6MM
1149	P04931249	LOCK PLATE
1150	PHTEK19M	TAP SCREW M5 X 16
1151	P04931251	BASE RIGHT SIDE COVER
1152	P04931252	HARDENED STEEL BALL 6MM
1153	P04931253	SLIDE PLATE
1154	P04931254	WOOL PAD
1155	PFH38M	FLAT HD SCR M6-1 X 16

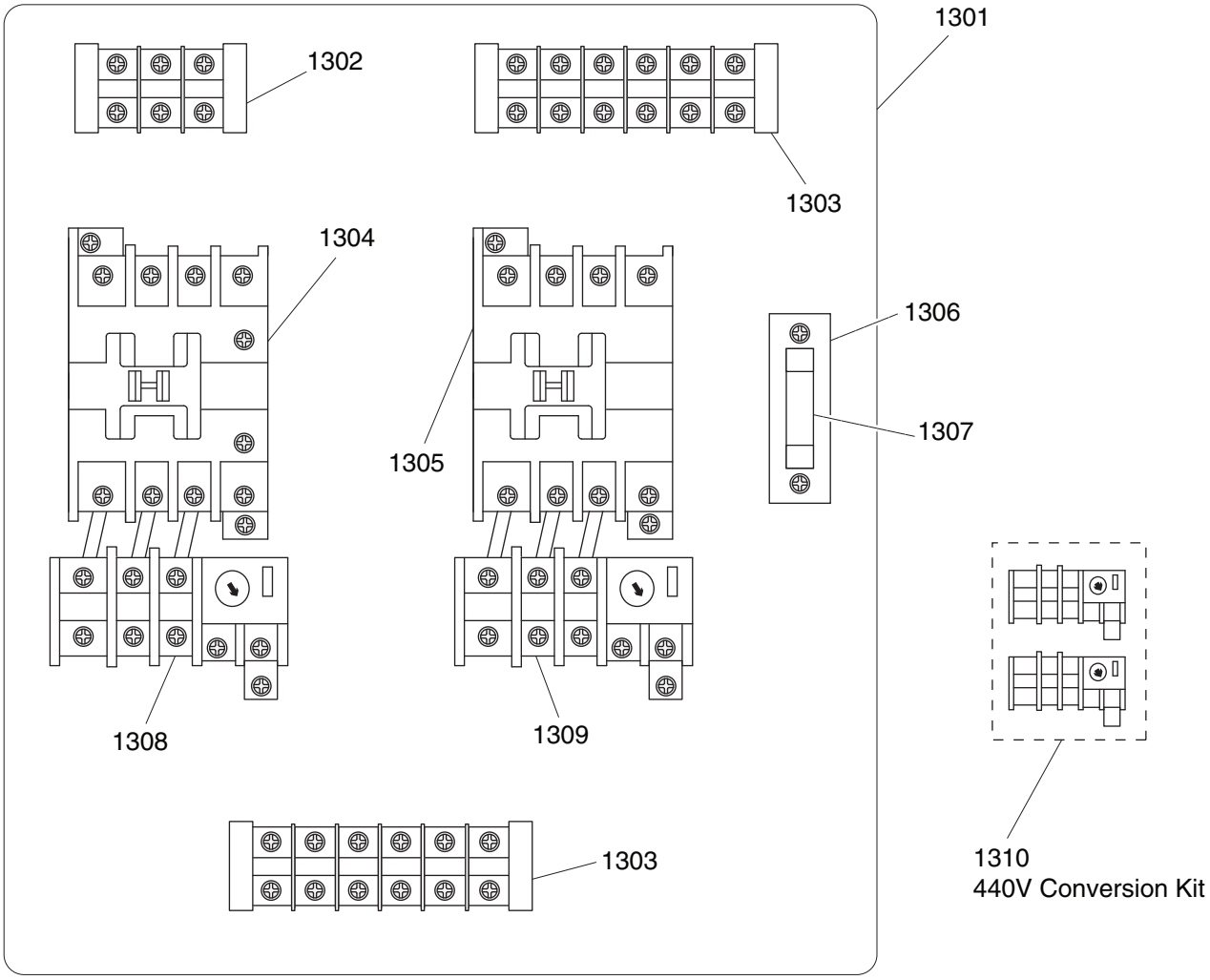
Blade Guard



REF	PART #	DESCRIPTION
1201	PCAP64M	CAP SCREW M10-1.5 X 25
1202	P06991202	MAIN BLADE GUARD 2-PC
1203	PLN05M	LOCK NUT M10-1.5
1204	PHTEK34M	TAP SCREW M3 X 16
1206	P06991206	PIVOT SCREW M5-.8 X 10
1207	P06991207	PIVOT SLEEVE
1208	P06991208	SCORING BLADE GUARD 2-PC

REF	PART #	DESCRIPTION
1209	P06991209	HOSE CLAMP 2-1/2"
1210	PCAP64M	CAP SCREW M10-1.5 X 25
1211	PLW06M	LOCK WASHER 10MM
1212	P06991212	DUST HOSE SUPPORT PLATE
1213	PW04M	FLAT WASHER 10MM
1214	PLN05M	LOCK NUT M10-1.5
1215	PLN02M	LOCK NUT M5-.8

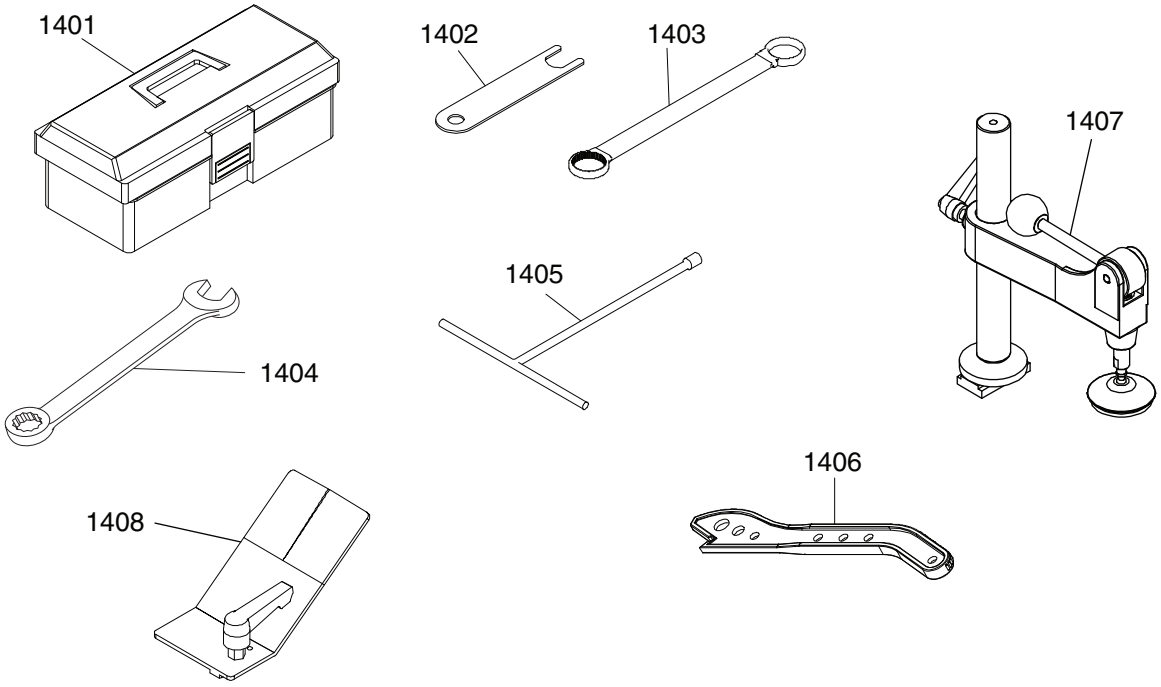
Electrical Cabinet



REF	PART #	DESCRIPTION
1301	P06991301	ELECTRICAL CABINET BACK PLATE
1302	P06991302	TERMINAL BAR 3-POST
1303	P06991303	TERMINAL BAR 6-POST
1304	P06991304	CONTACTOR SDE MA-18 220V
1305	P06991305	CONTACTOR SDE MA-09 220V

REF	PART #	DESCRIPTION
1306	P06991306	FUSE HOLDER
1307	P06991307	FUSE 3A
1308	P06991308	OL RELAY SDE RA-30 18-26A
1309	P06991309	OL RELAY SDE RA-20 1.7-4.4A
1310	P06991310	440V CONVERSION KIT

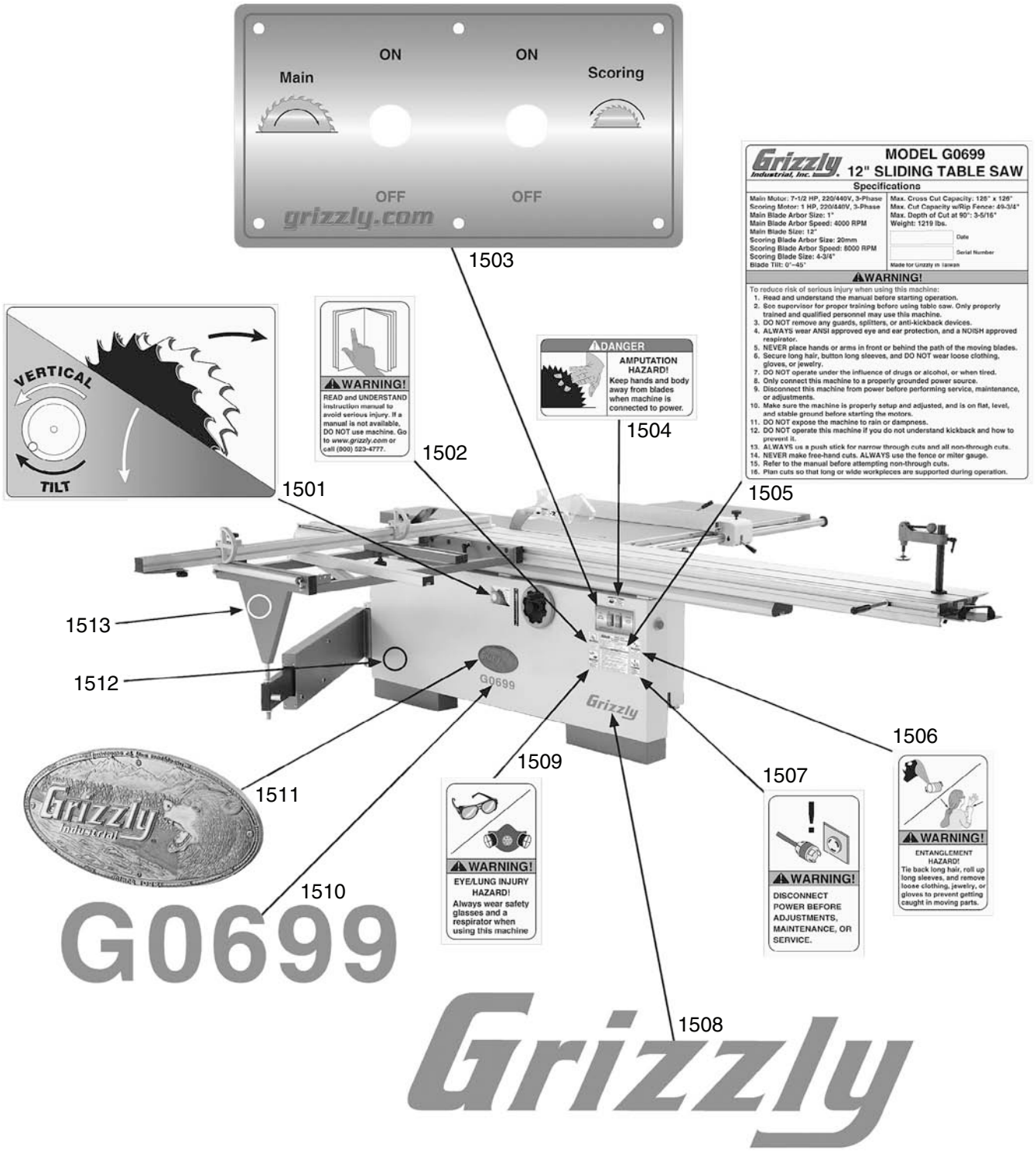
Accessories



REF	PART #	DESCRIPTION
1401	P06991401	TOOL BOX
1402	P06991402	SCORING ARBOR WRENCH
1403	PWR1719	WRENCH 17/19MM
1404	P06991404	WRENCH 30MM

REF	PART #	DESCRIPTION
1405	P06991405	T-HANDLE WRENCH 8MM
1406	P06991406	PUSH STICK
1407	P06991407	HOLD-DOWN ASSEMBLY
1408	P06991408	EDGE SHOE ASSEMBLY

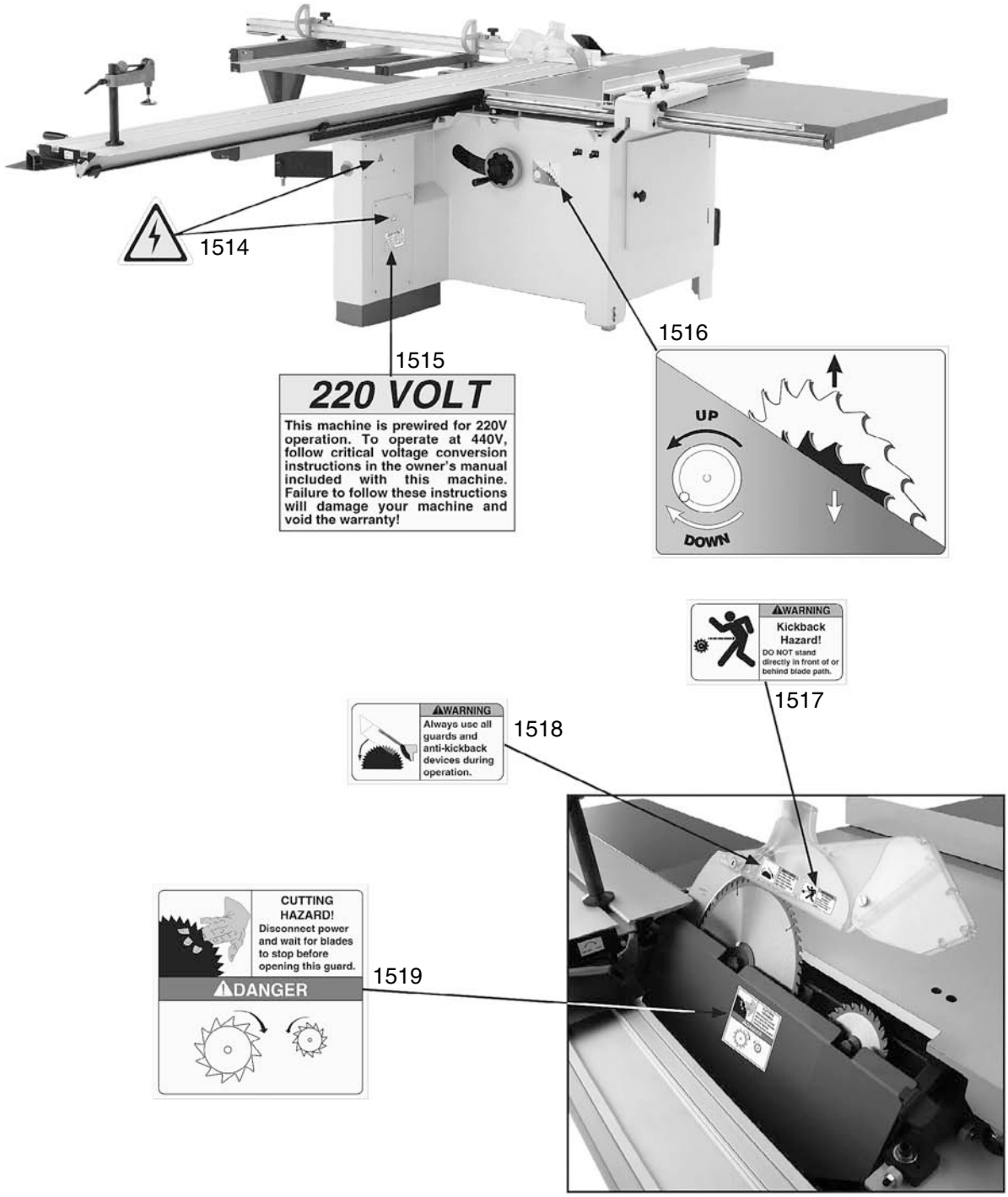
Front Machine Labels



⚠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.

Rear & Blade Guard Machine Labels



REF	PART #	DESCRIPTION
1501	P06991501	SAW BLADE TILT LABEL
1502	PLABEL-12A	READ MANUAL LABEL
1503	P06991503	CONTROL PANEL LABEL
1504	PLABEL-60B	AMPUTATION HAZARD LABEL
1505	P06991505	MACHINE ID LABEL
1506	PLABEL-55	ENTANGLEMENT HAZARD LABEL
1507	PLABEL-63	DISCONNECT POWER LABEL
1508	P06991508	GRIZZLY LABEL
1509	PLABEL-57	EYE/LUNG HAZARD LABEL
1510	P06991510	MODEL NUMBER LABEL

REF	PART #	DESCRIPTION
1511	G8589	GRIZZLY OVAL NAMEPLATE
1512	PPAINT-11	GRIZZLY PUTTY TOUCH-UP PAINT
1513	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
1514	PLABEL-14	ELECTRICITY LABEL
1515	P06991515	PREWIRED 220V LABEL
1516	P06991516	SAW BLADE ELEVATION LABEL
1517	P06991517	KICKBACK HAZARD LABEL
1518	P06991518	BLADE GUARD WARNING LABEL
1519	P06991519	CUTTING HAZARD LABEL

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

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

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

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

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

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

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

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

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

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

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

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

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

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