

Grizzly **Industrial, Inc.**®

MODEL G0555X

14" EXTREME SERIES BANDSAW

OWNER'S MANUAL

(For models manufactured since 4/12)



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#TR8670 PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

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

The owner of this machine/tool 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, cutting/sanding/grinding tool 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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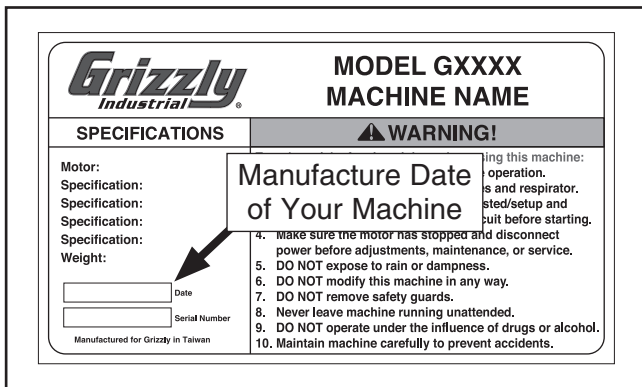
INTRODUCTION

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 questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com





MACHINE DATA SHEET

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

MODEL G0555X 14" EXTREME SERIES BANDSAW

Product Dimensions:

Weight..... 236 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 30 x 26 x 67-1/4 in.
 Footprint (Length x Width)..... 17-1/4 x 16 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard Box
 Content..... Machine
 Weight..... 199 Lbs.
 Length x Width x Height..... 21 x 41 x 20 in.
 Must Ship Upright..... No

Carton #2

Type..... Cardboard Box
 Content..... Stand
 Weight..... 60 Lbs.
 Length x Width x Height..... 17 x 18 x 26 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
 Prewired Voltage..... 110V
 Full-Load Current Rating..... 15A at 110V, 7.5A at 220V
 Minimum Circuit Size..... 20A at 110V, 15A at 220V
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 14 AWG
 Plug Included..... Yes
 Included Plug Type..... 5-15 for 110V
 Recommended Plug Type..... 6-15 for 220V
 Switch Type..... ON/OFF Push Button Switch

Motors:

Main

Type..... TEFC Capacitor-Start Induction
 Horsepower..... 1.5 HP
 Phase..... Single-Phase
 Amps..... 15A/7.5A
 Speed..... 1725 RPM
 Power Transfer..... Belt Drive
 Bearings..... Shielded & Permanently Lubricated



Main Specifications:

Main Specifications

Bandsaw Size.....	14 in.
Max Cutting Width (Left of Blade).....	13-1/2 in.
Max Cutting Width (Left of Blade) w/Fence.....	12-1/4 in.
Max Cutting Height (Resaw Height).....	6 in.
Blade Speeds.....	3000 FPM

Blade Information

Standard Blade Length.....	93-1/2 in.
Blade Length Range.....	92-1/2 – 93-1/2 in.
Blade Width Range.....	1/8 – 3/4 in.
Type of Blade Guides.....	Ball Bearing
Guide Post Adjustment Type.....	Manual
Has Quick-Release.....	Yes

Table Information

Table Length.....	14 in.
Table Width.....	20-1/2 in.
Table Thickness.....	1-1/2 in.
Table Tilt.....	Left 15, Right 45 deg.
Table Tilt Adjustment Type.....	Manual
Floor-to-Table Height.....	44 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	Yes
Resaw Fence Attachment Included.....	Yes
Miter Gauge Included.....	Yes

Construction Materials

Table.....	Precision Ground Cast Iron
Trunnion.....	Aluminum
Fence.....	Extruded Aluminum and Cast Iron
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Cast Iron
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Rubber
Wheel Cover.....	Pre-Formed Steel
Paint.....	Powder Coating & Ure

Other Related Information

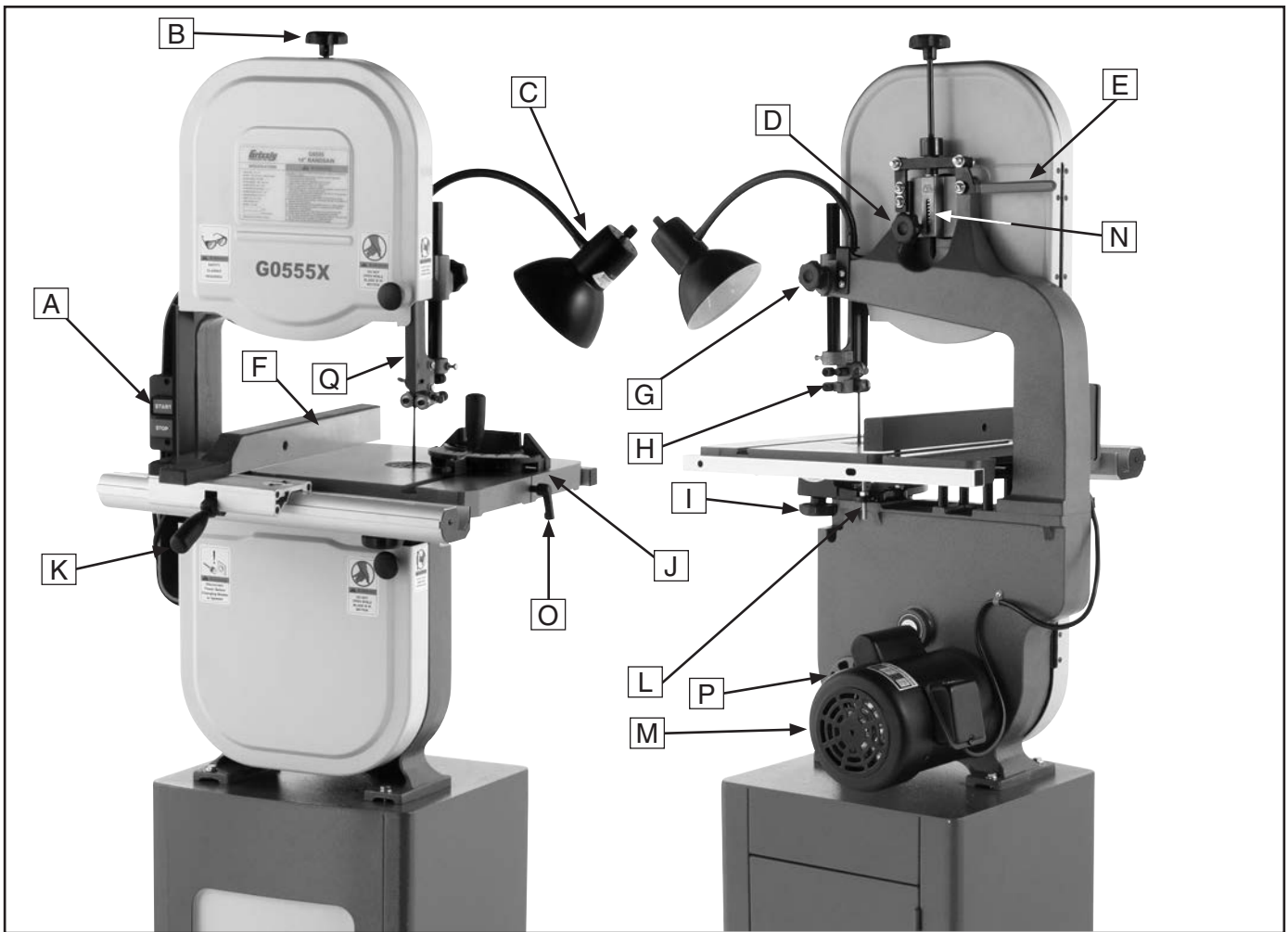
Wheel Diameter.....	13-3/4 in.
Wheel Width.....	1-3/16 in.
Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D3757

Other Specifications:

Country Of Origin.....	Taiwan
Warranty.....	1 Year
Approximate Assembly & Setup Time.....	1-1/2 Hours
Serial Number Location.....	ID Label on Top Cover
ISO 9001 Factory.....	Yes
CSA Certified.....	Yes
Awards.....	Popular Woodworking Best New Tool 2003



Identification



- A. Switch
- B. Blade Tension Knob
- C. Work Light
- D. Blade Tracking Knob
- E. Quick Release Blade Tension Lever
- F. Fence
- G. Guide Post Lock Knob
- H. Upper Blade Guide Assembly
- I. Table Tilt Lock Knob
- J. Miter Gauge
- K. Fence Lock Handle
- L. Lower Blade Guide Assembly
- M. Motor
- N. Blade Tension Scale
- O. Table Pin
- P. 4" Dust Port
- Q. Blade Guard



SECTION 1: SAFETY

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. Always use common sense and good judgment.



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



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



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.

Safety Instructions for Machinery

WARNING

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this 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!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

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.



WARNING

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 loss of workpiece control.

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.

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

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

INTENDED USAGE. Only use machine for its intended purpose and never make modifications not approved by Grizzly. Modifying machine or using it differently than intended may result in malfunction or mechanical failure that can lead to serious personal injury or death!

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.

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

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

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

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

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



WARNING

Additional Safety for Bandsaws

BLADE CONDITION. Do not operate with a 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.

HAND PLACEMENT. Never position fingers or thumbs in line with the cut. Serious personal injury could occur.

GUARDS. Do not operate this bandsaw without the blade guard in place.

BLADE REPLACEMENT. When replacing blades, make sure teeth face toward the workpiece and the blade is properly tensioned before operating.

WORKPIECE HANDLING. Never hold small workpieces with your fingers when cutting. Always support/feed the workpiece with push stick, table support, vise, or some type of clamping fixture.

CUTTING TECHNIQUES. Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw OFF and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing work away.

BLADE SPEED. Allow blade to reach full speed before cutting.

LEAVING WORK AREA. Never leave a machine running while unattended. Allow the bandsaw to come to a complete stop before leaving unattended.

FEED RATE. Always feed stock evenly and smoothly. DO NOT force or twist blade while cutting, especially when sawing tight curves.

WORKPIECE MATERIAL. This machine is designed to cut wood only—it is not designed to cut metal.

MAINTENANCE/SERVICE. Do all inspections, adjustments, and maintenance with the power OFF and the plug removed from the outlet. Wait for all moving parts to come to a complete stop.

BLADE CONTROL. Do not attempt to stop or slow the blade with your hand or a workpiece. Allow the blade to stop on its own.

EXPERIENCING DIFFICULTIES. If you experience difficulties performing the intended operation, stop using the machine and contact our Technical Support Department at (570) 546-9663.

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 lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

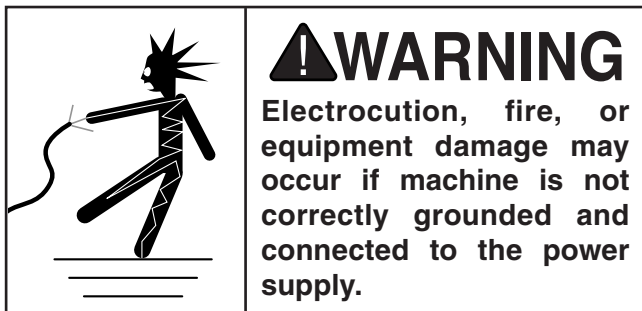
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: 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 an electrician or qualified service personnel in accordance with all applicable codes and standards.



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 110V..... 15 Amps

Full-Load Current Rating at 220V 7.5 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 Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

! CAUTION
For your own safety and protection of property, consult an 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.*

Circuit Requirements for 110V

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V/120V
Cycle.....60 Hz
Phase..... **Single-Phase**
Power Supply Circuit **15 Amps**
Plug/Receptacle **NEMA 5-15**

Circuit Requirements for 220V

This machine can be converted to operate on a 220V power supply (refer to **Voltage Conversion** instructions). This power supply must have a verified ground and meet the following requirements:

Nominal Voltage **220V/240V**
Cycle.....60 Hz
Phase..... **Single-Phase**
Power Supply Circuit **15 Amps**
Plug/Receptacle **NEMA 6-15**



Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). 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.

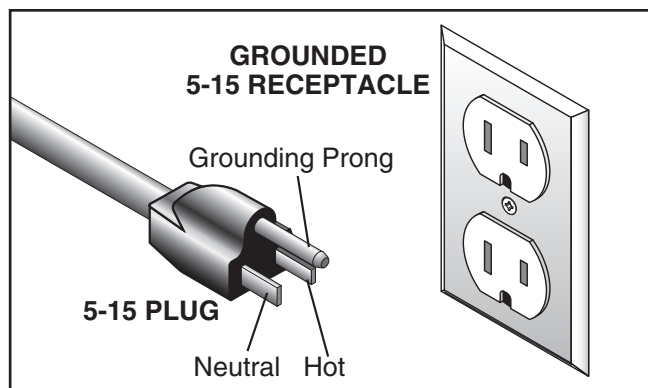
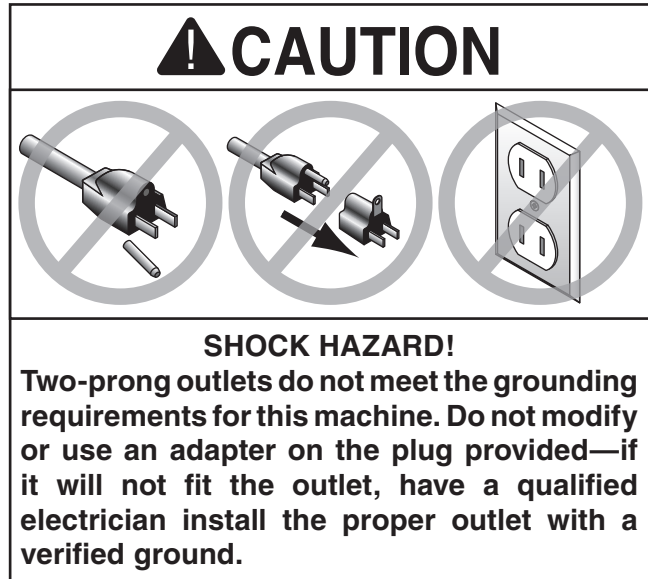


Figure 1. Typical 5-15 plug and receptacle.



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

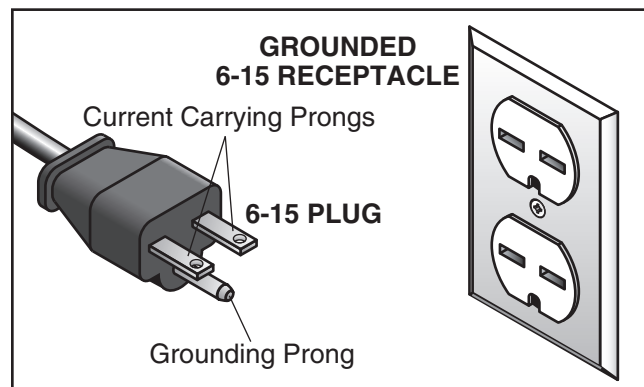


Figure 2. Typical 6-15 plug and receptacle.

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

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).

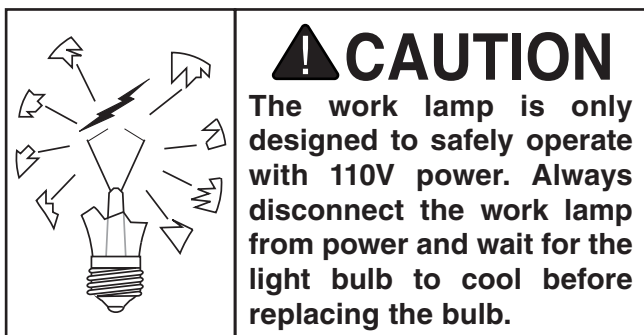
Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size14 AWG
Maximum Length (Shorter is Better).....50 ft.

Work Lamp

The work lamp included with this machine is not part of the electrical wiring of the machine. The lamp must be connected to a separate grounded 120V circuit that accepts the included 5-15 plug.

Use only a replacement light bulb that is rated 40 watts or below. When changing the light bulb, always disconnect the lamp from power and wait for the bulb to cool.



Voltage Conversion

The voltage conversion **MUST** be performed by an electrician or qualified service personnel.

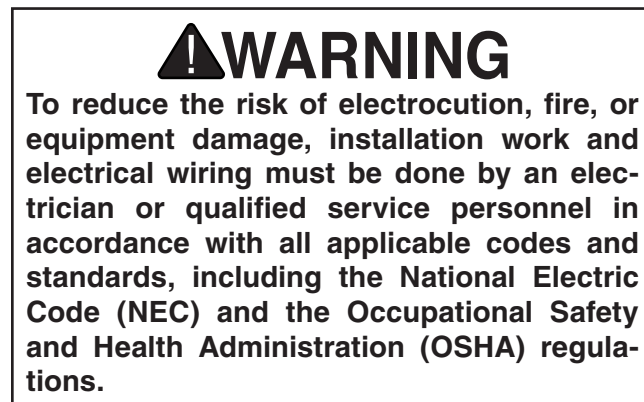
To perform the voltage conversion, install the correct plug and rewire the motor to the new voltage, according to the provided wiring diagram on **Page 47**.

The START/STOP switch is a dual-voltage switch (110V/220V) and does not need to be re-wired or replaced.

Note: *If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided inside the motor wiring junction box.*

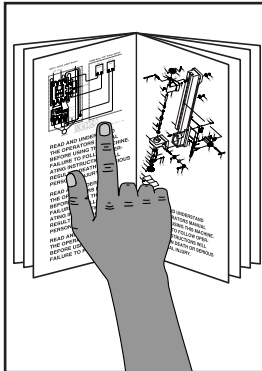
To convert the machine to 220V:

1. DISCONNECT MACHINE FROM POWER!
2. Replace the 5-15 plug on the power cord with a 6-15 plug.
3. Re-wire the motor as illustrated in the wiring diagram on **Page 47**.



SECTION 3: SET UP

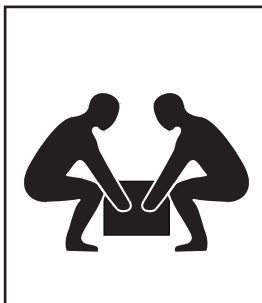
Set Up Safety



! 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 G0555X is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Needed for Setup

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

Description	Qty
• Straightedge	1
• Level.....	1
• Another Person for Lifting Help.....	1
• Square.....	1
• Safety Glasses (for each person)	1
• Dust Collection System	1
• 4" Dust Hose (length as needed).....	1
• 4" Hose Clamp	1

Unpacking

The Model G0555X 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 advice.*

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

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



Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary 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.

Main Components: (Figure 3)	Qty
A. Stand	1
B. Bandsaw Unit	1
C. Trunnion Base	1
D. Lever Board.....	1
E. Miter Gauge.....	1
F. Extension Table.....	1
G. Main Table.....	1
H. Fence Assembly.....	1
I. Resaw Fence	1
J. Front Fence Rail.....	1
K. Rear Fence Rail	1

Fasteners and Tools: (not shown)	Qty
• Rubber Feet (Stand)	4
• Hex Nuts 3/8-16 (Feet/Stand)	8
• Flat Washers 10mm (Feet/Stand)	8
• Hex Bolts M8-1.25 x 35 (Bandsaw/Stand) .	4
• Flat Washers 8mm (Bandsaw/Stand)	8
• Lock Washers 8mm (Bandsaw/Stand).....	4
• Hex Nuts M8-1.25 (Bandsaw/Stand).....	4
• Hex Bolts M8-1.25 x 30 (Trunnion Base)...	2
• Lock Washers 8mm (Trunnion Base).....	2
• Hex Bolt M8-1.25 x 80 (Positive Stop).....	1
• Hex Nut M8-1.25 (Positive Stop)	1
• Spacers (Lever Board)	4
• Cap Screws M8-1.25 x 60 (Lever Board) ..	4
• Hex Nuts M8-1.25 (Lever Board)	4
• Set Screws M8-1.25 x 20 (Lever Board)....	4
• Cap Screws M6-1 x 25 (Lever Board)	4
• Lock Washers 6mm (Lever Board)	4
• Flat Washers 6mm (Lever Board).....	4
• Knobs M10-1.5 (Table)	2
• Hex Bolts M6-1 x 20 (Front Rail)	2
• Flat Washers 6mm (Front Rail).....	2
• Lock Washers 6mm (Front Rail)	2
• Cap Screws M6-1 x 16 (Rear Rails)	2
• Lock Handle M8-1.25 x 20 (Fence).....	1
• Hex Nut M8-1.25 (Fence).....	1

- Moving Plate (Resaw)..... 1
- Lock Handle M8-1.25 x 44 (Resaw)..... 1
- Flat Washer 8mm (Resaw)
- Hex Wrenches 3, 4, 5mm

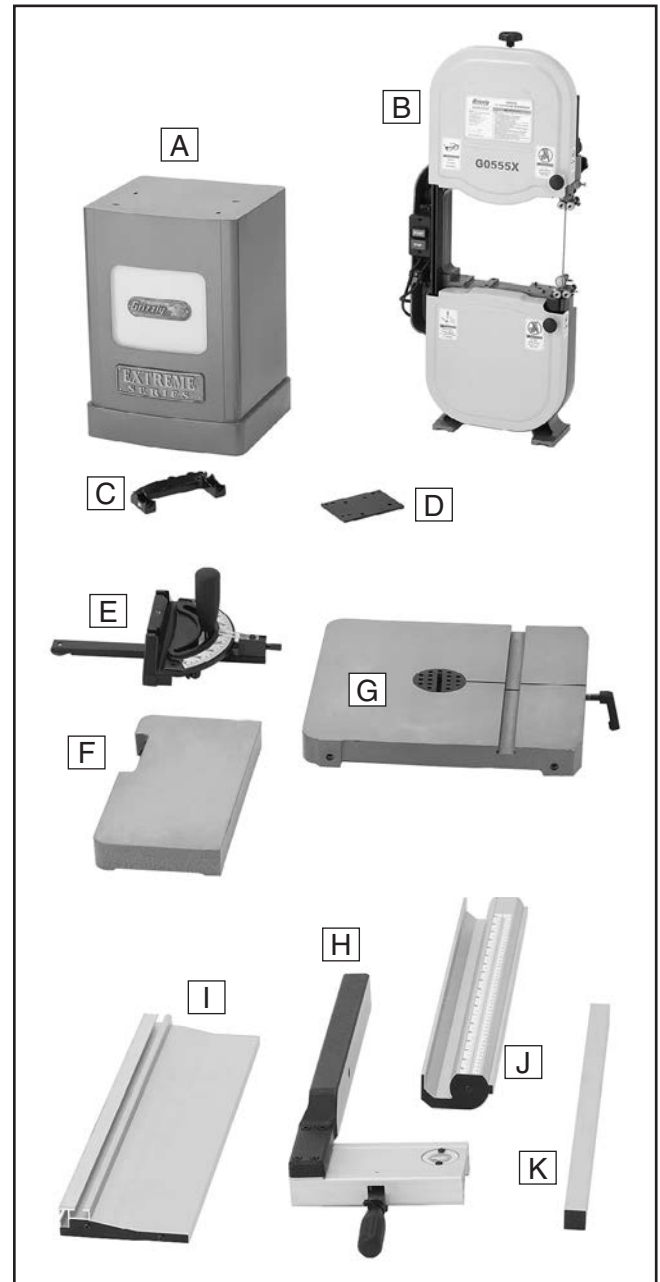


Figure 3. Main components inventory.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.



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 works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

Site Considerations

Workbench Load

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

Placement Location

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.

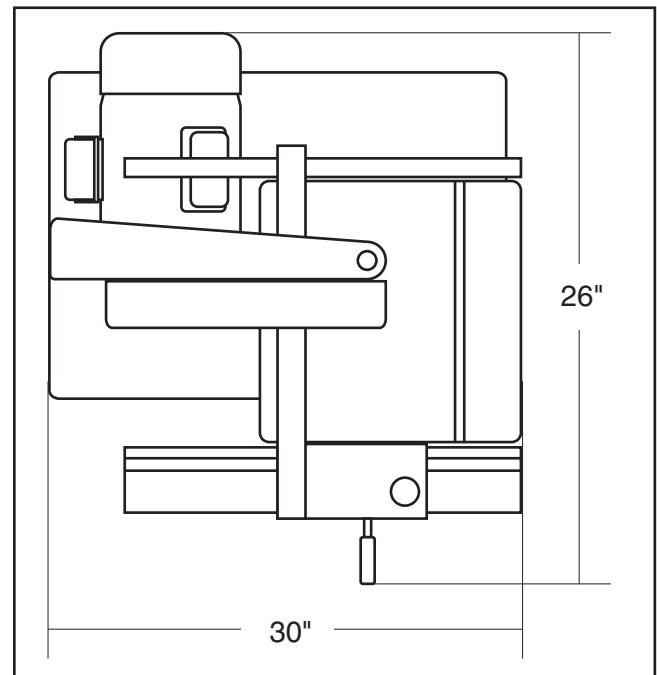
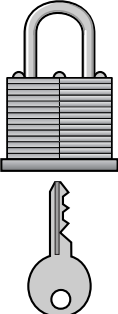


Figure 4. Minimum working clearances.

	<p>CAUTION</p> <p>Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
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Assembly

To assemble the bandsaw:

1. Install the rubber feet into the bottom of the cabinet stand, as shown in **Figure 5**, with the $\frac{3}{8}$ -16 hex nuts and 10mm flat washers.

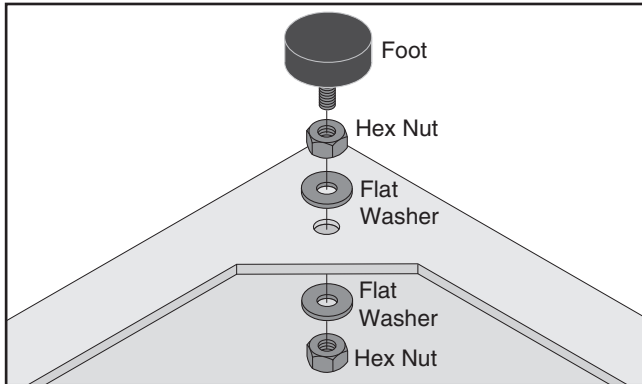
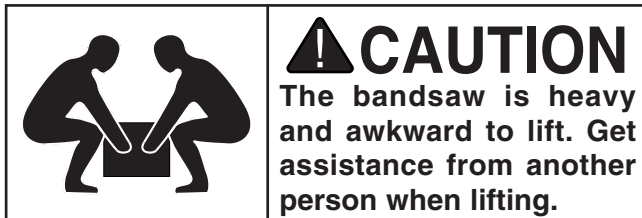


Figure 5. Rubber foot order of installation.

2. Level the cabinet stand by adjusting the feet up or down, then tighten the hex nuts against the stand to secure the feet in place.



3. Get an assistant to help you lift the bandsaw and place it on top of the stand.
4. Line up the mounting holes on the bandsaw base with those on the stand.
5. Secure the bandsaw to the stand with the four M8-1.25 x 35 hex bolts, eight 8mm flat washers, four 8mm lock washers, and four M8-1.25 hex nuts (**Figure 6**).



Figure 6. Bandsaw mounted to stand.

6. Fasten the trunnion base to the bandsaw, as shown in **Figure 7**, with the two M8-1.25 x 30 hex bolts and two 8mm lock washers.

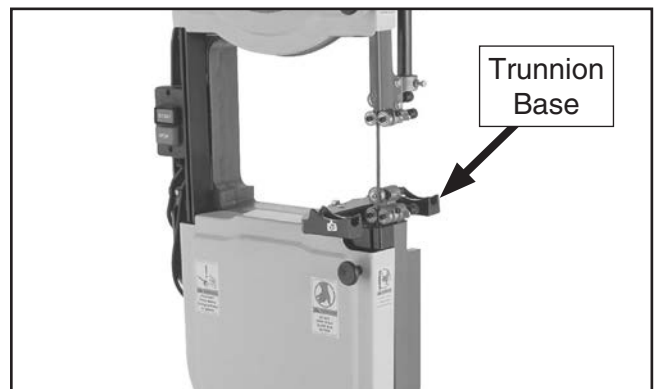


Figure 7. Installing trunnion base.

7. Thread an M8-1.25 hex nut halfway up the M8-1.25 x 80 hex bolt.
8. Thread the M8-1.25 x 80 hex bolt (a.k.a. positive stop bolt) into the trunnion base so it is installed similar to **Figure 8**.

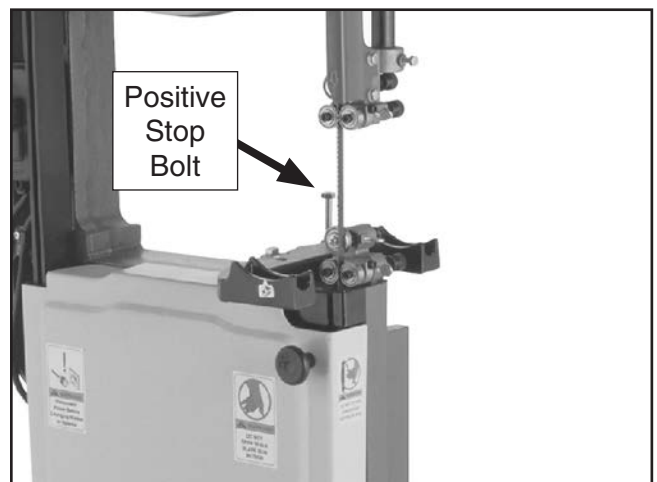


Figure 8. Shows positive stop bolt installed.

- Attach the lever board to the bandsaw body with the four spacers and four M8-1.25 x 60 cap screws, as shown in **Figure 9**.

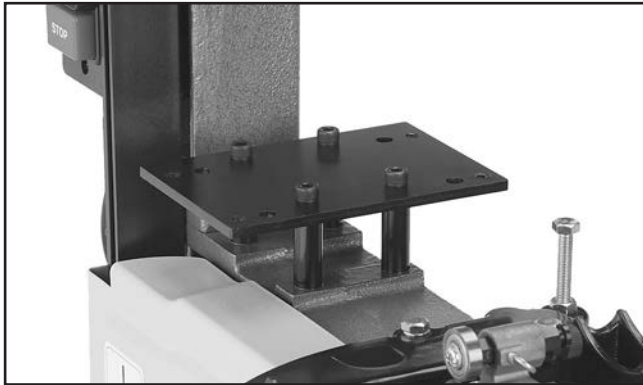


Figure 9. Lever body attached.

- Thread the four set screws into the lever board from underneath until they are flush with the top of the lever board (**Figure 10**), then thread the M8-1.25 hex nuts up the set screws and against the lever board.

Note: *The hex nuts act to lock the set screws in place once they are positioned, so they do not vibrate loose during operation.*

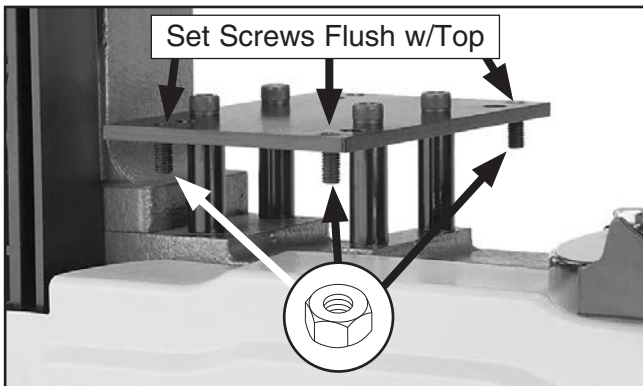


Figure 10. Set screws installed in lever board (3 of 4 shown).

- Attach the extension table to the lever board with the four M6-1 x 25 cap screws, four 6mm flat washers, and four 6mm lock washers (**Figure 11**). Only thread the cap screws in halfway for now (adjustments to the extension table will be made later).

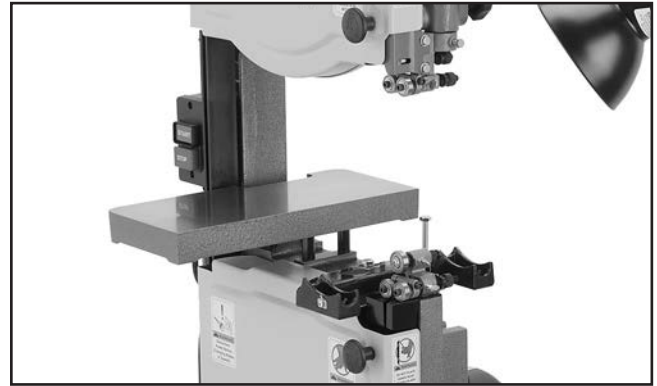


Figure 11. Extension table installed.

- Remove the table insert from the center of the table and remove the table pin from the end of the table slot.
- Fit the table around the blade and rest the table trunnions on the trunnion base, making sure the trunnion bolts are hanging out of the bottom of the trunnion base.
- Thread the two M10-1.5 knobs onto the trunnion bolts hanging through the bottom of the trunnion base, as illustrated in **Figure 12**.

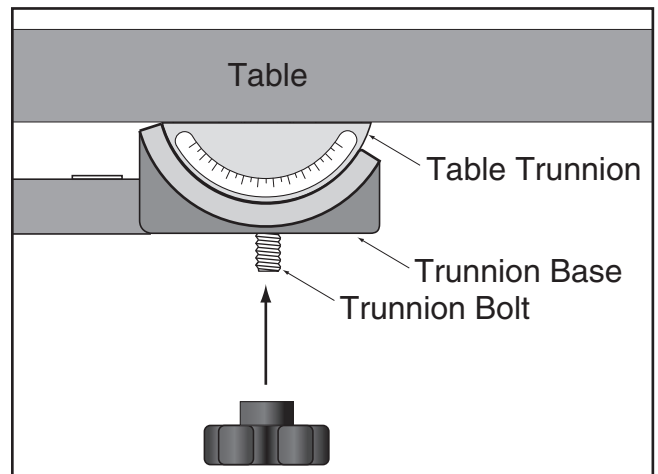


Figure 12. Table installation on trunnion base.

- Place the table insert in the center of the table, so it sits flush with the table top surface.
- Insert the pin into the end of the table slot.

17. Fasten the front fence rail to the front of the bandsaw table with the two M6-1 x 20 hex bolts, two 6mm lock washers, and two 6mm flat washers, as shown in **Figure 13**.



Figure 13. Fastening front fence rail to table.

18. Fasten the rear fence rail to the back of the bandsaw with two M6-1 x 16 cap screws.
19. Thread the M8-1.25 hex nut from the hardware bag onto the fence handle threads, then thread the fence handle into the fence.
20. Tighten the hex nut (already on the fence handle threads) down to the fence body to keep the fence handle from rotating.
21. Pull the fence handle up and place the fence on the front fence rail as shown in **Figure 14**.

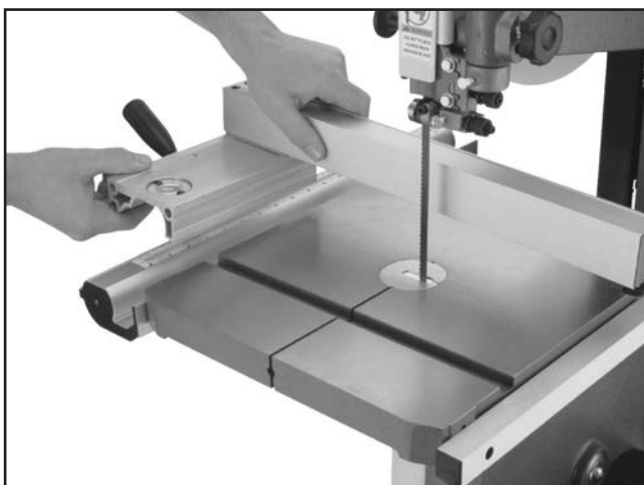


Figure 14. Installing fence onto rails.

22. Push the fence handle down to lock the fence in position.
23. Insert the lock handle with washer through the hole in the fence and attach the moving plate (**Figure 15**) on the other side.
24. Slide the resaw fence over the moving plate as shown in **Figure 15**, center it with your original fence, then lock it in position by tightening the lock handle.

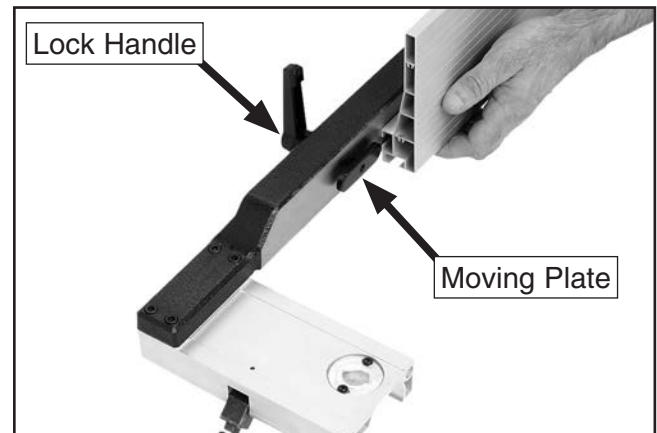


Figure 15. Installing resaw fence.

25. Install a light bulb that is rated for the wired voltage of the machine. The bulb must not exceed 60W.

Dust Collection

⚠ CAUTION

Only operate the Model G0555X with an adequate dust collection system. This saw creates substantial amounts of fine wood dust while operating. Failure to use a dust collection system can result in respiratory illness.

Recommended CFM at Dust Port: 400 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 a dust collection hose:

1. Fit the 4" dust hose over the dust port, as shown in **Figure 16**, and secure in place with a hose clamp.
2. Tug the hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.

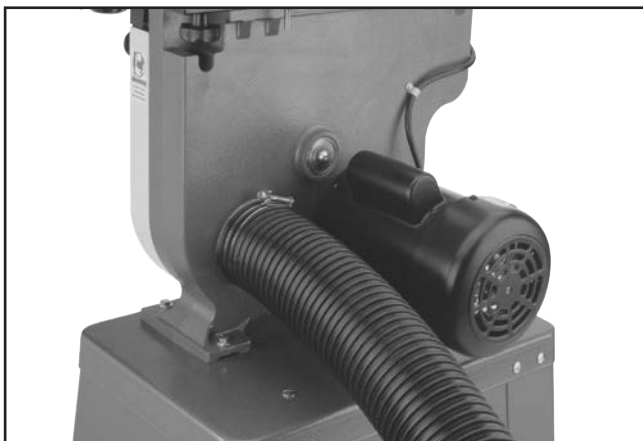


Figure 16. Dust hose attached to dust port.

Blade Tracking

"Blade Tracking" is how the blade rides on the wheels. When tracking correctly, the blade rides in the center of both wheels.

Blade tracking is primarily controlled by adjusting the upper wheel tilt. Tracking the blade in this manner is referred to as "Center Tracking," because you tilt the wheel until the blade rides in the center.

Another way to track the blade is known as "Coplanar Tracking." Coplanar tracking involves aligning the wheels so they are parallel and aligned. (See **Wheel Alignment** on **Page 42**.) When wheels are coplanar, the bandsaw decreases vibration and heat.

The wheels on the Model G0555X are factory aligned, so center tracking is the only adjustment that needs to be performed

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Adjust the upper/lower guide bearings and support bearings away from the blade.
3. Open the upper wheel cover.
4. Adjust the blade tension to match the size of the installed blade with the mark on the blade tension scale located on the back of the bandsaw.
5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 17** for an illustration of this concept.

—If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, then the bandsaw is already tracked properly and no additional adjustments are needed. Skip to **Step 9**.

—If the blade does not ride in the center of the upper wheel and is not centered on the peak of the wheel crown, then continue with the next step.



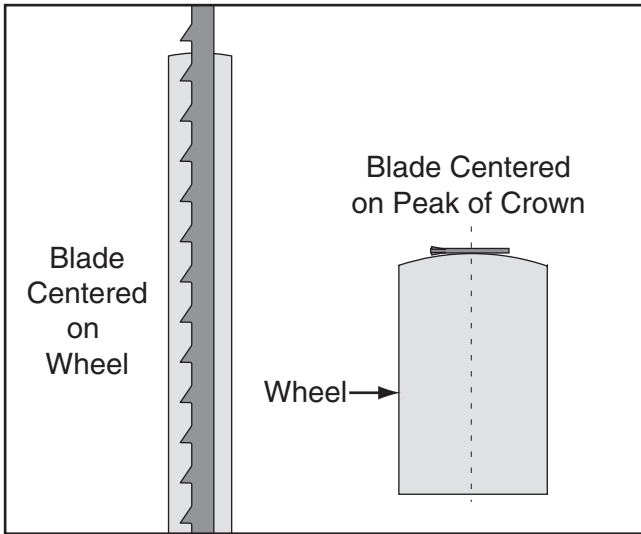


Figure 17. Center tracking profiles.

6. Loosen the lock nut on the blade tracking knob threads so the blade tracking knob will rotate for adjustments.
7. Spin the upper wheel with one hand and rotate the blade tracking knob with the other hand to make the blade ride in the center of the bandsaw wheel tire.
8. After the blade consistently rides in the center of the wheel, tighten the tracking control lock nut.
9. Close the upper wheel cover.

Note: For the best performance from your saw, regularly maintain the proper tracking of the blade.

NOTICE

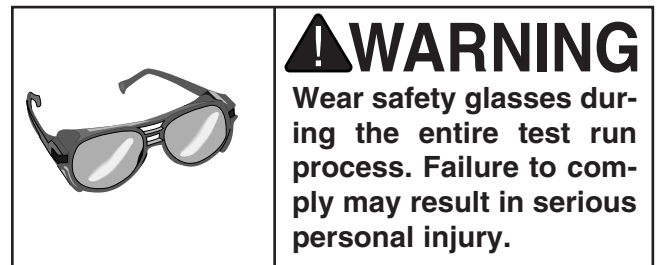
Changes in the blade tension may change the blade tracking.

Test Run

Once the assembly is complete and you have performed the **Blade Tracking** steps on **Page 18**, you need to test run the machine to continue with the remainder of the adjustments.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop the machine immediately, then review **Troubleshooting** on **Page 37**.

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



To test run the machine:

1. Connect the machine to the power source.
2. Make sure that you have read the **Safety** section at the beginning of the manual and that the machine is setup properly.
3. Make sure all tools and objects used during set up are cleared away from the machine.
4. Turn the machine **ON**.
5. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises must be investigated and corrected before operating the machine further. Always disconnect the machine from power before investigating or correcting potential problems.



Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is a prerequisite for making many bandsaw adjustments.

To tension the bandsaw blade:

1. Make sure that you have performed the **Test Run** instructions on the previous page and that the blade is tracking properly.
2. With the blade tension lever in the down (engaged) position, adjust the blade tension so the mark on the blade tension scale matches the size of blade that is installed on the bandsaw.

Note: *Because each blade is different and all blades stretch, this scale can only be considered as a general guide.*

3. Turn the bandsaw **ON**.
4. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.
5. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension one more quarter of a turn.
6. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future.

Note: *However, do not rely on this measurement for long periods of time because the blade will stretch with use.*

NOTICE

To reduce blade stretching, remove the tension from the blade when not in use.

NOTICE

After blade tension and tracking are set correctly, properly adjust the upper/lower support bearings and guide-block assemblies into position before cutting operations.

Adjusting Support Bearings

The support bearings are positioned behind the blade and support the back of the blade during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Familiarize yourself with the support bearing controls shown in **Figure 18**.

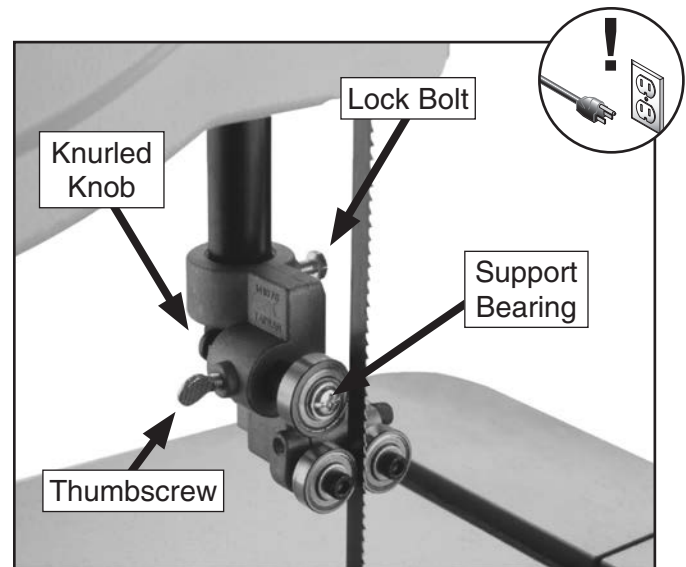


Figure 18. Support bearing controls.

4. Loosen the lock bolt shown in **Figure 18**.

5. Look at the face of the support bearing and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing as illustrated in **Figure 19**.

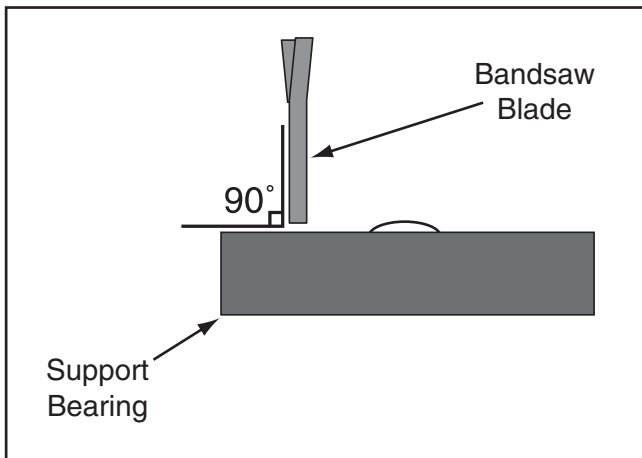


Figure 19. Blade should be perpendicular (90°) to the face of the support bearing.

6. Tighten the lock bolt.
7. Loosen the thumbscrew on the support bearing adjustment shaft.
8. Use the knurled knob to position the support bearing approximately 0.016" away from the back of the blade as illustrated in **Figure 20**.

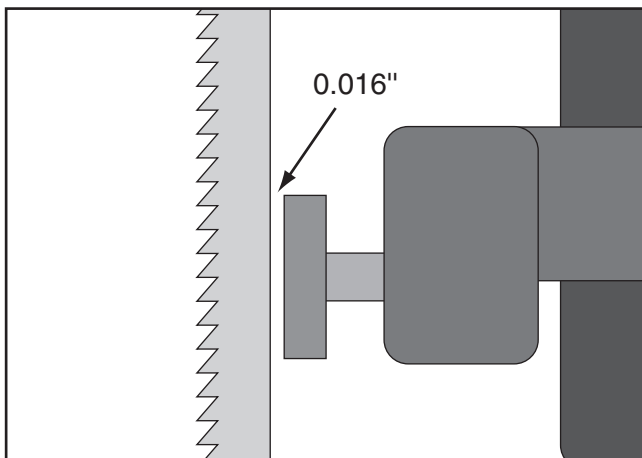


Figure 20. Blade should be aligned approximately 0.016" away from the bearing edge.

9. To quickly gauge this setting, fold a dollar bill in half twice (when folded tightly, four thicknesses of a dollar bill is approximately 0.016"). Place the folded dollar bill between the support bearing and the blade as shown in **Figure 21**.

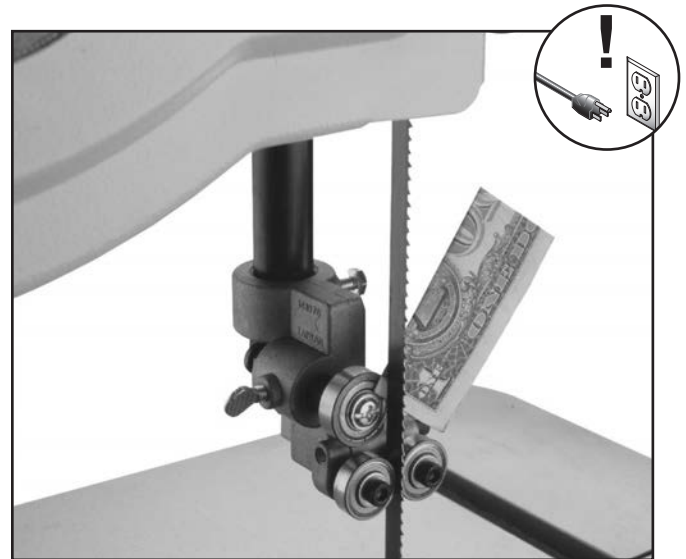


Figure 21. Dollar bill folded twice to make a quick 0.016" gauge.

10. Tighten the thumbscrew to lock the support bearing in place.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be re-adjusted before cutting operations.

Adjusting Blade Guides

The blade guides provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side. Properly adjusted blade guides are essential to making accurate cuts.

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Familiarize yourself with the blade guide controls shown in **Figure 22**.

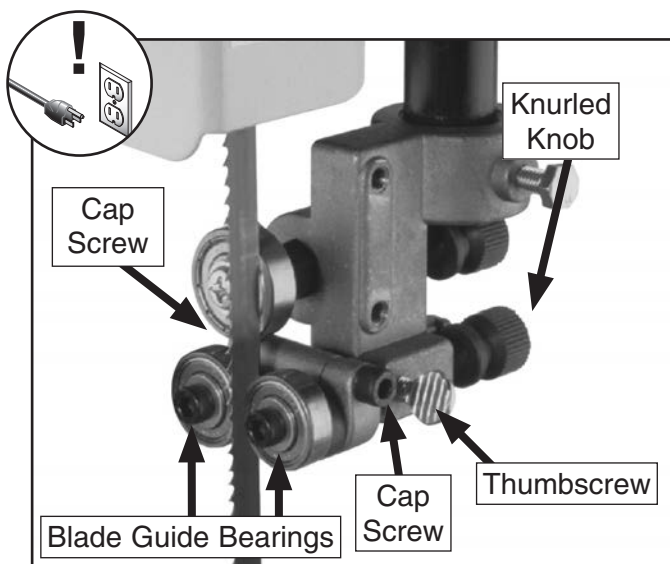


Figure 22. Blade guide controls.

4. Loosen the thumbscrew on the forward/backward adjustment rod.
5. Rotate the knurled knob behind the blade guides to position the blade guides laterally, so the front edges of the bearings are just behind the blade gullets as illustrated in **Figure 23**.

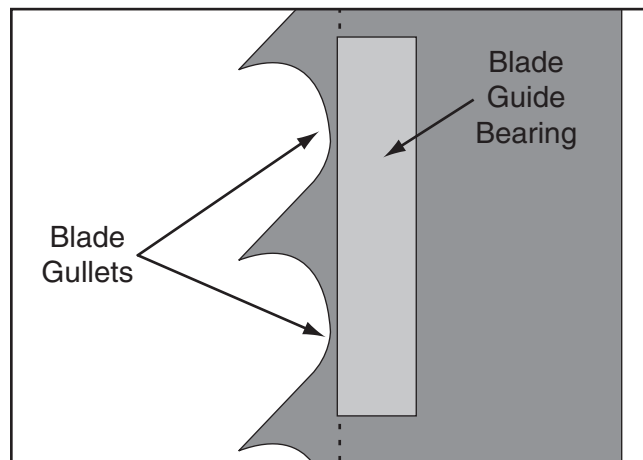


Figure 23. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut.

6. Tighten the thumbscrew on the lateral adjustment rod so the knurled knob will not turn.
7. Use a hex wrench to loosen the cap screws behind the blade guides.
8. With a hex wrench, rotate the cap screws in the center portion of the blade guides to position the bearings so they make very light contact on both sides of the blade as illustrated in **Figure 24**.

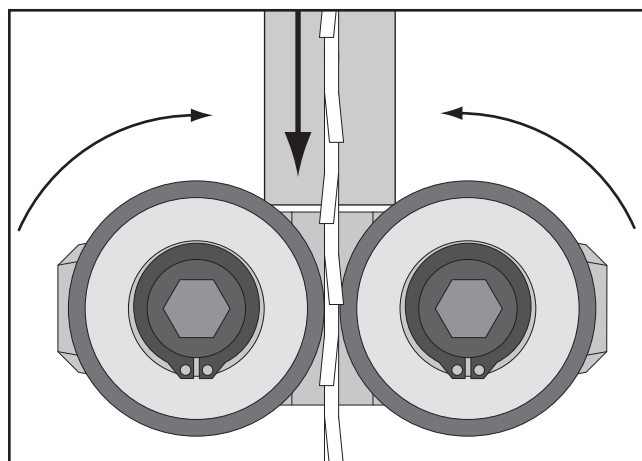


Figure 24. Blade guide bearings against both sides of blade.

NOTICE

The blade guides should only have light pressure against the blade.

9. Tighten the cap screws to lock the blade guides in position.

When the blade guide bearings are properly positioned, they rotate when the bandsaw wheel is turned and they can be rotated with your fingers when the blade is still.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade guide bearings and guide-blocks must be re-adjusted before cutting operations.

Adjusting Positive Stop

An adjustable positive stop allows the table to easily return to 90° after tilting.

To set the positive stop 90° to the blade:

1. Make sure the blade is correctly tensioned as described in the **Tensioning Blade** instructions on **Page 20**.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Loosen the two plastic knobs that secure the table to the trunnions.
4. Loosen the hex nut that locks the positive stop bolt in place.
5. Raise the upper blade guide assembly and place a 6" machinist's square or try-square on the table next to the side of the blade as illustrated in **Figure 25**. Adjust the positive stop bolt to raise or lower the table until the table is 90° to the blade.

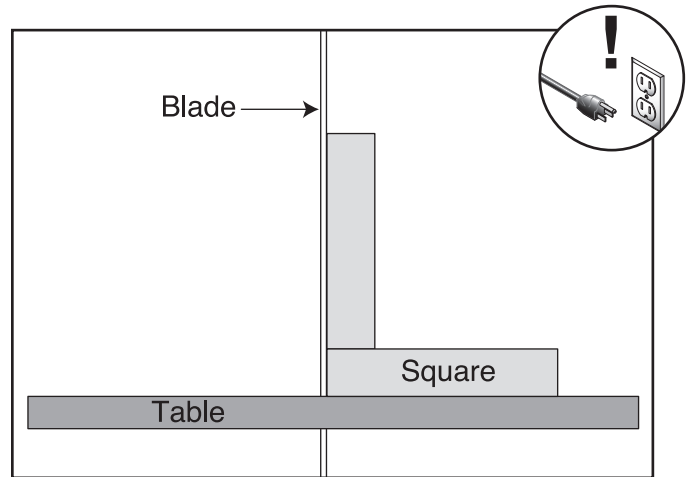


Figure 25. Squaring table to blade.

6. Secure the plastic knobs and lock the positive stop bolt by tightening the hex nut against the casting. *Ensure that the bolt does not turn by holding with another wrench while tightening the hex nut.*

Setting Table Tilt Scale to 0°

The pointer on the table tilt scale must be calibrated in order for the scale reading to be accurate.

To calibrate the pointer on the table tilt scale:

1. Make sure that the blade is tensioned and is tracking correctly, and that the table is 90° to the blade (this procedure should be already completed with the **Adjusting Positive Stop** instructions).
2. Loosen the screw on the pointer so the pointer is able to move.
3. Align the tip of the pointer with the 0° mark on the table tilt scale.
4. Tighten the screw on the pointer so the pointer is locked in place.

Leveling Extension Table

The extension table must be level with the main table. It is important to keep the extension table at least $\frac{1}{8}$ " away from the main table during leveling to allow the table room for tilting.

To level the extension table:

1. Set the table to 90°.
2. Locate the lever board set screws underneath the extension table (see **Figure 10** on **Page 16**) and loosen the hex nuts on the set screws. This will allow you to adjust the set screws when leveling the extension table.
3. Place a straightedge across the front of the main table and extension table as shown in **Figure 26**.

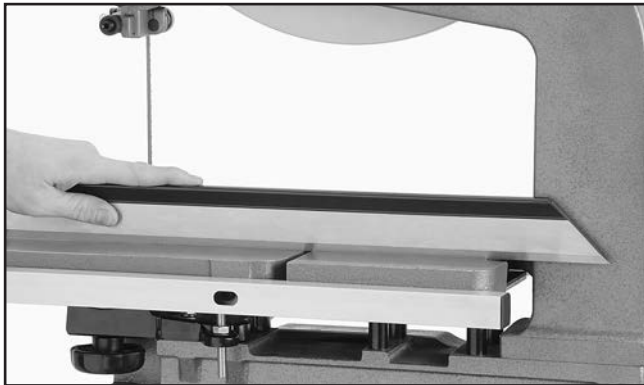


Figure 26. Leveling extension table with straightedge.

4. Adjust the two front setscrews in the lever board until the extension table is even with the main table.
5. Place a straightedge across the rear of the main table and extension table.
6. Adjust the two front setscrews in the lever board until the extension table is even with the main table.
7. Repeat **Steps 3–4**.
8. Repeat **Steps 5–6**.
9. Tighten the cap screws that secure the extension table to the lever board.
10. Verify that the extension table did not move during tightening and adjust if necessary.
11. Tighten the hex nuts, loosened in **Step 2**, against the lever board so the set screws cannot vibrate out of adjustment.

Aligning Table

To ensure cutting accuracy when the table is first installed, the table should be aligned so the miter slot is parallel to the bandsaw blade. *This procedure works best with a 3/4" blade.*

To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Loosen the trunnion bolts that secure the trunnions to the table.
4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.
5. Use a fine ruler to gauge the distance between the blade and the miter slot. The distance you measure should be the same at both the front and back ends of the miter slot.
6. Adjust the table as needed until the distance between the blade and miter slot is equal at both ends, as measured in **Step 5**.
7. Tighten the trunnion bolts.

Aligning Fence

To ensure cutting accuracy, the fence must be parallel with the miter slot.

To align the fence parallel with the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and remount it on the right-hand side of the blade.
2. Loosen the four cap screws located on the top face of the fence.
3. Adjust the fence face parallel with the edge of the miter slot.
4. Tighten the four cap screws, being careful not to move the fence.

NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the Aligning Table instructions.

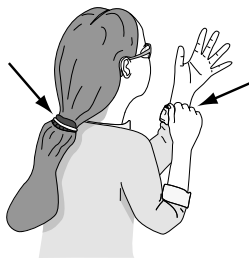
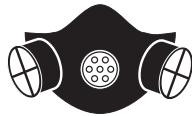


SECTION 4: OPERATIONS

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.

Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing the following types of cuts:

Straight Cuts

- Mitters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

A properly adjusted bandsaw can be safer to operate than most other saws and performs many functions with ease and accuracy.

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades as necessary. Make adjustments periodically to keep the saw running in top condition.
- Use light and even pressure while cutting. Light contact with the blade eases line following and prevents undue friction.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners.
- Misusing the saw or using incorrect techniques is unsafe and results in poor cuts. Remember—the blade does the cutting with the operator's guidance.



Disabling & Locking Switch

The ON/OFF switch can be disabled and locked by inserting a padlock through the ON button, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

IMPORTANT: Locking the switch with a padlock only restricts its function. It is not a substitute for disconnecting power from the machine when adjusting or servicing.

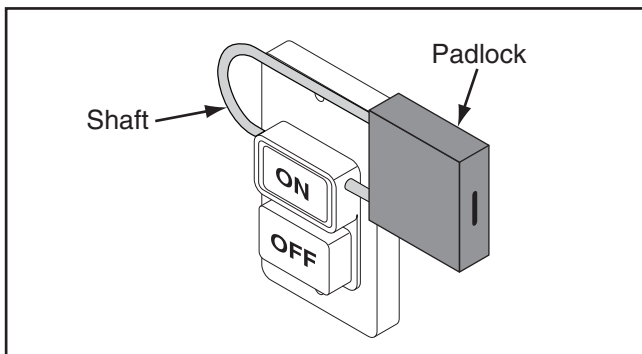


Figure 27. Switch disabled by a padlock.

!WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, disable and lock the switch before leaving machine unattended! Place key in a well-hidden or secure location.

NOTICE

The padlock shaft diameter is important to the disabling function of the switch. With any padlock used to lock the switch, test the switch after installation to ensure that it is properly disabled.

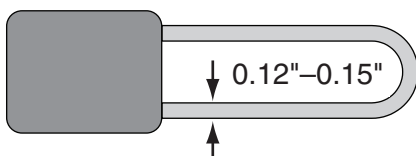


Figure 28. Minimum lock shaft requirements.

Motor Switch

The motor switch shown in **Figure 29** is clearly marked for starting/stopping the machine.

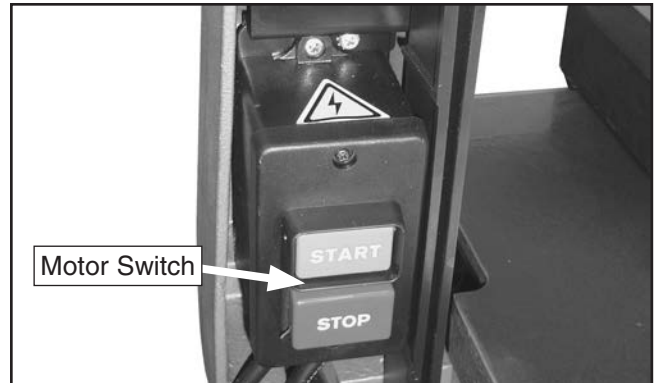


Figure 29. Motor switch.

Table Tilt

The bandsaw table tilts 10° left and 45° right to provide a wide range of cutting options.

To tilt the table:

1. Loosen the two table-trunnion knobs underneath the table.
2. Tilt the table to the desired angle. (Refer to the angle gauge on the front table trunnion.)
3. Retighten both table-trunnion knobs.

NOTICE

When tilting the table to the left, it is necessary to remove the positive stop.

Guide Post

The guide post (shown in **Figure 30**) connects the upper blade guide assembly to the bandsaw. The guidepost allows the blade guide assembly to move up or down to be as close to the workpiece as possible. In order to cut accurately and safely, the bottom of the blade guide assembly must be no more than 1" from the workpiece at all times—this positioning provides the greatest support to the blade and minimizes operator exposure to the blade.

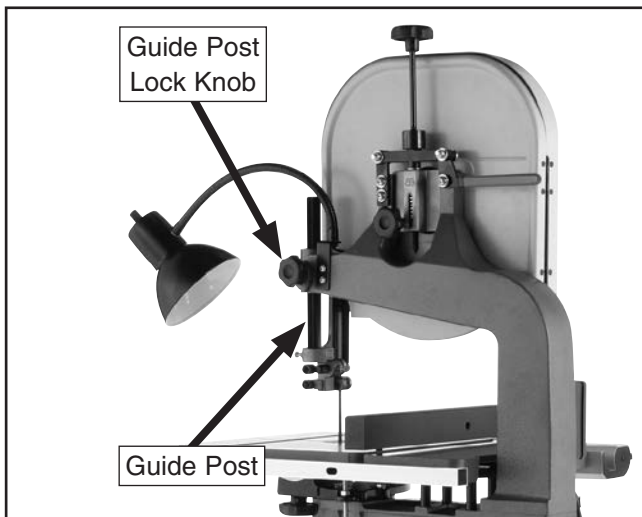


Figure 30. Guide post controls.

To adjust the blade guide assembly on the guide post (the bandsaw must be turned OFF):

1. Make sure that the blade tension, blade tracking, support bearing and blade guides are adjusted correctly.
2. Loosen the guide post lock knob shown in **Figure 30**.
3. Raise/lower the guide post so the bottom of the blade guide assembly is less than 1" from the top of the workpiece.
4. Lock the guide post with the lock knob.

Ripping

"Ripping" means cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece, then lock the fence in place.
2. Adjust the blade guide assembly to less than 1" away from the workpiece.
3. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 31** shows a typical ripping operation.

Note: *If you cut narrow pieces, use a push stick to protect your fingers.*



Figure 31. Typical ripping operation.

⚠ WARNING

NEVER place fingers or hands in the line of cut. If you slip, your hands or fingers may go into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!

Crosscutting

"Crosscutting" means cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the workpiece.

To make a 90° crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.
2. Adjust the blade guide assembly to less than 1" away from the workpiece and make sure the miter gauge is set to 90°.
3. Move the fence out of the way. Place the workpiece evenly against the miter gauge.
4. Hold the workpiece against the miter gauge and align the mark with the blade.
5. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 32** shows a typical crosscutting operation.

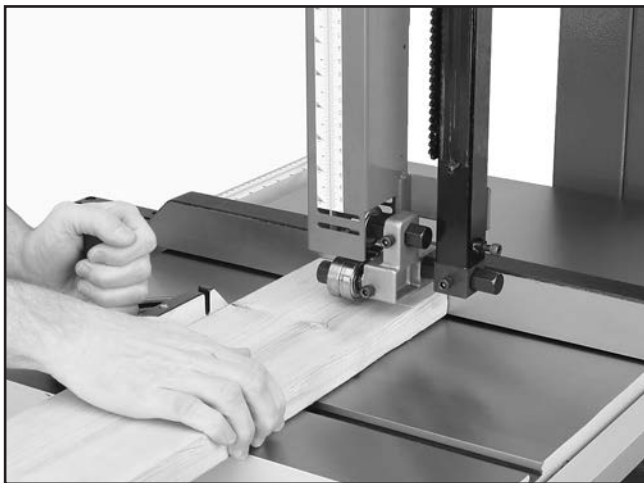


Figure 32. Typical crosscutting operation.

Resawing

"Resawing" (**Figure 33**) means cutting the thickness of a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

One of the most important considerations for resawing is blade selection—a wide blade cuts straighter and is less prone to blade lead (see **Page 41** for more info on blade lead).

For most applications, use a blade with a hook or a skip tooth style. Choose blades with fewer teeth-per-inch (from 3 to 6), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.



Figure 33. Typical resawing operation.

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the table is perpendicular to the blade.
2. Use the widest blade your bandsaw will accept. **Note:** *The blade must also be sharp and clean.*
3. Install the resaw fence, adjust it to the desired width of cut, and lock it in place.

!WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the side of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.

4. Support the ends of the board if necessary.
5. Turn the bandsaw **ON**.
6. Using push paddles and a push stick, maintain workpiece pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece (see **Figure 33**).

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so the blade follows the layout line without twisting. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use a narrower blade, a blade with more TPI (teeth per inch), or more relief cuts.

Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. Relief cuts reduce the chance that the blade will be pinched or twisted by removing waste wood from the workpiece and alleviating any pressure on the back of the blade.

NOTICE

The list below shows the minimum radii for different blade widths.

Width	Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking workpieces together and cutting them as one. Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90°; otherwise, any error will be compounded.

To complete a stacked cut:

1. Align your pieces from top-to-bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)
3. On the face of the top piece, mark the shape you intend to cut.
4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could cause the blade to bind.
5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 34**.

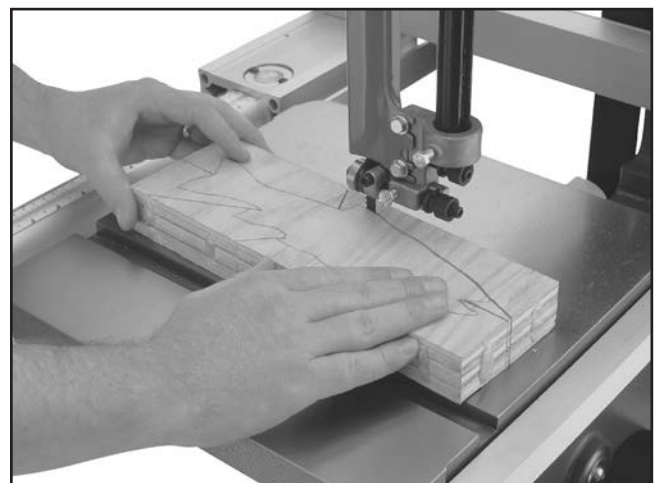


Figure 34. Typical stacked cut.

Blade Information

Selecting the right blade requires a knowledge of various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0555X is designed for blades that are 93½" long. Refer to **Page 32** for blade replacements.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0555X uses blades from ⅛" to ¾" in width. Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 35** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

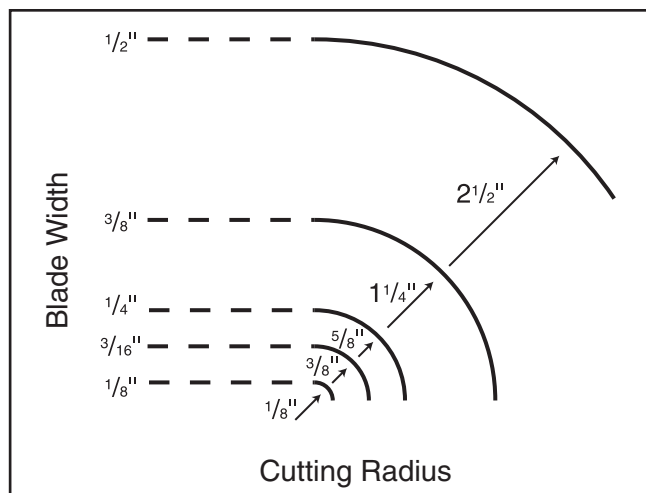


Figure 35. Blade width radii.

- **Straight Cutting:** Use the largest width blade that you own. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, large blades excel at cutting straight lines, but function poorly at cutting small curves because of their size.

Tooth Style

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

Figure 36 illustrates the three main categories of tooth style:

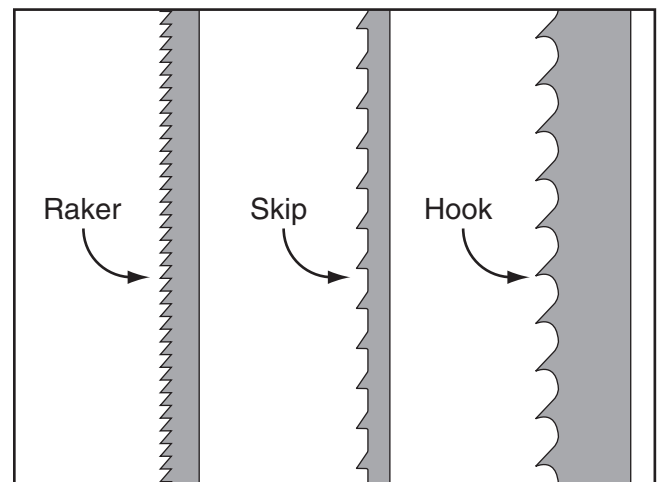


Figure 36. Raker, Skip & Hook tooth styles.

- **Raker:** This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but do not cut fast and generate more heat while cutting.
- **Skip:** This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.

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

Tooth Pitch

Usually measured as TPI (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

Blade Care

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

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

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

Blade Breakage

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

The most common causes of blade breakage are:

- Faulty alignment/adjustment of the guides.
- Forcing or twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull teeth or damaged tooth sufficient set.
- Overtensioned blade.
- Top blade guide assembly set too high above the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving blade tensioned when not in use.

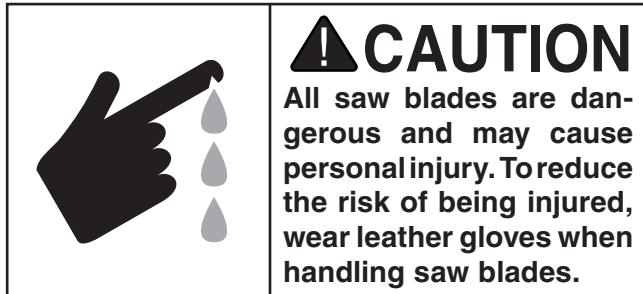
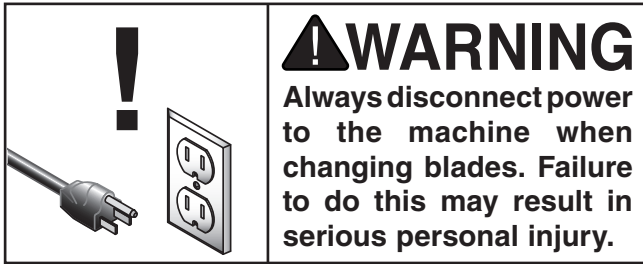
Grizzly Bandsaw Blades

MODEL	LENGTH	WIDTH	TPI	GAUGE
G5151	93½"	1/16"	24 Raker	0.025
G5152	93½"	1/8"	14 Raker	0.025
G5153	93½"	1/8"	18 Raker	0.025
G5154	93½"	3/16"	4 Skip	0.025
G5155	93½"	3/16"	10 Raker	0.025
G5156	93½"	3/16"	14 Raker	0.025
G5157	93½"	1/4"	4 Hook	0.025
G5158	93½"	1/4"	6 Hook	0.025
G5159	93½"	1/4"	10 Raker	0.025
G5160	93½"	1/4"	14 Raker	0.025
G5161	93½"	1/4"	18 Raker	0.025
G5162	93½"	3/8"	4 Hook	0.025
G5163	93½"	3/8"	6 Hook	0.025
G5164	93½"	3/8"	10 Raker	0.025
G5165	93½"	3/8"	14 Raker	0.025
G5166	93½"	1/2"	3 Hook	0.025
G5167	93½"	1/2"	4 Hook	0.025
G5168	93½"	1/2"	6 Hook	0.025
G5169	93½"	1/2"	10 Raker	0.025
G5170	93½"	1/2"	14 Raker	0.025
G5171	93½"	3/4"	3 Hook	0.025
G5172	93½"	3/4"	6 Hook	0.025
G5173	93½"	3/4"	10 Raker	0.025

Call 1-800-523-4777 To Order



Blade Changes



To remove the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Release the tension lever.
3. Remove the table insert and the table pin. Adjust the upper and lower guide blocks away from the blade.

4. Open the upper and lower wheel covers and slide the blade off both wheels.
5. Rotate the blade 90° and slide it through the slot in the table.

To replace the blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table. *If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it rightside-out.*
2. Slip the blade through the guides, and mount it over the upper and lower wheels.
3. Apply tension. If the blade cannot be tensioned as described on **Page 20**, adjust the tensioner as described in **Steps 4-6**. If the tension is correct, go to **Step 7**.

Note: *The tensioner must be adjusted if you are using a different length of blade.*

Continued on next page →



- Remove the setscrew in the spacer indicated in **Figure 37**, and rotate the spacer up 5-6 turns.

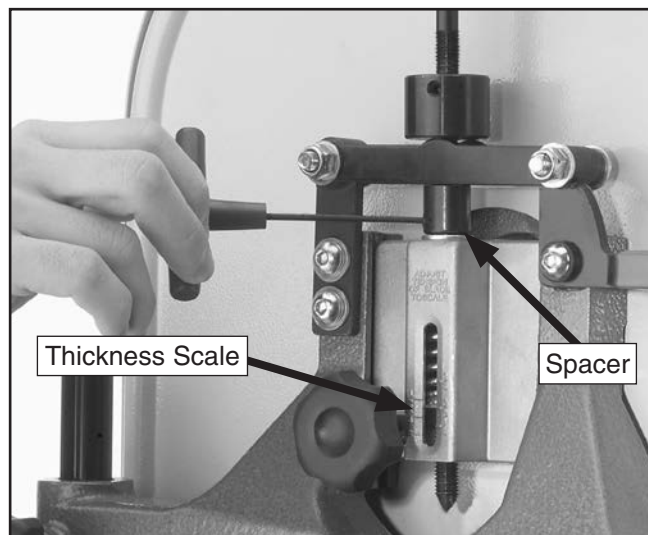


Figure 37. Tensioner adjustment.

- Turn the tension knob until proper blade tension has been reached according to the blade thickness scale on the sliding bracket and fine tune as needed.
- Thread the spacer down until it slightly contacts the top of the sliding bracket. Move the spacer back up the shaft about 1-2 turns to leave a small space. Replace the setscrew in the spacer and tighten (**Figure 37**).
- Check and adjust the tracking.
- Adjust the upper/lower guide blocks and the support bearings.
- Close the wheel covers.
- Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.

Scale Calibration

You may need to recalibrate the fence scale after changing or adjusting the blade, or if the scale is not producing accurate cuts. Recalibrate the fence scale by adjusting the hairline indicator on the fence and testing your adjustment by cutting a piece of scrap wood.

To calibrate the scale:

- Set the fence anywhere along the scale and locate a piece of scrap wood with at least one straight edge. *Joint the edge with a jointer if needed to make the edge straight.*
- Hold the straight edge of the workpiece firmly against the fence, and feed the workpiece through the saw blade with a push stick.
- Measure the width of the cut workpiece. The width of the workpiece should match the reading on the fence scale.
- If the reading on the scale is not the same as the width of the cut workpiece, loosen the screws on the magnifying window (**Figure 38**) and adjust it to match the width of the cut workpiece.
- Tighten the screws; the scale is now correctly calibrated.



Figure 38. Scale recalibration screws.

SECTION 5: ACCESSORIES

⚠ WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

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

Call 1-800-523-4777 To Order

6" Extension Block Kit - H3051

Increase your cutting capacity from 6" to 12" cutting height with this bolt-on 6" extension block kit. Includes all necessary hardware plus extended blade guard and 105" x $\frac{3}{8}$ " x 6 TPI blade. *We also carry a full line of 105" blades!*

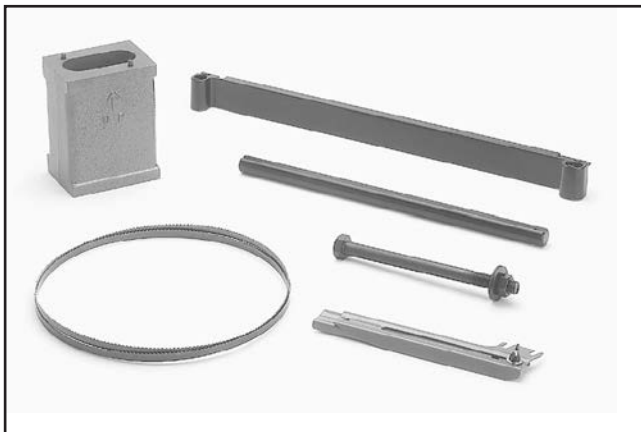


Figure 39. H3051 Extension Block Kit.

- 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 40. Recommended lubricants for protecting unpainted cast iron/steel part on machinery.

G8683Z—SHOP FOX® Mini Mobile Base

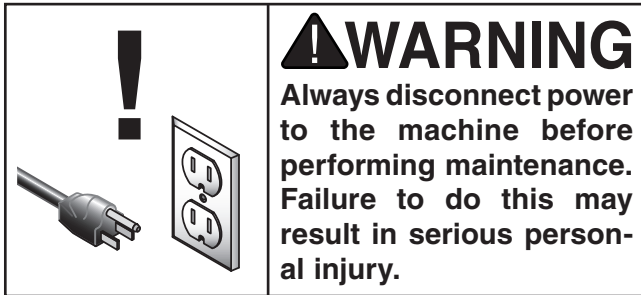
Make your machine mobile with this popular patented mobile base. The unique outrigger-type supports increase stability and lower machine height. This heavy duty mobile base is rated for up to a 600 lb. capacity.



Figure 41. G8683Z SHOP FOX® Mobile Base.



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule:

Daily

- Check/correct loose mounting bolts.
- Check/correct damaged saw blade.
- Check/correct worn or damaged wires.
- Correct any other unsafe condition.

Monthly

- Check for V-belt tension, damage, or wear.
- Remove blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If resin has built up, use a resin dissolving cleaner to remove it.

Once a month, remove the blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.

Lubricating

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 on **Page 35**.

If the table becomes difficult to tilt, remove it and lubricate the trunnions and the slides in the trunnion base.

Redressing Rubber Tires

As the bandsaw ages, the rubber tires may need to be redressed if they harden or glazed over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult. At that point, redressing will no longer be effective and the rubber tires must be replaced.

To redress the rubber tires:

1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires.
5. Hold 100 grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

Note: Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting

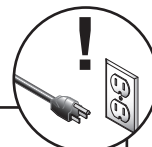


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Power supply is at fault/switched OFF. 2. Plug/receptacle is at fault or wired incorrectly. 3. Wiring is open/has high resistance. 4. Motor connection wired incorrectly. 5. Motor ON button or ON/OFF switch is at fault. 6. Start capacitor is at fault. 7. Motor centrifugal switch is at fault. 	<ol style="list-style-type: none"> 1. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 2. Test for good contacts; correct the wiring. 3. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 4. Correct motor wiring connections. 5. Replace faulty ON button or ON/OFF switch. 6. Test/replace if faulty. 7. Adjust/replace the centrifugal switch if available.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Wrong workpiece material (wood). 2. Feed rate too fast for task. 3. Belt slipping. 4. Motor connection is wired incorrectly. 5. Plug/receptacle is at fault. 6. Motor bearings are at fault. 7. Motor has overheated. 8. Motor is at fault. 9. Centrifugal switch is at fault. 	<ol style="list-style-type: none"> 1. Use wood with correct moisture content, without glues, and little pitch/resin. 2. Decrease feed rate. 3. Tighten/repair/replace. 4. Correct motor wiring connections. 5. Test for good contacts; correct the wiring. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Clean off motor, let cool, and reduce workload. 8. Test/repair/replace. 9. Adjust/replace centrifugal switch if available.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. Belt(s) worn or loose. 3. Motor fan is rubbing on fan cover. 4. Pulley is loose. 5. Machine is incorrectly mounted or sits unevenly on floor. 6. Blade is at fault. 7. Cast iron motor mount loose/broken. 8. Centrifugal switch. 9. Motor or spindle bearings are at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, use thread locking fluid, and retighten. 2. Tension belt (refer to Page 39) or replace belt (refer to Page 40). 3. Replace dented fan cover; replace damaged fan. 4. Tighten pulley set screw. 5. Tighten/replace anchor studs in floor; relocate/shim machine. 6. Replace blade. 7. Tighten/replace. 8. Replace centrifugal switch. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Cutting Operations



Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. Blade is dull. 	<ol style="list-style-type: none"> 1. Reduce feed rate. See Basic Cutting Tips on Page 26. 2. Replace blade (Page 33).
Ticking sound when the saw is running.	<ol style="list-style-type: none"> 1. Blade weld contacting guide/support bearings (a light tick is normal). 2. Blade weld may be failing. 	<ol style="list-style-type: none"> 1. Use file or stone to smooth and round the back of the blade; slightly loosen the blade guides. 2. Inspect and replace blade if necessary (Page 33).
Blade contacting table insert.	<ol style="list-style-type: none"> 1. Insert installed upside down or backwards. 2. Table improperly mounted or aligned. 	<ol style="list-style-type: none"> 1. Re-install insert a different way. 2. Align table (Page 25).
Vibration when cutting.	<ol style="list-style-type: none"> 1. Loose or damaged blade. 2. Sawdust buildup on wheels. 	<ol style="list-style-type: none"> 1. Tighten or replace blade (Page 33). 2. Clean all sawdust from rubber tires on wheels.
Burn marks on the edge of the cut.	<ol style="list-style-type: none"> 1. Too much side pressure when feeding workpiece; blade is binding. 2. Blade too wide for size of radius being cut. 	<ol style="list-style-type: none"> 1. Feed workpiece straight into the blade. See Basic Cutting Tips on Page 26. 2. Install a smaller width blade/increase blade tension. See Page 33 or 20.
Rough or poor quality cuts.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. Blade guides adjusted incorrectly. 	<ol style="list-style-type: none"> 1. Reduce feed rate. See Basic Cutting Tips on Page 26. 2. Re-adjust all blade guides and support bearings.
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean out dust port. 2. Three options: <ul style="list-style-type: none"> —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a more powerful dust collector.
Blade wanders or doesn't cut straight.	<ol style="list-style-type: none"> 1. Blade lead. 2. Sawdust buildup on wheels. 	<ol style="list-style-type: none"> 1. Refer to Blade Lead on Page 41. 2. Clean all sawdust from rubber tires on wheels.
Cuts are not square (vertically).	<ol style="list-style-type: none"> 1. Table tilt is not adjusted to 0° or positive stop has moved out of adjustment. 2. Table tilt scale pointer is not calibrated. 3. Table is not square to the blade. 	<ol style="list-style-type: none"> 1. Adjust table tilt to 0°; readjust positive stop if necessary (Page 23). 2. Calibrate table tilt scale pointer to 0° (Page 23). 3. Shim table (Page 41).

Miscellaneous

Symptom	Possible Cause	Possible Solution
Quick-release mechanism has poor range of motion.	<ol style="list-style-type: none"> 1. Spacer blocks on quick-release tension mechanism have moved out of adjustment. 	<ol style="list-style-type: none"> 1. Readjust the quick-release spacer blocks (Page 44).
Blade tension scale is grossly inaccurate.	<ol style="list-style-type: none"> 1. The spring in the blade tension mechanism has lost its "spring." This is caused by not releasing the blade tension when not in use or frequently over-tensioning the bandsaw. 	<ol style="list-style-type: none"> 1. Replace spring in the blade tension mechanism, then take better care of the bandsaw by releasing tension when not in use and not over-tensioning the blade.
Wheel is noisy.	<ol style="list-style-type: none"> 1. Wheel bearing is worn out. 2. Belt is too tight (lower wheel). 	<ol style="list-style-type: none"> 1. Replace the wheel bearing. 2. Check/loosen the belt tension (Page 39).
Blade does not track consistently, correctly, or at all.	<ol style="list-style-type: none"> 1. Wheels are not coplanar or aligned with each other. 2. Rubber tires on wheels are worn out. 	<ol style="list-style-type: none"> 1. Adjust wheels to be coplanar/aligned with each other (Page 42). 2. Redress the rubber tires on the wheels (Page 36); replace the rubber tires on the wheels.



Checking Belt

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

To check the belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Check the belt tension. When tensioned correctly, the middle of the belt will deflect approximately $\frac{1}{4}$ " when pushed with moderate pressure (see **Figure 42**).

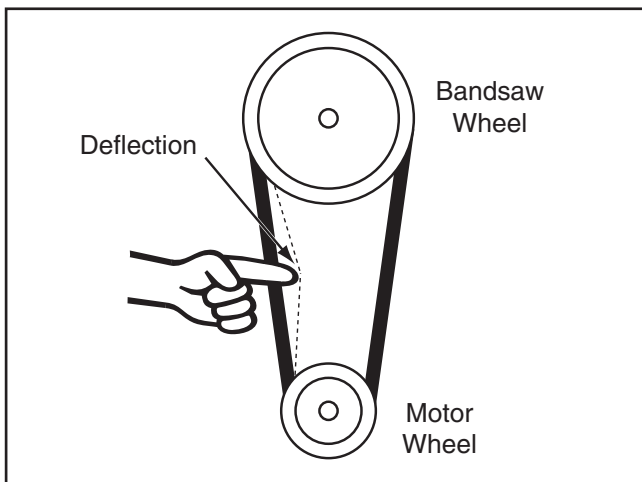


Figure 42. Belt deflection.

4. Note the condition of the belt. If the belt is cracked, frayed, or glazed; it should be replaced as soon as convenient.

Tensioning Belt

To tension the belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Loosen the motor mount bolts shown in **Figure 43**.

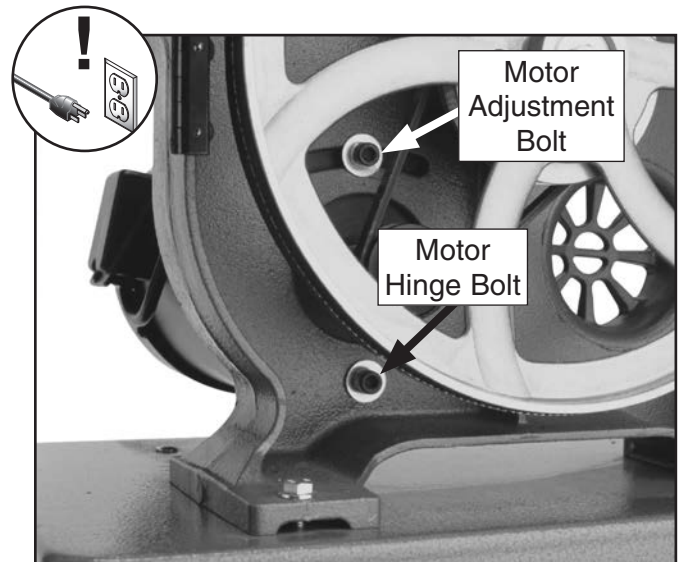


Figure 43. Motor mount bolts.

4. Move the body of the motor so the motor adjustment bolt slides to the left-hand side of the adjustment slot.
5. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.
6. Push the center of the belt. If deflection is approximately $\frac{1}{4}$ " with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more than $\frac{1}{4}$ ", repeat **Steps 3–6**.
7. When the belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Replacing Belt

To replace the belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open both wheel covers.
3. Remove the bandsaw blade.
4. Loosen the motor mount bolts shown in **Figure 44**.

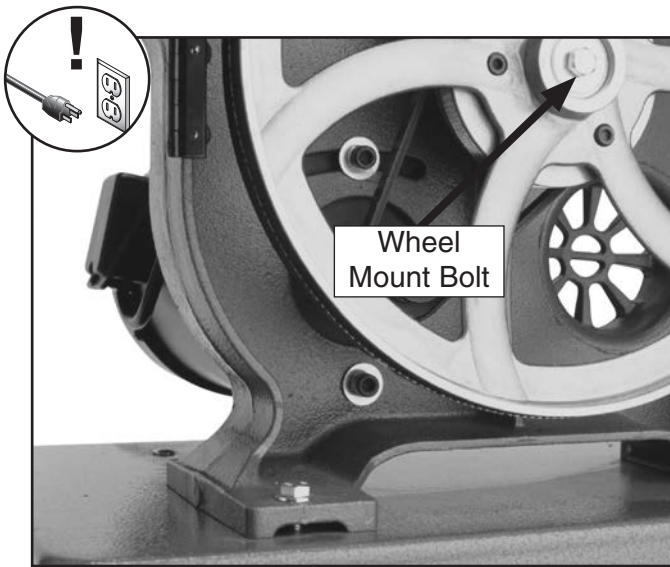


Figure 44. Wheel mount bolt.

5. Move the body of the motor so the motor adjustment bolt slides to the right-hand side of the adjustment slot.
6. Pull the belt off of the motor pulley.
7. Unthread the wheel mount bolt shown in **Figure 44**, and slide the lower wheel off of the bearing shaft.
8. Slip the old belt off of the wheel pulley and install the new belt in its place.
9. Re-install the lower wheel onto the bearing shaft, and replace/tighten the wheel mount bolt.
10. Position the belt over the motor pulley.
11. Move the body of the motor so the motor adjustment bolt slides to the left-hand side of the adjustment slot.
12. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.
13. Check the belt tension and adjust if necessary (see **Tensioning Belt** on **Page 39**).
14. When the belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Shimming Table

To ensure accuracy when cutting stacked workpieces, the table should be 90° to the back of the blade as shown in **Figure 45**. If the table is not perpendicular to the back of the blade, the table needs to be shimmed.

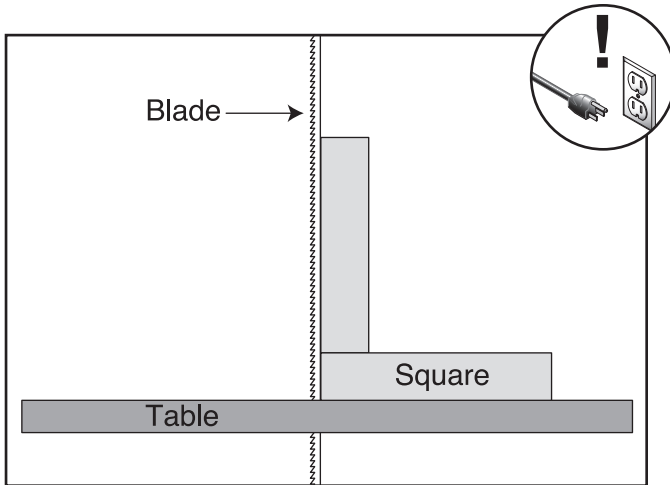


Figure 45. Squaring table to blade back.

To shim the table:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Loosen the trunnion bolts that secure the trunnions to the table.
4. Place shim stock between the table and the two trunnions to shim the table in the desired direction.

Note: Another way to shim the table is to add washers between the table and the trunnion. Electrical washers are a good choice for this procedure because they are very thin and will allow for fine adjustment.

5. Follow the **Aligning Miter Slot** instructions on **Page 25** to complete this procedure.

Blade Lead

"Blade Lead" means that the blade does not cut straight when using the fence or miter gauge (see **Figure 46**). This is a common condition with all bandsaws. Worn or damaged blades may cause lead and replacing them will fix the problem. Still, if your bandsaw is setup correctly and lead occurs, compensate for it by skewing the fence.

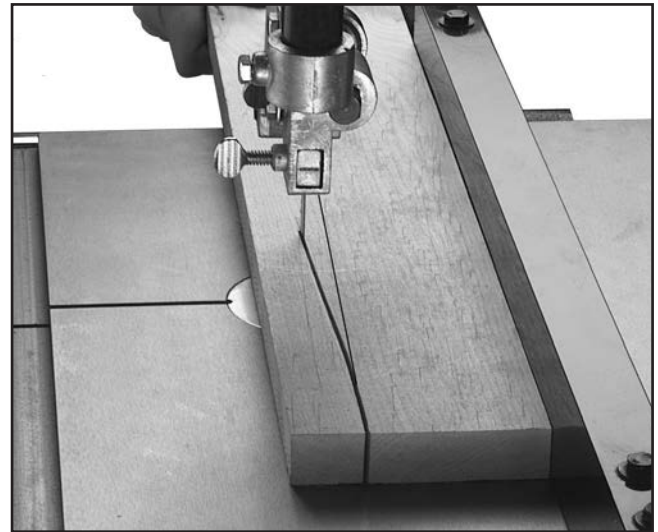


Figure 46. Blade leading away from line of cut.

To correct blade lead, do the following steps and make a test cut before skewing the fence:

1. Ensure that you have proper blade tension (refer to **Page 20**).
2. Ensure that the blade guides are adjusted correctly (refer to **Pages 20 & 22**).
3. Ensure that the miter slot or fence is parallel to the blade (refer to **Page 25**).

To skew your fence:

1. Cut a piece of scrap wood approximately $\frac{3}{4}$ " thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.
2. Slide the fence out of the way and cut free-hand along the line. Stop at the halfway point. Turn the bandsaw *OFF* and wait for the blade to stop.

3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.
4. Loosen the four cap screws on top of the fence.
5. Skew the fence as needed until it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.
6. While maintaining the skew, tighten the cap screws.

To compensate for lead when making straight crosscuts with the miter gauge, you will need to shift the table:

1. Set the miter gauge to 90°.
2. On a scrap piece of wood, mark a line that is perpendicular to the front edge. Starting where the line begins, cut the board by pushing it through the blade with the miter gauge. *The miter gauge should be checked for square before beginning this procedure.*
3. Loosen the table mounting bolts, and shift the table to compensate for the blade lead.
4. Repeat **Steps 1 & 2** until the blade cuts straight when wood is pushed through with the miter gauge.

NOTICE

If the table is shifted, the fence will be affected since it is attached.

NOTICE

Lead adjustments will change when new blades are mounted on the saw.

Wheel Alignment

Wheel alignment is one of the easiest ways to ensure you get optimal performance from your bandsaw. When wheels are aligned, or coplanar, the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel. This is known as "Coplanar Tracking."

To verify if the upper and lower wheels are coplanar:

1. DISCONNECT BANDSAW FROM POWER!
2. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure the straightedge fully extends across the wheels as shown in **Figure 47**.

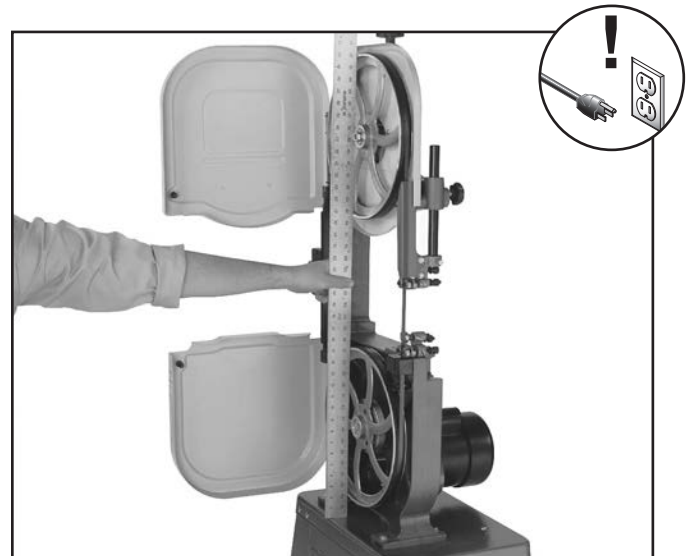


Figure 47. Checking wheel alignment with a straightedge.

- If the wheels are coplanar, the straightedge will touch the top and bottom of the outside rims on each wheel.
- If your wheels are not coplanar, place the straightedge on the lower wheel first—ensuring that it touches both the top and bottom rim—and adjust the tracking knob to see how the upper wheel lines up with the straightedge.



—If the straightedge will not touch the top and bottom rim of the upper wheel evenly, determine which wheel sticks out farther. The wheel that does NOT stick out the farthest is the wheel that needs to be shimmed.

Shimming a wheel

1. Adjust the tracking knob so the top wheel is parallel with the bottom wheel. With the straightedge touching both points of the wheel that does not need to be adjusted, measure the distance away from the incorrect wheel with a fine ruler (see **Figure 48**). The distance measured with the ruler is the distance the wheel must be corrected.

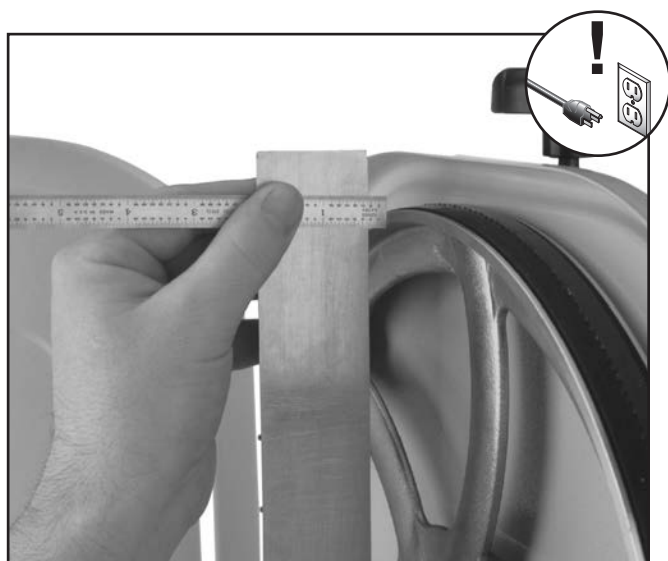


Figure 48. Measuring wheel difference.

2. Remove the blade from the saw, then remove the wheel that needs to be shimmed.
3. Shim washers work well because they are available in a wide range of thicknesses. Measure how many you need and place them on the mounting shaft.

4. Replace the wheel, any remaining washers, and the securing nut. Tighten the blade as it will be used during operation before you check the wheels. Often the wheels may be coplanar with the blade loose, then be pulled out of alignment when it is tightened.
5. The first time you get the wheels coplanar, place a mark on each wheel where you held the straightedge. This assures repeated accuracy every time you adjust your wheels.

When wheels are properly coplanar, the blade may not be centered on the crown of the wheel, but it will be balanced. See **Figure 49** to better understand coplanarity.

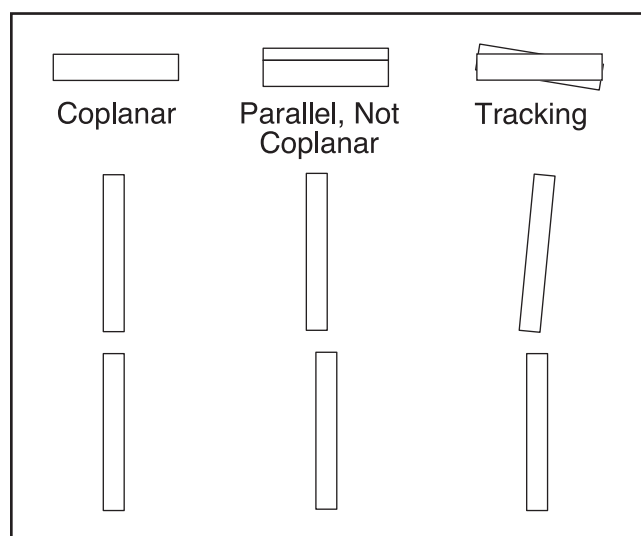


Figure 49. Coplanar diagram.

Blade Tensioner

Over the life of the machine, the blade tensioner system may need to be reset for correct operation.

To reset the blade tensioner:

1. DISCONNECT BANDSAW FROM POWER!
2. Release the tension lever shown in **Figure 50** and remove the bandsaw blade.

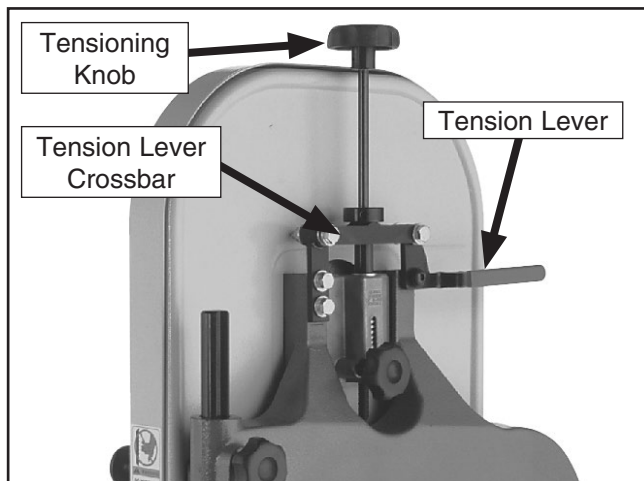


Figure 50. Blade tension controls/components.

3. Place the new blade onto the wheels and between the blade guide bearings.

Note: A new blade is used to calibrate the tensioner because it is unstretched.

4. Loosen the setscrews in both of the spacers indicated in **Figure 51**.
5. Back the spacers away from the tension lever crossbar shown in **Figure 50**.

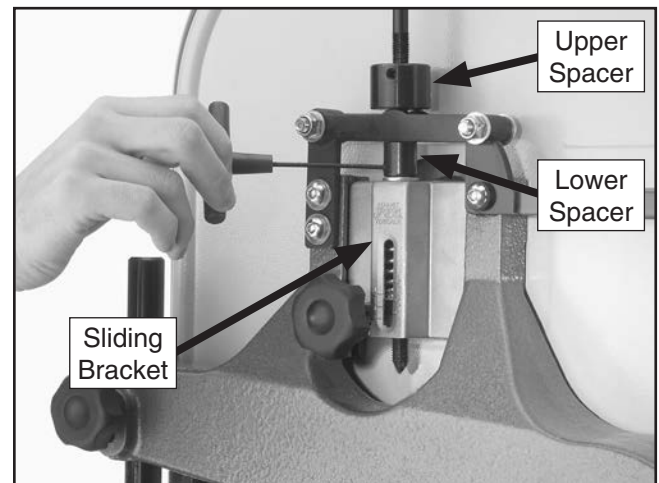


Figure 51. Loosening the spacer set screws.

6. Pull the tension lever down to the horizontal position.
7. Pull up on the tensioning knob (**Figure 50**) until the blade touches the wheel.
8. Thread the upper spacer down until it touches the top of the tension lever crossbar.
9. Tighten the setscrew on the upper spacer.
10. Tension the blade (refer to **Page 20**).
11. Thread the lower spacer down until it touches the top of the sliding bracket indicated in **Figure 51**.
12. Move the lower spacer back up the shaft about 1-2 turns to leave a small space, and tighten the setscrew (**Figure 51**).
13. Make sure there is no tension on the blade when the lever is released. If all the tension is not released, the lower spacer needs to be threaded farther down the shaft toward the sliding bracket.

SECTION 8: WIRING

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. Compare the manufacture date of your machine to the one stated in this manual, and 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. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

WARNING

Wiring Safety Instructions

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!

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 after-market parts.

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.

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

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.

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.







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.

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

NOTICE

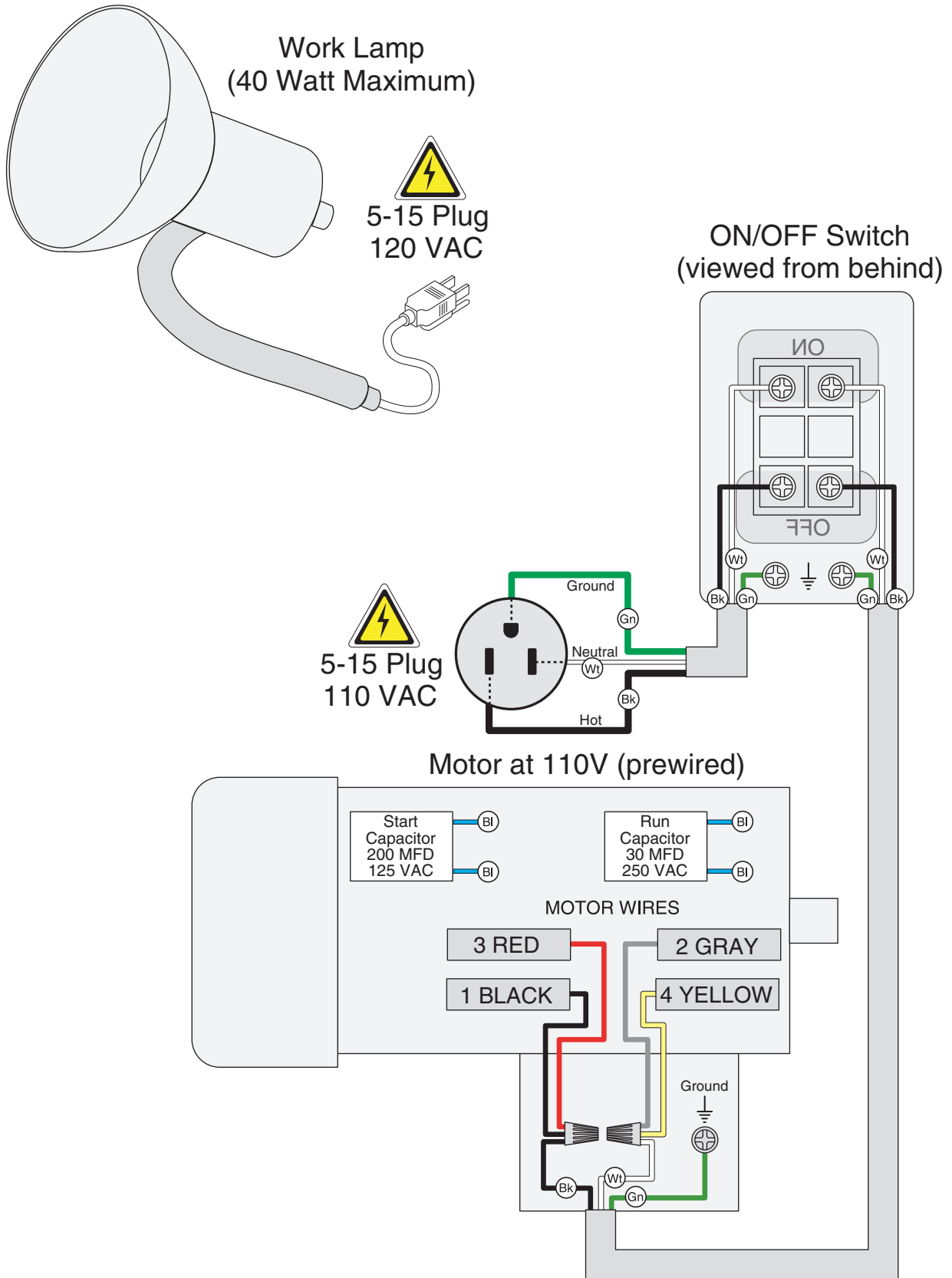
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

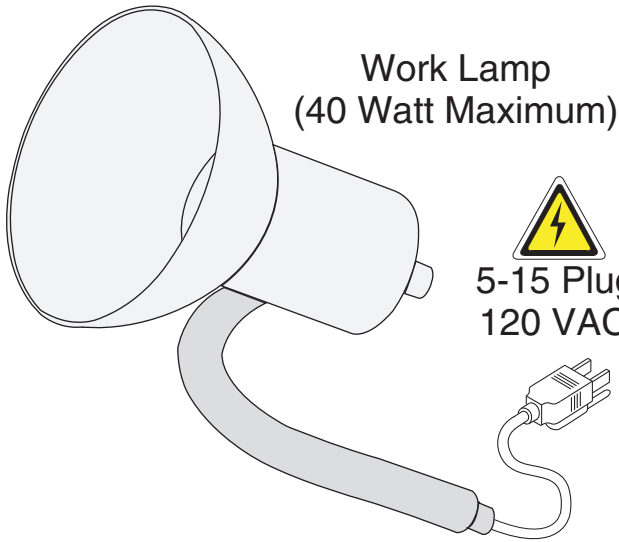
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WHITE		BROWN		YELLOW GREEN		BLUE WHITE	
GREEN		GRAY		PURPLE		TURQUOISE	
RED		ORANGE		PINK			



110V Wiring Diagram (Prewired)

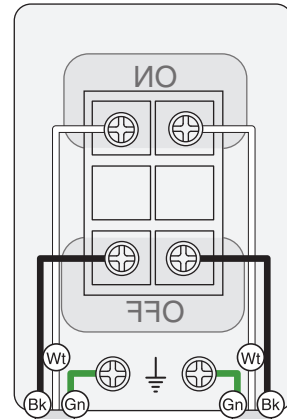


220V Wiring Diagram

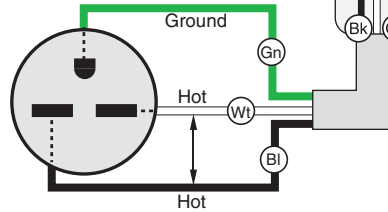



5-15 Plug
120 VAC

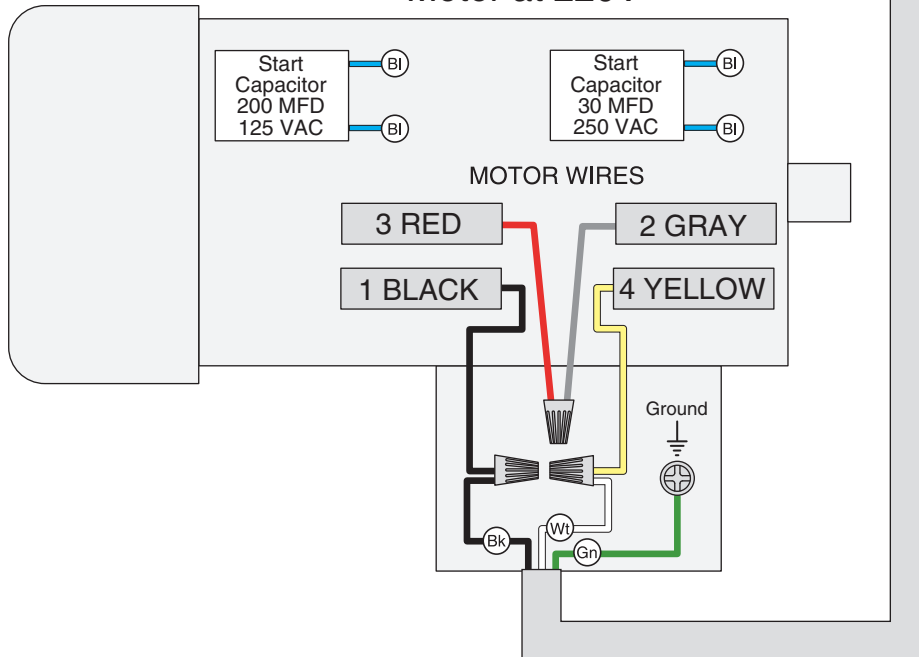
ON/OFF Switch
(viewed from behind)




6-15 Plug
220 VAC

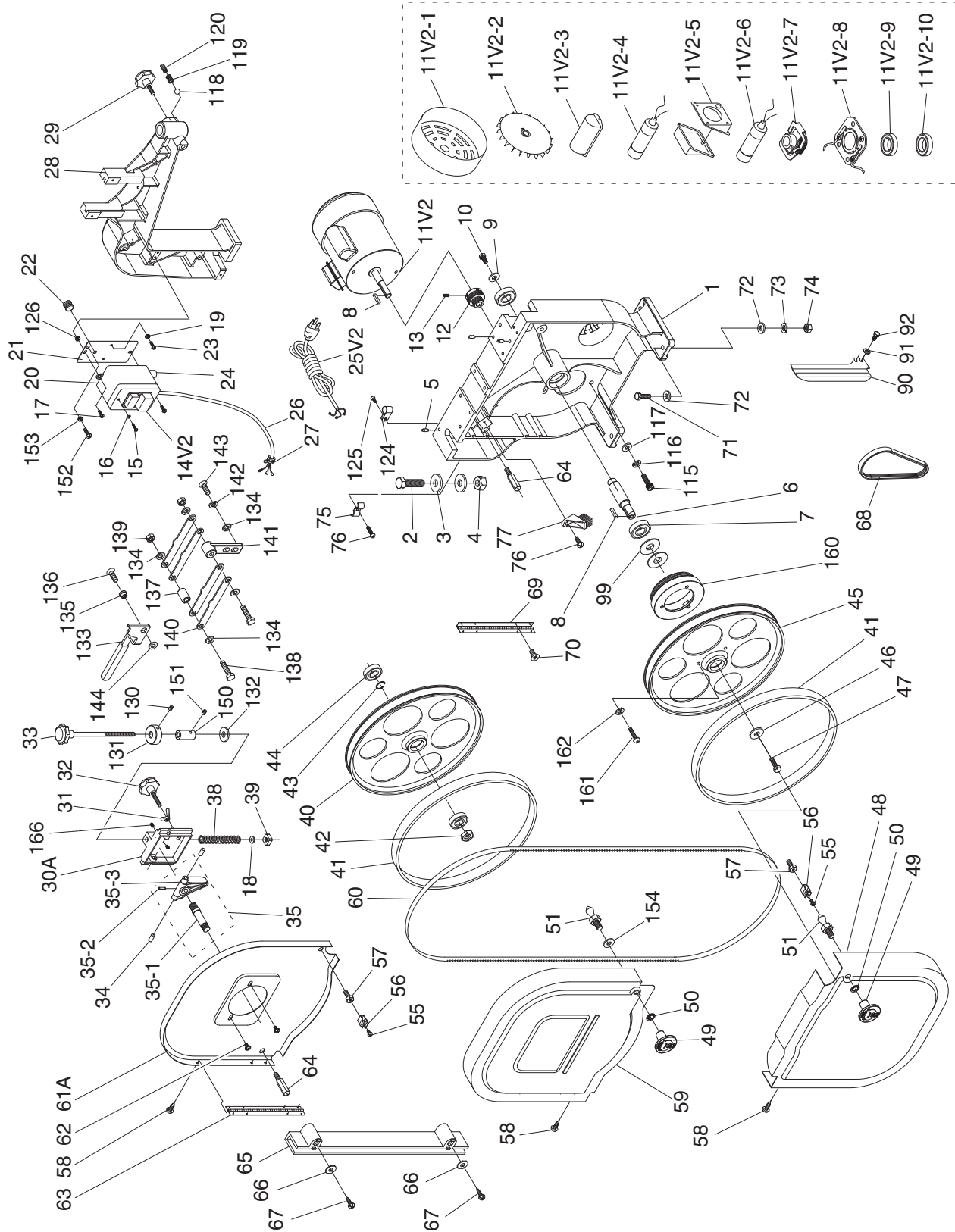


Motor at 220V



SECTION 9: PARTS

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0555X001	BASE
2	PB80M	HEX BOLT M16-2 X 55
3	PW08M	FLAT WASHER 16MM
4	PN13M	HEX NUT M16-2
5	P0555X005	ALIGNMENT PIN
6	P0555X006	LOWER WHEEL SHAFT
7	P6204LLU	BALL BEARING 6204LLU
8	PK23M	KEY 5 X 5 X 25
9	PWF08M	FENDER WASHER 8MM
10	PCAP11M	CAP SCREW M8-1.25 X 16
11V2	P0555X011V2	MOTOR 1.5HP 1PH 110/220V V2.05.11
11V2-1	P0555X011V2-1	MOTOR FAN COVER V2.05.11
11V2-2	P0555X011V2-2	MOTOR FAN V2.05.11
11V2-3	P0555X011V2-3	CAPACITOR COVER V2.05.11
11V2-4	P0555X011V2-4	S CAPACITOR 200M 125V V2.05.11
11V2-5	P0555X011V2-5	MOTOR JUNCTION BOX V2.05.11
11V2-6	P0555X011V2-6	R CAPACITOR 30M 250V V2.05.11
11V2-7	P0555X011V2-7	CENTRIFUGAL SWITCH V2.05.11
11V2-8	P0555X011V2-8	CONTACT PLATE V2.05.11
11V2-9	P6205ZZ	BALL BEARING 6205ZZ
11V2-10	P6203ZZ	BALL BEARING 6203ZZ
12	P0555X012	MOTOR PULLEY
13	PSS04M	SET SCREW M6-1 X 12
14V2	P0555014V2	ON/OFF SWITCH 110/220V V2.05.11
15	PHTEK1M	TAP SCREW M3.5 X 12
16	PW05M	FLAT WASHER 4MM
17	PS40M	PHLP HD SCR M5-.8 X 16
18	P0555X018	TENSION INDICATOR
19	PTLW02M	EXT TOOTH WASHER 5MM
20	P0555X020	SWITCH BOX
21	P0555X021	SWITCH BOX MOUNT PLATE
22	P0555X022	STRAIN RELIEF
23	PS19M	PHLP HD SCR M5-.8 X 6
24	P0555X024	STRAIN RELIEF
25V2	P0555X025V2	POWER CORD 14G 3C 6FT 5-15 V2.05.11
26	P0555X026	MOTOR CORD
27	P0555X027	STRAIN RELIEF
28	P0555X028	UPPER FRAME ARM
29	P0555X029	KNOB BOLT M10-1.5 X 30
30A	P0555X030A	UPPER WHEEL BRACKET V2.08.07
31	P7945097	WING NUT 8MM
32	P0555X032	KNOB BOLT M8-1.25 X 45
33	P0555X033	TENSION KNOB BOLT ASSEMBLY
34	P0555X035	STEEL PIN
35	P0555X035	UPPER WHEEL SHAFT HINGE ASSY
35-1	P0555X035	UPPER WHEEL SHAFT
35-2	PRP04M	ROLL PIN 4 X 24
35-3	P0555X035	UPPER WHEEL SHAFT HINGE
38	P0555X038	COMPRESSION SPRING
39	PSN04M	SQUARE NUT M10-1.5
40	P0555X040	UPPER WHEEL

REF	PART #	DESCRIPTION
41	P0555X041	WHEEL TIRE
42	PN09M	HEX NUT M12-1.75
43	PR21M	INT RETAINING RING 35MM
44	P6202LLU	BALL BEARING 6202LLU
45	P0555X045	LOWER WHEEL ASSEMBLY
46	PWF08M	FENDER WASHER 8MM
47	PB81M	HEX BOLT M8-1.25 X 20 LH
48	P0555X048	LOWER WHEEL GUARD
49	P0555X049	GRIZZLY ROUND KNOB M8-1.25
50	PTLW03M	INT TOOTH WASHER 8MM
51	P0555X051	LATCH STUD M8-1.25 X 14
55	PS08M	PHLP HD SCR M5-.8 X 12
56	P0555056	CATCH
57	P0555X057	ALIGNMENT BOLT
58	PHTEK4M	TAP SCREW M4 X 8
59	P0555X059	UPPER WHEEL COVER
60	P0555X060	SAW BLADE 6TPI 93-1/2 X 3/8" X .5MM
61A	P0555X061A	UPPER WHEEL BACK COVER V2.08.07
62	PFS01M	FLANGE SCREW M5-.8 X 8
63	P0555X063	UPPER WHEEL COVER HINGE
64	P0555X064	STANDOFF STUD
65	P0555X065	LEFT BLADE GUARD
66	P0555X066	TAP SCREW FLAT WASHER
67	PHTEK2M	TAP SCREW M3.5 X 16
68	P0555068	RIBBED V-BELT 200J5
69	P0555X069	LOWER WHEEL COVER HINGE
70	PFH07M	FLAT HD SCR M5-.8 X 10
71	PB20M	HEX BOLT M8-1.25 X 35
72	P0555X072	FLAT WASHER M8-1.25 X 18
73	PLW04M	LOCK WASHER 8MM
74	PN03M	HEX NUT M8-1.25
75	P0555X075	CORD CLAMP
76	PS05M	PHLP HD SCR M5-.8 X 8
77	P0555X077	WHEEL BRUSH
90	P0555X090	RIGHT UPPER BLADE GUARD
91	PW03M	FLAT WASHER 6MM
92	PB04M	HEX BOLT M6-1 X 10
99	P0555X099	PULLEY FLAT WASHER
115	PCAP31M	CAP SCREW M8-1.25 X 25
116	PLW04M	LOCK WASHER 8MM
117	PWF08M	FENDER WASHER 8MM
118	P0555X118	STEEL BALL
119	P0555X119	COMPRESSION SPRING
120	PSS30M	SET SCREW M10-1.5 X 10
124	P0555X124	CORD CLAMP
125	PS05M	PHLP HD SCR M5-.8 X 8
126	PLN01M	LOCK NUT M4-.7
130	PSS05M	SET SCREW M5-.8 X 10
131	P0555X131	UPPER LOCK COLLAR
132	PW04M	FLAT WASHER 10MM
133	P0555X133	TENSION LEVER



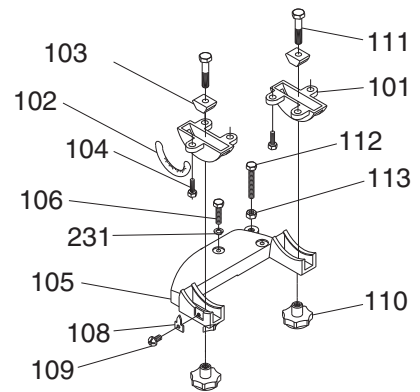
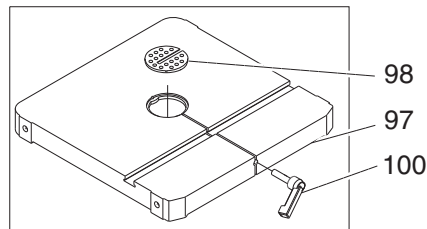
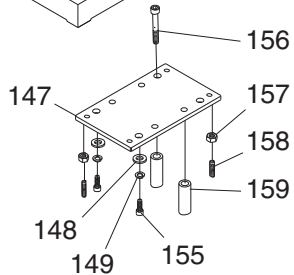
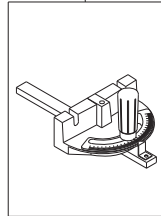
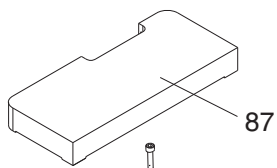
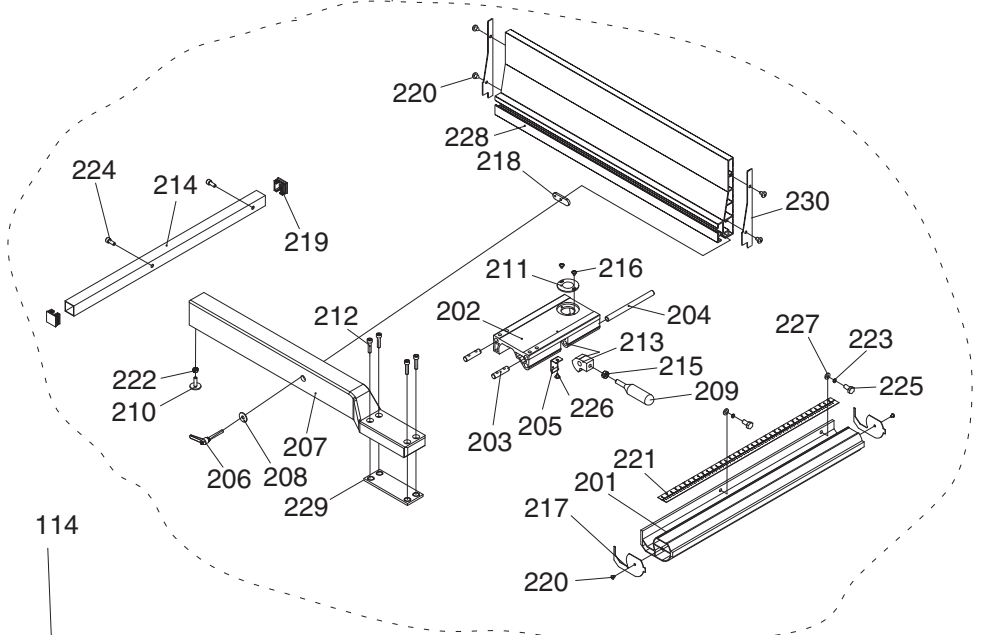
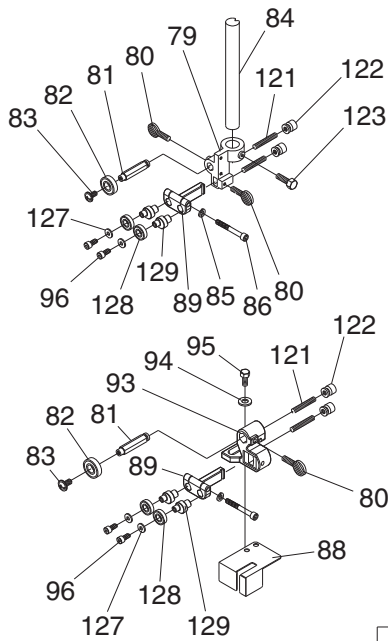
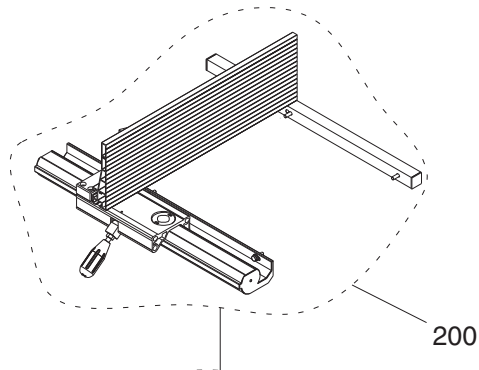
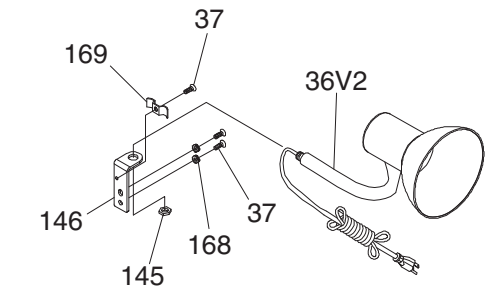
Main Parts List (continued)

REF	PART #	DESCRIPTION
134	PW01M	FLAT WASHER 8MM
135	P0555X135	BUSHING
136	PBHS01M	BUTTON HD CAP SCR M8-1.25 X 20
137	P0555X137	SPACER
138	PB15M	HEX BOLT M8-1.25 X 40
139	PLN04M	LOCK NUT M8-1.25
140	P0555X140	SUPPORT PLATE
141	P0555141	PIVOT ARM
142	PLW04M	LOCK WASHER 8MM
143	PCAP14M	CAP SCREW M8-1.25 X 20

REF	PART #	DESCRIPTION
144	P0555X144	SPACER 8 X 20MM
150	P0555X150	LOWER LOCK COLLAR
151	PSS07M	SET SCREW M5-.8 X 5
153	PTLW02M	EXT TOOTH WASHER 5MM
154	PW01M	FLAT WASHER 8MM
160	P0555X160	WHEEL PULLEY
161	PBHS21	BUTTON HD CAP SCR 5/16-18 X 3/4
162	PLW03M	LOCK WASHER 6MM
166	PSS31M	SET SCREW M5-.8 X 8



Table, Fence & Guides



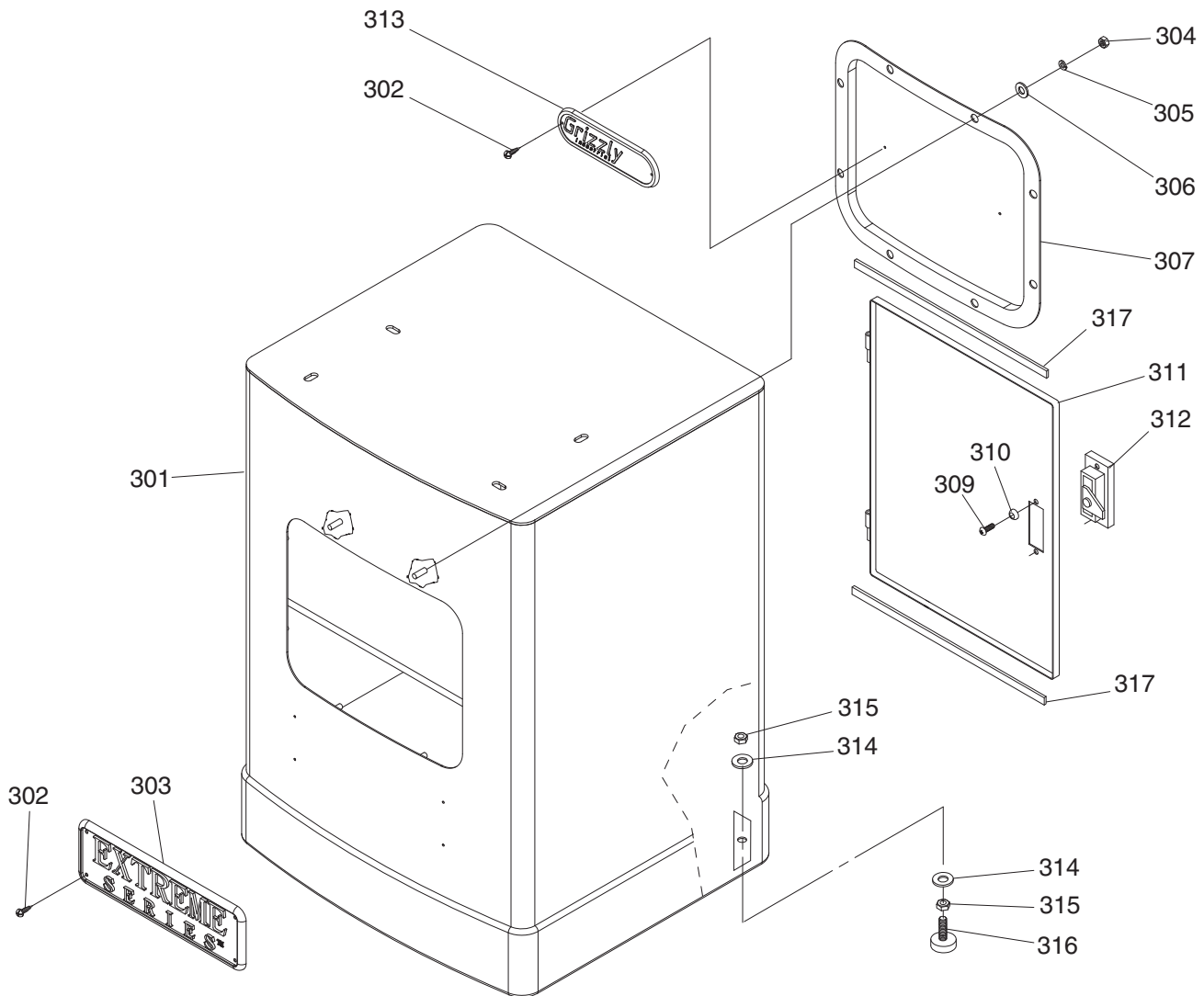
Table, Fence & Guides Parts List

REF	PART #	DESCRIPTION
36V2	P0555X036V2	LAMP ASSY W/POWER CORD V2.04.12
37	PFS01M	FLANGE SCREW M5-.8 X 8
79	P0555079	UPPER BLADE GUIDE BRACKET
80	PTS001M	THUMB SCREW M6-1 X 16
81	P0555X081	GUIDE SUPPORT SHAFT
82	P6000ZZ	BALL BEARING 6000Z
83	PFS06M	FLANGE SCREW M6-1 X 8
84	P0555X084	GUIDE POST
85	PLW01M	LOCK WASHER 5MM
86	PCAP78M	CAP SCREW M5-.8 X 40
87	P0555X087	TABLE EXTENSION
88	P0555088	LOWER RIGHT BLADE GUARD
89	P0555089	GUIDE BEARING SUPPORT BRACKET
93	P0555X093	LOWER BLADE GUIDE BRACKET
94	PW03M	FLAT WASHER 6MM
95	PB08M	HEX BOLT M6-1 X 20
96	PCAP33M	CAP SCREW M5-.8 X 12
97	P0555X097	TABLE
98	P0513X127	TABLE INSERT
100	P0555X100	TABLE PIN
101	P0555X101	TRUNNION
102	P0555102	SCALE
103	P0555X103	TRUNNION CLAMP SHOE
104	PB02M	HEX BOLT M6-1 X 12
105	P0555X105	TRUNNION SUPPORT BRACKET
106	PB26M	HEX BOLT M8-1.25 X 30
108	P0555X108	POINTER
109	PFS03M	FLANGE SCREW M5-.8 X 6
110	P0555X110	KNOB 10MM
111	PB73M	HEX BOLT M10-1.5 X 50
112	PB82M	HEX BOLT M8-1.25 X 80
113	PN03M	HEX NUT M8-1.25
114	P0555X114	MITER GAUGE BODY ASSEMBLY
121	PSS98M	SET SCREW M8-1 X 35
122	P0555X122	MICRO ADJUSTING NUT
123	PB08M	HEX BOLT M6-1 X 20
127	PW02M	FLAT WASHER 5MM
128	G3845	BALL BEARING 608ZZ
129	P0555129	ECCENTRIC BEARING SHAFT
145	P0555X036	LAMP NUT
146	P0555X036	LAMP BRACKET
147	P0555X147	LEVER BOARD

REF	PART #	DESCRIPTION
148	PW03M	FLAT WASHER 6MM
149	PLW03M	LOCK WASHER 6MM
155	PCAP06M	CAP SCREW M6-1 X 25
156	PCAP35M	CAP SCREW M8-1.25 x 60
157	PN03M	HEX NUT M8-1.25
158	PSS09M	SET SCREW M8-1.25 X 20
159	P0555X159	SPACER
168	PTLW02M	EXT TOOTH WASHER 5MM
169	P0555X169	CORD CLAMP
200	P0555X200	FENCE KIT ASSEMBLY
201	P0555X201	FRONT FENCE RAIL
202	P0555X202	FENCE BASE
203	P0555X203	FENCE MOUNTING SHAFT
204	P0555X204	LOCK ROD
205	P0555X205	SPRING PIECE
206	P0555X206	LOCK KNOB M8-1.25 X 44
207	P0555X207	FENCE BRACKET
208	PW01M	FLAT WASHER 8MM
209	P0555X209	LOCK HANDLE
210	P0555X210	FENCE STAND-OFF
211	P0555X211	SCALE WINDOW
212	PCAP06M	CAP SCREW M6-1 X 25
213	P0555X213	LOCK CAM
214	P0555X214	REAR FENCE RAIL
215	PN03M	HEX NUT M8-1.25
216	PFS04M	FLANGE SCREW M4-.7 X 6
217	P0555317	FRONT RAIL END CAP
218	P0555X218	FENCE MOUNTING KEY
219	P0555319	REAR RAIL END CAP
220	PHTEK3M	TAP SCREW M3.5 X 8
221	P0555X221	SCALE
222	PN01M	HEX NUT M6-1
223	PLW03M	LOCK WASHER 6MM
224	PCAP01M	CAP SCREW M6-1 X 16
225	PB08M	HEX BOLT M6-1 X 20
226	PFS17M	FLANGE SCREW M4-.7 X 8
227	PW03M	FLAT WASHER 6MM
228	P0555X228	FENCE
229	P0555X229	FENCE BRACKET MOUNTING PLATE
230	P0555X230	FENCE END CAP
231	PLW04M	LOCK WASHER 8MM



Stand

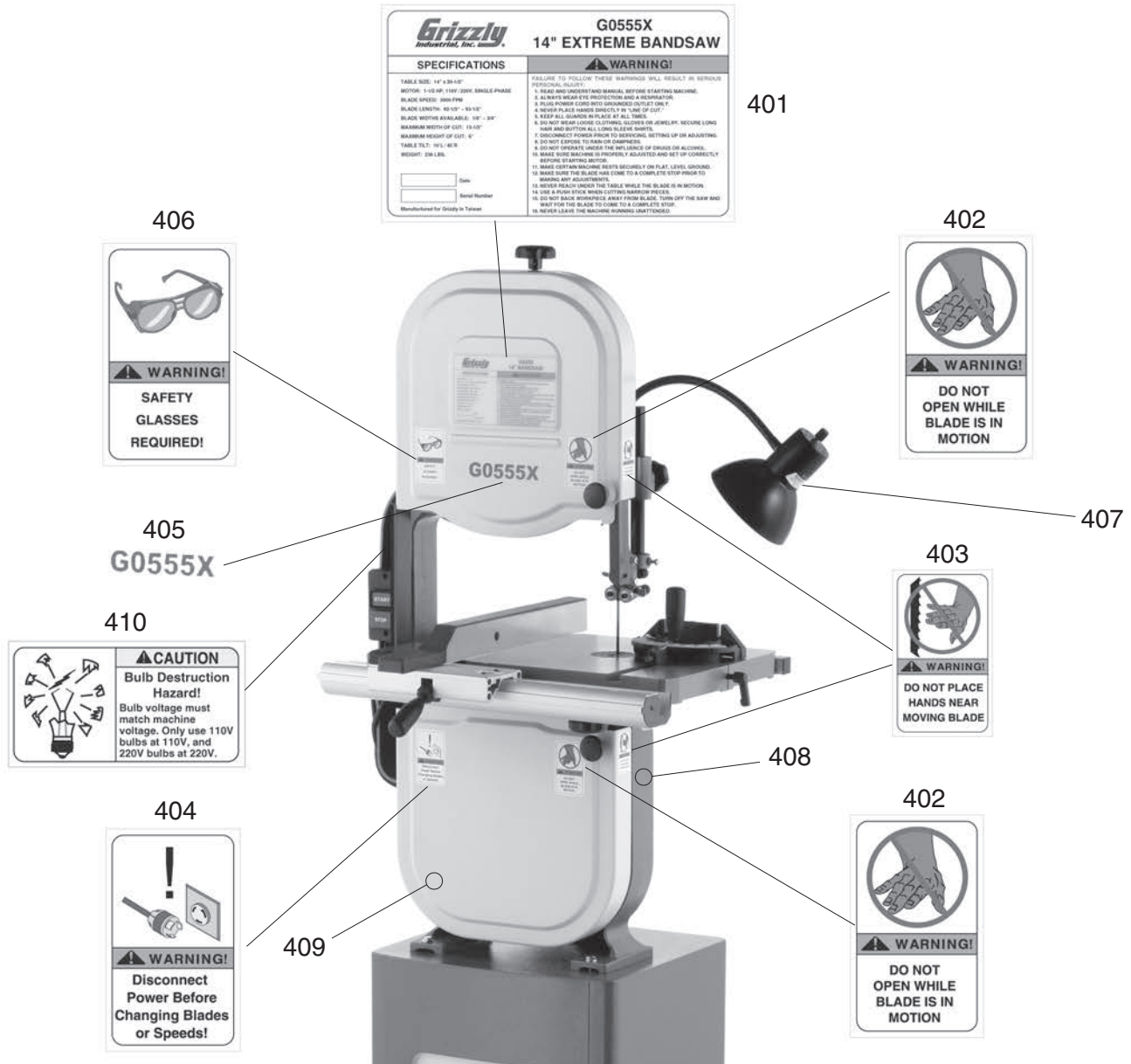


REF	PART #	DESCRIPTION
301	P0555X301	STAND
302	PHTEK3M	TAP SCREW M3.5 X 8
303	H7942	EXTREME SERIES LOGO
304	PN01M	HEX NUT M6-1
305	PLW03M	LOCK WASHER 6MM
306	PW03M	FLAT WASHER 6MM
307	P0555X307	FRONT STAND PANEL
309	PS17M	PHLP HD SCR M4-.7 X 6

REF	PART #	DESCRIPTION
310	PW05M	FLAT WASHER 4MM
311	P0555X311	DOOR
312	P0555X312	DOOR LATCH ASSEMBLY
313	P0555X313	GRIZZLY LOGO PLATE
314	PW04M	FLAT WASHER 10MM
315	PN08	HEX NUT 3/8-16
316	P0555X316	STAND FOOT
317	P0555X317	DOOR CUSHION



Labels



REF	PART #	DESCRIPTION
401	P0555X401	MACHINE ID LABEL
402	PLABEL-20	DONT OPEN DOOR LABEL
403	PLABEL-19	BANDSAW BLADE LABEL
404	PLABEL-18	UNPLUG BANDSAW LABEL
405	P0555X405	MODEL NUMBER LABEL

REF	PART #	DESCRIPTION
406	PLABEL-11	SAFETY GLASSES LABEL
407	P0555X407	LAMP WARNING LABEL
408	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
409	PPAINT-14	GRIZZLY PUTTY TOUCH-UP PAINT
410	P0555X410	BULB DESTRUCTION LABEL

WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

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

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

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



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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.

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