

# *Grizzly* *Industrial, Inc.*®

## MODEL G1010 4" x 6" METAL-CUTTING BANDSAW

### INSTRUCTION MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**  
#PC5506 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

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## Foreword

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We are proud to offer the Model G1010 4" x 6" Metal-Cutting Bandsaw. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G1010. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G1010 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

## Contact Info

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

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

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

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





# MACHINE DATA SHEET

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

## MODEL G1010 4" X 6" METAL CUTTING BANDSAW

### Product Dimensions:

Weight ..... 108 lbs.  
Length/Width/Height ..... 38 x 15 x 55 in.  
Foot Print (Length/Width) ..... 29 x 12 in.

### Shipping Dimensions:

Type ..... Cardboard  
Content ..... Machine  
Weight ..... 112 lbs.  
Length/Width/Height ..... 38 x 13 x 15 in.

### Electrical:

Switch ..... Automatic Shut Off  
Switch Voltage ..... 110  
Cord Length ..... 6 ft.  
Cord Gauge ..... 18 gauge  
Plug ..... Yes

### Motors:

#### Main

Type ..... TEFC Capacitor Start Induction  
Horsepower ..... 1/2  
Voltage ..... 110/220  
Prewired ..... 110  
Phase ..... Single  
Amps ..... 9/4.5  
RPM ..... 1720  
Cycle ..... 60  
Number Of Speeds ..... 1  
Power Transfer ..... Belt Drive  
Bearings ..... Shielded and Lubricated for Life

### Main Specifications:

#### Operation Info

Blade Speeds ..... 80, 120, 220 FPM  
Std. Blade Len ..... 64-1/2 in.



### Cutting Capacities

Angle Cuts .....	45 - 90 deg.
Vise Jaw Depth .....	7-7/8 in.
Vise Jaw Height .....	2-1/2 in.
Max. Capacity Rect. Height At 90D .....	4 in.
Max. Capacity Rect. Width At 90D .....	6 in.
Max. Capacity Rnd. At 90D .....	4-1/2 in.
Max. Capacity Rect. Height At 45D .....	5 in.
Max. Capacity Rect. Height At 30D .....	5 in.
Max. Capacity Rect. Width At 30D .....	4-3/4 in.
Max. Capacity Rnd. At 30D .....	4-3/4 in.
Max. Capacity Rect. Width At 45D .....	3 in.
Max. Capacity Rnd. At 45D .....	3 in.

### Construction

Table Construction .....	Precision Ground Cast Iron
Wheel Construction Upper .....	Cast Iron
Wheel Construction Lower .....	Cast Iron
Body Construction .....	Cast Iron
Stand Construction .....	Sheet Metal
Wheel Cover Construction .....	Pre-formed Steel
Paint .....	Epoxy

### Other

Wheel Size .....	7-1/2 in.
Blade Guides Upper .....	Ball Bearing
Blade Guides Lower .....	Ball Bearing

### Table Info

Table Size Length .....	9-5/8 in.
Table Size Width .....	9-1/2 in.
Floor To Cutting Area Height .....	32-1/2 in.

### Other Specifications:

ISO Factory .....	ISO 9001
Country Of Origin .....	Taiwan
Warranty .....	1 Year
Serial Number Location .....	Machine Label on Body Frame
Assembly Time .....	30 minutes

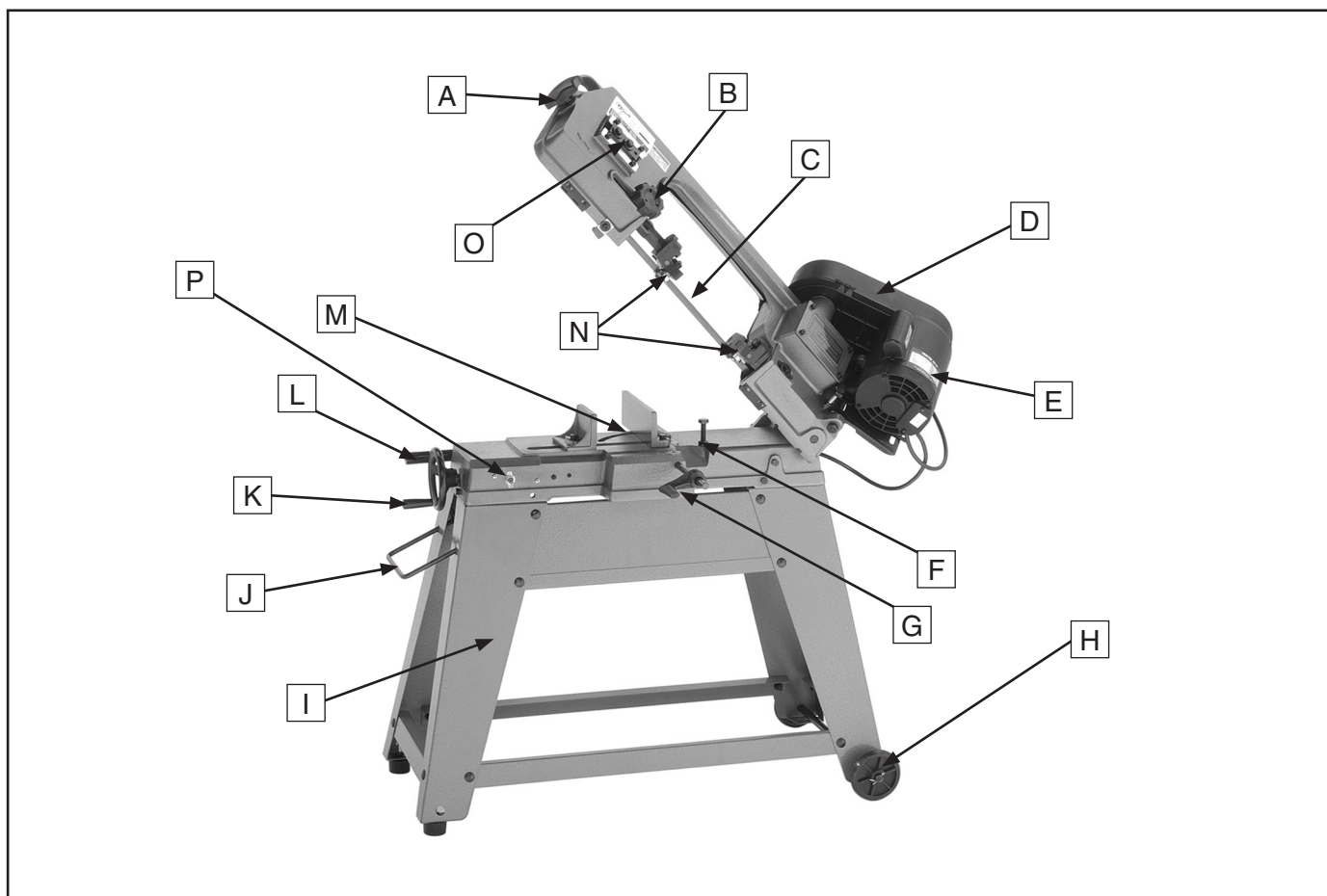
### Features:

- Vertical Position Work Table
- Stop for Stock
- Wheels for Moving Machine
- Includes Blade

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



# Identification



**Figure 1.** Main view of machine features.

- |                                      |                                   |
|--------------------------------------|-----------------------------------|
| <b>A.</b> Blade Tension Knob         | <b>I.</b> Bandsaw Stand           |
| <b>B.</b> Guide Post Adjustment Knob | <b>J.</b> Transport Handle        |
| <b>C.</b> Blade                      | <b>K.</b> Vise Handwheel          |
| <b>D.</b> Pulley Cover               | <b>L.</b> Feed Control Handle     |
| <b>E.</b> ½ HP Motor                 | <b>M.</b> Vise                    |
| <b>F.</b> Horizontal Stop            | <b>N.</b> Blade Guides            |
| <b>G.</b> Work Stop                  | <b>O.</b> Blade Tracking Controls |
| <b>H.</b> Wheels                     | <b>P.</b> ON/OFF Switch           |



# SECTION 1: SAFETY


## WARNING

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

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

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

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

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

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

## WARNING

### Safety Instructions for Machinery

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

# WARNING

## Safety Instructions for Machinery

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



## **WARNING**

# Safety Instructions for Metal-Cutting Bandsaws

- 1. BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.
- 2. HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Serious personal injury could occur.
- 3. GUARDS.** Do not operate this bandsaw without blade guard in place.
- 4. BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Make sure the blade is properly tensioned after installing.
- 5. WORKPIECE HANDLING.** Always support the workpiece with table, vise, or some type of support fixture. Never hold the workpiece with your hands during a cut.
- 6. BLADE SPEED.** Blade should be running at full speed and the feed rate set before beginning a cut.
- 7. FEED RATE.** Always determine feed rate before the cut is started. Do not increase feed rate while cutting, especially when sawing small diameter tubes and rods.
- 8. MATERIAL.** This machine is designed to cut metal only. Not all metals react the same when cutting. Know the material you are working with before cutting.
- 9. CUTTING FLUID SAFETY.** For saws designed to use cutting fluid, always follow manufacturer's cutting-fluid safety instructions on use, storage, maintenance, and disposal.
- 10. LEAVING WORK AREA.** Never leave a machine running and unattended. Allow the bandsaw to come to a complete stop before you leave it unattended.
- 11. MAINTENANCE/SERVICES.** All inspections, adjustments, and maintenance are to be done with the power **OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
- 12. HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
- 13. 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**

Like all machines there is danger associated with the Model G1010. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## **CAUTION**

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



# SECTION 2: CIRCUIT REQUIREMENTS

## 110/220V Operation

### **⚠️ WARNING**

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

### Amperage Draw

The Model G1010 features a 1/2 HP 110/220V motor that is prewired at 110V.

Motor Draw at 110V ..... 9 Amps  
Motor Draw at 220V ..... 4.5 Amps

### Circuit Requirements

Only connect your machine to a circuit that meets the requirements below. Always check to see if the wires and circuit breaker in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

110V Circuit ..... 15 Amp  
220V Circuit ..... 15 Amp

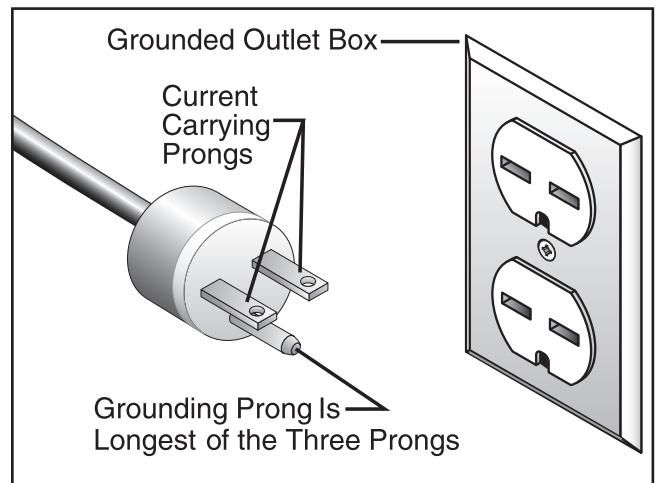
## Wiring for 220V

The Model G1010 can be rewired to operate on a 220V power source. The motor must be rewired according to the wiring diagram on the motor label. The wiring configuration can also be found on the inside of the motor wire cover, as well as on **Page 38**.

### Plug Type

The Model G1010 comes prewired with a NEMA 5-15 plug. If you wish to rewire the motor to 220V you will need the following 220V plug (see **Figure 2** for an example):

220V Plug & Receptacle ..... 6-15

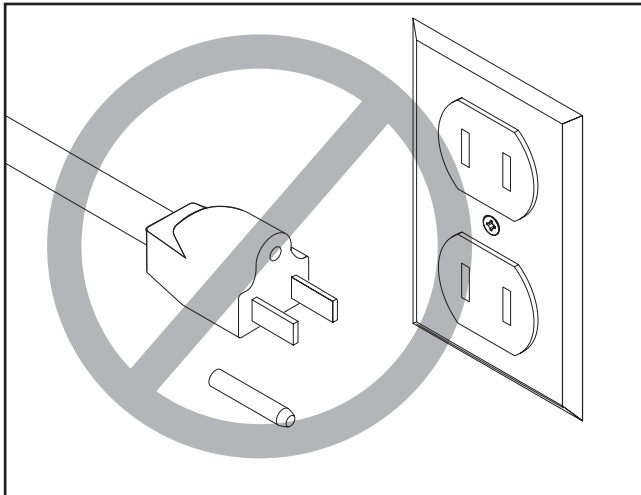
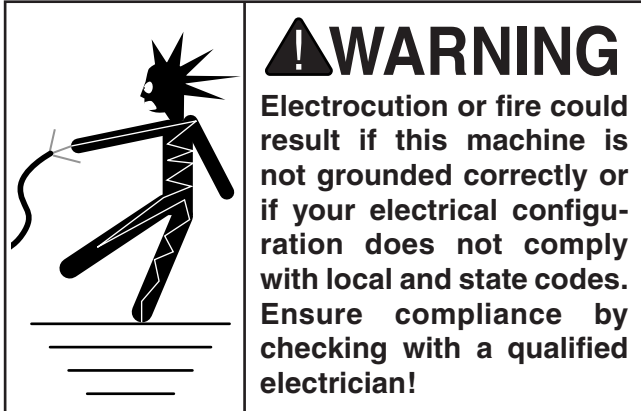


**Figure 2.** 6-15 plug and outlet.



# Grounding

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



## **! CAUTION**

This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

# Extension Cords

## 110V Operation

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

If you find it absolutely necessary to use an extension cord at 110V with your machine:

- Use at least a 16 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.

## 220V Operation

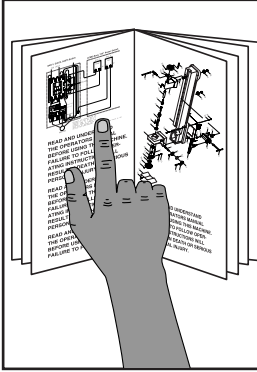
We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

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

- Use at least a 16 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.

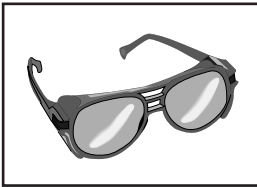
# SECTION 3: SET UP

## Set Up Safety



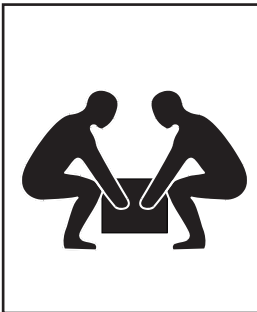
### **!WARNING**

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 set up process!



### **!WARNING**

The Model G1010 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

## Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Wrench 12mm.....	1
• Wrench or Socket 14mm.....	1
• Safety Glasses (for each person) .....	1
• Pliers .....	1
• Phillips Head Screwdriver #2 .....	1
• Level.....	1
• An Assistant .....	1
• Square.....	1
• Wrench 1/2".....	1
• Wrench 7/16".....	1
• Wrench 9/16".....	1

## Unpacking

The Model G1010 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advise.*

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

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



# Inventory

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

Box Contents (Figure 3)	Qty
A. Table.....	1
B. Upper Stand Support .....	1
C. Legs.....	4
D. Long Leg Braces .....	2
E. Short Leg Braces .....	2
F. Tool Tray .....	1
G. Work Stop Shaft .....	1
H. Wheels .....	2
I. Transport Handle.....	1
J. Vise Handwheel .....	1
K. Pulley Cover .....	1
L. Rubber Feet $\frac{3}{8}$ "-16 x $1\frac{1}{4}$ " .....	2
M. Work Stop.....	1
N. V-Belt.....	1
O. Bracket .....	1
P. Handwheel Handle .....	1

## Items not shown:

Metal-Cutting Bandsaw .....	1
Blade $\frac{3}{4}$ " x .032" x 85" .....	1
Axle .....	1

## Hardware Bag .....

—Cotter Pins .....	4
—Hex Wrench 4mm .....	1
—Carriage Bolts $\frac{5}{16}$ "-18 x $\frac{3}{4}$ " .....	14
—Hex Bolts $\frac{5}{16}$ "-18 x 1" .....	8
—Pan Head Screw $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " .....	2
—Flat Head Screw $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " .....	1
—Hex Nuts $\frac{5}{16}$ -18.....	22
—Hex Nuts $\frac{3}{8}$ -16.....	4
—Hex Nut $\frac{1}{4}$ -20.....	1
—Flat Washers $\frac{5}{16}$ " .....	30
—Tap Screw $\frac{3}{4}$ " .....	1
—Flat Washers $\frac{3}{8}$ " .....	4
—Flat Washers $\frac{5}{8}$ " .....	4

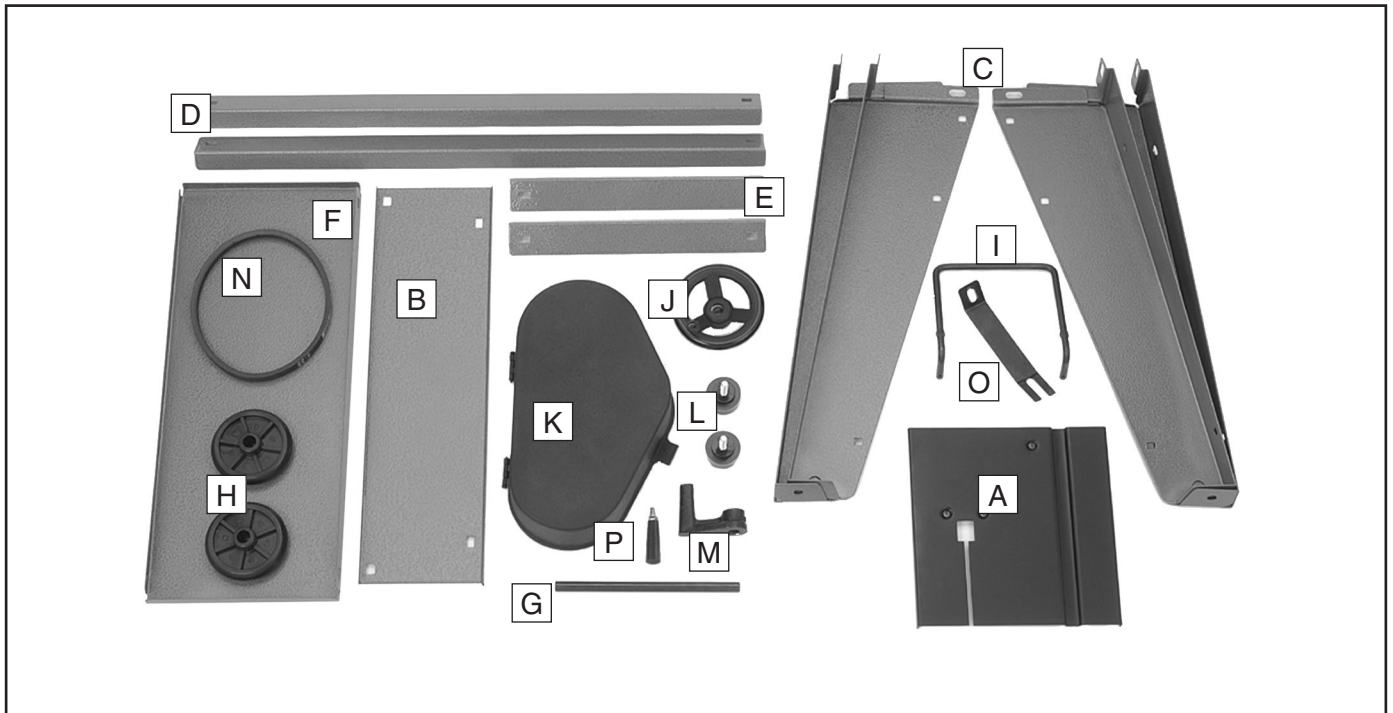


Figure 3. Loose parts inventory.

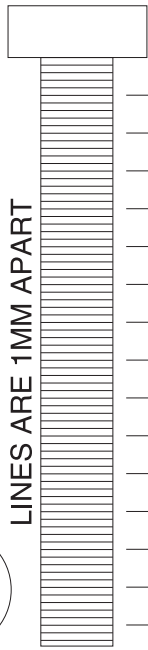
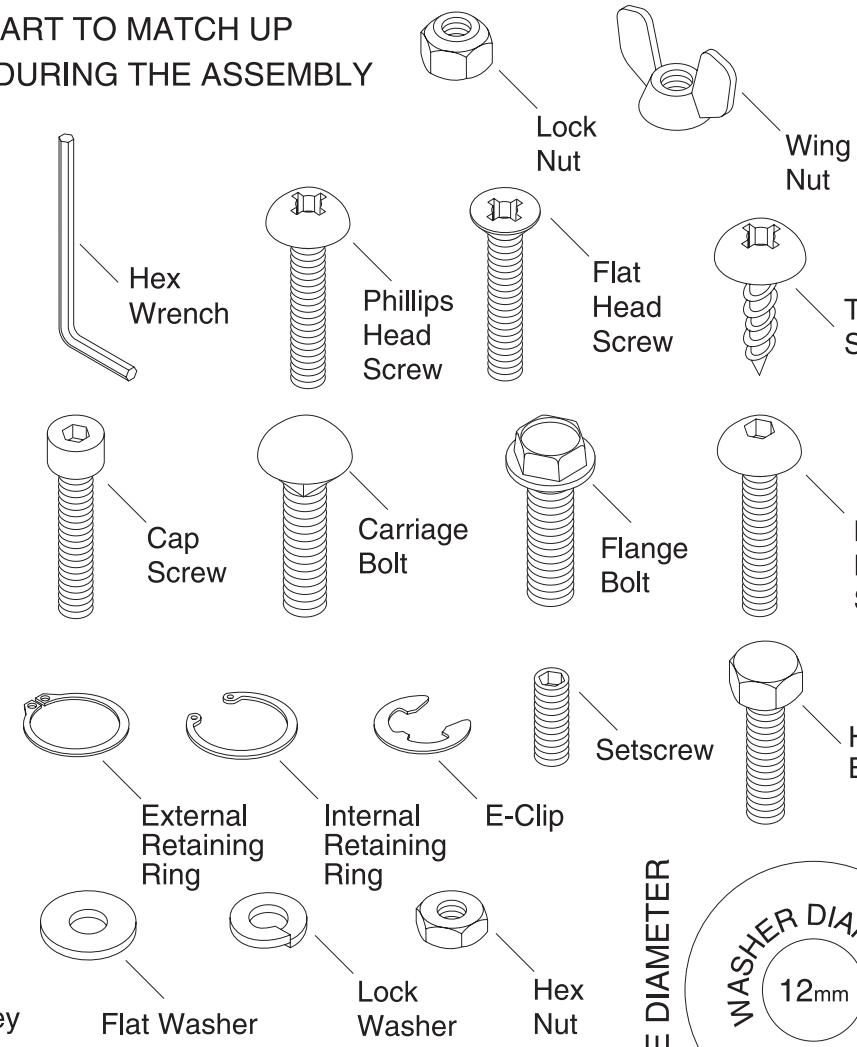
# Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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

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

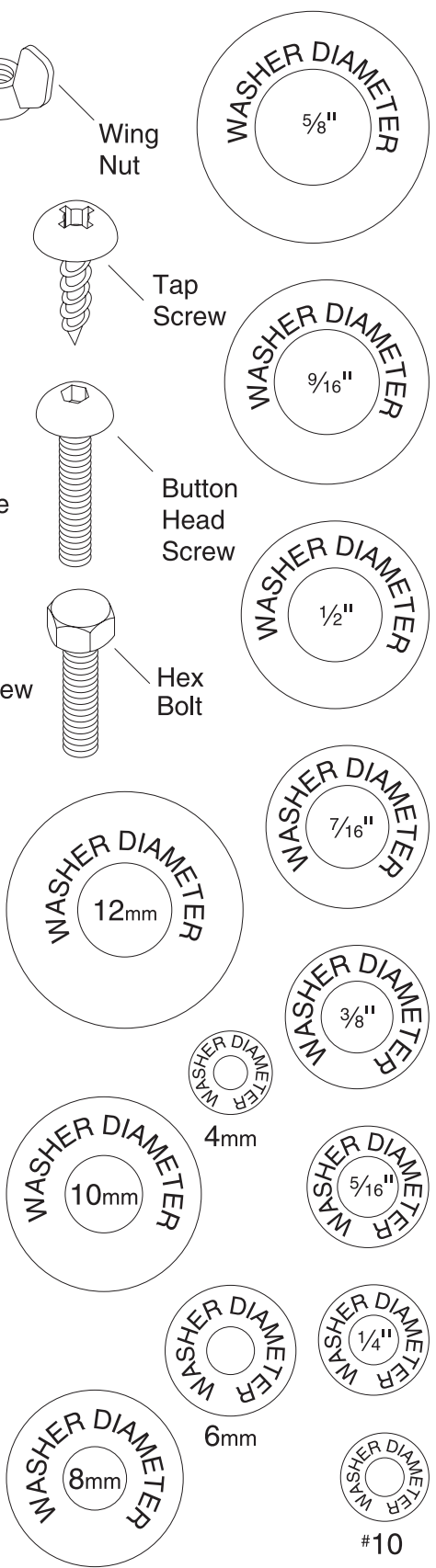


- 5mm
- 10mm
- 15mm
- 20mm
- 25mm
- 30mm
- 35mm
- 40mm
- 45mm
- 50mm
- 55mm
- 60mm
- 65mm
- 70mm
- 75mm



- 1/4"
- 3/8"
- 1/2"
- 5/8"
- 5/16"
- 7/16"
- 9/16"
- 3/4"
- 7/8"
- 1"
- 1 1/4"
- 1 1/2"
- 1 3/4"
- 2"
- 2 1/4"
- 2 1/2"
- 2 3/4"
- 3"


WASHERS ARE MEASURED BY THE INSIDE DIAMETER

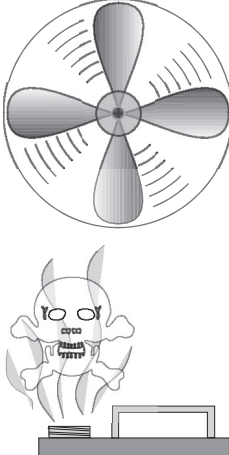




# Clean Up

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

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

## Floor Load

The weight and footprint size for your machine is located in the machine data sheet. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

## Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

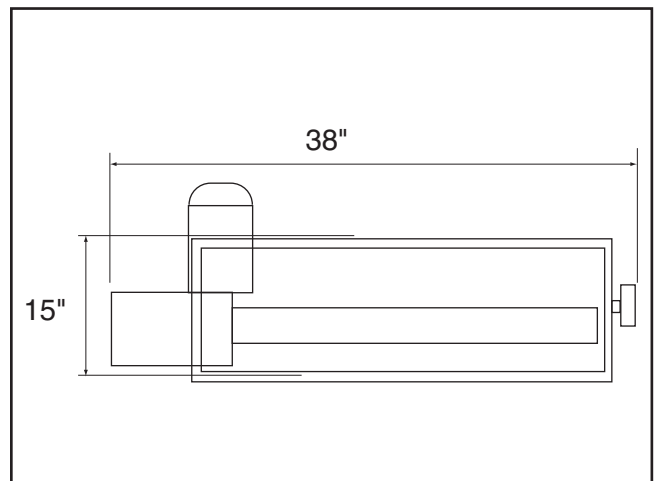


Figure 4. Minimum G1010 working clearances.

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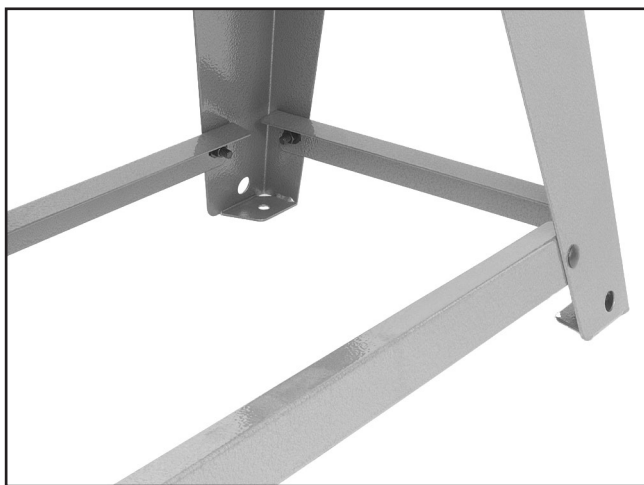
# Stand Assembly

Components and Hardware Needed:	Qty
Carriage Bolts $\frac{5}{16}$ "-18 x $\frac{3}{4}$ " .....	14
Hex Nuts $\frac{5}{16}$ -18 .....	14
Flat Washers $\frac{5}{16}$ " .....	14
Legs .....	4
Long Leg Braces .....	2
Short Leg Braces .....	2
Upper Stand Support .....	1
Tool Tray .....	1
Axle .....	1
Wheels .....	2
Cotter Pins .....	4
Transport Handle .....	1
Rubber Feet .....	2
Flat Washers $\frac{3}{8}$ " .....	4
Hex Nuts $\frac{3}{8}$ "-16 .....	4
Flat Washers $\frac{5}{8}$ " .....	4

## To assemble the stand:

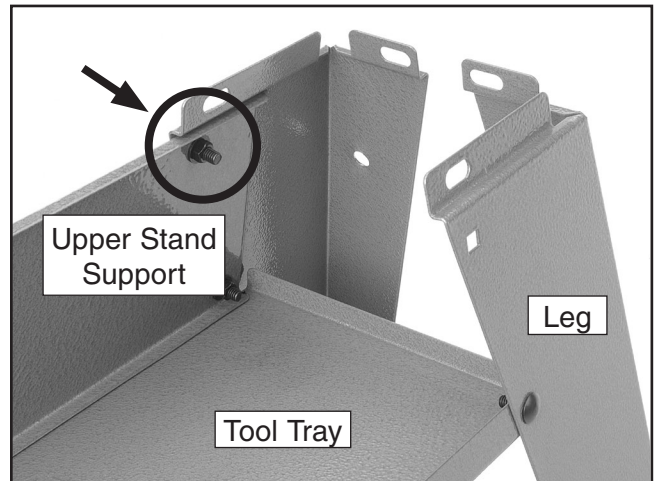
1. Attach the short leg braces and then the long leg braces to the legs with carriage bolts, washers and hex nuts as shown in **Figure 5**.

**Note:** At this time, tighten with a 12mm wrench or socket just enough to secure the parts. Final tightening will take place when the stand is fully assembled.



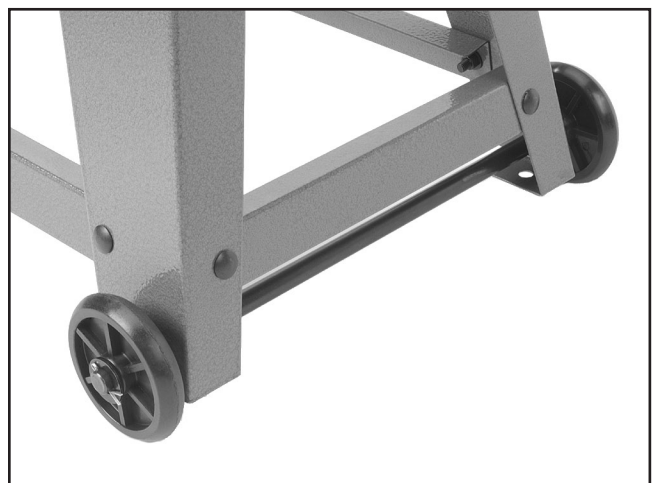
**Figure 5.** Leg braces.

2. Secure the upper stand support to the inside of the legs using the carriage bolts. Start by securing the upper carriage bolt highlighted in **Figure 6**.
3. Attach the tool tray to the legs as shown in **Figure 6**. One side of the tool tray will share the lower carriage bolt of the upper stand support.



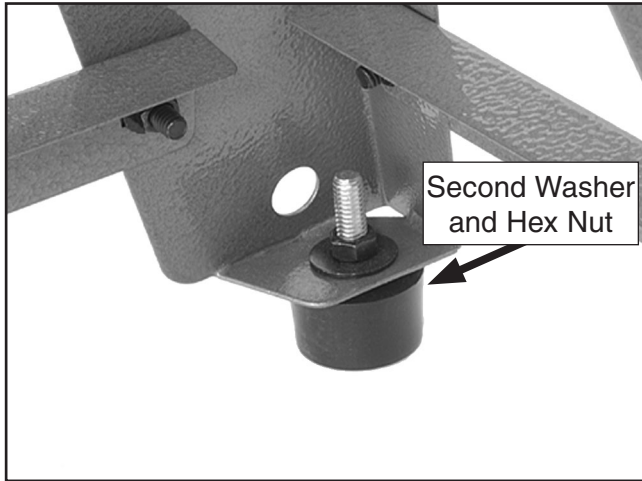
**Figure 6.** Upper stand support and tool tray.

4. Slide the axle through the two holes at the bottom of the legs as shown in **Figure 7**.
5. Slide the wheels onto the axle with two  $\frac{5}{8}$ " flat washers on either side of the wheel.
6. With a pair of pliers, insert a cotter pin through each hole at the end of the axle and bend back one end of the cotter pin to keep the wheel in place.



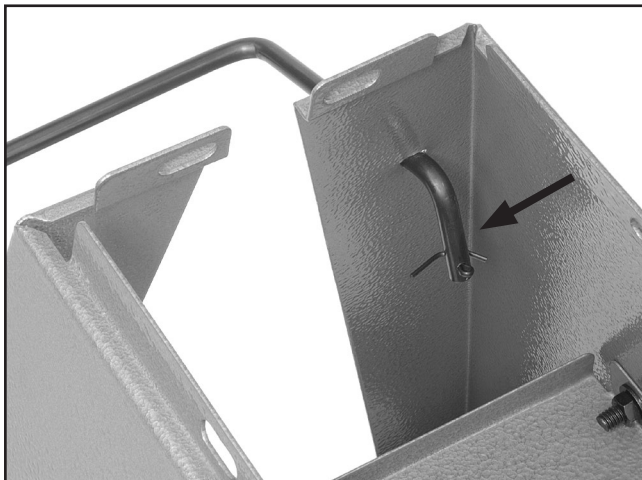
**Figure 7.** Axle and wheels.

- Install each of the rubber feet on the legs with two  $\frac{3}{8}$ "-16 hex nuts and two  $\frac{3}{8}$ " flat washers (see **Figure 8**).



**Figure 8.** Rubber feet.

- Slide the ends of the handle through the holes in the legs. Do this on the same end as the rubber feet (see **Figure 9**).



**Figure 9.** Handle installation.

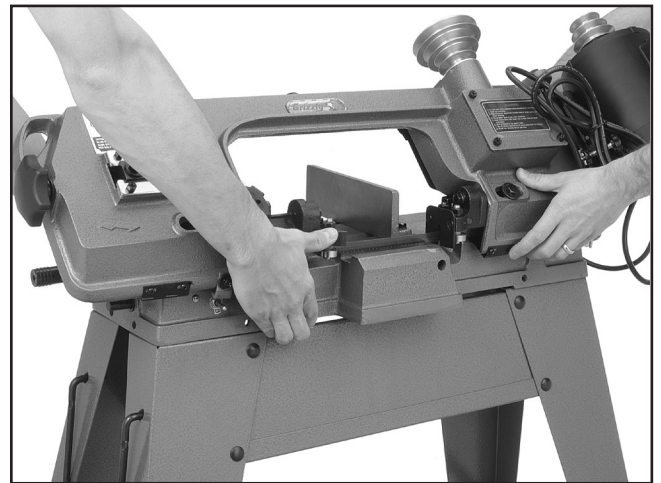
- With a pair of pliers, insert a cotter pin through each hole at the end of the handle and bend back one end of the cotter pin to secure the handle to the leg.

# Mounting

Components and Hardware Needed:	Qty
Bandsaw .....	1
Hex Bolts $\frac{5}{16}$ "-18 x 1" .....	8
Flat Washers $\frac{5}{16}$ " .....	16
Hex Nuts $\frac{5}{16}$ "-18 .....	8

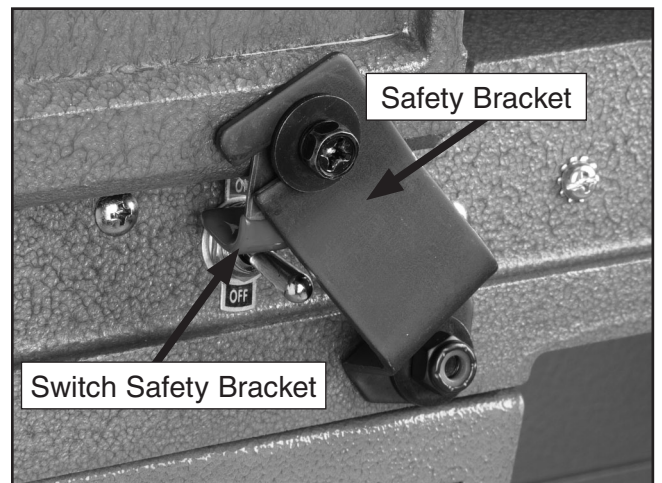
## To mount the bandsaw to the stand:

- With the help of an assistant, set the bandsaw onto the stand (see **Figure 10**).



**Figure 10.** Setting the bandsaw.

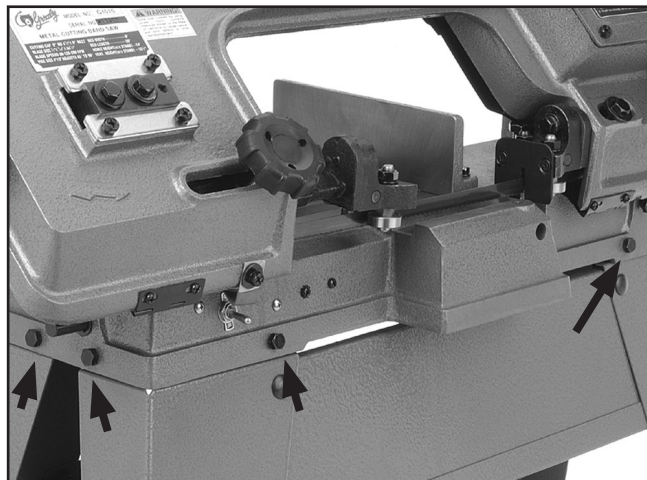
- Remove the safety bracket with a Phillips head screwdriver, then tighten down the switch safety bracket (see **Figure 11**).



**Figure 11.** Safety bracket installed for shipping.



3. Attach the bandsaw to the stand with 8 hex bolts, 16 flat washers and 8 hex nuts and tighten with a 12mm wrench (see **Figure 12**).



**Figure 12.** Front view of bolt locations.

## Pulley Cover

Components and Hardware Needed:	Qty
Pulley Cover .....	1
Pan Head Screw 1/4"-20 x 5/8" .....	2

### To install the pulley cover:

1. Slide the pulley cover over the drive-shaft.
2. Align the holes and secure with the two 1/4"-20 x 5/8" screws (see **Figure 13**).



**Figure 13.** Installing pulley cover.

# V-Belt

**Components and Hardware Needed:** Qty  
V-Belt..... 1

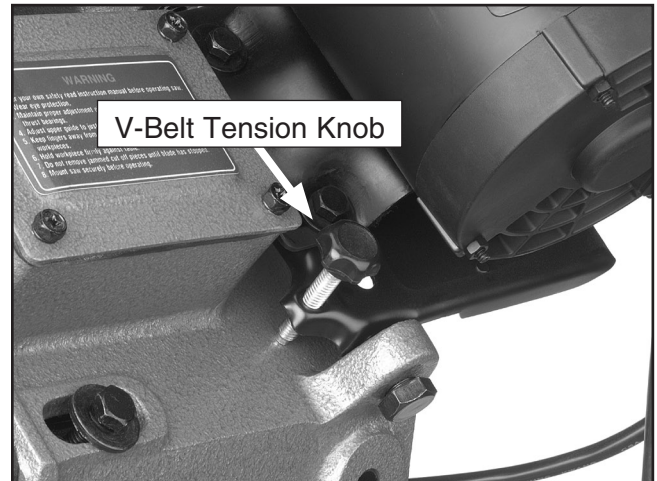
**To install the V-belt:**

1. **UNPLUG THE BANDSAW!**
2. Lift the motor and slip the V-belt over both pulleys as shown in **Figure 14**. Make sure the belt is on parallel sheaves.

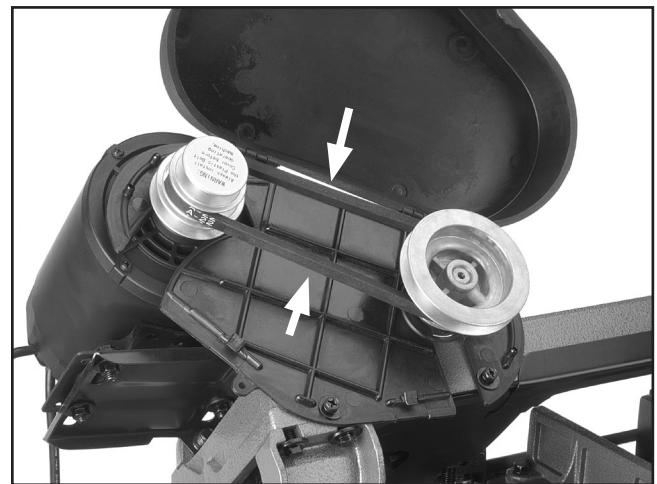


**Figure 14.** Installing V-belt.

3. Lower the motor, apply downward pressure on the motor base and adjust the V-belt tension knob to tension the belt (see **Figure 15**). Apply enough tension so the belt deflects about  $\frac{1}{2}$ " with moderate pressure when pinched together at the points shown in **Figure 16**.



**Figure 15.** V-belt tension knob.



**Figure 16.** V-belt in place and tensioned.

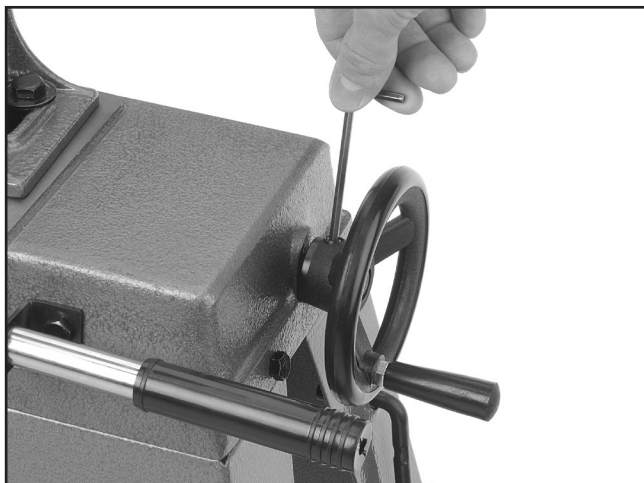
4. Close the pulley cover.

# Vise Handwheel

Components and Hardware Needed:	Qty
Handwheel.....	1
Handwheel Handle .....	1

## To install the handwheel:

1. Attach the handwheel handle to the handwheel.
2. Slide the handwheel onto the shaft and tighten the set screw with a 4mm hex wrench (see **Figure 17**).



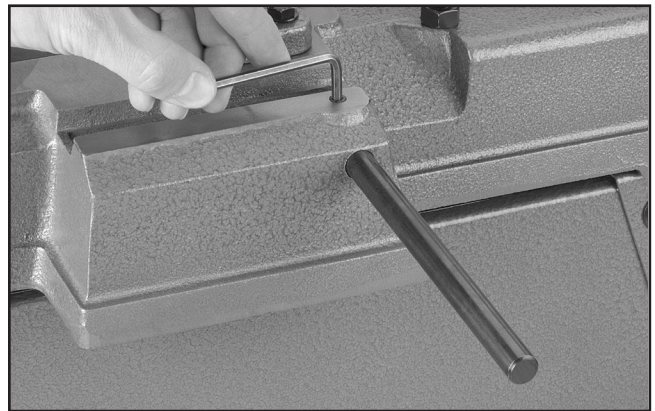
**Figure 17.** Installing handwheel.

# Work Stop

Components and Hardware Needed:	Qty
Work Stop.....	1
Work Stop Shaft .....	1

## To install the work stop:

1. Slide the work stop shaft into the casting until it reaches the stop.
2. Tighten the set screw with the 4mm hex wrench as shown in **Figure 18**.



**Figure 18.** Installing work stop shaft.

3. Slide the work stop onto the work stop shaft and tighten the setscrew.
4. Position it down and out of the way for longer stock, as shown in **Figure 19**, or set the work stop to a measured distance from the blade for consistent, repeatable cut lengths.



**Figure 19.** Installing work stop.

# Vertical Assembly

The Model G1010 can easily be set up for vertical cutting operations.

Components and Hardware Needed:	Qty
Table.....	1
Bracket .....	1
Flat Head Screw $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " .....	1
Former Switch Safety Bracket.....	1
Hex Nut $\frac{1}{4}$ "-20.....	1

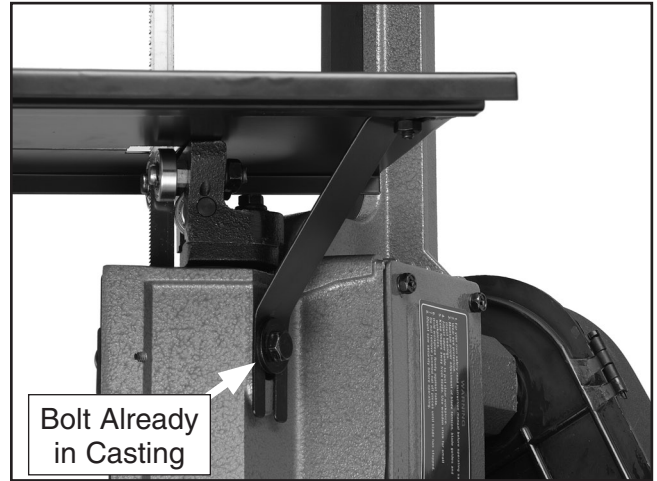
To assemble the bandsaw for vertical cutting:

1. Remove the blade guide cover as shown in **Figure 20**.



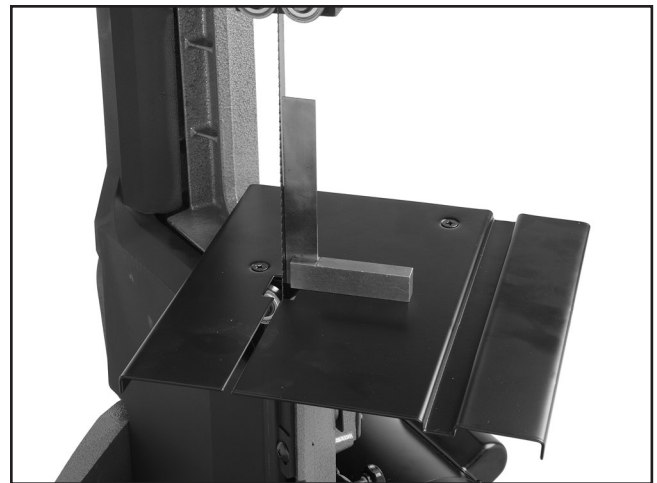
**Figure 20.** Removing blade guide cover.

2. Install the table and replace the two screws removed in **Step 1**.
3. Install the bracket shown in **Figure 21** with the bolt already in the casting and the flat head screw, and the hex nut.



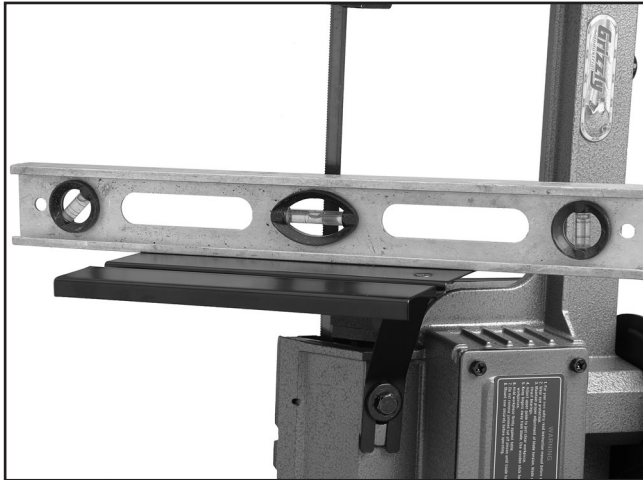
**Figure 21.** Table and bracket installed.

4. Set a square to the side of the blade, as shown in **Figure 22**, and adjust the bracket to square the table to the blade.

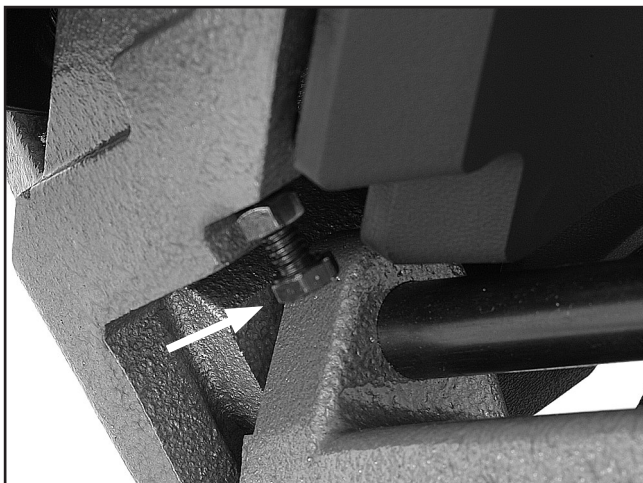


**Figure 22.** Squaring table to blade.

5. Place a level on the table, as shown in **Figure 23**, and adjust the adjustment bolt shown in **Figure 24** until the table is level.



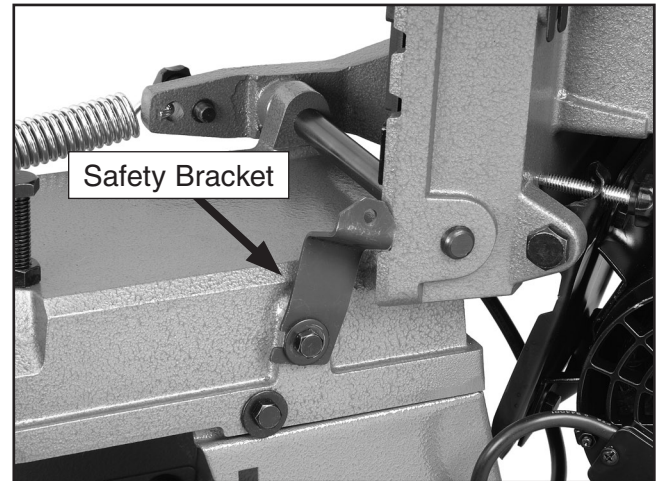
**Figure 23.** Adjusting table level.



**Figure 24.** Adjustment bolt.

6. Install the safety bracket as shown in **Figure 25** to keep the saw from falling.

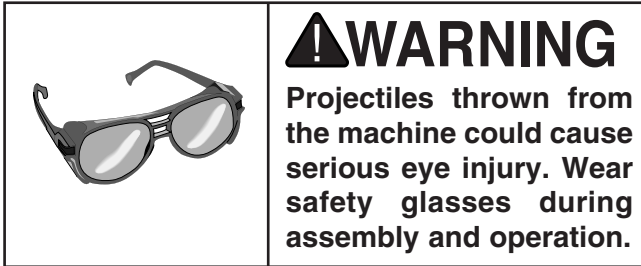
**Note:** To ensure the safety bracket fits securely in the notch on the body frame, the safety bracket may need to be slightly "modified" with a hammer or other appropriate implement to fit securely.



**Figure 25.** Safety bracket.



# Test Run

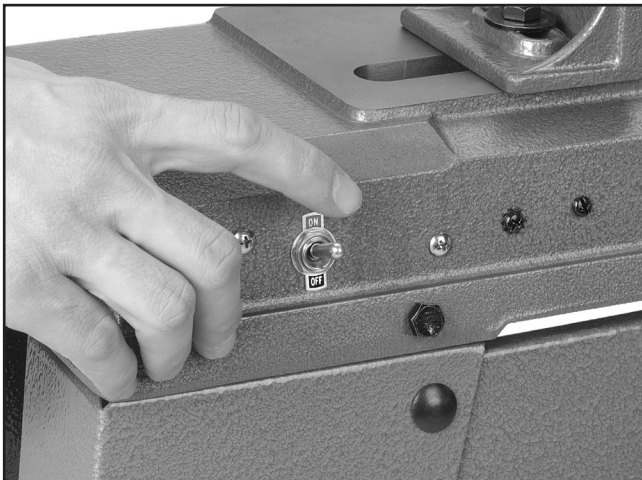


## Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Put on safety glasses and secure loose clothing or long hair.
4. Raise the bandsaw by the handle.
5. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run (**Figure 26**). The bandsaw should run smoothly with little or no vibration.

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

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



**Figure 26.** ON/OFF switch.

# Recommended Adjustments

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

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

## Factory adjustments that should be verified:

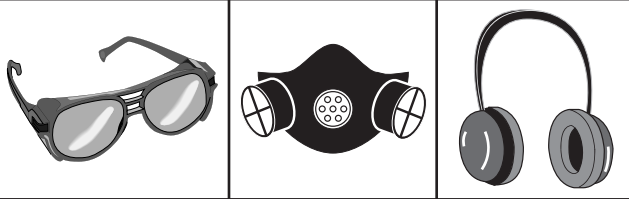
1. Blade Tracking (**Page 32**).
2. Squaring the Blade (**Page 33**).
3. Blade Guide Bearings (**Page 34**).

# SECTION 4: OPERATIONS

## Operation Safety

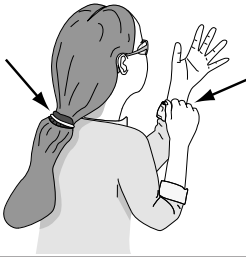
### **!WARNING**

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



### **!WARNING**

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



### **NOTICE**

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, 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.

### **!WARNING**

Electrocution Hazard. The motor and switch on this bandsaw are not protected against liquids. Do not use cutting fluids with this bandsaw. Serious injury could occur.

## Blade Speed

The Model G1010 has these three blade speeds: 80, 120, and 220 FPM.

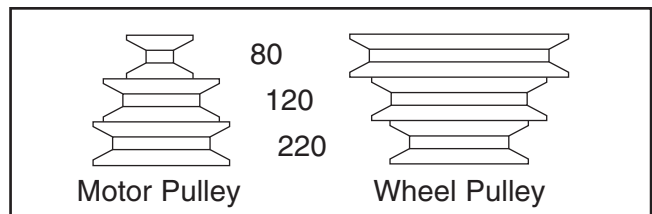
To change blade speeds:

1. **UNPLUG THE BANDSAW!**
2. Determine the best speed for your cut. The table in **Figure 27** is provided as a rough guideline. Material thickness and the type of blade used will factor into FPM selection.

Material	Feet Per Minute (FPM)
Aluminum	250
Plastics	800
Brass (soft)	500
Carbon Tool Steel	100-150
Cast Iron	100-150
Cold Rolled Steel	150-200
High Speed Steel	90-125
Malleable Iron	150-200
Hard Rubber	150-200

**Figure 27.** Blade speed table.

3. Slacken the V-belt and position on the pulley for the desired FPM (see **Figure 28**).



**Figure 28.** V-belt positions in FPM.

4. Tension the V-belt as described in **V-Belt** section on **Page 19**.

# Blade Selection

The Model G1010 uses 64½" x ½" bandsaw blades.

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

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

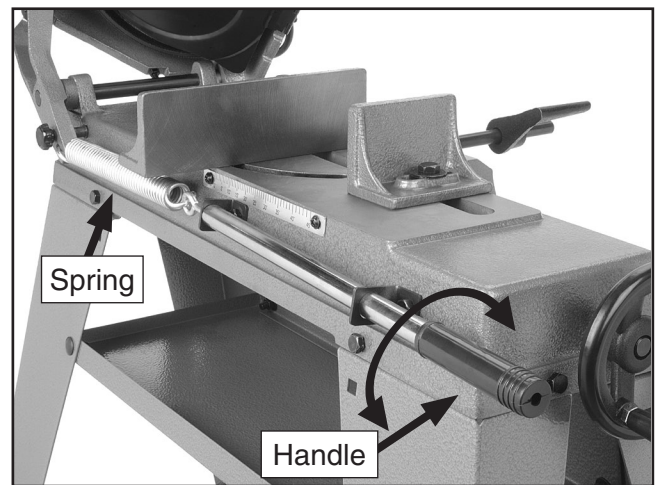
Grizzly is proud to offer a variety of selections that can be found in the current catalog and in **ACCESSORIES** on **Page 28**.

# Feed Rate

The feed rate is controlled by the spring and handle shown in **Figure 29**.

**To adjust the feed rate:**

- Slower:** Twist the handle clockwise to add tension to the spring.
- Faster:** Twist the handle counterclockwise to remove tension from the spring.



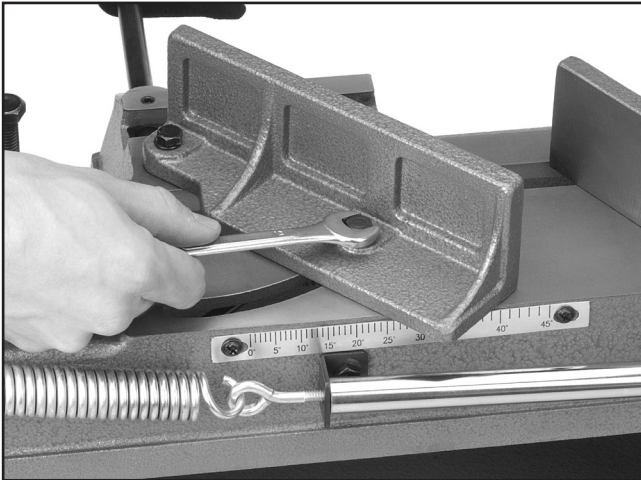
**Figure 29.** Feed rate adjustment.

# Vise

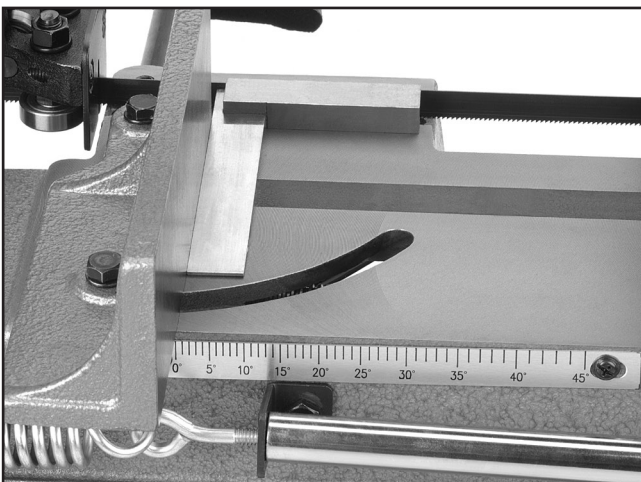
The vise can hold material up to six inches wide and be set to cut angles from 0 to 45 degrees.

## To adjust the angle on the vise:

1. Loosen the lock nut with a 12mm hex wrench or socket as shown in **Figure 30**.
2. Use the scale as a guide to set your angle or use a machinist square to square the blade to the vise as shown in **Figure 31**.
3. Tighten the lock nut.

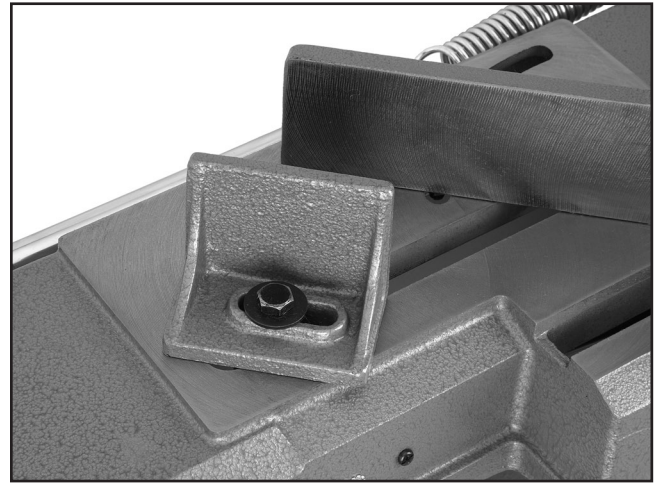


**Figure 30.** Setting vise angle.



**Figure 31.** Squaring vise to blade.

4. Loosen the lock nut in **Figure 32** on the opposite jaw so the jaw can float, and match the angle of the workpiece.
5. Tighten the vise against the workpiece.



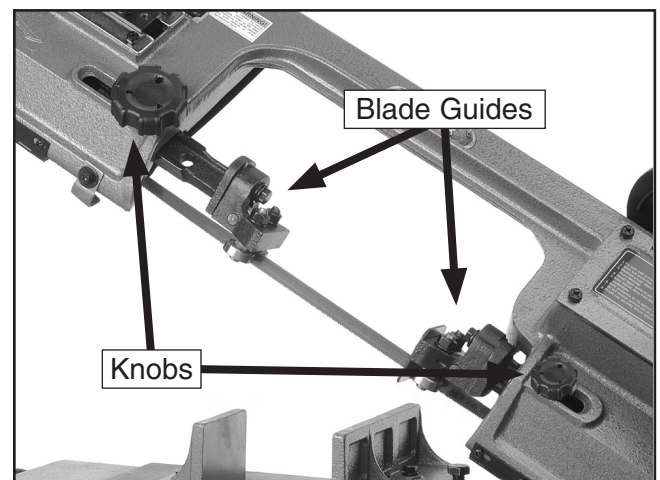
**Figure 32.** Vise jaw lock-nut.

# Blade Guides

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

## To adjust the blade guides:

1. Loosen the knobs shown in **Figure 33** and slide the blade guides as close to the workpiece as possible, then tighten the knobs.



**Figure 33.** Blade guides.

# Operation Tips

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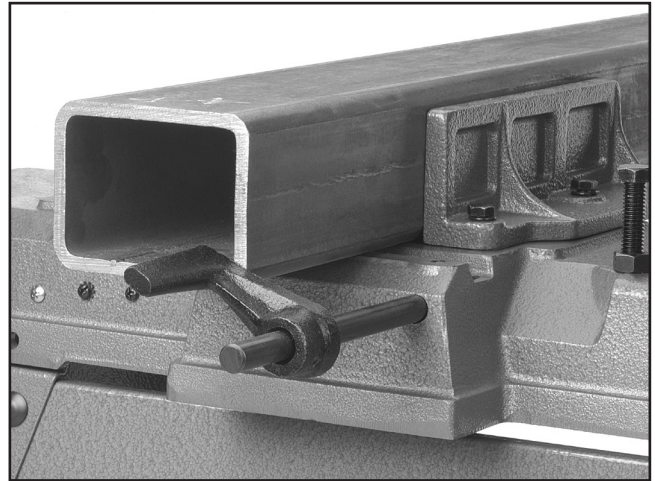
The following tips will help you safely and effectively operate your bandsaw and help you get the maximum life out of your saw blades.

## Tips for horizontal cutting:

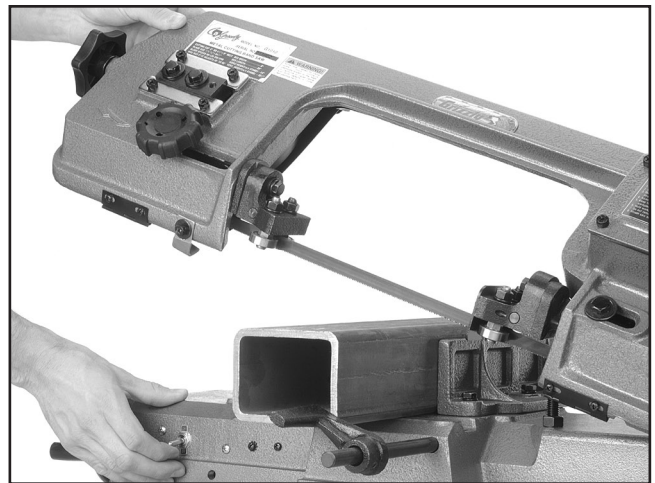
- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length (see **Figure 34**).
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 35**).
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate.
- Chips that are burned, indicate a need to reduce your blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!

## Tips for vertical cutting:

- Make sure that the vertical table assembly is securely fastened to the bandsaw frame so it will adequately support the workpiece.
- Always keep your fingers away from the blade and always hold the workpiece securely in your hand (**Figure 36**).
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.



**Figure 34.** Using the work stop.



**Figure 35.** Proper starting position.



**Figure 36.** Using the vertical set-up.

# SECTION 5: ACCESSORIES

- G5107—64 1/2 x 1/2 x .025 10 TPI Raker
- G5108—64 1/2 x 1/2 x .025 14 TPI Raker
- G5109—64 1/2 x 1/2 x .025 18 TPI Raker
- G5110—64 1/2 x 1/2 x .025 24 TPI Raker
- G5111—64 1/2 x 1/2 x .025 6-10 Variable Pitch
- G5112—64 1/2 x 1/2 x .025 8-12 Variable Pitch
- G5113—64 1/2 x 1/2 x .025 10-14 Variable Pitch
- G5114—64 1/2 x 1/2 x .025 14-18 Variable Pitch
- G5115—64 1/2 x 1/2 x .025 20-24 Variable Pitch

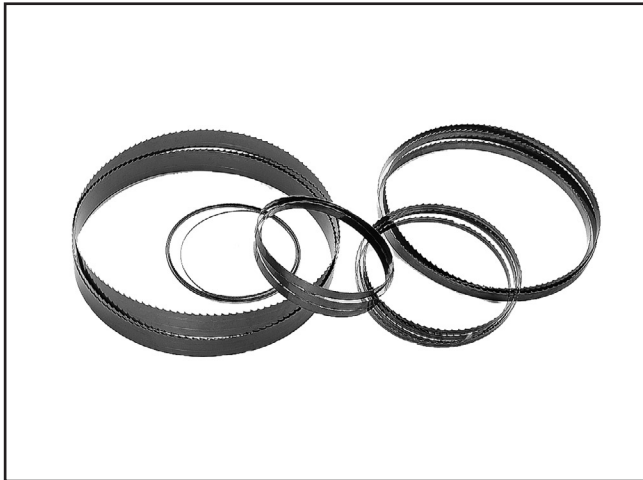


Figure 37. Blades

Call 1-800-523-4777 To Order

## H5405—Lenox® Lube Tube™

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



Figure 38. Lenox® Lube Tube™.

## H5408—Blade Tensioning Gauge

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



Figure 39. H5408 Blade Tensioning Gauge.



- G5618—Deburring Tool w/2 Blades**
- G5619—Extra Aluminum Blades**
- G5620—Extra Brass and Cast Iron Blade**

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



**Figure 40.** G5618 Deburring tool.

- G7984—Face Shield**
- H1298—Dust Sealed Safety Glasses**
- H1300—UV Blocking, Clear Safety Glasses**
- H2347—Uvex® Spitfire Safety Glasses**
- H0736—Shop Fox® Safety Glasses**

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



**Figure 41.** Our most popular safety glasses.

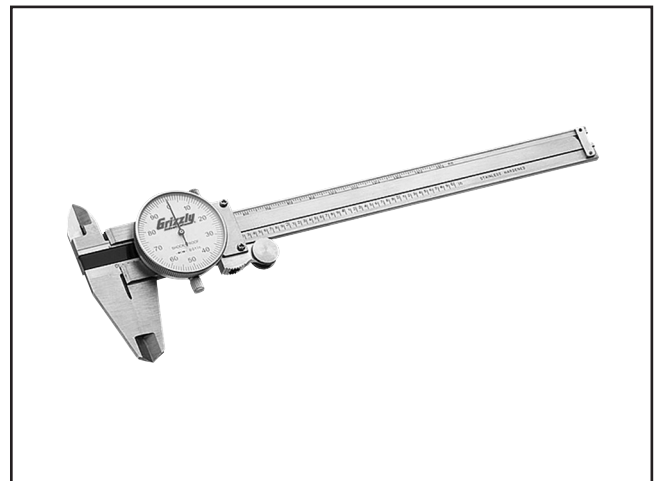
- H1302—Standard Earmuffs**
  - H4979—Deluxe Twin Cup Hearing Protector**
  - H4977—Work-Tunes Radio Headset Earmuffs**
- Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



**Figure 42.** Our most popular earmuffs.

- G9256—6" Dial Caliper**
- G9257—8" Dial Caliper**
- G9258—12" Dial Caliper**

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

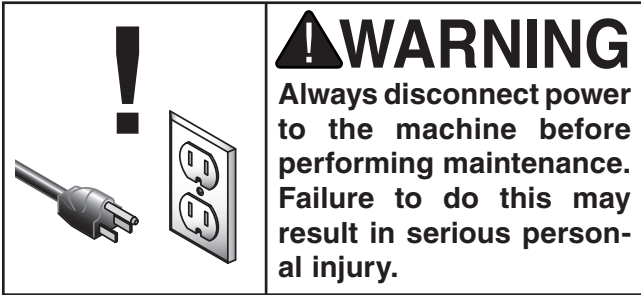


**Figure 43.** Grizzly® Dial Calipers.

**Call 1-800-523-4777 To Order**



# SECTION 6: MAINTENANCE



## Schedule

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

### Daily Check:

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

### Monthly Check:

- V-belt tension, damage, or wear.
- Lubricate vise screw.

### Annual Check:

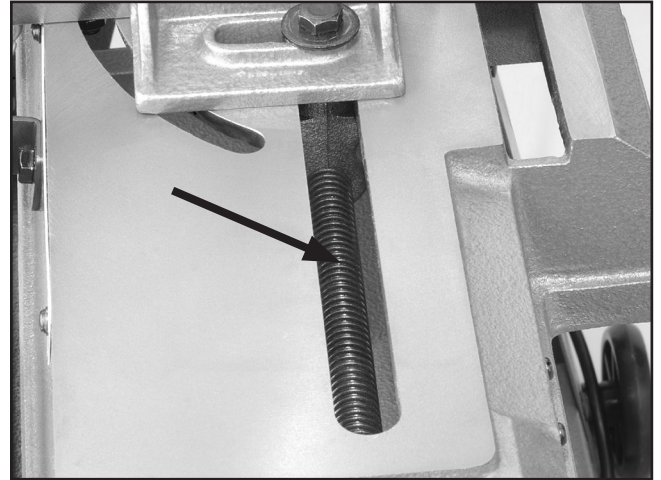
- Lubricate gear box.

## Cleaning

Cleaning the Model G1010 is relatively easy. After using your bandsaw, remove excess chips by sweeping.

## Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise screw shown in **Figure 44** with general purpose grease.



**Figure 44.** Vise screw lubrication.

Remove the cover on the gear box in **Figure 45** and coat the gears with general purpose grease.



**Figure 45.** Gear box lubrication.

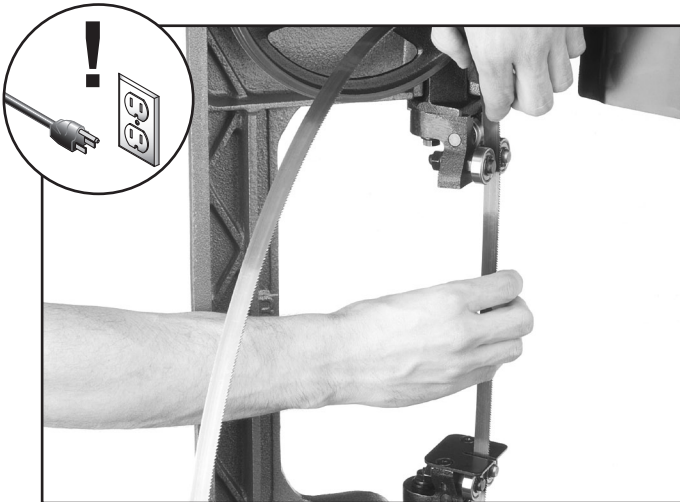


# Blade Change

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

**To change the blade on the bandsaw:**

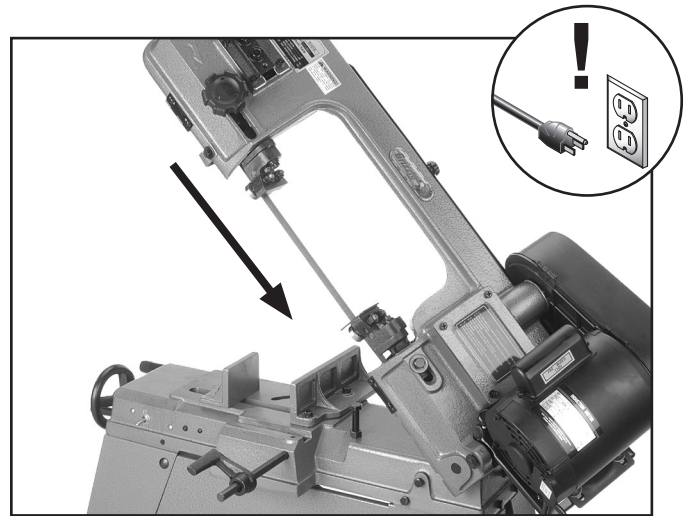
1. **UNPLUG THE BANDSAW!**
2. Raise the head of the bandsaw to the vertical position and remove the wheel access cover.
3. Loosen the tension knob and slip the blade off of the wheels.



**Figure 46.** Installing blade.

4. Install the new blade through both blade guide bearings as shown in **Figure 46** and around the bottom wheel.
5. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

**Note:** It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 47**, after mounting to the bandsaw. Some blades will have a directional arrow as a guide.



**Figure 47.** Blade cutting direction.

6. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels.
7. Tighten the tension knob in **Figure 48** so the blade will not slip on the wheels on start up.
8. Connect the bandsaw to the power source.
9. Briefly turn the bandsaw **ON** then **OFF** to position the blade and resume the previous tracking.

—If the tracking needs to be adjusted, see **Tracking** in the next section.

—If the tracking is fine, proceed to **Blade Tension** on **Page 33**.



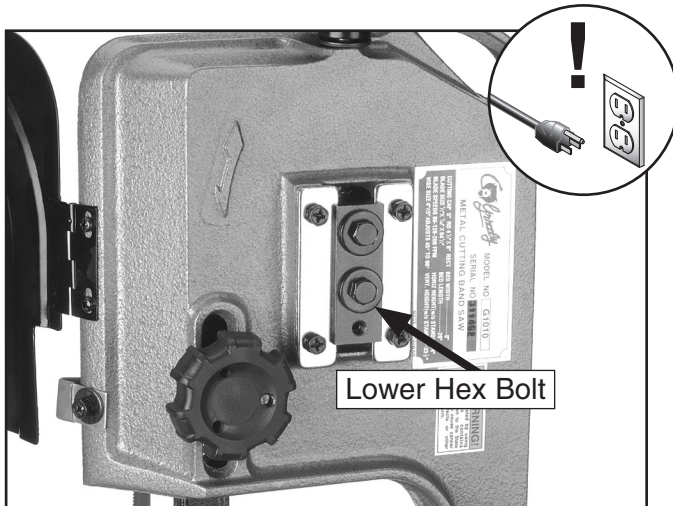
**Figure 48.** Tension knob and blade.

# Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

To adjust the blade tracking on the bandsaw:

1. **UNPLUG THE BANDSAW!**
2. Position the bandsaw in the vertical position.
3. Open the wheel access cover.
4. Loosen, but do not remove the lower hex bolt in the blade wheel tilting mechanism (**Figure 49**).

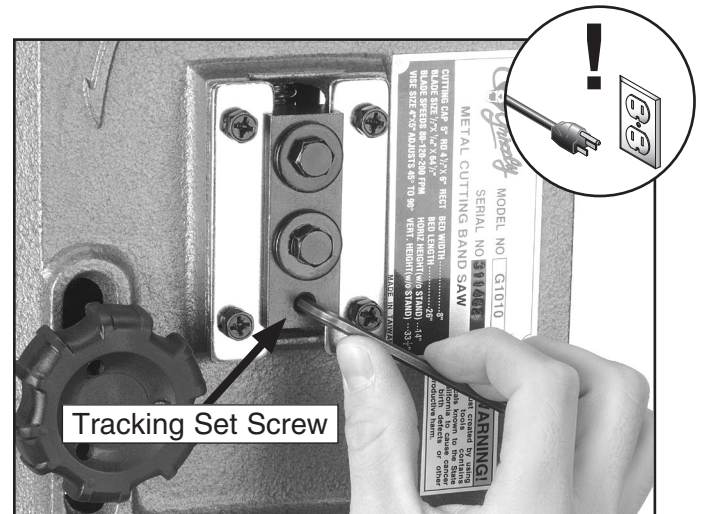


**Figure 49.** Blade tracking adjustments.

5. Relax the blade tension.
6. Adjust the set screw with a 4mm hex wrench shown in **Figure 50**, then tighten the hex bolt loosened in **Step 4**.

—Tightening the set screw will move the blade closer to the shoulder of the wheel.

—Loosening the set screw will move the blade away from the shoulder.



**Figure 50.** Adjusting tracking set screw.

7. Tension the blade.
8. Reconnect the power and turn **ON** the bandsaw.

—If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.

—If the blade walks away from the shoulder of the wheel or hits the shoulder, repeat **Steps 4-7**.

9. Replace the blade guard and wheel access cover.



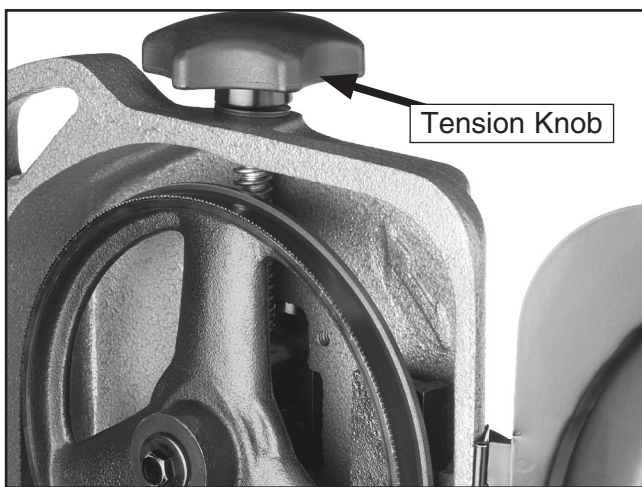
# Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting times.

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

## To tension the blade on the bandsaw:

1. Make sure the blade is tracking properly.
2. **UNPLUG THE BANDSAW!**
3. Loosen and slide the blade guides as far apart as they will go then tighten them down again.
4. Turn the tension knob in **Figure 51** clockwise to tighten the blade as tight as you can get.
5. Using moderate finger pressure, push against the side of the blade. The blade should not move more than 0.004".
6. Another option is to use a blade tensioning gauge, like the one found in **ACCESSORIES** on **Page 28**. If you use this option please follow the instructions included with your gauge.



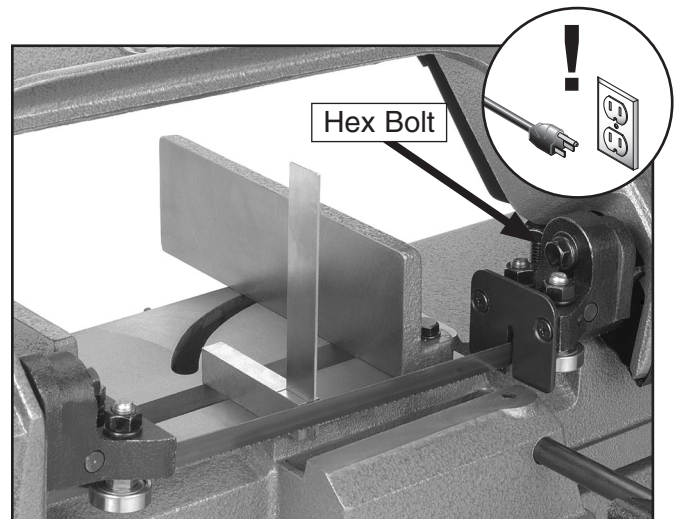
**Figure 51.** Tension knob and blade.

# Squaring the Blade

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

## To square the blade to the bed of the table:

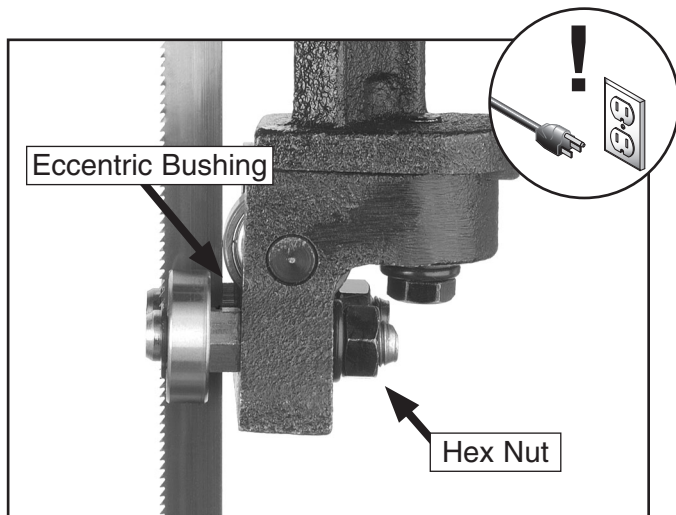
1. **UNPLUG THE BANDSAW!**
2. Lower the head of the bandsaw all the way until it contacts the horizontal stop.
3. Place a square on the table bed and against the edge of the blade (**Figure 52**), and check different points along the length of the table between the blade guides.
4. Loosen the hex bolt shown in **Figure 52**, and rotate the seat until the blade is vertical to the bed, then tighten the hex bolt.



**Figure 52.** Squaring the blade.

# Blade Guide Bearings

The blade guide bearings must be properly adjusted. One bearing on each assembly has an eccentric bushing that allows the distance between bearings to be adjusted. The bearings are secured in place by a hex nut and lock washer shown in **Figure 53**.



**Figure 53.** Blade guide adjustments.

To adjust the blade guide bearings:

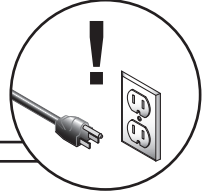
1. **UNPLUG THE BANDSAW!**
2. Position the bandsaw in the vertical position.
3. Loosen the hex nut that secures the bearing to the eccentric bushing.
4. Using a 13mm open-end wrench, adjust the eccentric bushing position to achieve the desired clearance. The bearing and blade should have a clearance of 0.001".
5. Tighten the nut to lock the bearing in position.
6. Adjust the other eccentric blade guide bearing in the same manner. The backing bearing should have a gap between 0.002-0.003" from the back of the blade.



# SECTION 7: SERVICE

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If you need help troubleshooting, you need replacement parts, or you are unsure of how to perform the procedures in this section, 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.	<ol style="list-style-type: none"> <li>1. Plug/receptacle is at fault or wired incorrectly.</li> <li>2. Start capacitor is at fault.</li> <li>3. Motor connection wired incorrectly.</li> <li>4. Power supply is at fault/switched OFF.</li> <li>5. ON/OFF switch is at fault.</li> <li>6. Wiring is open/has high resistance.</li> <li>7. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Test for good contact or correct the wiring.</li> <li>2. Test/replace if faulty.</li> <li>3. Correct motor wiring connections.</li> <li>4. Make sure all hot lines/grounds are operational and have correct voltage on all legs.</li> <li>5. Replace faulty ON button or ON/OFF switch.</li> <li>6. Troubleshoot wires for internal/external breaks; check for disconnected/corroded connections; repair/replace wiring.</li> <li>7. Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Wrong blade for the workpiece material (metal).</li> <li>2. Feed rate too fast for task.</li> <li>3. V-belt slipping.</li> <li>4. Blade is slipping on wheels.</li> <li>5. Pulley/sprocket slipping on shaft.</li> <li>6. Motor bearings are at fault.</li> <li>7. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use blade with correct properties for your type of cutting.</li> <li>2. Decrease feed rate.</li> <li>3. Replace bad V-belt and re-tension.</li> <li>4. Adjust blade tracking and tension.</li> <li>5. Replace loose pulley/shaft.</li> <li>6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>7. Test/repair/replace.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. V-belt is slapping belt cover.</li> <li>2. V-belt) worn or loose.</li> <li>3. Pulley is loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect belt cover for proper installation.</li> <li>2. Inspect/replace belt with a new one.</li> <li>3. Realign/replace shaft, pulley, setscrew, and key as required.</li> </ol>



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> <li>Excessive feed rate.</li> <li>The blade TPI is too great, or the material is too coarse.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Feed Rate</b> on <b>Page 25</b>, or <b>Changing Blade Speed</b> on <b>Page 24</b>, and adjust as required.</li> <li>Refer to <b>Blade Selection</b> on <b>Page 25</b> and adjust as required.</li> </ol>
Blades break often.	<ol style="list-style-type: none"> <li>The workpiece is loose in the vise.</li> <li>The feed or cut speed is wrong.</li> <li>The blade TPI is too great, or the material is too coarse.</li> <li>The blade is rubbing on the wheel flange.</li> <li>The bandsaw is being started with the blade resting on the workpiece.</li> <li>The guide bearings are misaligned, or the blade is rubbing on the wheel flange.</li> <li>The blade is too thick, or the blades are of low quality.</li> </ol>	<ol style="list-style-type: none"> <li>Clamp the workpiece tighter, or use a jig to hold the workpiece.</li> <li>Refer to <b>Feed Rate</b> on <b>Page 25</b>, or <b>Changing Blade Speed</b> on <b>Page 24</b>, and adjust as required.</li> <li>Refer to <b>Blade Selection</b> on <b>Page 25</b>, and adjust as required.</li> <li>Refer to <b>Blade Tracking</b> on <b>Page 32</b>, and adjust as required.</li> <li>Start bandsaw and then slowly lower the headstock by setting the feed rate.</li> <li>Refer to <b>Blade Tracking</b> on <b>Page 32</b>, or <b>Blade Guides</b> on <b>Page 26</b>, and adjust as required.</li> <li>Use a higher quality blade.</li> </ol>
Blade dulls prematurely.	<ol style="list-style-type: none"> <li>The cutting speed is too fast.</li> <li>The blade TPI is too coarse.</li> <li>The blade feed pressure is too light.</li> <li>The workpiece has hard spots, welds, or scale is on the material.</li> <li>The blade is twisted.</li> <li>The blade is sipping on the wheels.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Changing Blade Speed</b> on <b>Page 24</b>, and adjust as required.</li> <li>Refer to <b>Blade Selection</b> on <b>Page 25</b>, and adjust as required.</li> <li>Refer to <b>Feed Rate</b> on <b>Page 25</b>, and adjust as required.</li> <li>Increase the feed pressure, and reduce the cutting speed.</li> <li>Replace the blade.</li> <li>Refer to <b>Blade Tension</b> on <b>Page 33</b>, and adjust as required.</li> </ol>
Blade wears on one side.	<ol style="list-style-type: none"> <li>The blade guides are worn or mis-adjusted.</li> <li>The blade guide slide bracket is loose.</li> <li>The wheels are out of alignment.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Blade Guides</b> on <b>Page 26</b> and replace or adjust.</li> <li>Tighten the blade guide bracket.</li> <li>Refer to <b>Blade Tracking</b> on <b>Page 32</b>, and adjust as required.</li> </ol>
Teeth are ripping from the blade.	<ol style="list-style-type: none"> <li>The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece.</li> <li>The workpiece is vibrating in the vise.</li> <li>The blade gullets are loading up with chips.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Blade Selection</b> on <b>Page 25</b> and decrease the feed pressure. Refer to <b>Feed Rate</b> on <b>Page 25</b>, and adjust as required.</li> <li>Re-clamp the workpiece in the vise, and use a jig if required.</li> <li>Use a coarser-tooth blade.</li> </ol>
The cuts are crooked.	<ol style="list-style-type: none"> <li>The feed pressure is too high.</li> <li>The guide bearings are out of adjustment, or too far away from the workpiece.</li> <li>The blade tension is low.</li> <li>The blade is dull.</li> <li>The blade speed is wrong.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Feed Rate</b> on <b>Page 25</b>, and adjust as required.</li> <li>Refer to <b>Blade Guides</b> on <b>Page 26</b> and replace or adjust.</li> <li>Refer to <b>Blade Tension</b> on <b>Page 33</b>, and adjust as required.</li> <li>Refer to <b>Changing the Blade</b> on <b>Page 31</b> and replace the blade.</li> <li>Refer to <b>Changing Blade Speed</b> on <b>Page 24</b>, and adjust as required.</li> </ol>



# Wiring Diagram G1010

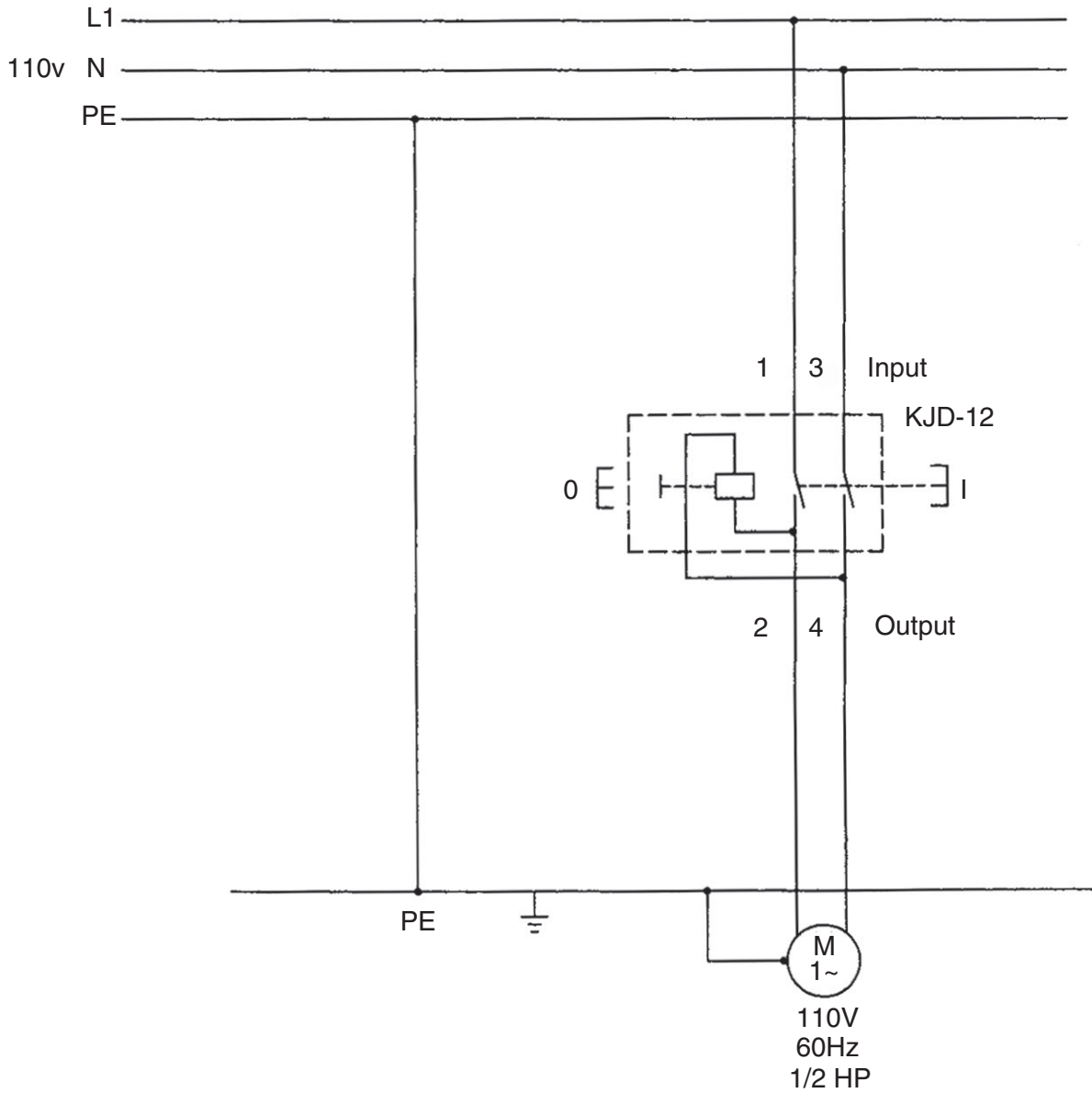


Figure 54. G1010 Wiring diagram.

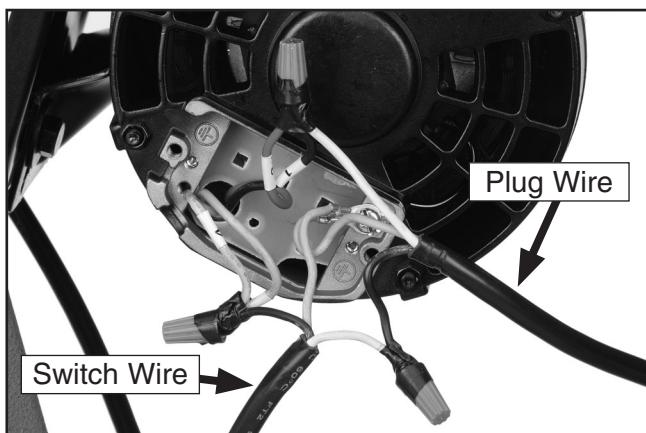


Figure 55. G1010 Junction box.

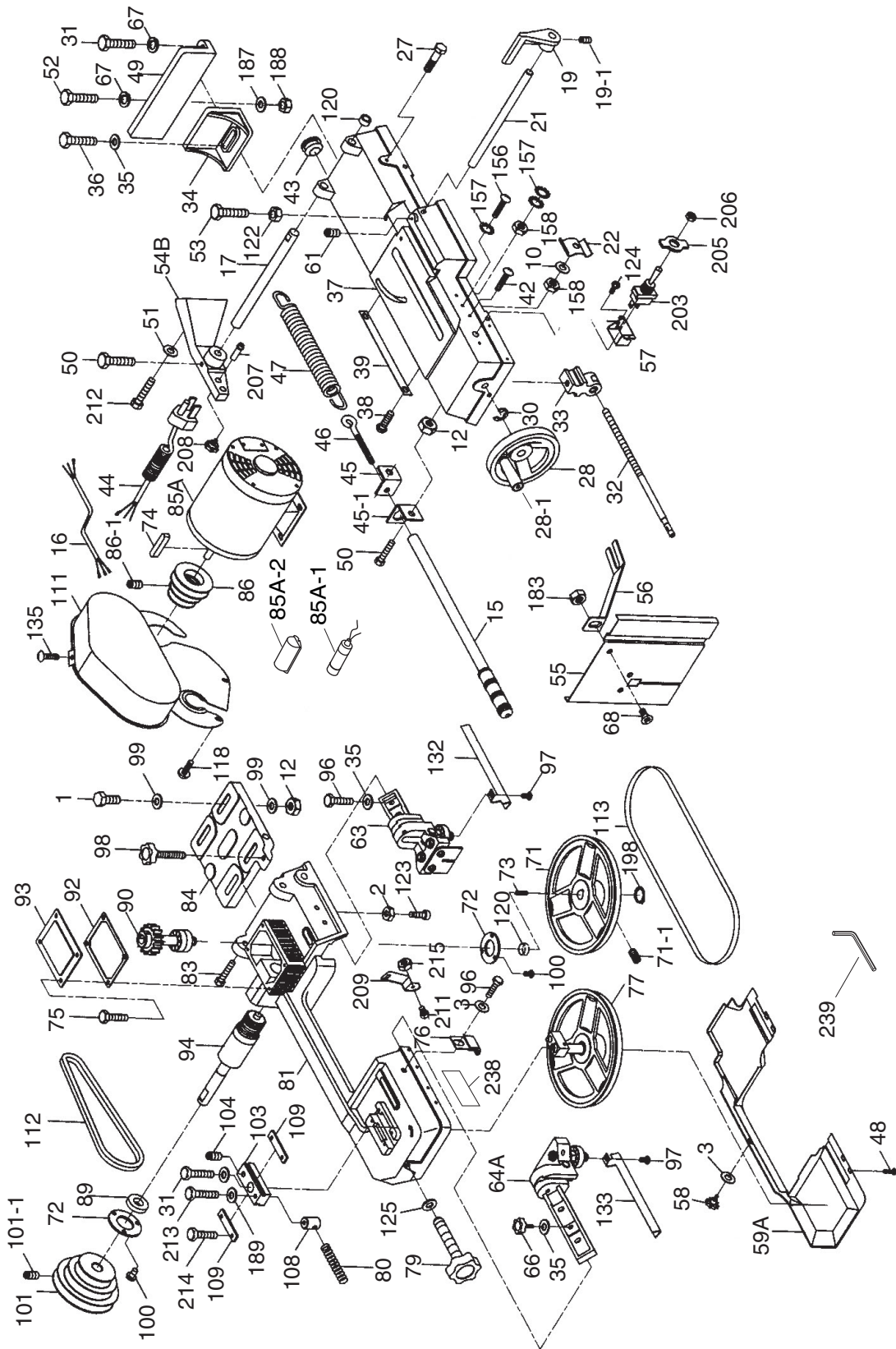


Figure 56. G1010 Capacitor.





# Parts Breakdown G1010



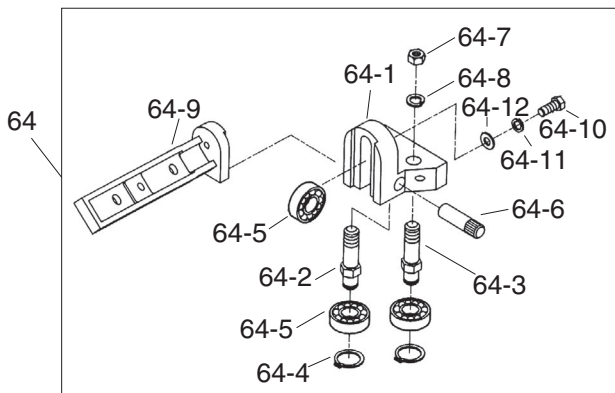
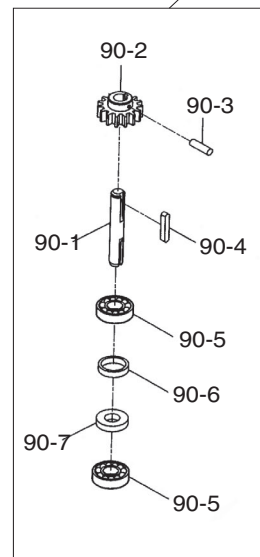
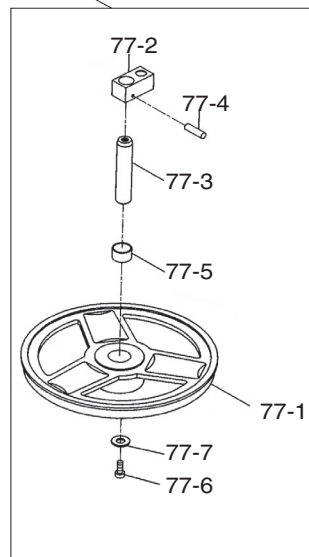
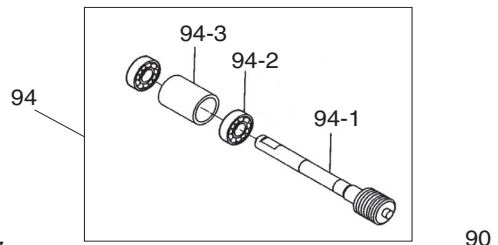
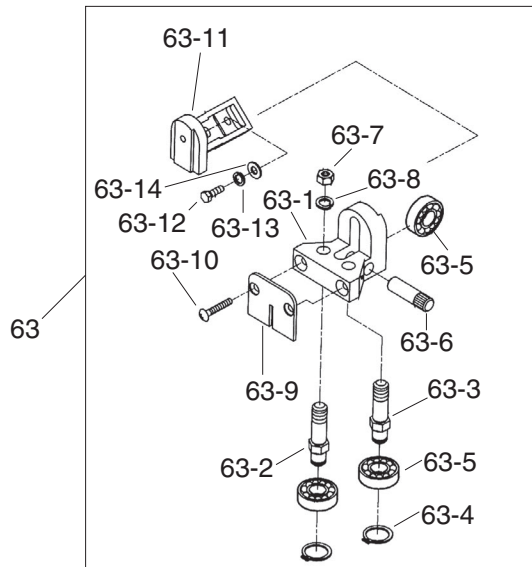
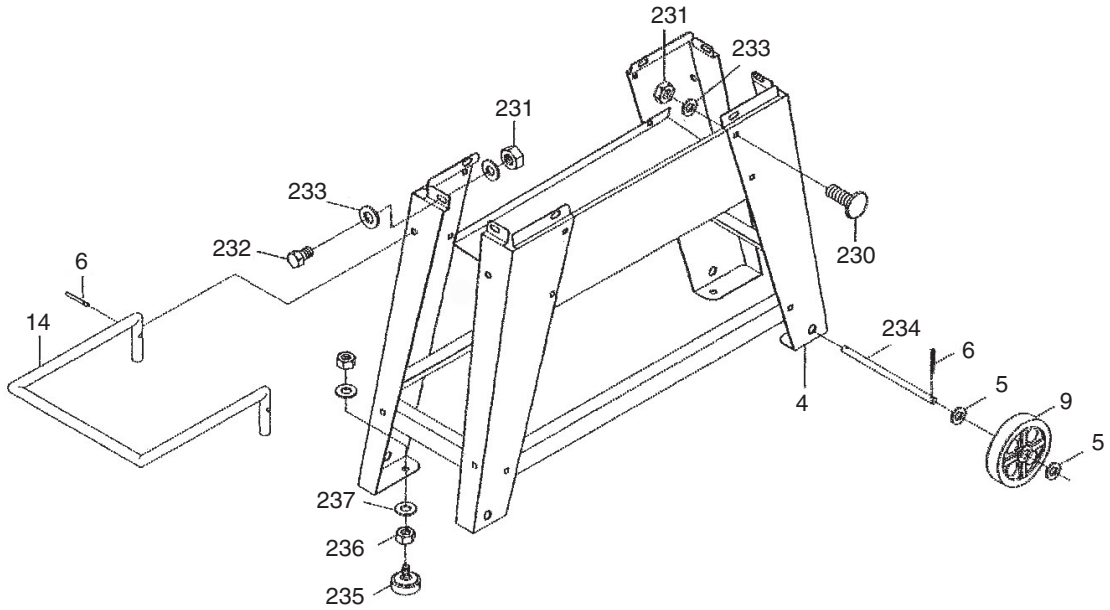
# Parts List G1010

REF	PART #	DESCRIPTION
1	PB19	HEX BOLT 1/4-20 X 1/2
3	PW06	FLAT WASHER 1/4
4	P1010004	STAND COMPLETE ASSEMBLY
5	PW02	FLAT WASHER 3/8
6	P1010006	COTTER PIN 1/8 X 1
9	P1010009	WHEEL
10	PW06	FLAT WASHER 1/4
11	PB12	HEX BOLT 5/16-18 X 1-1/4
12	PN02	HEX NUT 5/16-18
14	P1010014	LIFTING HANDLE
15	P1010015	ADJUSTING TENSION ROD
16	P1010016	MOTOR CABLE
17	P1010017	PIVOTING ROD
19	P1010019	WORK STOP
19-1	PSS08	SET SCREW 5/16-18 X 1/2
21	P9742021	STOCK STOP ROD 1/2 X 216
22	P9742022	STRAIN RELIEF
27	PB03	HEX BOLT 5/16-18 X 1
28	P1010028	HANDWHEEL
28-1	P1010028-1	HANDWHEEL HANDLE
30	PEC03M	E-CLIP 10MM
31	PB03	HEX BOLT 5/16-18 X 1
32	P1010032	LEAD SCREW
33	P1010033	WISE NUT
34	P1010034	MOVEABLE VISE PLATE
35	PW04	FLAT WASHER 7/16
36	PB24	HEX BOLT 3/8-16 X 1-1/4
37	P1010037	SWIVEL BASE
38	PS80	PHLP HD SCR 3/16-32 X 1/4
39	P1010039	SCALE
42	PS56M	PHLP HD SCR M4-.7 X 16
43	P1010043	STRAIN RELIEF
44	P1010044	POWER CABLE
45	P1010045	SPRING HANDLE BRACKET
45-1	P1010045-1	SPRING HANDLE BRACKET
46	P1010046	SPRING ADJ SCREW
47	P1010047	EXTENTION SPRING
48	PS06	PHLP HD SCR 10-24 X 3/8
49	P1010049	MOVABLE VISE PLATE
50	PB07	HEX BOLT 5/16-18 X 3/4
51	PW07	FLAT WASHER 5/16
52	PB11	HEX BOLT 5/16-18 X 1-1/2
53	PB38	HEX BOLT 7/16-14 X 2
54B	P1010054B	PIVOT 3/8 HOLES 8-1/2L
55	P1010055	VERTICAL CUTTING PLATE
56	P1010056	TABLE SUPPORTING PLATE
57	P1010057	ADJUSTABLE BRACKET LEFT
58	P1010058	PLUM HANDLE SCREW
59A	P1010059A	PLASTIC SAFETY COVER N/S
61	PSS38	SET SCREW 5/16-18 X 5/8

REF	PART #	DESCRIPTION
63	P1010063	BEARING SHAFT ASSEMBLY
63-1	P1010063-1	BEARING BLOCK
63-2	P1010063-2	BEARING SHAFT
63-3	P1010063-3	BEARING SHAFT
63-4	PR01M	EXT RETAINING RING 10MM
63-5	P6000	BALL BEARING 6000ZZ
63-6	P1010063-6	BEARING PIN
63-7	PN11	HEX NUT 3/8-24
63-8	PLW04	LOCK WASHER 3/8
63-9	P1010063-9	DEFLECTOR PLATE
63-10	PFH19	FLAT HD SCR 1/4-20 X 3/8
63-11	P1010063-11	ADJUSTABLE BRACKET (RIGHT)
63-12	PB12	HEX BOLT 5/16-18 X 1-1/4
63-13	PLW01	LOCK WASHER 5/16
63-14	PW07	FLAT WASHER 5/16
64A	P1010064A	BLADE ADJ SEAT ASSEMBLY
64-1	P1010064-1	BLADE ADJUSTMENT (FRONT)
64-2	P1010064-2	BEARING SHAFT
64-3	P1010064-3	BEARING SHAFT
64-4	PR01M	EXT RETAINING RING 10MM
64-5	P6000	BALL BEARING 6000ZZ
64-6	P1010064-6	BEARING PIN 10 X 36
64-7	PN11	HEX NUT 3/8-24
64-8	PLW04	LOCK WASHER 3/8
64-9	P1010064-9	ADJUSTABLE BRACKET (LEFT)
64A	P1010064A	BLADE ADJ SEAT
64-10	PB12	HEX BOLT 5/16-18 X 1-1/4
64-11	PLW01	LOCK WASHER 5/16
64-12	PW07	FLAT WASHER 5/16
66	P1010066	BLADE ADJUSTABLE KNOB
67	PLW01	LOCK WASHER 5/16
68	PFH19	FLAT HD SCR 1/4-20 X 3/8
71	P1010071	BLADE WHEEL (FRONT)
71-1	PSS17	SET SCREW 5/16-18 X 5/16
72	P1010072	BEARING COVER
73	PK23M	KEY 5 X 5 X 25
74	PK12M	KEY 5 X 5 X 30
75	PB02	HEX BOLT 1/4-20 X 5/8
76	P1010076	SWITCH CUT OFF TIP
77	P1010077	BLADE WHEEL REAR ASSY
77-1	P1010077-1	BLADE WHEEL (REAR)
77-2	P1010077-2	SLIDING PLATE DRAW BLOCK
77-3	P1010077-3	BLADE WHEEL SHAFT
77-4	P1010077-4	PIN 4 X 20
77-5	P1010077-5	BUSHING
77-6	PB07	HEX BOLT 5/16-18 X 3/4
77-7	PW07	FLAT WASHER 5/16
79	P1010079	BLADE TENSION KNOB
80	P1010080	SPRING
81	P1010081	BODY FRAME



# Parts Breakdown G1010



# Parts List G1010

REF	PART #	DESCRIPTION
83	PB41	HEX BOLT 1/2-12 X 1-1/2
84	P1010084	MOTOR MOUNT PLATE
85A	P1010085A	MOTOR 1/2HP 110V/220V
85A-1	P1010085A-1	CAPACITOR 200MFD 125V
85A-2	P1010085A-2	CAPACITOR COVER
86	P1010086	MOTOR PULLEY
86-1	PSS17	SET SCREW 5/16-18 X 5/16
89	P1010089	OIL SEAL 15 X 35 X 7
90	P1010090	TRANS WHEEL SHAFT
90-1	P1010090-1	TRANSMISSION WHEEL SHAFT
90-2	P1010090-2	TRANSMISSION GEAR
90-3	P1010090-3	PIN 4 X 22
90-4	PK23M	KEY 5 X 5 X 25
90-5	P6202	BALL BEARING 6202ZZ
90-6	P1010090-6	BUSHING
90-7	P1010090-7	OIL SEAL TC15 X 35 X 7
92	P1010092	GEAR BOX GASKET
93	P1010093	GEAR BOX COVER
94	P1010094	WORM GEAR SHAFT ASSEMBLY
94-1	P1010094-1	WORM GEAR SHAFT
94-2	P6202	BALL BEARING 6202ZZ
94-3	P1010094-3	BEARING BUSHING
96	P1010096	BEARING BUSHING
97	PS14M	PHLP HD SCR M6-1 X 12
98	P1010098	KNOB M10 X 50
99	P1010099	BUSHING 11/16 X 1/4
100	PFH13	FLAT HD SCR 6-32 X 3/8
101	P1010101	WORM GEAR PULLEY
101-1	PSS18	SET SCREW 5/16-18 X 3/4
103	P1010103	BLADE TENSION SLIDING PLATE
104	PSS38	SET SCREW 5/16-18 X 5/8
108	P1010108	SHAFT BLOCK
109	P1010109	BLADE TENSION SLIDING GUIDE
111	P1010111	PLASTIC MOTOR PULLEY COVER
112	PVA22	V-BELT A-22 4L220
113	G5107-G5115	B/S BLADE 64-1/2" X 1/2" 10TPI
118	PS07	PHLP HD SCR 1/4-20 X 3/8

REF	PART #	DESCRIPTION
120	P1010120	BUSHING 19 X 17 X 7
122	PN19	HEX NUT 7/16-14
123	PB31	HEX BOLT 1/4-20 X 1
124	PS08	PHLP HD SCR 10-24 X 3/4
125	PW02	FLAT WASHER 3/8
132	P1010132	SAFETY GUARD (RIGHT)
133	P1010133	SAFETY GUARD (LEFT)
135	PS12	PHLP HD SCR 1/4-20 x 5/8
156	PS06	PHLP HD SCR 10-24 X 3/8
157	PTLW08M	EXT TOOTH WASHER 1/4
158	PN07	HEX NUT 10-24
183	PN05	HEX NUT 1/4-20
187	PW07	FLAT WASHER 5/16
188	PN02	HEX NUT 5/16-18
189	PW07	FLAT WASHER 5/16
198	P1010198	C-RETAINER RING S/S
203	P1010203	TOGGLE SWITCH
205	P1010205	SWITCH INDICATOR
206	P1010206	SWITCH NUT
207	P1010207	POSITION PIN
208	P1010208	PLUM HANDLE
209	P1010209	SAFETY BRACKET
211	PB05	HEX BOLT 1/4-20 X 3/4
212	PB03	HEX BOLT 5/16-18 X 1
213	PB07	HEX BOLT 5/16-18 X 3/4
214	PB02	HEX BOLT 1/4-20 X 5/8
215	PN05	HEX NUT 1/4-20
230	PCB05	CARRIAGE BOLT 5/16-18 X 3/4
231	PN02	HEX NUT 5/16-18
232	PB03	HEX BOLT 5/16-18 X 1
233	PW07	FLAT WASHER 5/16
234	P1010234	WHEEL ROD
235	P1010235	RUBBER HD SCR 3/8 X 20
236	PN08	HEX NUT 3/8-16
237	PW02	FLAT WASHER 3/8
238	P1010238	MACHINE ID LABEL
239	PAW04M	HEX WRENCH 4MM



# WARRANTY AND RETURNS

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

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

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

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

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

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





# WARRANTY CARD

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Phone # \_\_\_\_\_ Email \_\_\_\_\_ Invoice # \_\_\_\_\_  
 Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

0-2       3-5       6-9       10+

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

Yes       No

8. Would you recommend Grizzly Industrial to a friend?

Yes       No

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

Note: *We never use names more than 3 times.*       Yes       No

10. Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

\_\_\_\_\_  
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Place  
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