

# *Grizzly* *Industrial, Inc.*®

## MODEL G0720R HEAVY-DUTY BENCHTOP MILLING MACHINE OWNER'S MANUAL



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OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**  
(FOR MODELS MANUFACTURED SINCE 11/10) #CR13495 PRINTED IN CHINA



## **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.

|  |  |  |  |
|--|--|--|--|
|                   |  | <b>MODEL GXXXX</b><br><b>MACHINE NAME</b>  |  |
| <b>SPECIFICATIONS</b>  |  | <b>WARNING!</b>  |  |
| Motor:   |  | <b>Manufacture Date of Your Machine</b><br>ing this machine:<br>operation.<br>s and respirator.<br>sted/setup and<br>suit before starting. |  |
| Specification:   |  |  |  |
| Specification:   |  |  |  |
| Specification:   |  |  |  |
| Weight:  |  |  |  |
| <input type="text"/> Date  |  |  |  |
| <input type="text"/> Serial Number   |  |  |  |
| Manufactured for Grizzly in Taiwan   |  |  |  |
| 4. make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. |  |  |  |
| 5. DO NOT expose to rain or dampness.  |  |  |  |
| 6. DO NOT modify this machine in any way.  |  |  |  |
| 7. DO NOT remove safety guards.  |  |  |  |
| 8. Never leave machine running unattended.   |  |  |  |
| 9. DO NOT operate under the influence of drugs or alcohol.   |  |  |  |
| 10. Maintain machine carefully to prevent accidents.   |  |  |  |

For your convenience, we post all available manuals and manual updates for free on our website at [www.grizzly.com](http://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](mailto: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](mailto:manuals@grizzly.com)

## Machine Description

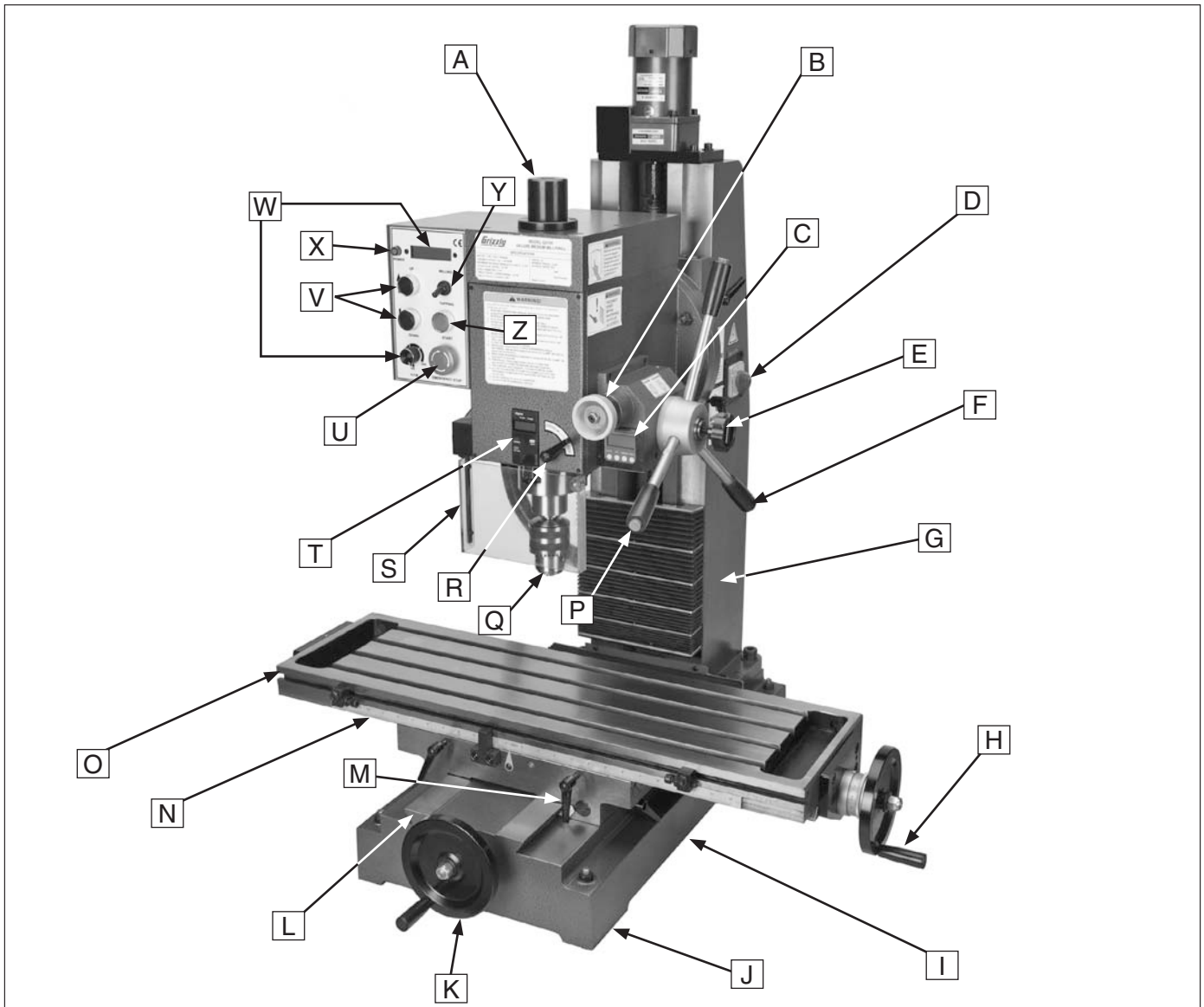
The Model G0720R Heavy-Duty Benchtop Mill removes material from workpieces to form complex shapes. The headstock can be held stationary at various angles while the spindle rotates the cutter. The operator then has the option to use the coarse or fine feed controls to move the spindle and cutter into the workpiece which is clamped to the table. The operator also has the option to move the table and workpiece into the cutter by the use of the table handwheels.

Cutting speeds are adjustable through the use of a spindle speed dial located on the control panel, where a digital tachometer is also located.

The mill has a tapping feature where when in the tapping mode, the spindle immediately reverses rotation when any of the buttons located at the end of the downfeed handles are pushed. This is an important feature for tap removal.



# Identification



**Figure 1.** G0720R Identification.

- |  |  |
|--|--|
| <b>A.</b> Safety Cover and Drawbar           | <b>N.</b> Longitudinal Scale                       |
| <b>B.</b> Fine Feed Knob                     | <b>O.</b> Milling Table                            |
| <b>C.</b> Mini Digital Protractor            | <b>P.</b> Spindle Rotation Button                  |
| <b>D.</b> Main Power Switch                  | <b>Q.</b> Drill Chuck                              |
| <b>E.</b> Fine Feed Lock Knob w/Assist Lever | <b>R.</b> Quill Lock Lever                         |
| <b>F.</b> Downfeed Handle                    | <b>S.</b> Polycarbonate Chip Guard w/Magnetic Lock |
| <b>G.</b> Precision Dovetailed Column        | <b>T.</b> Digital Spindle Depth Scale              |
| <b>H.</b> Longitudinal (X-Axis) Handwheel    | <b>U.</b> Emergency Stop Button                    |
| <b>I.</b> Cast-Iron Base                     | <b>V.</b> Headstock Power UP and DOWN Buttons      |
| <b>J.</b> Base Mounting Boss                 | <b>W.</b> Spindle Speed Dial and RPM Display       |
| <b>K.</b> Cross (Y-Axis) Handwheel           | <b>X.</b> Power Light                              |
| <b>L.</b> Precision Dovetailed Table Ways    | <b>Y.</b> Tapping and Milling Mode Switch          |
| <b>M.</b> Table Locks                        | <b>Z.</b> Start Button                             |



# MACHINE DATA SHEET

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

## MODEL G0720R HEAVY-DUTY BENCH TOP MILLING MACHINE

### Product Dimensions:

Weight..... 596 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 14-1/2 x 30-1/2 x 43 in.  
Footprint (Length x Width)..... 28-1/2 x 14-1/2 in.

### Shipping Dimensions:

Type..... Wood  
Content..... Machine  
Weight..... 641 lbs.  
Length x Width x Height..... 46 x 37 x 44 in.

### Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 16A  
Minimum Circuit Size..... 20A  
Switch..... On Button & Emergency Stop Switch  
Switch Voltage..... 110V  
Cord Length..... 8 ft.  
Cord Gauge..... 14 AWG  
Plug Included..... Yes  
Included Plug Type..... NEMA 5-15

### Motors:

#### Spindle

Type..... Brushless DC  
Horsepower..... 2 HP  
Voltage..... 230V  
Amps..... 10A  
Speed..... 0 – 3600  
Power Transfer ..... Belt Drive  
Bearings..... Shielded and Permanently Sealed

#### Elevation

Type..... AC Induction  
Horsepower..... 1/12 HP  
Voltage..... 110V  
Phase..... Single-Phase  
Amps..... 1.12A  
Speed..... 1400/1700 RPM  
Cycle..... 50 Hz / 60 Hz  
Power Transfer ..... Direct Drive  
Bearings..... Shielded and Permanently Sealed



## Main Specifications:

### Operation Info

|  |                        |
|--|------------------------|
| Spindle Travel.....                    | 3-5/16 in.             |
| Swing.....                             | 22-3/4 in.             |
| Longitudinal Table Travel.....         | 17-5/8 in.             |
| Cross Table Travel.....                | 9-5/8 in.              |
| Head Travel.....                       | 13-1/8 in.             |
| Head Tilt (Left-to-Right).....         | Left 45, Right 45 deg. |
| Distance Spindle to Column.....        | 11-3/8 in.             |
| Distance Spindle to Table.....         | 15-3/4 in.             |
| Drilling Capacity for Cast Iron.....   | 1-1/8 in.              |
| Drilling Capacity for Steel.....       | 1-1/8 in.              |
| Number of Vertical Spindle Speeds..... | Variable               |
| Range of Vertical Spindle Speeds.....  | 100 – 1600 RPM         |
| Quill Diameter.....                    | 2.56 in.               |
| Tapping Speed.....                     | 50 – 800 RPM           |

### Table Info

|                        |            |
|------------------------|------------|
| Table Length.....      | 32-1/4 in. |
| Table Width.....       | 9-1/2 in.  |
| Table Thickness.....   | 2-5/8 in.  |
| Table Pocket Size..... | 25 x 11 mm |
| Number of T-Slots..... | 4          |
| T-Slots Width.....     | 1/2 in.    |
| T-Slots Height.....    | 15/16 in.  |
| T-Slots Centers.....   | 2-1/8 in.  |
| Stud Size.....         | 3/8 in.    |

### Spindle Info

|                              |                           |
|------------------------------|---------------------------|
| Spindle Taper.....           | R8                        |
| Spindle Sleeve Diameter..... | 1.97 in.                  |
| End Milling Capacity.....    | 1-1/2 in.                 |
| Face Milling Capacity.....   | 2-1/8 in.                 |
| Drawbar Diameter.....        | 7/16 in.                  |
| Drawbar TPI.....             | 7/16-20                   |
| Drawbar Length.....          | 13-1/2 in.                |
| Spindle Bearings.....        | Thrust/Deep Groove, Taper |

### Lead Screw Info

|                         |  |
|-------------------------|--|
| Leadscrew Diameter..... | 20mm (X, Y, Z axes)                    |
| Leadscrew TPI.....      | 8 TPI (X, Y axes)                      |
| Leadscrew Length.....   | 36 in. (X), 18-3/4 in. (Y), 21-1/2 (Z) |

### Construction

|                            |               |
|----------------------------|---------------|
| Spindle Housing/Quill..... | Cast Iron     |
| Table.....                 | Cast Iron     |
| Head.....                  | Cast Iron     |
| Column.....                | Cast Iron     |
| Base.....                  | Cast Iron     |
| Paint.....                 | Powder Coated |

### Other Specifications:

|                                      |                       |
|--------------------------------------|-----------------------|
| Country Of Origin .....              | China                 |
| Warranty .....                       | 1 Year                |
| Serial Number Location .....         | ID Label on Headstock |
| Customer Assembly & Setup Time ..... | 30 Minutes            |





# SECTION 1: SAFETY


## **WARNING**

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

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

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

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

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

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

## **WARNING**

### **Safety Instructions for Machinery**

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

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

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

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

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

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





# WARNING

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

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

**DANGEROUS ENVIRONMENTS.** Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in dark areas. Keep work area clean, dry, and well-lighted.

**ONLY USE AS INTENDED.** Only use machine for its intended purpose. Never modify machine for a purpose not intended by the manufacturer!

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

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

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

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

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

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

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

**NEVER STAND ON MACHINE.** Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

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

**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.

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

**MAINTAIN WITH CARE.** Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine increases risk of injury.

**CHECK DAMAGED PARTS.** Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always 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 are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



# **WARNING**

## **Additional Safety for Mills**

**UNDERSTANDING CONTROLS.** Make sure you understand the use and operation of all controls.

**SAFETY ACCESSORIES.** Always use a chip guard in addition to your safety goggles when milling to prevent bodily injury.

**WORK HOLDING.** Before starting the machine, be certain the workpiece has been properly clamped to the table. NEVER hold the workpiece by hand when using the mill.

**CHUCK KEY SAFETY.** Always remove your chuck key, drawbar wrench, and any service tools immediately after use.

**SPINDLE SPEEDS.** Select the spindle speed that is appropriate for the type of work and material. Allow the mill to gain full speed before beginning a cut.

**POWER DISRUPTION.** In the event of a local power outage during use of the mill, turn **OFF** all switches to avoid possible sudden start up once power is restored.

**STOPPING SPINDLE.** DO NOT stop the mill using your hand against the chuck.

**CUTTING TOOL INSPECTION.** Inspect drills and end mills for sharpness, chips, or cracks before each use. Replace dull, chipped, or cracked cutting tools immediately. Handle new cutting tools with care. Leading edges are very sharp and can cause lacerations.

### **MACHINE CARE AND MAINTENANCE.**

Never operate the mill with damaged or worn parts. Maintain your mill in proper working condition. Perform routine inspections and maintenance promptly. Put away adjustment tools after use.

**DISCONNECT POWER.** Make sure the mill is turned **OFF**, disconnected from its power source and all moving parts have come to a complete stop before starting any inspection, adjustment, or maintenance procedure.

**AVOIDING ENTANGLEMENT.** Keep loose clothing articles such as sleeves, belts or jewelry items away from the mill spindle. Never wear gloves when operating the mill.

**BE ATTENTIVE.** DO NOT leave mill running unattended for any reason.

**TOOL HOLDING.** Always use the proper tools for the material you are milling. Make sure they are held firmly in the proper tool holder for the job.

**CLEAN-UP.** DO NOT clear chips by hand. Use a brush, and never clear chips while the mill is turning.

**EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support 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 decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## **CAUTION**

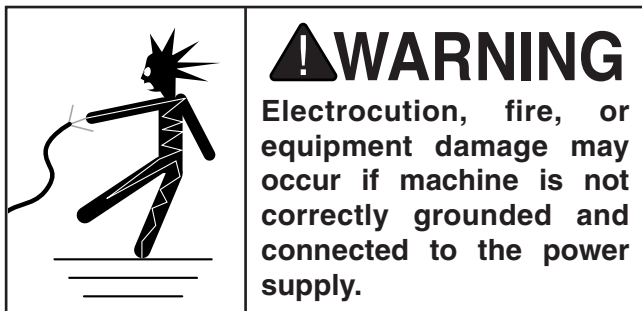
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



# SECTION 2: POWER SUPPLY

## Availability

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



## 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..... 16 Amps

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

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

## Circuit Requirements

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**  
**Minimum Circuit Size ..... 20 Amps**

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.)



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



## Grounding & Plug Requirements

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.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). 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.

**⚠ WARNING**

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

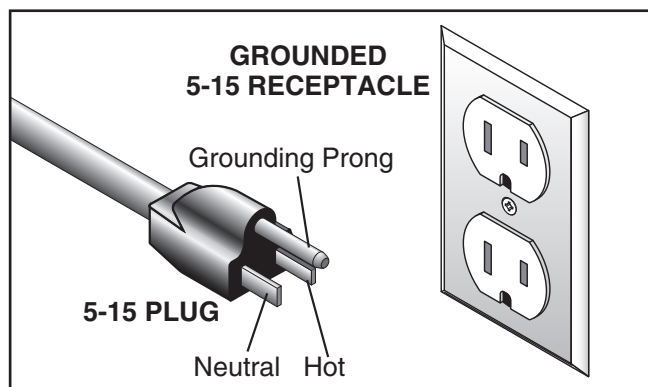


Figure 2. Typical 5-15 plug and receptacle.

**⚠ CAUTION**

**SHOCK HAZARD!**

**Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.**

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.

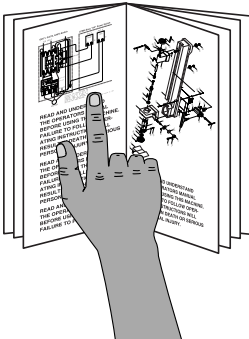
Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 Size ..... 12 AWG**  
**Maximum Length (Shorter is Better)..... 50 ft.**




# SECTION 3: SETUP



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



**!WARNING**  
 Wear safety goggles during the entire setup process!



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

## Needed for Setup

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

| Description   | Qty     |
|---|---------|
| • An Assistant .....  | 1       |
| • Precision Level .....   | 1       |
| • Safety Glasses .....  | 2 Pair  |
| • Mineral Spirits.....  | 1 Quart |
| • Shop Rags.....  | 5       |
| • Lifting Straps (1500lb Min. Capacity) .....                   | 2       |
| • Forklift or Hoisting Apparatus (1500lb Minimum Capacity)..... | 1       |

## Unpacking

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

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

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



**!WARNING**  
**SUFFOCATION HAZARD!**  
 Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.





# Inventory

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

| <b>Box 1: (Figures 3 &amp; 4)</b>       | <b>Qty</b> |
|---|------------|
| A. Assembled Mill .....                 | 1          |
| B. Drill Chuck .....                    | 1          |
| C. Open End Wrench 8/10mm.....          | 1          |
| D. Open End Wrench 14/17mm .....        | 1          |
| E. Open End Wrench 19/22mm.....         | 1          |
| F. Spindle Lock Pin .....               | 1          |
| G. Chuck Key .....                      | 1          |
| H. Fuse 1 Amp, Fast-Blow 5 x 20mm ..... | 1          |
| I. Fuse 2 Amp, Fast-Blow 5 x 20mm ..... | 1          |
| J. Hex Wrench Set 4, 5, 6, & 12mm.....  | 1 Ea       |
| K. Bottle for Oil .....                 | 1          |

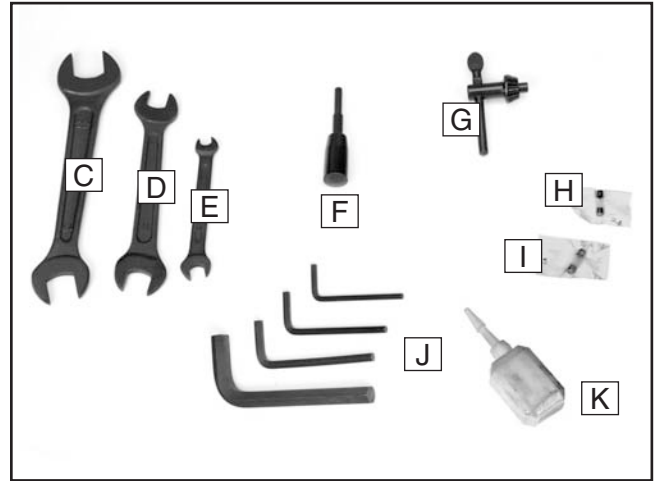


Figure 4. Inventory.

## ***NOTICE***

If you cannot find an item on this list, carefully check the machine and the packaging materials. Some of these items may be pre-installed for shipping or become misplaced during unpacking.

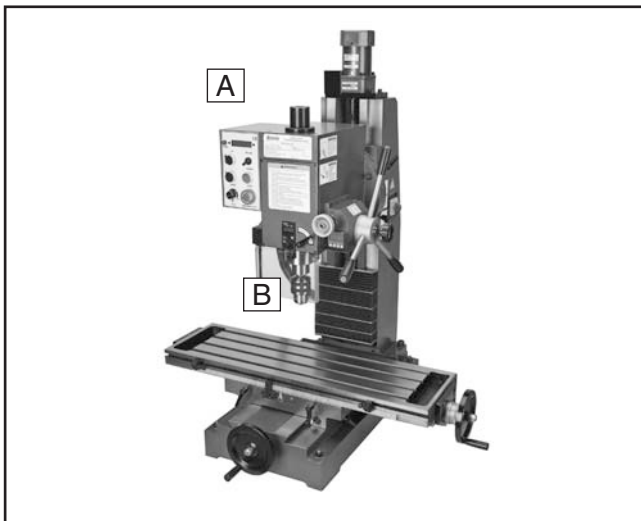


Figure 3. G0720R out of the crate.



# 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.

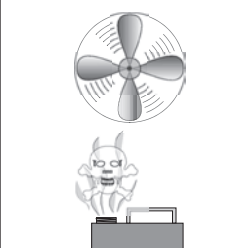
## Before cleaning, gather the following:

- 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.

|  |  |
|--|--|
|  | <b>⚠ WARNING</b><br>Gasoline or products with low flash points can explode or cause fire if used to clean machinery. Avoid cleaning with these products. |
|--|--|

|  |  |
|--|--|
|  | <b>⚠ CAUTION</b><br>Many cleaning solvents are toxic if concentrated amounts are inhaled. Only work in a well-ventilated area. |
|--|--|

|  |
|--|
| <b>NOTICE</b><br>Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces. Test all cleaners in an inconspicuous area before using to make sure they will not damage paint. |
|--|





# Site Considerations

## Weight Load

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

## Space Allocation

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



## Physical Environment

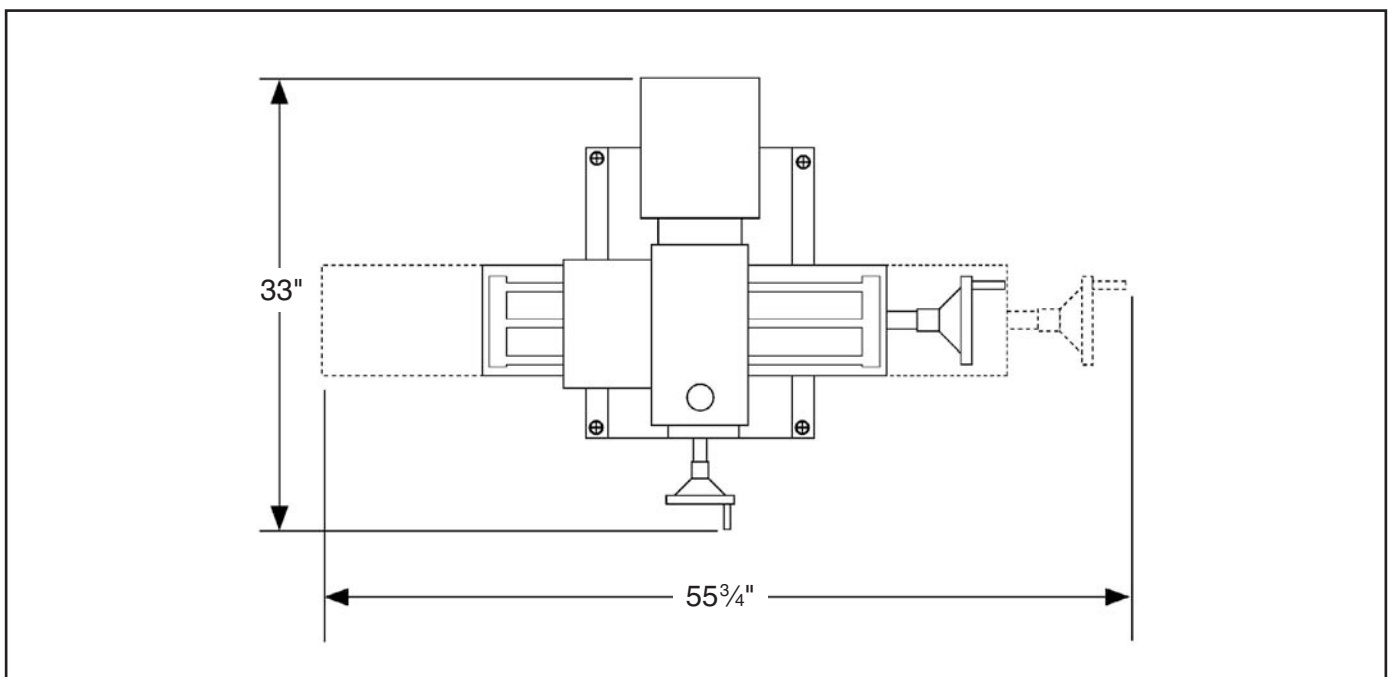
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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

## Electrical Installation

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

## Lighting

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



**Figure 6.** Minimum working clearances.



# Mounting to Workbench

Your mill should be bolted to a workbench to provide maximum rigidity and safety.

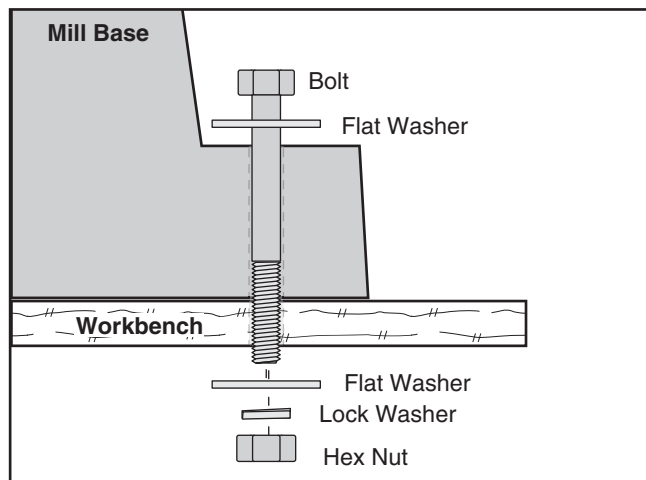
| Components and Hardware Needed:             | Qty |
|---|-----|
| Hex Bolts 1/2"-13 x (length as needed)..... | 4   |
| Flat Washers 1/2".....                      | 8   |
| Lock Washers 1/2".....                      | 4   |
| Hex Nuts 1/2"-13.....                       | 4   |

## To mount the mill to the workbench:

1. Determine the best position for the mill on the workbench.

**Note:** For the best performance, make sure the cross feed and the longitudinal handwheels extend out beyond the edge of the table surface. This will allow unrestricted handwheel operation.

2. Mark your hole locations using the mounting holes in the base as a guide.
3. Drill the holes needed in the workbench.
4. Place a precision level on the mill table and shim the mill until it is level side-to-side and front-to-back.
5. Bolt the mill to the top of the workbench (see **Figure 7**).



**Figure 7.** Example of a through mount setup.

# Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation. The test run consists of verifying the following: 1) The motors power up and run correctly and 2) the stop button and chip guard safety feature works correctly.

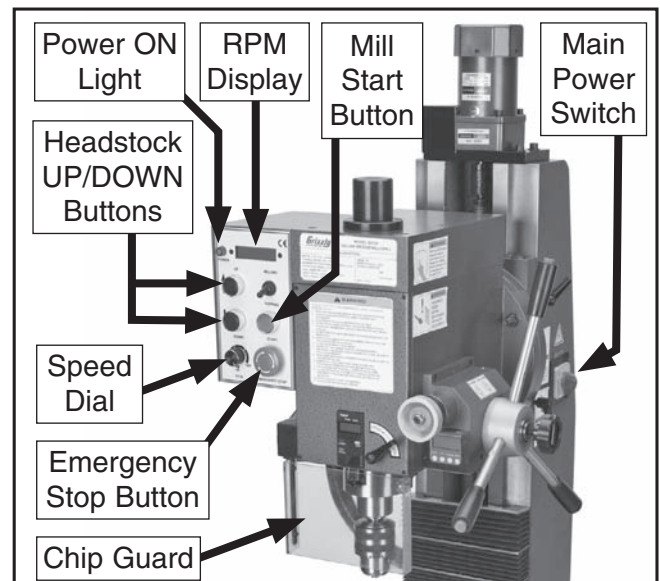
If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting on Page 34**. If you cannot find a remedy, contact our Tech Support at (570) 546-9663 for assistance.

## ⚠ WARNING

**Before starting the machine, make sure you have performed the preceding assembly and adjustment instructions. You must read through the rest of the manual and understand the various functions and safety features. Failure to follow this warning could result in serious personal injury or even death!**

## To test run the machine:

1. Push the EMERGENCY STOP button in, and turn the main power switch to **OFF** (see **Figure 8**).



**Figure 8.** Machine controls.



2. Do all lubrication procedures highlighted in **Lubrication** in **SECTION 6: MAINTENANCE** on **Page 30**.

3. If there is no arbor or chuck installed in the spindle, remove the drawbar cap and the drawbar to prevent vibration.

**Note:** *The drawbar cap has left-hand threads and loosens when turned clockwise.*

4. Put on safety goggles, make sure the area is clean, all tools are put away, and no entanglement hazards exist.

5. Rotate the spindle speed dial (see **Figure 8**) counterclockwise to the slowest setting.

6. Close the chip guard (see **Figure 8**) and connect the machine to power.

7. Twist the EMERGENCY STOP button clockwise so it pops out and is reset.

**Note:** *The power ON light shown in **Figure 8** illuminates to indicate that all machine controls are now LIVE and ready for use.*

8. Loosen the headstock lock levers, and push the UP and DOWN buttons to test the headstock elevation motor.

9. Push the START button to start the spindle.

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

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

10. Test the variable speed by turning the spindle speed dial up then down.

11. Press the EMERGENCY STOP button to stop the spindle.

12. WITHOUT resetting the EMERGENCY STOP switch, press the START button. The machine should **not** start.

13. Reset the EMERGENCY STOP switch, open the chip guard, and press the START button again. The machine should **not** start.

—If the machine starts, shut it **OFF** and, disconnect it from power. Do not operate the machine any further until the safety features are fixed.

14. Test run is complete. Next, complete **Spindle Break-In** before putting the mill into full service.

## **NOTICE**

**Failure to follow start up and spindle break-in procedures will likely cause rapid deterioration of spindle and other related parts.**



# Spindle Break-In

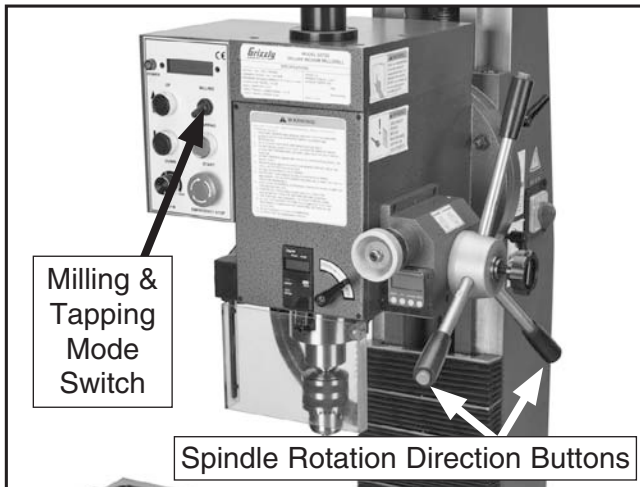
Before putting this machine into full service, the **Test Run** must be completed and the spindle bearings must be broken in.

## **⚠️ WARNING**

**DO NOT** leave the area while break-in procedure is under way. You must be ready to stop the machine if any problem occurs.

### To break in the machine:

1. Move the MILLING & TAPPING mode switch (see **Figure 9**) to the TAPPING position.



**Figure 9.** Tapping controls.

2. Push the START button.

**Note:** *When in tapping mode, the spindle speed is reduced by half automatically, and the speed range will be 50–800 RPM. Tapping requires lower speeds than other milling operations.*

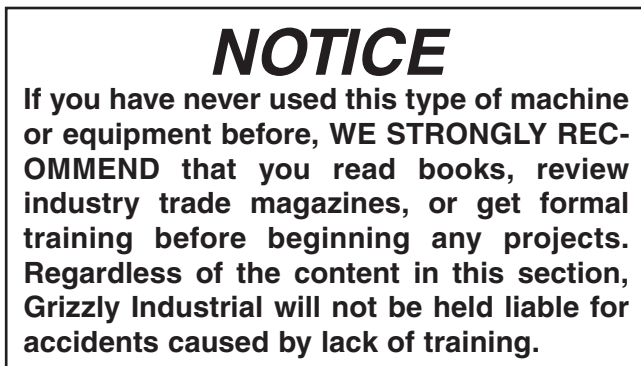
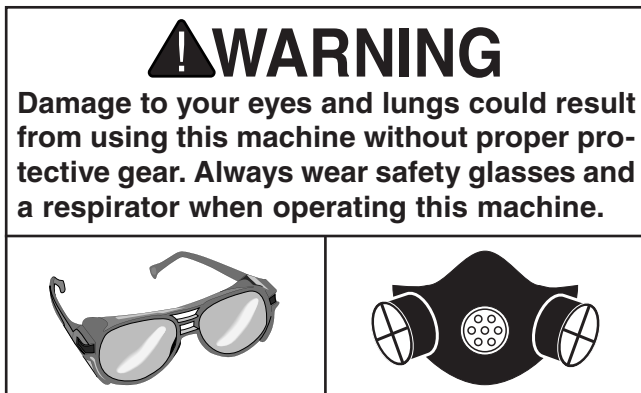
3. Rotate the spindle speed dial so the spindle runs at 500 RPM, and let it run for ten minutes.
4. Increase the speed to 800 RPM, and let it run for another ten minutes.
5. Push the EMERGENCY STOP button, and rotate the spindle speed dial counterclockwise to its minimum position.
6. Start the mill, and push one of the three buttons on the end of the downfeed handles to reverse spindle rotation.
7. Run the mill again at both speeds (as described above) to finish the break-in procedure.
8. Move the MILLING & TAPPING mode switch to the MILLING position, then run machine at a speed of 1600 RPM for ten minutes.
9. Run the machine at 800 RPM for another 15 minutes to allow it cool down.

# SECTION 4: OPERATIONS

## Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



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

1. Examines the workpiece to make sure it is suitable for milling.
2. Puts on the required safety gear.
3. Firmly clamps the workpiece to the table.
4. Installs the correct cutting tool for the operation.
5. Uses the manual downfeed and table controls to confirm the correct positioning of the cutting tool and workpiece for the operation.
6. Sets the digital depth stop and mini digital protractor to the required units of measurement.
7. Locks the headstock and the required table locks in place.
8. Determines the feed rate and cutting speed.
9. Connects the machine to power, and turns the main power switch **ON**.
10. Presses the start button and adjusts the spindle RPM with the spindle speed dial.
11. Begins milling, drilling, or tapping.
12. When finished, turns the mill **OFF** and disconnects it from power.



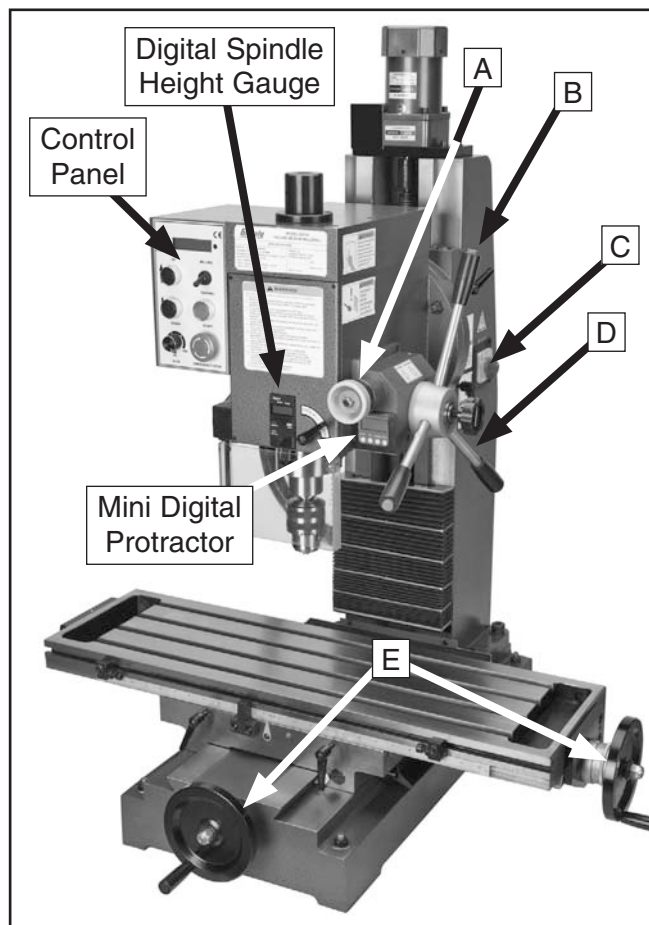


# Controls

Review this section to locate and understand how to use the mill controls and factors for machine operation.

## General Controls

The controls shown in **Figure 10** turn the main machine power **ON** and **OFF**, and reverse spindle direction. Also shown are the locations of the control panel, spindle height gauge, and the digital protractor, which will be detailed in their own sub-sections



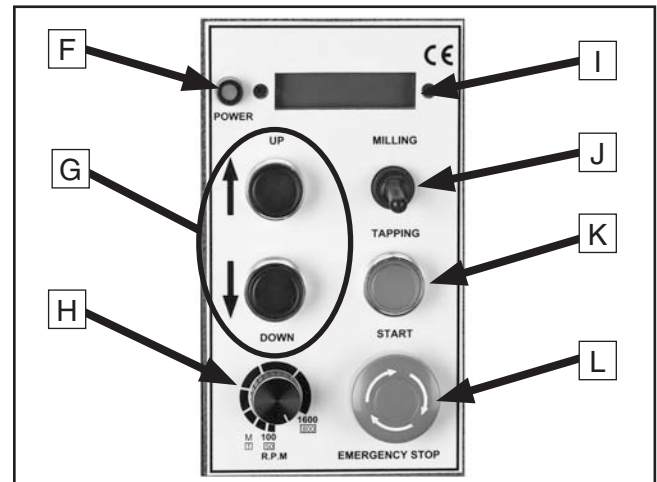
**Figure 10.** General controls.

- A. Fine Feed knob:** Raises and lowers the spindle in fine increments.
- B. Spindle Rotation Buttons:** When in the tapping mode, these buttons change spindle rotation direction. In this mode, spindle direction can be reversed at any RPM without having to stop the spindle first.

- C. Main Power Switch:** Toggles power **ON** and **OFF** to the control panel.
- D. Downfeed Handle:** Raises and lowers the spindle in coarse increments.
- E. Handwheels:** Move the table in the X- and Y-axis.

## Control Panel

The controls shown in **Figure 11** start and stop the spindle, set spindle speed, and adjust the headstock height.

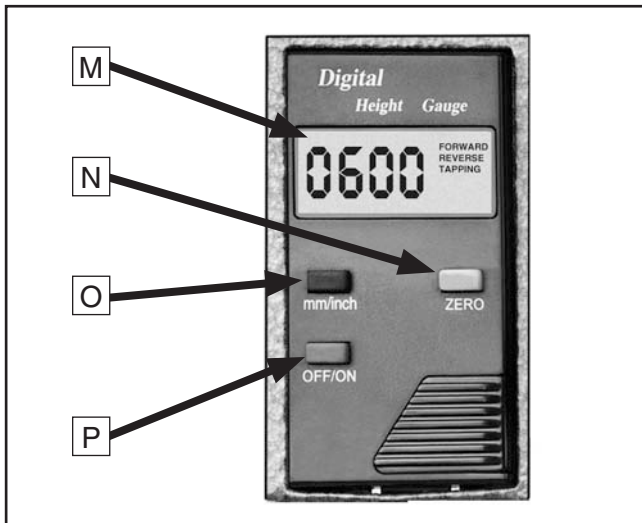


**Figure 11.** Control panel overview.

- F. POWER Lamp:** Glows when the main power switch is **ON** to indicate that all machine controls are **LIVE** and ready for use.
- G. UP/DOWN Buttons:** Raises and lowers the headstock.
- H. RPM Dial:** Adjusts spindle speed between 100–1600 RPM or tapping speed between 50–800 RPM.
- I. Spindle Speed Readout:** Displays the spindle speed RPM, direction, and mode.
- J. MILLING & TAPPING Switch:** Selects which mode the machine is in.
- K. START Button:** Starts the spindle motor for milling or tapping operations.
- L. EMERGENCY STOP Button:** Stops the mill and prevents restarting while it is in the depressed position. Rotate the button clockwise to reset it.

## Digital Spindle Height Gauge

The digital spindle height scale shown in **Figure 12** displays spindle position and movement. An auto shut-off feature will turn the unit **OFF** after several minutes of idle time. When turned back **ON**, the last measurement is recalled so work can be resumed. However, if the battery is changed or becomes discharged, the stored value is lost.

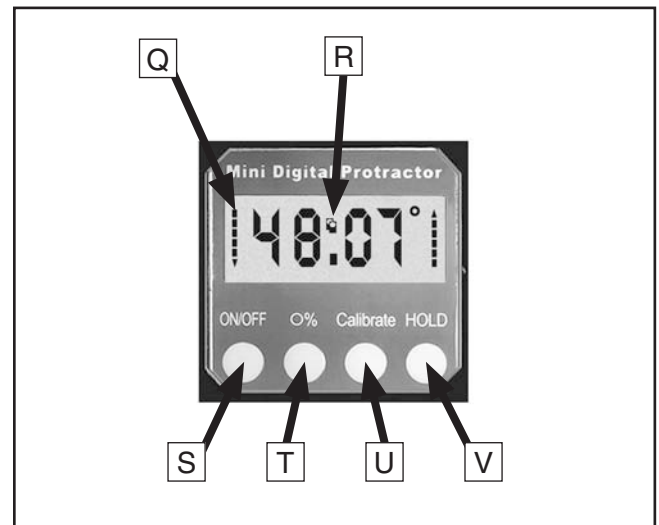


**Figure 12.** Digital spindle height scale.

- M. Digital Spindle Height Display:** Displays spindle position and movement with a resolution of 0.0005" (0.01mm).
- N. ZERO Button:** Zeros the digital spindle scale at any point along its stroke.
- O. mm/inch Button:** Toggles units of measure between metric and inch conventions.
- P. OFF/ON Button:** Turns the digital height gauge **ON** or **OFF**.

## Mini Digital Protractor

The mini digital protractor shown in **Figure 13** displays the headstock spindle angle and slope in relationship with the table surface. An auto shut-off feature will turn **OFF** the unit after several minutes of idle time. When turned back **ON**, the last measurement is recalled so work can be resumed. However, if the battery is changed or becomes discharged, the stored value is lost.



**Figure 13.** Mini digital protractor.

- Q. Tilt Arrows:** Indicate the direction of tilt.
- R. Battery Life:** Icon becomes viewable when batteries need replacement.
- S. ON/OFF Button:** Turns the protractor **ON** or **OFF**. For **OFF**, press and hold the button.
- T. 0%:** Toggles units of measure between degrees and percent of grade conventions.
- U. Calibrate:** Zeros the protractor at any position within the range of headstock tilt.
- V. HOLD:** Locks the protractor at its current displayed value.





# Selecting Spindle RPM

Closely follow the proper cutting speed and proper feed to reduce undue strain on all moving parts and increase operator safety.

Prior to milling, determine the RPM needed to cut your workpiece, then set the RPM on the machine.

## To determine the needed RPM:

1. Use the table in **Figure 14** to determine the cutting speed required for your workpiece material.
2. Measure the diameter of your cutting tool in inches.
3. Use the following formula to determine the needed RPM for the milling operation:

$$(\text{Cutting Speed} \times 4) / \text{Tool Diameter} = \text{RPM}$$

| Cutting Speeds for High Speed Steel (HSS) Cutting Tools |                     |
|---|---------------------|
| Workpiece Material                                      | Cutting Speed (sfm) |
| Aluminum & alloys                                       | 300                 |
| Brass & Bronze  | 150                 |
| Copper  | 100                 |
| Cast Iron, soft   | 80                  |
| Cast Iron, hard   | 50                  |
| Mild Steel  | 90                  |
| Cast Steel  | 80                  |
| Alloy Steel, hard                                       | 40                  |
| Tool Steel  | 50                  |
| Stainless Steel   | 60                  |
| Titanium  | 50                  |
| Plastics  | 300-800             |
| Wood  | 300-500             |

**Note:** For carbide cutting tools, double the cutting speed. These values are a guideline only. Refer to the *MACHINERY'S HANDBOOK* for more detailed information.

**Figure 14.** Cutting speed table for HSS cutting tools.

# Setting Spindle Height

Spindle height is changed by unlocking the quill lock and using the downfeed handles or the fine feed knob (see **Figure 15**). The digital height gauge indicates the spindle height.

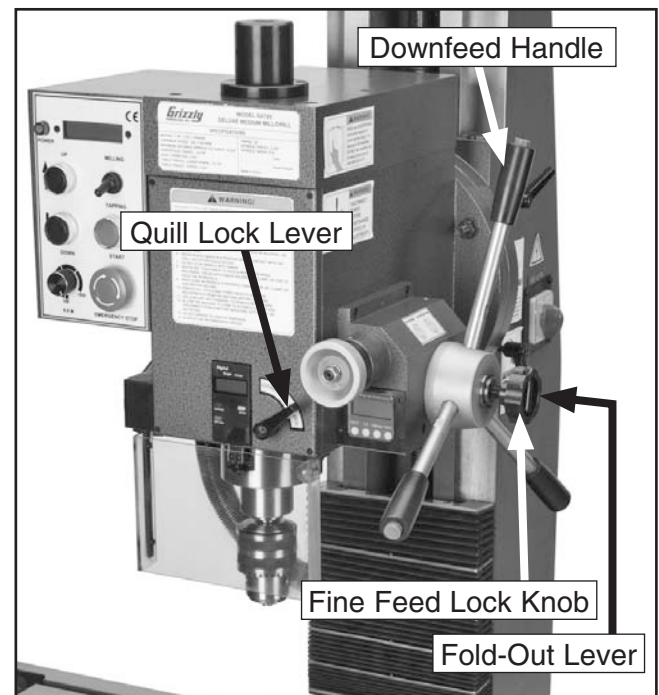
## To change the spindle position:

1. Unlock the quill lock lever and loosen the fine feed lock knob.

**Tip:** Use the fold-out lever (see **Figure 15**) for additional leverage to unlock the fine feed lock knob if the knob is too tight. Do not use the fold-out lever to tighten the knob.

2. Pull down on the downfeed handles to lower or raise the spindle. Tighten the quill lock to secure the spindle in a particular position (if desired).

**Tip:** Milling with the quill fully extended can cause tool chatter. For maximum spindle rigidity, it is better to keep the spindle retracted into the headstock as far as possible with the quill lock lever and fine feed lock knob tightened.



**Figure 15.** Spindle controls.



# Drill Chuck Installation & Removal

The chuck is attached to an R-8 arbor using a B18 taper. This attachment is considered to be semi-permanent. There should be no need to separate the chuck from the arbor.

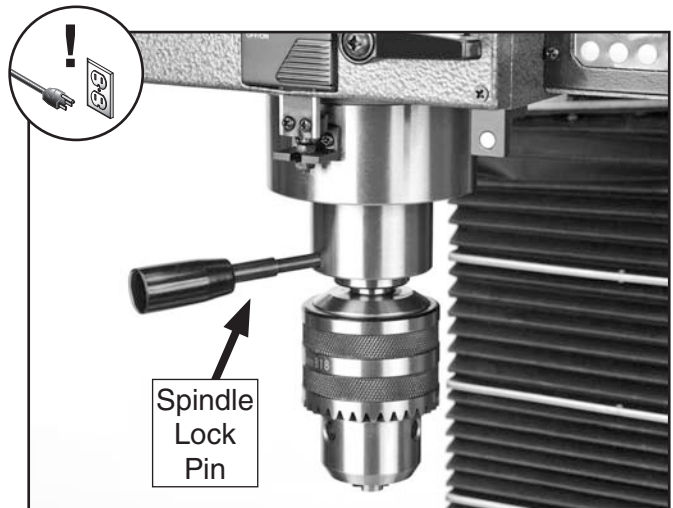
## Installation

1. DISCONNECT MILL FROM POWER!
2. Insert the chuck arbor into the spindle so it engages the alignment pin inside of the spindle and makes contact with the drawbar threads.
3. Thread the drawbar into the arbor until the arbor is seated up into the spindle taper.
4. While supporting the chuck and arbor with one hand, snug the drawbar with the drawbar hex wrench.

**Note:** Do not overtighten the drawbar. Overtightening makes arbor removal difficult and will damage the arbor and threads.

## Removal

1. DISCONNECT MILL FROM POWER!
2. Lock the quill in place with the quill lock.
3. Insert the spindle lock pin into the hole in the side of the spindle (see **Figure 16**).



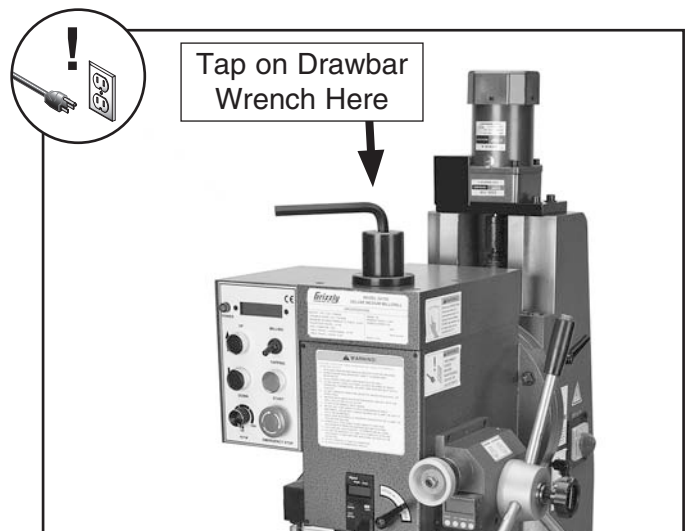
**Figure 16.** Spindle lock pin holding spindle.

4. Using the drawbar hex wrench, loosen the drawbar two turns. DO NOT remove the drawbar.

## NOTICE

**DO NOT completely unscrew the drawbar before tapping it with the hammer in the next Step. You will damage the threads on the drawbar and the arbor.**

5. Put on safety goggles and tap the top of the drawbar wrench with the hammer. This will unseat the taper of the arbor from the spindle (see **Figure 17**).



**Figure 17.** Drawbar wrench.

6. Hold one hand under the chuck and finish loosening the drawbar by hand until it falls out of the spindle.

# R-8 Collet Installation & Removal

If you do not use the drill chuck and arbor, you need to use a collet to insert the cutting tool into the spindle. Your Model G0720R features an R-8 spindle taper, which gives the freedom to use common R-8 collets. These optional collets come in many sizes, typically ranging from 1/16" to 7/8" and 3mm to 20mm, and should be matched to your cutting tool shank size.

## Installation

1. DISCONNECT MILL FROM POWER!
2. Unscrew the drawbar cap.
3. Carefully clean the surface of the collet and spindle taper. Ensure that it is free of debris and is lightly oiled.
4. Insert the cutting tool into the collet, then insert the collet into the spindle taper.
5. Rotate the collet so it engages the alignment pin inside of the spindle, then slide the collet upward until it makes contact with the drawbar threads.
6. Thread the drawbar into the collet until the collet draws up into the spindle taper.
7. While supporting the tool in the collet with one hand, snug the drawbar with the drawbar hex wrench in your opposite hand.

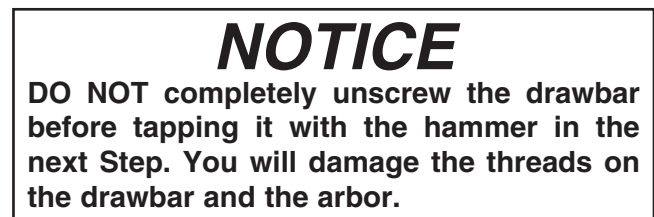
**Note:** Do not overtighten the drawbar. Overtightening makes collet removal difficult and will damage the drawbar threads, collet, and the spindle taper. Keep in mind that the taper keeps the collet and tool in place. The drawbar simply aids in seating the taper.

## Removal

1. DISCONNECT MILL FROM POWER!
2. Tighten the headstock lock.



3. Protect the table surface with a piece of cardboard or hold the cutter/tool with a shop towel to prevent it from falling out of the collet.
4. Using the drawbar hex wrench, loosen the drawbar two turns, but DO NOT remove it.



5. Put on safety goggles, and tap the hex wrench to unseat the collet from the taper.
6. Unscrew the rest of the drawbar and allow the collet and tool to fall into your hand.

**Note:** When not in use, always remove collets and cutting tools from the spindle taper. Oxidation may cause the collet to seize and make it hard to remove later.

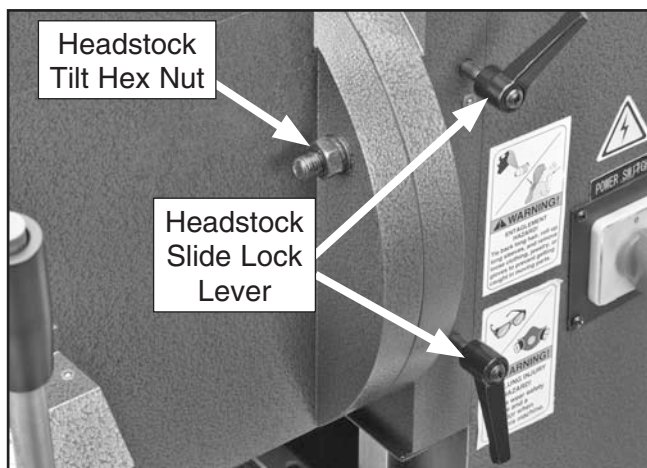


# Headstock Travel (Z-Axis & Rotation)

Your mill has a dovetailed column that allows you to reposition the headstock along the Z-axis and change tooling without losing your alignment with a hole or milling path. For angled milling operations, the headstock can be rotated left and right 45°.

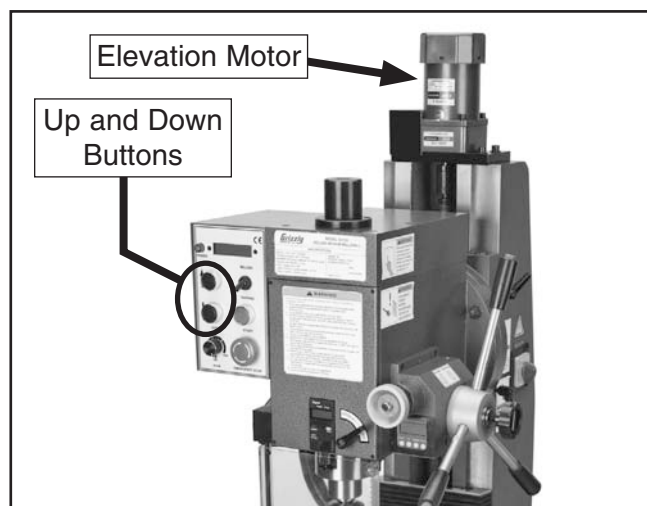
## Raising & Lowering

1. Unlock the headstock slide lock lever shown in **Figure 18**.



**Figure 18.** Headstock slide controls.

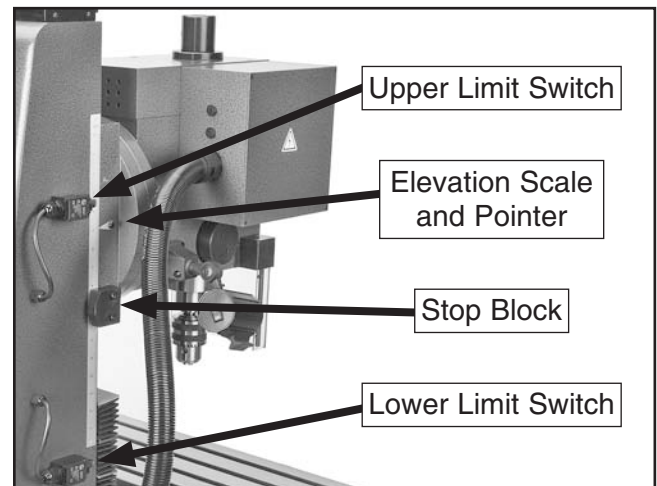
2. On the control panel push the UP or DOWN buttons (see **Figure 19**) to raise or lower the headstock with the elevation motor.



**Figure 19.** Z-axis control.

3. Observe the height scale on the left side column shown in **Figure 20** to determine the headstock travel. This scale is broken down in 1/8" graduations.

**Note:** When the headstock reaches a point of travel where the leadscrew has run out of thread, a stop block (see **Figure 20**) contacts either the upper or lower limit switch to stop the elevation motor from over running the physical limitations of the leadscrew length, which would cause damage.



**Figure 20.** Column switches and scale.

**Note:** For maximum spindle rigidity when milling, keep the spindle retracted into the headstock as far as possible with the quill lock lever locked and with the fine feed lock knob tightened.

Continued on next page →



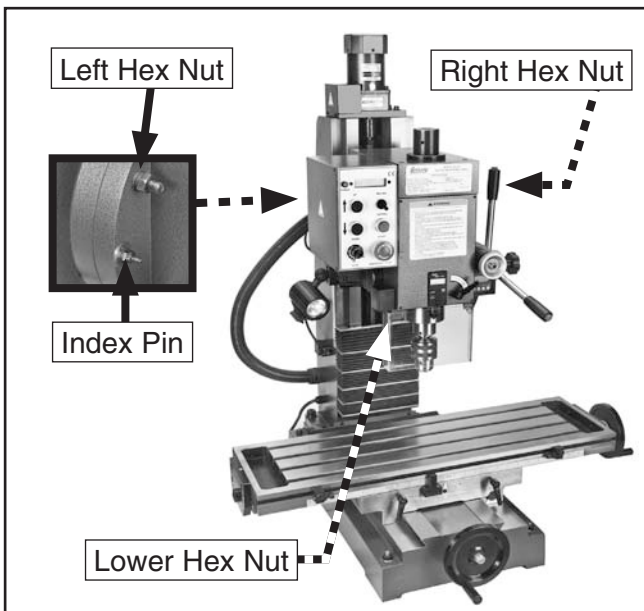
## Tilting

1. DISCONNECT MILL FROM POWER!
2. On the digital protractor shown in **Figure 21**, press the ON/OFF button to turn it **ON**, and press **CALIBRATE** to set its digital display to zero.



**Figure 21.** Digital protractor.

3. Press **0%** button to select the type of angle units shown on the digital display.
4. Located on the headstock swivel mount, loosen the left, right, and lower headstock tilt lock nuts shown in **Figure 22**.



**Figure 22.** Headstock tilt locking hex nuts.

5. Pull and hold the spring-loaded index pin (see **Figure 22**) outward approximately  $\frac{1}{4}$ " to disengage it while you rotate the headstock to the desired angle as shown by the digital protractor.

**Note:** The spring-loaded index pin serves only as a quick way to return or position the headstock close to zero, or  $45^\circ$  to the left or right. It is not intended to be an exact angle stop.

6. Snug the three hex nuts in place.
7. Place the appropriate angle finding tooling on the workpiece or milling table, and fine-tune your angle adjustment and alignments according to standard machine shop practices.
8. When satisfied with the position of the headstock, tighten the three hex nuts, and recheck your settings.

**Note:** As described earlier in the manual, the digital protractor is equipped with an auto-shutoff feature. So if during setup or milling operations it shuts **OFF**, your angle setting is retained in volatile memory. When the protractor is needed again, push the **ON/OFF** button and the digital display will retrieve and show the last angle or grade measured.

# Table Travel (X-Axis & Y-Axis)

Using the handwheels, the milling table can be moved in and out (Y-axis), and left and right (X-axis). The handwheels are fitted with a graduated dial shown in Figure 23 that reads in increments of 0.001" where one complete rotation equals 1/8" of table travel. The Y-axis handwheel can be disengaged from the leadscrew, so it can safely freewheel if a power feed is installed and in use. Both the X and Y leadscrews are 8 TPI and 20mm in diameter.

## X-Axis

Fastened to the front of the table is a 24" inch long scale (see Figure 24) that is broken down in increments of 1/8". This inch scale is used for general workpiece positioning, and the graduated dial on the handwheel is for precise positioning.

For milling operations where the table is moved in or out in the Y-axis, left and right X-axis movement can be prevented by using the table lock levers located on the front of the table shown in Figure 25.

The table also is equipped with adjustable table stops for when X-axis travel must be kept within range.

## Y-Axis

For milling operations where the table is moved left or right in the X-axis, in and out Y-axis movement can be prevented by using the table lock levers located under the right-side of the table shown in Figure 25.



Figure 23. Handwheel scale.

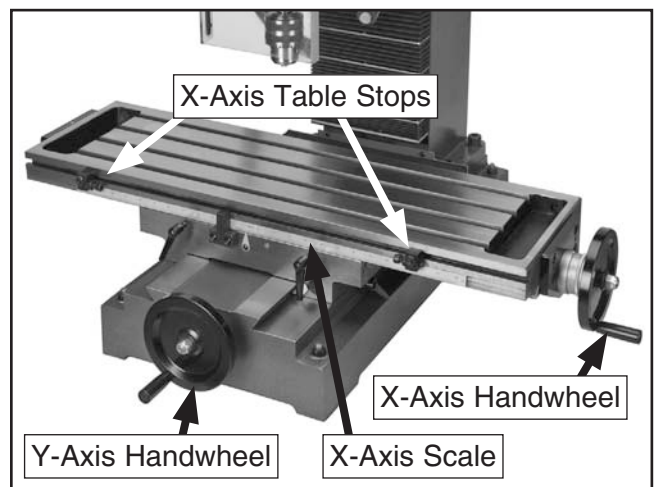


Figure 24. Table X- and Y-axis controls.

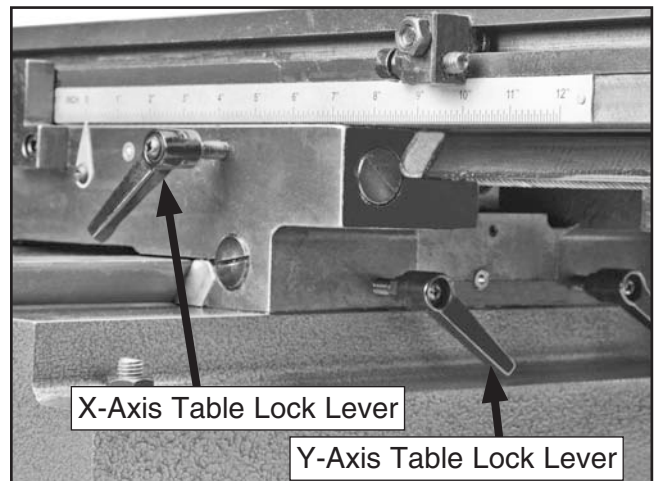


Figure 25. Table locks and scales.

# Milling/Drilling Mode

---

This mill is designed to use end mills, taps, drill bits, and face cutters up to 2 1/8" in diameter. The milling table has a coolant trough with drain for an optional cutting fluid system.

## WARNING

Overloading the bit, tap, or cutter or using excessive spindle speeds may threaten operator safety from ejected parts or broken tools.

### To mill a workpiece:

1. Refer to **Controls** on **Page 19** to understand the functions of the machine controls.
2. Zero the spindle height scale and select units of measure, then close the chip guard.
3. Clamp the workpiece to the milling table, and adjust the headstock to the needed angle, height, depth of cut, and milling path.

**Remember:** Milling with the quill fully extended can cause tool chatter. For maximum spindle rigidity, keep the spindle retracted into the headstock as far as possible with the quill lock lever locked and the fine feed lock knob tightened.

4. Refer to **Selecting Spindle RPM** on **Page 21** to find the best spindle RPM.
5. Put your safety goggles on, then turn the power switch **ON**.
6. Select **MILLING** with the toggle switch. **FORWARD** will be shown in the digital display.
7. Press the ON button to start the mill, and turn the spindle speed dial until the required RPM is shown in the spindle speed readout.
8. Lock the appropriate table lock levers and use an X or Y handwheel to slowly feed the workpiece into the cutter.

# Tapping Mode

---

When in the tapping mode, the spindle direction can immediately alternate between forward and reverse immediately by pressing any of the spindle direction buttons at the end of the downfeed handles. This feature is critical to back the tap out of a hole before it bottoms and snaps off. However, using this feature takes practice and cutting threads into blind holes should be avoided.

## WARNING

Overloading the bit, tap, or cutter or using excessive spindle speeds may threaten operator safety from ejected parts or broken tools.

### To drill and thread a hole:

1. Refer to **Controls** on **Page 19** to understand the functions of the machine controls.
2. Zero the spindle height scale and select units of measure, and calculate your maximum tapping depth without bottoming-out the tap.
3. Clamp the workpiece to the milling table, and adjust the headstock to the needed height for drilling and tapping.
4. Put on safety goggles, select **MILLING** with the toggle switch. **FORWARD** will be shown in the digital display.
5. Drill your hole with the appropriate speed and drill bit size for the tap. For large holes, drill a pilot hole.
6. Install the tap, and apply tapping fluid.
7. Select **TAPPING** with the toggle switch, press the ON button, and turn the spindle speed dial to 100 RPM.
8. Begin threading, but without disengaging the tap from the threads, frequently push the spindle direction buttons to alternate spindle rotation back and forth to eject chips from the tap and hole in order to prevent chip loading and tap breakage.





# SECTION 5: ACCESSORIES

## **⚠️ WARNING**

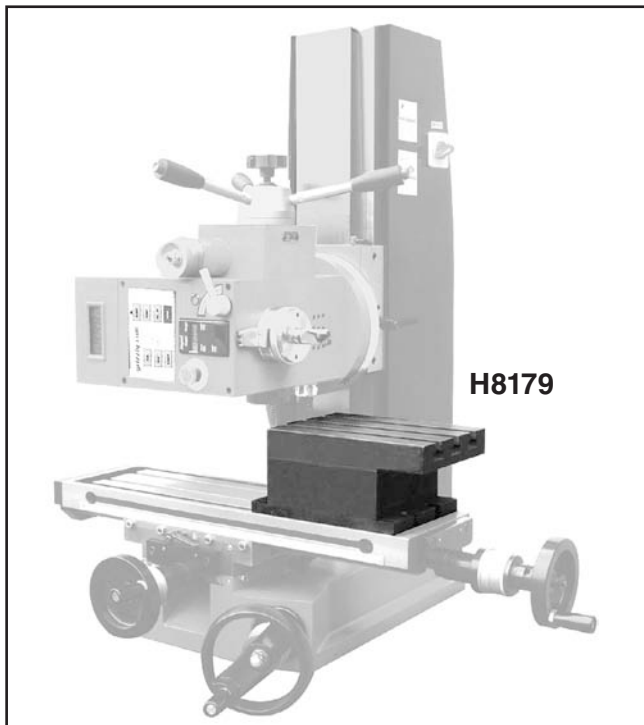
Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

## **NOTICE**

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

### **H8179—Horizontal Milling Table**

Take advantage of the G0720R tilting headstock feature. Install this lifted cast-iron milling table for the correct workpiece height when making special tilted headstock milling operations.

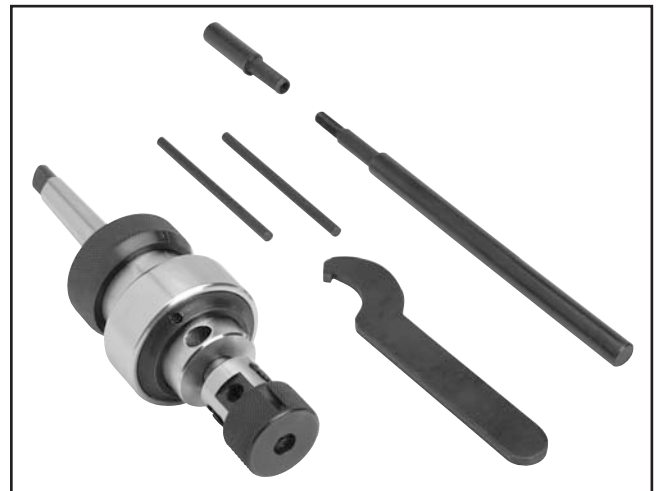


**Figure 26.** Horizontal milling worktable.  
**Note:** Model G0619 Mill/Drill Shown.

### **T10057—Tapping Attachment**

Safely use your benchtop milling machine to tap threads into blind holes. An internal adjustable clutch mechanism allows you to adjust slip, so if a tap bottoms in a blind hole before the spindle is reversed, the clutch slips without the tap shearing off. You can tap  $\frac{3}{16}$ " to  $\frac{1}{2}$ " or M5 to M12 threads. Maximum speed is 700 RPM.

**Note:** To use this tapping attachment on the Model G0720R mill, you must purchase the G1427 R-8/ MT #2 Morse Taper sleeve.



**Figure 27.** T10057 Tapping Attachment.

### **G2861—Face Mill**

#### **G4051—Carbide Insert for Face Mill**

This  $2\frac{1}{2}$ " face mill accepts four carbide inserts (not included). Comes with an R-8 arbor.



**Figure 28.** G2861 Face Mill.

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

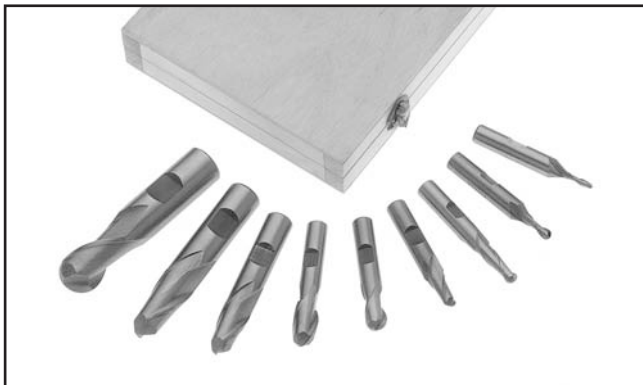


**G9760—20-PC. 2 & 4 Flute TiN End Mill Set.**  
 Includes these sizes and styles in two and four flute styles:  $\frac{3}{16}$ " ,  $\frac{1}{4}$ " ,  $\frac{5}{16}$ " ,  $\frac{3}{8}$ " ,  $\frac{7}{16}$ " ,  $\frac{1}{2}$ " ,  $\frac{9}{16}$ " ,  $\frac{5}{8}$ " ,  $\frac{3}{8}$ " ,  $\frac{11}{16}$ " , and  $\frac{3}{4}$ " .



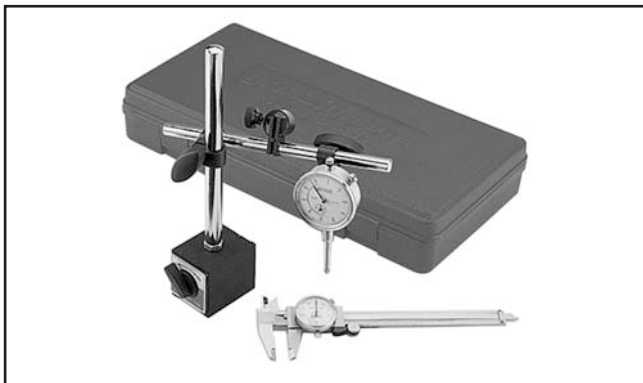
**Figure 29.** G9760 20-PC End Mill Set.

**G9765—9-PC. Ball End Mill Set**  
 Features 2 flute ball nose end mills. Includes the following sizes:  $\frac{1}{8}$ " ,  $\frac{3}{16}$ " ,  $\frac{1}{4}$ " ,  $\frac{5}{16}$ " ,  $\frac{3}{8}$ " ,  $\frac{7}{16}$ " ,  $\frac{1}{2}$ " ,  $\frac{5}{8}$ " and  $\frac{3}{4}$ " .



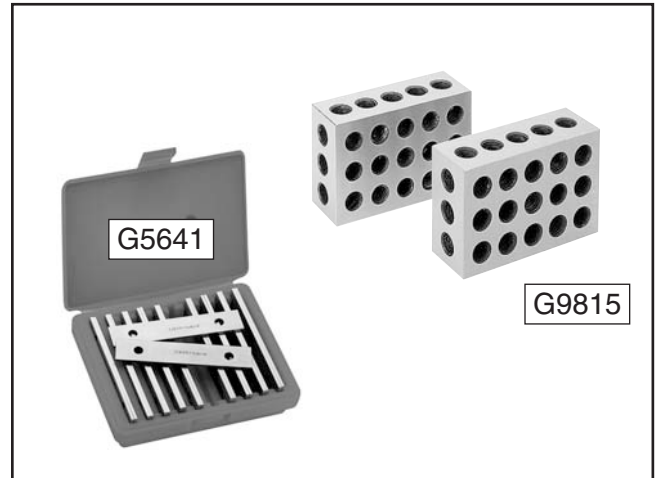
**Figure 30.** G9765 9 PC. Ball End Mill Set.

**H3022—Measurement Tool Set**  
 Includes magnetic base, 1" dial indicator (.001"), and 6" dial caliper (.001"). The extremely low price has made this a very popular seller!



**Figure 31.** H3022 Measurement Tool Set.

**G5641—1-2-3 Blocks**  
**G9815—Parallel Set**



**Figure 32.** G5641 1-2-3 Blocks, G9815 Parallel Set, and H5556 Edge Finder Set.

**G9324—Boring Head Combo Set**  
 Hardened and ground adjusting screws along with a wide base design guarantee a long life and trouble-free use. Includes a 3" boring head, R-8 shank with  $\frac{1}{2}$ "-18 TPI, and a 12 piece  $\frac{3}{4}$ " boring bar set.

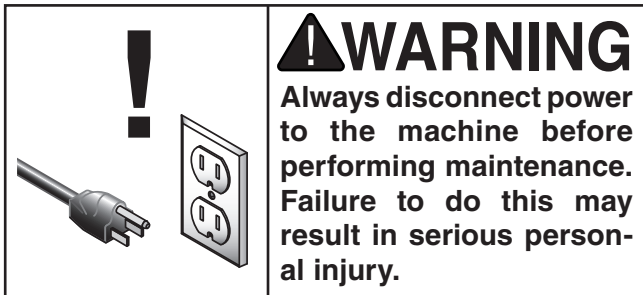


**Figure 33.** G9324 Boring Head Combo Set.

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



# SECTION 6: MAINTENANCE



## Schedule

Typically, each operator is responsible for ensuring proper care of the equipment. We strongly recommend all operators make a habit of following the daily maintenance procedures.

### Ongoing

To maintain a low risk of injury and proper machine operation, if you ever observe any of the items below, shut down the machine immediately and fix the problem before continuing operations:

- Loose mounting bolts or fasteners.
- Worn, frayed, cracked, or damaged wires.
- Chip guard removed.
- EMERGENCY STOP button not working correctly or not requiring you to reset it before starting the machine again.
- Any other unsafe condition.

### Daily, Before Operations

- Lubricate the ball oilers.
- Turn spindle speed dial all the way down.

### Daily, After Operations

- Vacuum/clean all swarf from table, slides, and way cover.
- Wipe down all unpainted or machined surfaces with an oiled rag.
- Push the EMERGENCY STOP button and shut **OFF** the master power switch (to prevent accidental startup).
- Remove any rotary tables, vises, fixtures, or workpieces from the table to prevent rusting the table surface.

### Monthly

- Clean/lubricate the leadscrew.
- Check gib adjustment.

### Annually

- Disconnect machine from power, open electrical box, and clean with compressed air or a vacuum.

## Lubrication

Regular lubrication will ensure your mill performs at its highest potential. Place two to three drops of a lathe way oil directly on the exposed table ways, the table, and any other exposed unpainted metal and work it into the metal with a clean rag.

You may also protect the unpainted cast iron surfaces with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9. Lubricate these before and after mill use with a high quality way oil like what is shown in **Figure 34**.



**Figure 34.** Primrose Armor Plate Lubricant.

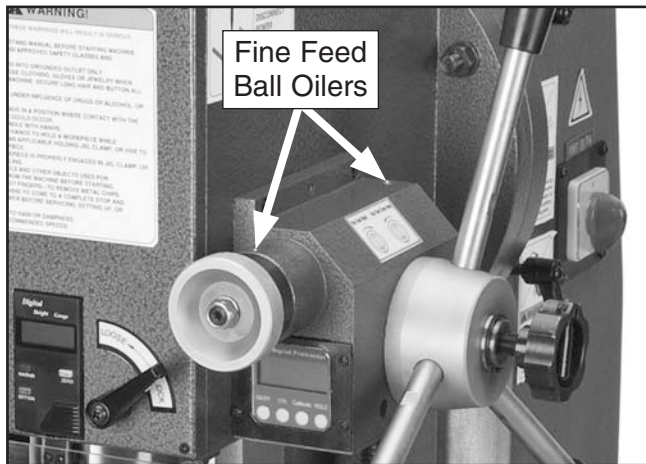


## Ball Oilers

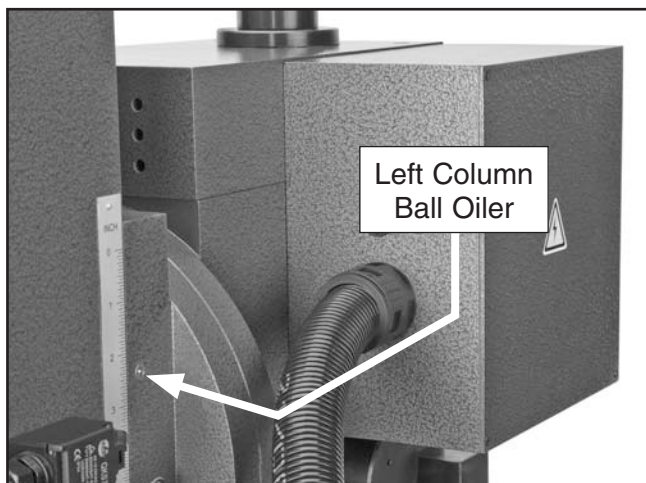
This mill has nine ball oilers shown in **Figures 35–39**. Make sure to use an oil gun fitted with a rubber tip that is wide enough to seal the ball oiler inlet. This seal allows the gun to build hydraulic pressure in order to flush out contaminants and deliver fresh oil to components at the end of long passages.

Do not use oil guns equipped with a sharp steel lance tip. These narrow tips often seal poorly and oil is not pumped deep into the system. Steel tips can also dislodge the sealing ball permanently exposing the system to contamination.

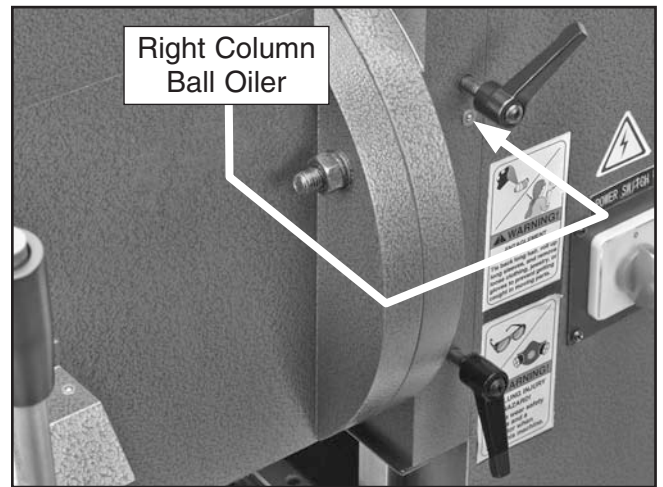
**Items Needed:** Qty  
 Rubber-Tipped Oil Gun Filled With Way Oil..... 1  
 Clean Rags..... 1



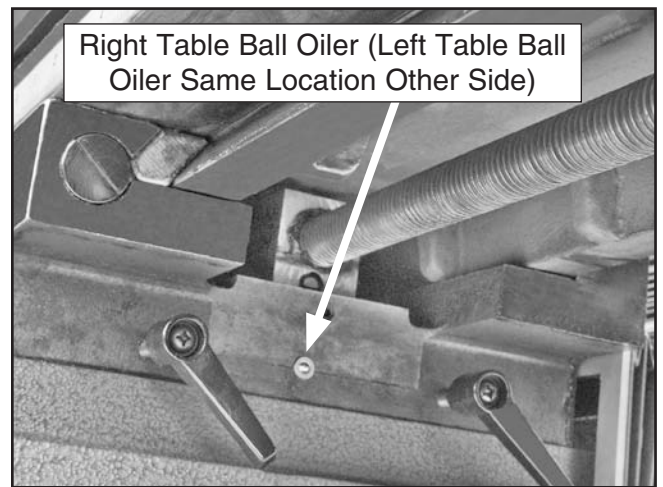
**Figure 35.** Headstock ball oiler locations.



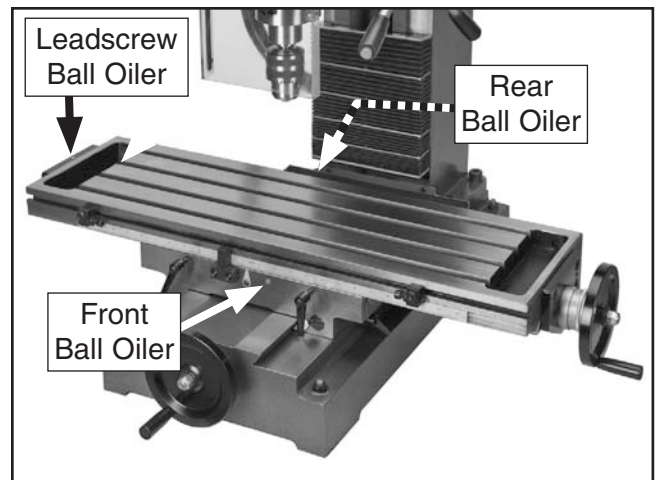
**Figure 36.** Left column ball oiler location.



**Figure 37.** Right column ball oiler location.



**Figure 38.** Table slide ball oiler locations.



**Figure 39.** Table and base ball oiler locations.



## Leadscrews

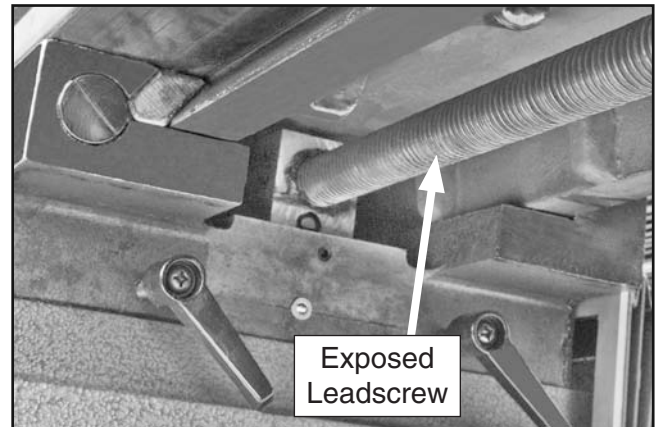
Clean and relubricate the leadscrews monthly. Repeat this task more frequently if the machine is under heavy use or operates in adverse conditions.

| Items Needed:                           | Qty   |
|---|-------|
| Tube of White Lithium Grease.....       | 1     |
| Paint Brush for Grease Application..... | 1     |
| Mineral Spirits.....                    | 1 Cup |

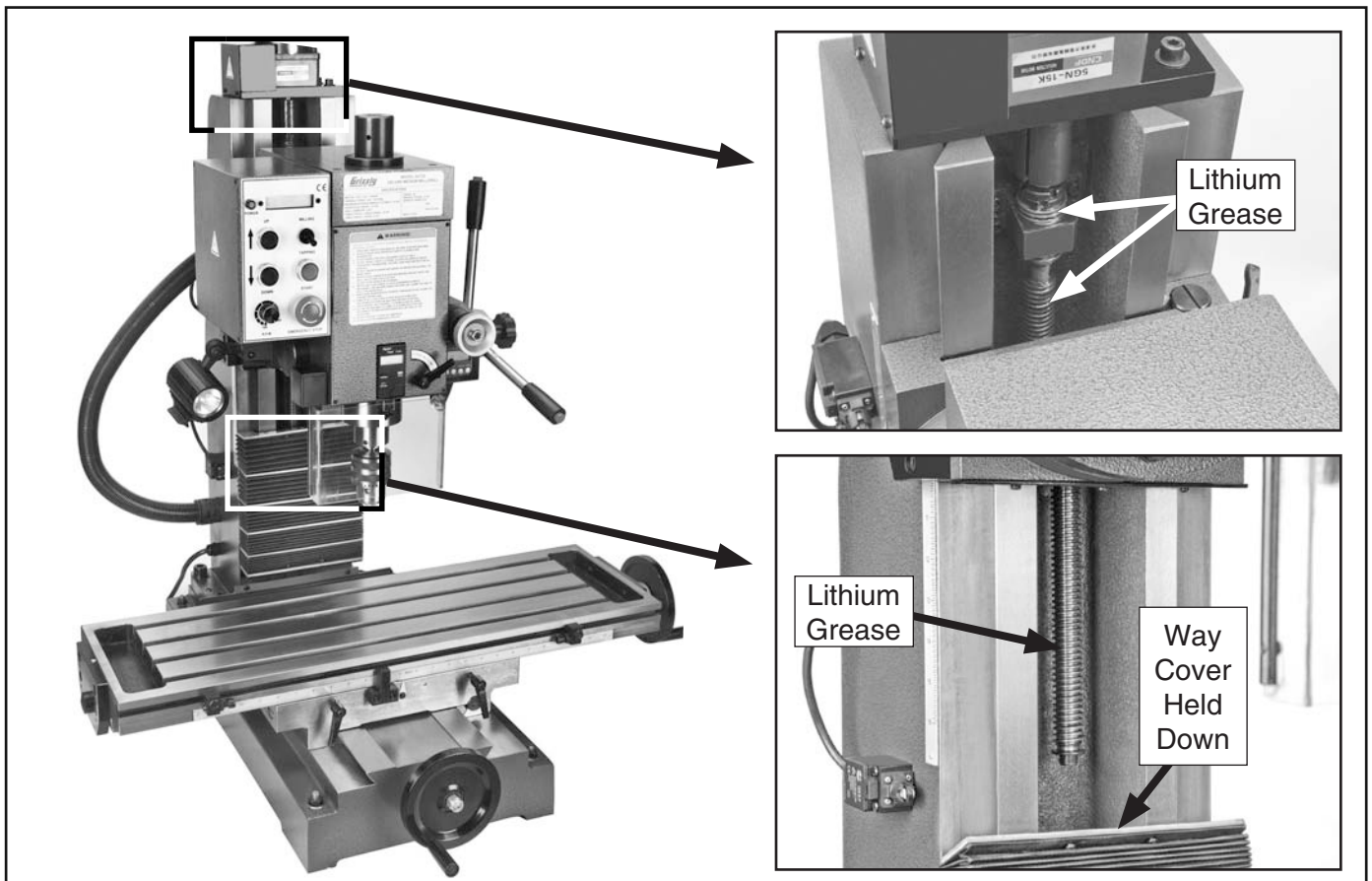
### To lubricate the leadscrews:

1. Move the headstock to the highest position.
2. DISCONNECT MILL FROM POWER!
3. Remove the way cover (see **Figure 41**) for lower column leadscrew access.
4. Using mineral spirits, clean the upper and lower portions of the column leadscrew.
5. Lightly coat the entire leadscrew with lithium grease.

6. Connect the mill to power, and run the headstock up and down to spread the grease.
7. Wipe-off excess grease with a clean rag.
8. Move the table to the far right and all the way forward to expose the leadscrew, as shown in **Figure 40**.
9. Clean and lubricate the table leadscrews in the same manner as the column leadscrew.



**Figure 40.** Table leadscrew.



**Figure 41.** Headstock leadscrew access and lubrication.

# Battery Replacement

When the batteries for the digital spindle scale need replacement, the display will be dim or not display at all.

When the batteries need replacement in the mini digital protractor, the battery icon shown in **Figure 42** will stay on the display until the batteries are replaced.

Only use the batteries listed or comparable replacements. Should the digital screen blink or remain blank after replacement, the battery chosen is incorrect.

Both of these digital measuring tools are equipped with volatile memory, meaning that when the battery is removed, or completely discharges, the last unit measured is lost from memory.

When putting the mill is into storage, remove the batteries to protect against damage from potential battery leakage.



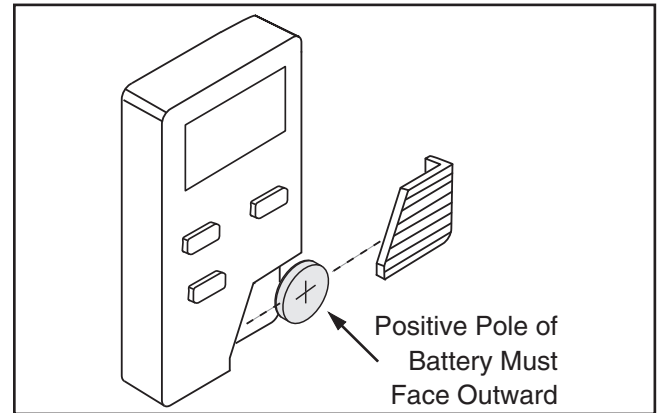
**Figure 42.** Battery replacement icon.

## Digital Spindle Height Gauge

**Items Needed:**  
Battery (Silver Cell SR44)..... 1

### To replace the battery:

1. Slide the battery cover to the right.
2. Replace the battery with the positive side facing out, as shown in **Figure 43**.



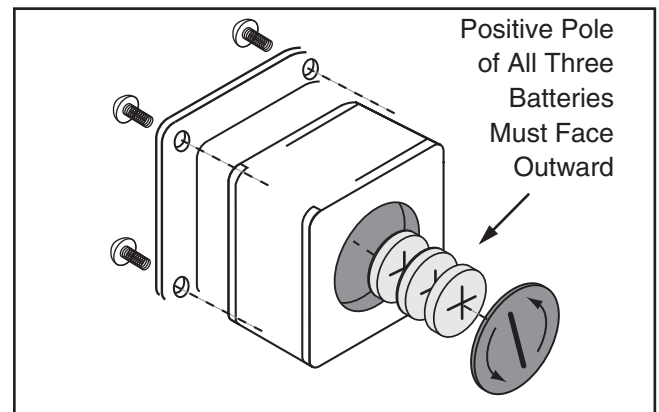
**Figure 43.** Digital height scale battery replacement.

## Mini Digital Protractor

**Items Needed:**  
Battery (Lithium CR2032 3V) ..... 3

### To replace the batteries:

1. Remove the four protractor retaining screws, the retainer, and the protractor.
2. Unthread the battery cover and replace the three batteries with the positive side facing out, as shown in **Figure 44**.



**Figure 44.** Digital protractor battery replacement.

3. Reassemble in reverse order.

# SECTION 7: SERVICE

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

## Troubleshooting



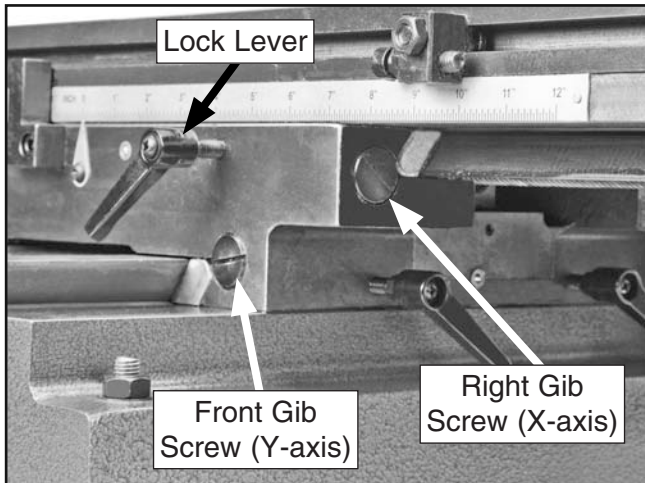
| Symptom   | Possible Cause  | Possible Solution   |
|---|---|---|
| Motor will not start.                             | <ol style="list-style-type: none"> <li>1. Emergency stop button is pressed.</li> <li>2. Chip guard switch at fault.</li> <li>3. Main power switch at fault.</li> <li>4. Blown electrical box fuse .</li> <li>5. Blown inverter fuse.</li> <li>6. Shorted capacitor.</li> <li>7. Shorted transformer.</li> <li>8. Open circuit in motor or loose connections.</li> </ol> | <ol style="list-style-type: none"> <li>1. Reset switch or replace bad switch.</li> <li>2. Fully close chip guard, or replace bad switch.</li> <li>3. Turn dial on, or replace bad switch.</li> <li>4. Repair for overload and install a new fast-blow fuse.</li> <li>5. Repair for overload and install a new fast-blow fuse.</li> <li>6. Replace both capacitors.</li> <li>7. Replace transformer.</li> <li>8. Inspect circuit boards, wiring connections, plugs, and repair/replace as required.</li> </ol> |
| Feed handle tapping button does not work.         | <ol style="list-style-type: none"> <li>1. Machine is not in "Tapping Mode."</li> <li>2. Tapping button slip ring switch is at fault.</li> <li>3. General electrical problem.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Move the mode switch to the tapping position.</li> <li>2. Replace tapping button slip ring switch.</li> <li>3. Inspect circuit boards, wiring connections, plugs, and repair/replace as required.</li> </ol>  |
| Poor surface finishes.                            | <ol style="list-style-type: none"> <li>1. Feed rate too fast.</li> <li>2. Dull cutter.</li> <li>3. Lock not tightened down.</li> <li>4. Gibs loose.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Slow feed rate.</li> <li>2. Always use newly sharpened cutters.</li> <li>3. Tighten column and table locks when possible to maintain rigidity.</li> <li>4. Adjust gib.</li> </ol>   |
| Vibration when running or cutting.                | <ol style="list-style-type: none"> <li>1. Feed rate too high.</li> <li>2. Loose table.</li> <li>3. Loose gibs.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Slow feed rate or adjust RPM.</li> <li>2. Tighten table locks.</li> <li>3. Adjust gib.</li> </ol>   |
| Headstock lift motor struggles to lift headstock. | <ol style="list-style-type: none"> <li>1. Headstock lock or gib is at fault.</li> <li>2. Headstock lead screw is binding.</li> <li>3. Motor or bearings at fault.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Loosen/replace lock lever and adjust gib.</li> <li>2. Clean and relubricate headstock leadscrew and gears.</li> <li>3. Replace motor or offending bearings.</li> </ol>  |





# Gib Adjustment

The headstock and table on this mill each use a long steel wedge called a gib that is positioned between the component and its dovetailed-ways. At the end of each gib is a screw, as shown in **Figure 45**.



**Figure 45.** Table gib screws and lock levers.

The screws at each end of the gib oppose one another to move and hold the gib in a forward or aft position. Depending which direction the gib is moved and held, the space between the sliding ways is increased or decreased to control the rigidity of the headstock and table.

The leadscrew and leadscrew nuts on this machine are non-adjustable and are only replaced as a matched set. Clean and relubricate the ways, slides, and leadscrews before attempting to adjust the gibs.

## **NOTICE**

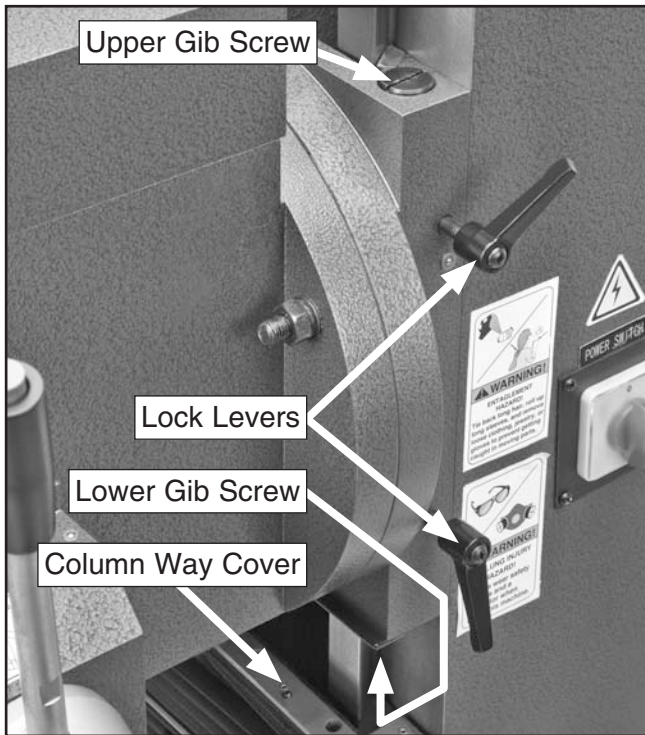
When adjusting gibs, keep in mind that the goal of gib adjustment is to remove unnecessary sloppiness from the slide without causing binding and excessive leadscrew nut wear.

### Table Gib Adjustment

1. DISCONNECT MILL FROM POWER!
2. Loosen the table lock levers (see **Figure 45**) so the table is free to slide.
3. For the X-axis gib, adjust as follows:
  - To increase slide tension, loosen the left gib screw  $\frac{1}{8}$ -turn, and tighten the right gib screw  $\frac{1}{8}$ -turn.
  - To decrease slide tension, loosen the right gib screw  $\frac{1}{8}$ -turn, and tighten the left gib screw  $\frac{1}{8}$ -turn.
4. For the Y-axis gib, remove the rear way cover and adjust as follows:
  - To increase slide tension, loosen the rear gib screw  $\frac{1}{8}$ -turn, and tighten the front gib screw  $\frac{1}{8}$ -turn.
  - To decrease slide tension, loosen the front gib screw  $\frac{1}{8}$ -turn, and tighten the rear gib screw  $\frac{1}{8}$ -turn.
5. Repeat adjustments as necessary until the gib screw drag is acceptable, and re-install the way cover.
6. When properly adjusted, there should be slight resistance felt in the handwheels when the table is moved.

## Headstock Gib Adjustment

1. DISCONNECT MILL FROM POWER!
2. Loosen the headstock lock levers shown in **Figure 46**.



**Figure 46.** Headstock gib adjustment.

3. Remove the column way cover (see **Figure 46**) for lower column leadscrew access.
4. For the Z-axis or headstock gib, adjust as follows:
  - To increase the headstock slide tension, loosen the lower gib screw  $\frac{1}{8}$ -turn, and tighten the upper gib screw  $\frac{1}{8}$ -turn.
  - To decrease the headstock slide tension, loosen the upper gib screw  $\frac{1}{8}$ -turn, and tighten the lower gib screw  $\frac{1}{8}$ -turn.

When properly adjusted, there should be a slight pre-loaded fit between the column and the headstock.

5. Reinstall the column way cover.

## Machine Storage

If the machine is not properly prepared for storage, it may develop rust or corrosion. Use the recommendations in this section to ensure that the mill remains in good condition for later use.

### To prepare your machine for storage:

1. Remove any residual cutting fluid from the table and machine body.
2. DISCONNECT MILL FROM POWER!
3. Remove any tooling from the spindle.
4. Thoroughly clean all unpainted, bare metal surfaces, then apply a liberal coat of way oil.
5. Lubricate the machine as outlined in the lubrication section.
6. Remove batteries from the digital depth scale and the mini digital protractor.
7. Place a few moisture-absorbing desiccant bags inside of the electrical box.
8. Cover and place the machine in a dry area that is out of direct sunlight and away from hazardous fumes, paint, solvents, or gas. Fumes and sunlight can bleach or discolor paint and make plastic guards cloudy.
9. Twice a year, depending on the ambient humidity levels in the storage environment, wipe down the machine with a rust prevention compound.

# 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. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

## WARNING

### Wiring Safety Instructions

**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](http://www.grizzly.com).

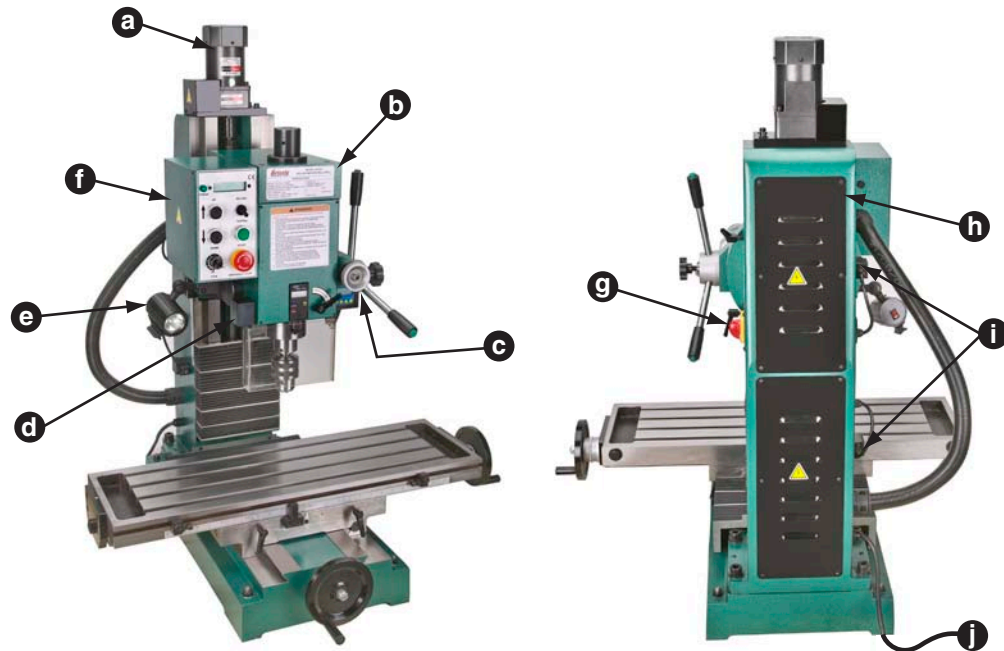
#### COLOR KEY

|   |  |  |  |
|---|--|--|--|
| BLACK  | BLUE    | YELLOW        | LIGHT BLUE  |
| WHITE  | BROWN   | YELLOW GREEN  | BLUE WHITE  |
| GREEN  | GRAY    | PURPLE        | TURQUOISE   |
| RED    | ORANGE  | PINK          |  |



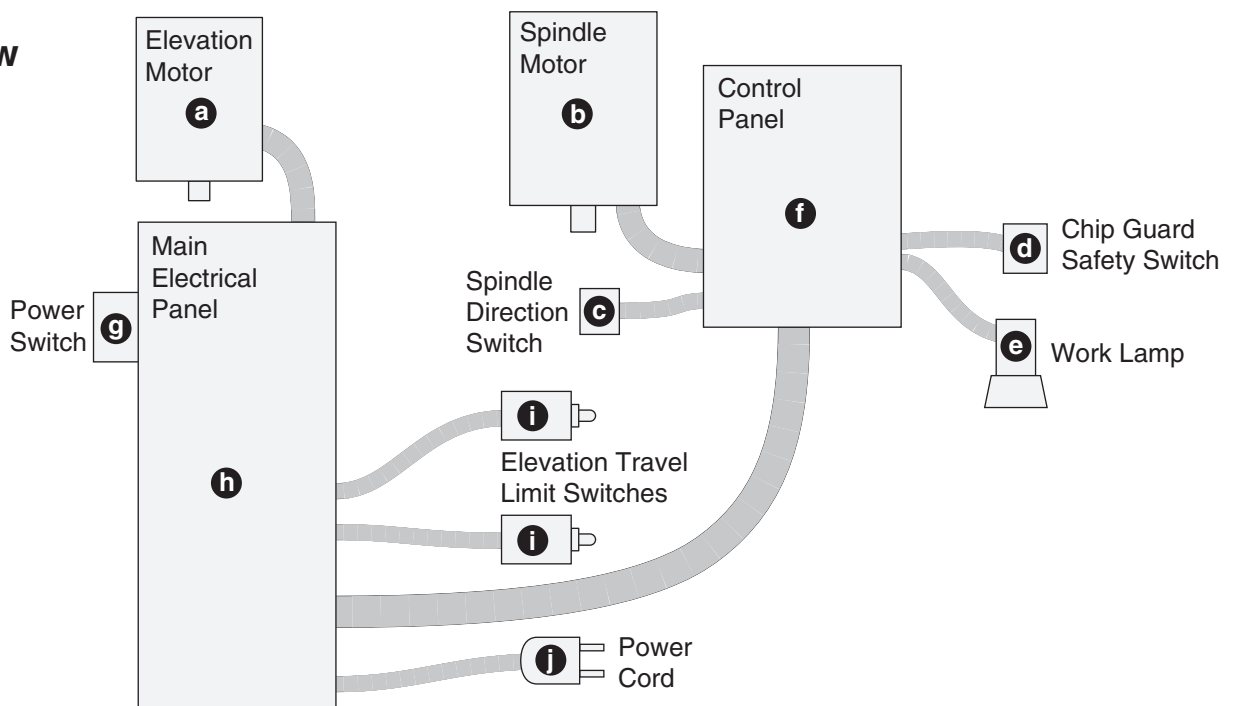
# Wiring Overview

## Component Locations

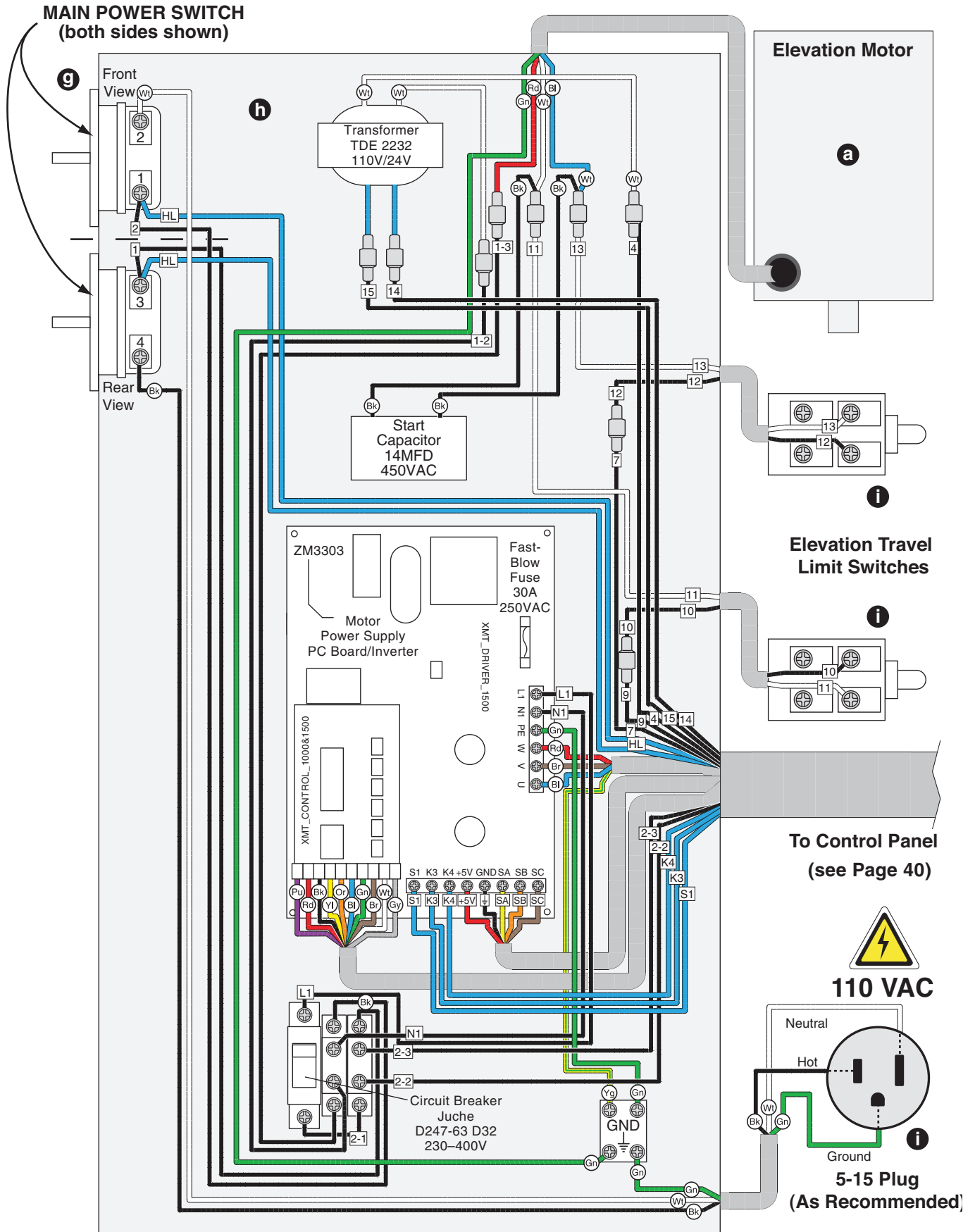


- a** Elevation Motor (See **Page 39** and **Figure 54**)
- b** Spindle Motor (See **Page 40** and **Figure 54**)
- c** Spindle Direction Switch (See **Page 40** and **Figure 52**)
- d** Chip Guard Safety Switch (See **Page 40** and **Figure 51**)
- e** Work Lamp (See **Page 40** and **Figure 49**)
- f** Control Panel (See **Page 40** and **Figure 50**)
- g** Main Power Switch (See **Page 39** and **Figure 48**)
- h** Main Electrical Panel (See **Page 39** and **Figure 47**)
- i** Elevation Travel Limit Switches (See **Page 39** and **Figure 49**)
- j** Power Cord (See **Page 39** and **Figure 49**)

## System Overview

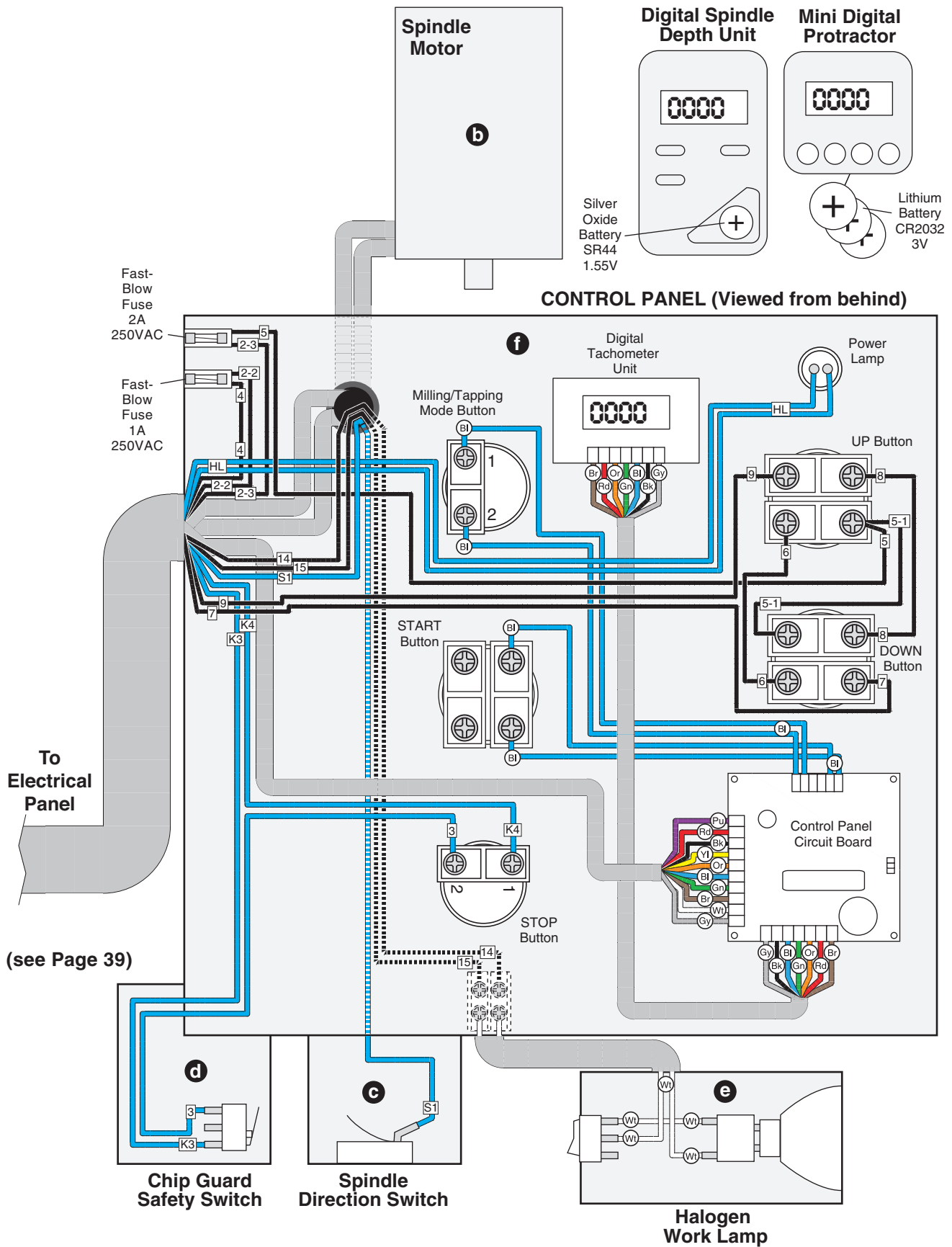


# Wiring Diagram





# Wiring Diagram





# Electrical Components

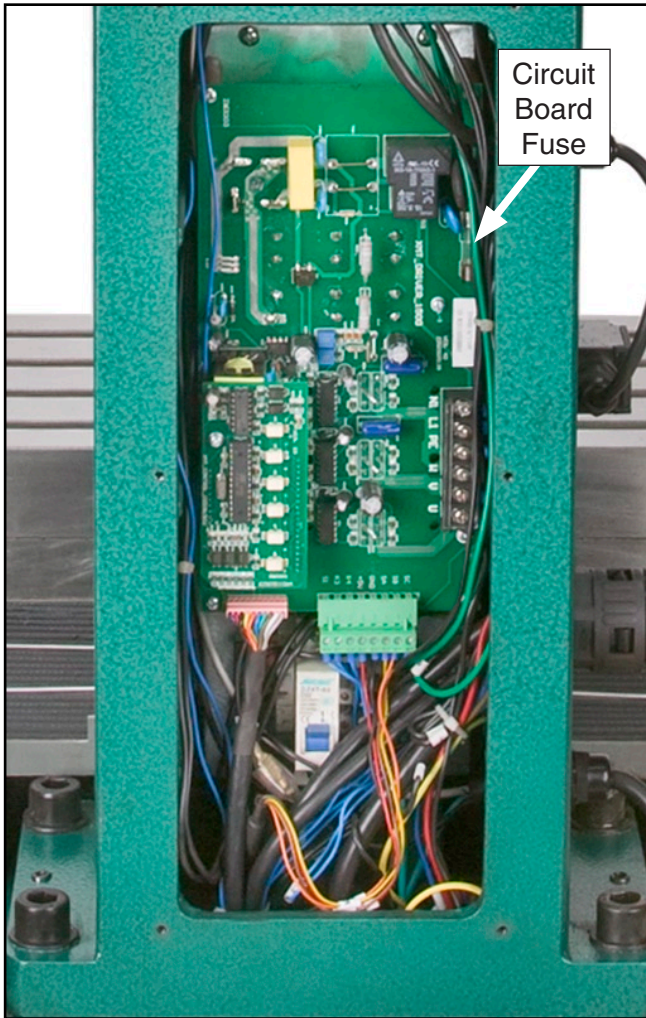


Figure 47. Motor power supply circuit board.

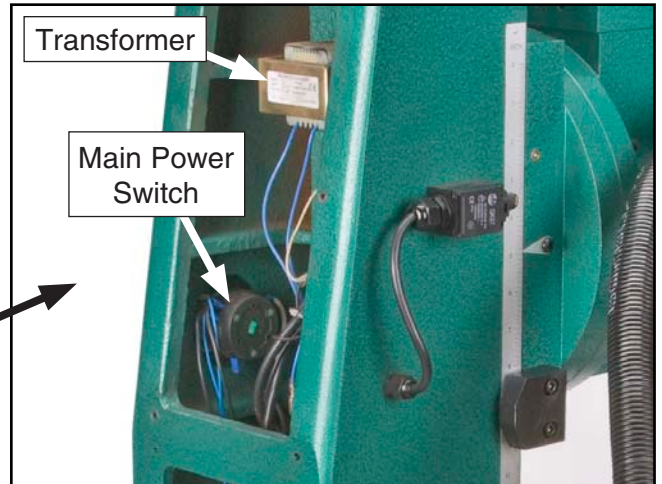


Figure 48. Main power switch and transformer.

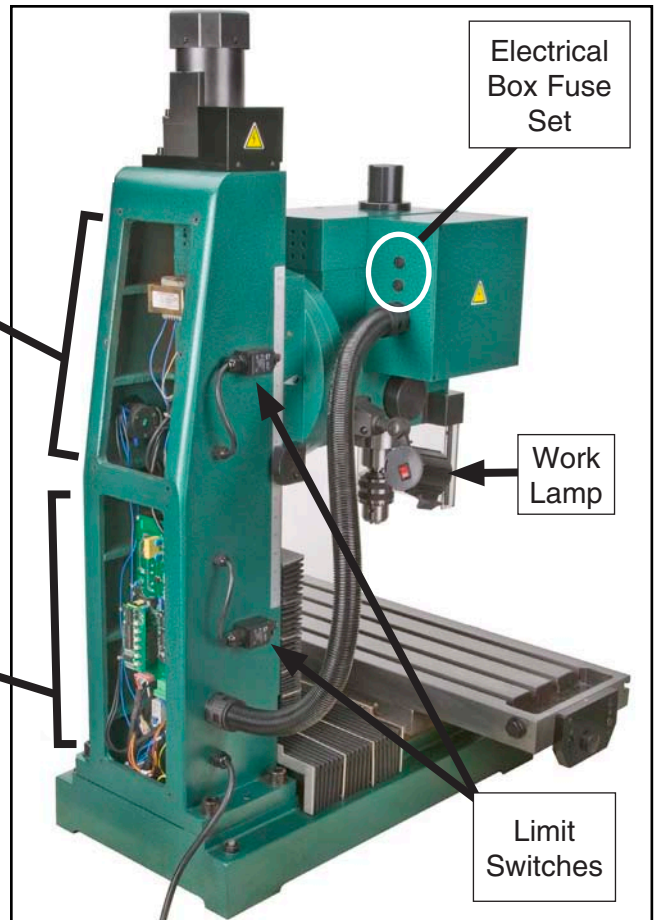


Figure 49. Rear view electrical components.

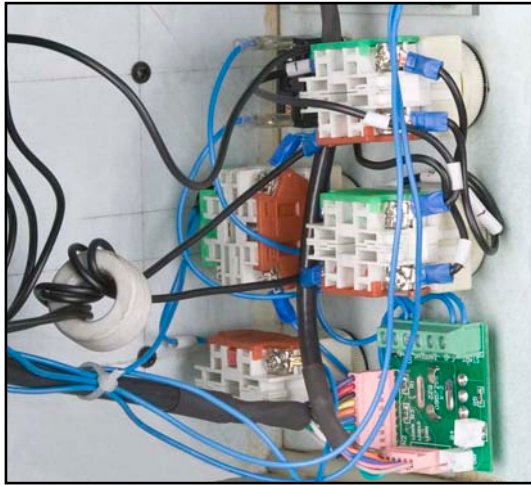


Figure 50. Control panel electrical.

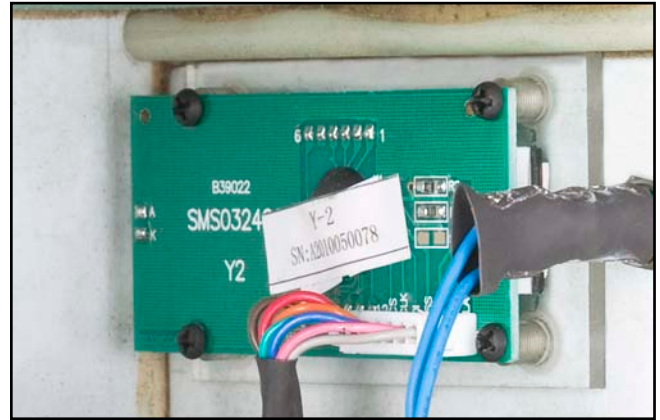


Figure 53. Tachometer electrical.



Figure 51. Chip guard safety switch.



Figure 52. Tapping button slip ring contact.

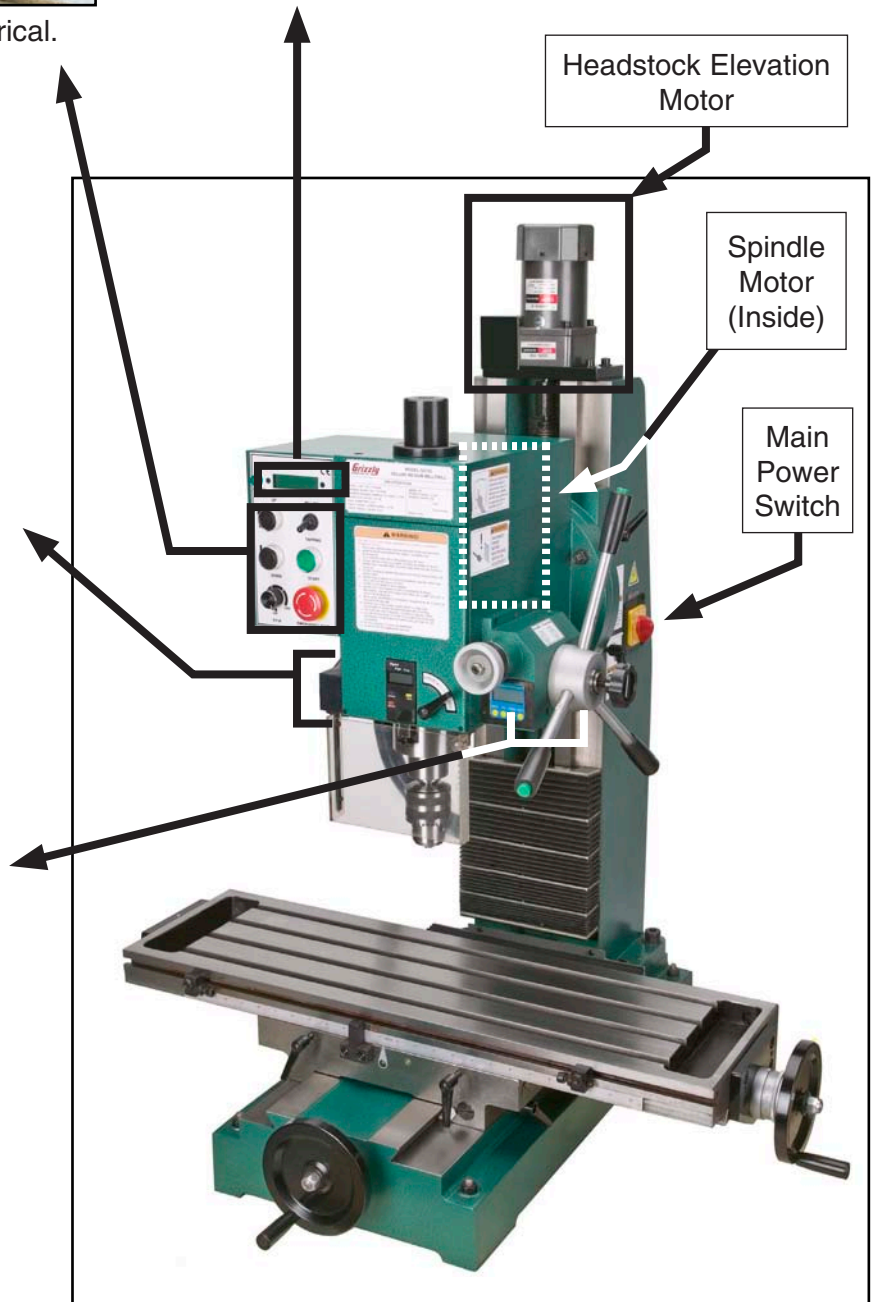


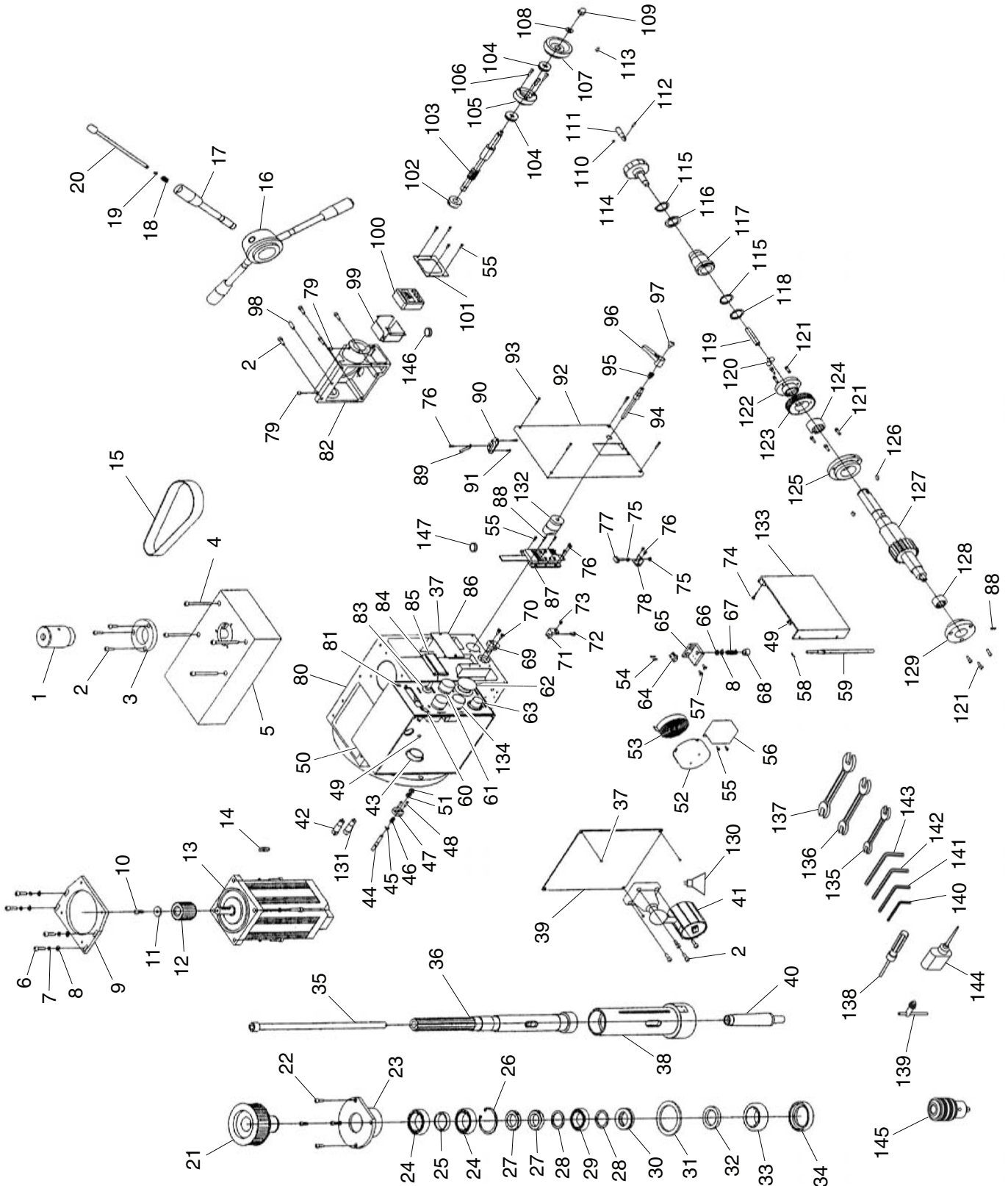
Figure 54. Front view electrical components.





# SECTION 9: PARTS

## Head Breakdown



# Head Parts List

| REF | PART #   | DESCRIPTION                     |
|-----|----------|---------------------------------|
| 1   | P0720001 | DRAWBAR COVER                   |
| 2   | PCAP24M  | CAP SCREW M5-.8 X 16            |
| 3   | P0720003 | FLANGE                          |
| 4   | PCAP49M  | CAP SCREW M6-1 X 60             |
| 5   | P0720005 | TOP HEAD COVER                  |
| 6   | PCAP02M  | CAP SCREW M6-1 X 20             |
| 7   | PLW03M   | LOCK WASHER 6MM                 |
| 8   | PW03M    | FLAT WASHER 6MM                 |
| 9   | P0720009 | SPINDLE MOTOR MOUNTING PLATE    |
| 10  | PCAP27M  | CAP SCREW M6-1 X 14             |
| 11  | P0720011 | MOTOR FLAT WASHER 6MM           |
| 12  | P0720012 | MOTOR PULLEY                    |
| 13  | P0720013 | SPINDLE MOTOR 2HP 220VDC        |
| 14  | PK143M   | KEY 6 X 6 X 25                  |
| 15  | P0720015 | RIBBED BELT GATES 535-5M-25     |
| 16  | P0720016 | COARSE DOWNFEED LEVER HUB       |
| 17  | P0720017 | COARSE DOWNFEED LEVER           |
| 18  | P0720018 | COMPRESSION SPRING 0.8 X 6 X 25 |
| 19  | PR45M    | INT RETAINING RING 10MM         |
| 20  | P0720020 | SPINDLE ROTATION BUTTON         |
| 21  | P0720021 | SPINDLE PULLEY                  |
| 22  | PS57M    | PHLP HD SCR M5-.8 X 14          |
| 23  | P0720023 | BEARING FLANGE                  |
| 24  | P6908ZZ  | BALL BEARING 6908ZZ             |
| 25  | P0720025 | BEARING SPACER                  |
| 26  | PR38M    | INT RETAINING RING 62MM         |
| 27  | P0720027 | SPANNER NUT                     |
| 28  | P0720028 | BEARING SPACER                  |
| 29  | P6907ZZ  | BALL BEARING 6907ZZ             |
| 30  | P8107    | THRUST BEARING 8107             |
| 31  | P0720031 | BEARING SPACER                  |
| 32  | P0720032 | BEARING SEAL                    |
| 33  | P32009   | TAPERED ROLLER BEARING 32009    |
| 34  | P0720034 | BOTTOM QUILL SEAL               |
| 35  | P0720035 | DRAWBAR 7/16-20 X 13-1/2        |
| 36  | P0720036 | SPINDLE R8                      |
| 37  | P0720037 | TAP SCREW 2.9 X 6.5             |
| 38  | P0720038 | QUILL                           |
| 39  | P0720039 | CONTROL PANEL SIDE COVER        |
| 40  | P0720040 | CHUCK ARBOR R8-B18              |
| 41  | P0720041 | WORK LIGHT ASSEMBLY             |
| 42  | P0720042 | FUSE 1A FAST-BLOW 5 X 20MM      |
| 43  | P0720043 | STRAIN RELIEF                   |
| 44  | P0720044 | TAPER PIN                       |
| 45  | PEC13M   | E-CLIP 5MM                      |

| REF | PART #    | DESCRIPTION                       |
|-----|-----------|-----------------------------------|
| 46  | P0720046  | COMPRESSION SPRING 0.8 X 10 X 14  |
| 47  | P0720047  | FLANGE PLASTIC                    |
| 48  | PS59M     | PHLP HD SCR M3-.5 X 14            |
| 49  | PS74M     | PHLP HD SCR M4-.7 X 14            |
| 50  | P0720050  | CONTROL PANEL BOX                 |
| 51  | PN01M     | HEX NUT M6-1                      |
| 52  | P0720052  | SPRING COVER                      |
| 53  | P0720053  | TORSION RETURN SPRING             |
| 54  | PS117M    | PHLP HD SCR M2-.4 X 10            |
| 55  | PS79M     | PHLP HD SCR M3-.5 X 8             |
| 56  | P0720056  | GUARD AXLE BRACKET                |
| 57  | PS38M     | PHLP HD SCR M4-.7 X 10            |
| 58  | PS111M    | PHLP HD SCR M3-.5 X 4             |
| 59  | P0720059  | GUARD AXLE                        |
| 60  | P0720060  | POWER LAMP ZD10                   |
| 61  | P0720061  | START BUTTON LAY7                 |
| 62  | P0720062  | EMERGENCY STOP BUTTON LAY7        |
| 63  | P0720063  | SPINDLE SPEED DIAL                |
| 64  | P0720064  | GUARD SAFETY SWITCH               |
| 65  | P0720065  | SAFETY SWITCH BRACKET             |
| 66  | PN01M     | HEX NUT M6-1                      |
| 67  | P0720067  | COMPRESSION SPRING 1.4 X 8.2 X 24 |
| 68  | P0720068  | BUSHING                           |
| 69  | P0720069  | FLANGE                            |
| 70  | PS02M     | PHLP HD SCR M4-.7 X 12            |
| 71  | P0720071  | STOP DOG                          |
| 72  | PS38M     | PHLP HD SCR M4-.7 X 10            |
| 73  | P0720073  | MAGNET                            |
| 74  | PS07M     | PHLP HD SCR M4-.7 X 8             |
| 75  | PN04M     | HEX NUT M4-.7                     |
| 76  | PS37M     | PHLP HD SCR M6-1 X 6              |
| 77  | P0720077  | SCALE SCREW                       |
| 78  | P0720078  | DIGITAL SCALE BRACKET             |
| 79  | PLUBE001M | TAP-IN BALL OILER 6MM             |
| 80  | P0720080  | HEAD CASTING                      |
| 81  | P0720081  | CONTROL PANEL PLATE               |
| 82  | P0720082  | WORM GEAR COVER                   |
| 83  | P0720083  | MODE TOGGLE SWITCH                |
| 84  | P0720037  | TAP SCREW 2.9 X 6.5               |
| 85  | P0720085  | LCD SCREEN Y-2                    |
| 86  | P0720086  | SPINDLE SPEED READOUT             |
| 87  | P0720087  | DIGITAL SPINDLE HEIGHT SCALE      |
| 88  | P0720088  | PIN 3 X 12 PLASTIC                |
| 89  | P0720089  | BUS BAR                           |
| 90  | P0720090  | CONTACT RACK                      |



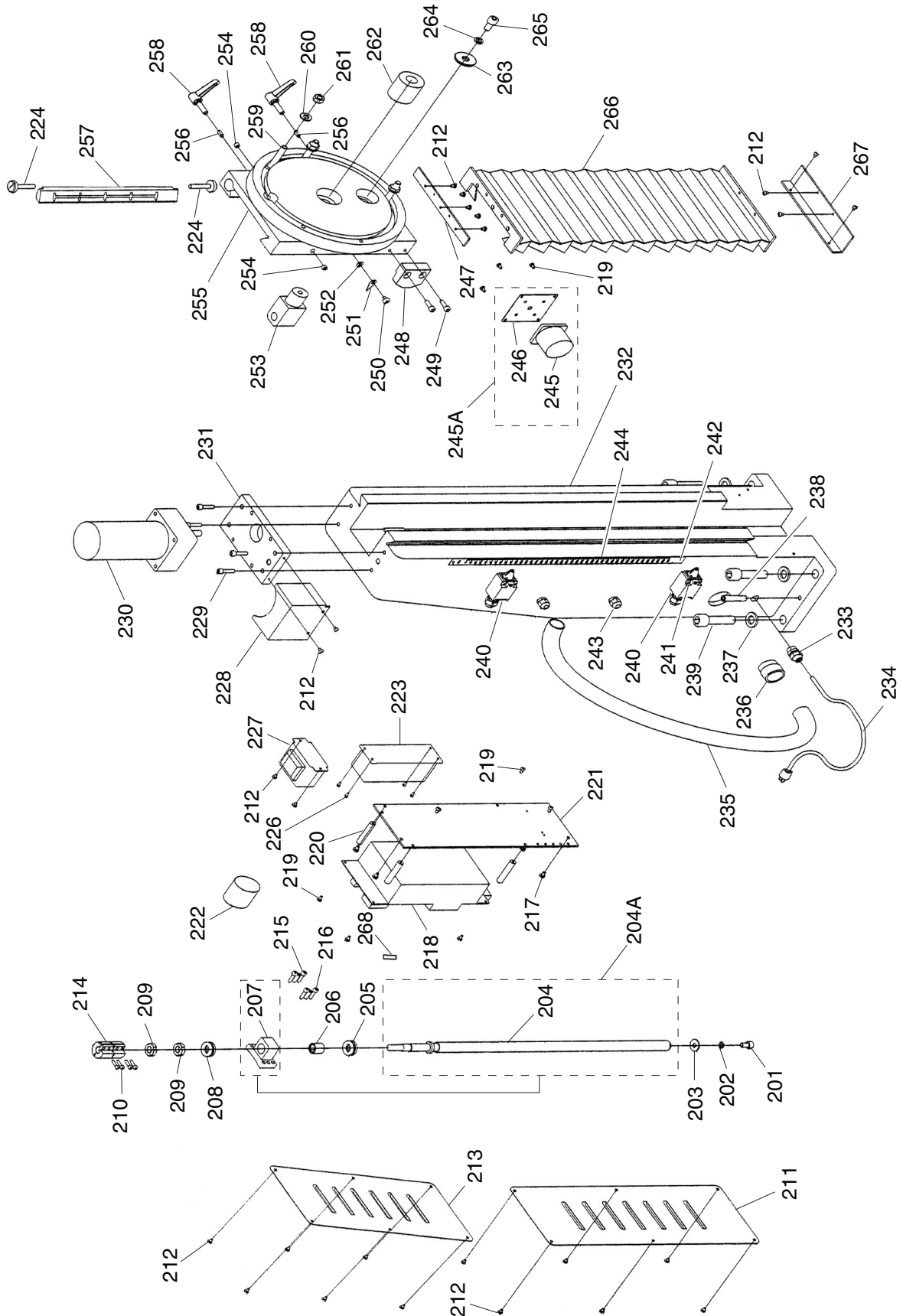
# Head Parts List

| REF PART # | DESCRIPTION                               |
|------------|---|
| 91         | PS79M PHLP HD SCR M3-.5 X 8               |
| 92         | P0720092 HEAD FRONT COVER                 |
| 93         | PS13M PHLP HD SCR M3-.5 X 20              |
| 94         | P0720094 LOCK SCREW                       |
| 95         | P0720095 COMPRESSION SPRING 0.8 X 10 X 14 |
| 96         | P0720096 LOCK HANDLE                      |
| 97         | PS68M PHLP HD SCR M6-1 X 10               |
| 98         | P0720098 INT THREADED TAPER PIN 6 X 20    |
| 99         | P0720099 DIGITAL PROTRACTOR BOX           |
| 100        | P0720100 DIGITAL PROTRACTOR               |
| 101        | P0720101 DIGITAL PROTRACTOR FRAME         |
| 102        | P0720102 LOCK COLLAR                      |
| 103        | P0720103 WORM SHAFT                       |
| 104        | P8101 THRUST BEARING 8101                 |
| 105        | P0720105 SHAFT FLANGE                     |
| 106        | PS56M PHLP HD SCR M4-.7 X 16              |
| 107        | P0720107 FINE DOWNFEED HANDWHEEL          |
| 108        | PW01M FLAT WASHER 8MM                     |
| 109        | PN03M HEX NUT M8-1.25                     |
| 110        | P0720110 MAGNET                           |
| 111        | P0720111 HANDWHEEL HANDLE                 |
| 112        | PRP37M ROLL PIN 3 X 14                    |
| 113        | P0720113 FLAP KEY 4 X 10                  |
| 114        | P0720114 COARSE DOWNFEED HANDWHEEL        |
| 115        | PR11M EXT RETAINING RING 25MM             |
| 116        | P0720116 GEAR SHAFT WASHER                |
| 117        | P0720117 DIGITAL PROTRACTOR SENSOR        |
| 118        | P0720118 SPACER                           |
| 119        | P0720119 PIN 10 X 55                      |

| REF PART # | DESCRIPTION                                |
|------------|--|
| 120        | PSTB005M STEEL BALL 10MM                   |
| 121        | PS74M PHLP HD SCR M4-.7 X 14               |
| 122        | P0720122 GEAR FLANGE                       |
| 123        | P0720123 WORM GEAR                         |
| 124        | P0720124 NEEDLE ROLLER BEARING HK283520    |
| 125        | P0720125 SHAFT FLANGE                      |
| 126        | PK06M KEY 5 X 5 X 10                       |
| 127        | P0720127 WORM SHAFT                        |
| 128        | P0720128 NEEDLE ROLLER BEARING HK222816    |
| 129        | P0720129 END FLANGE                        |
| 130        | P0720130 HALOGEN BULB 24V 60W W/REFLECTOR  |
| 131        | P0720131 FUSE 2A FAST-BLOW 5 X 20MM        |
| 132        | P0720132 LOCK PLUNGER                      |
| 133        | P0720133 CHIP SHIELD POLYCARBONATE         |
| 134        | P0720134 ELEVATION BUTTON                  |
| 135        | PWR810 COMBO WRENCH 8/10MM                 |
| 136        | PWR1417 COMBO WRENCH 14/17MM               |
| 137        | PWR1922 COMBO WRENCH 19/22                 |
| 138        | P0720138 SPINDLE LOCK PIN                  |
| 139        | P0720139 CHUCK KEY                         |
| 140        | PAW04M HEX WRENCH 4MM                      |
| 141        | PAW05M HEX WRENCH 5MM                      |
| 142        | PAW06M HEX WRENCH 6MM                      |
| 143        | PAW12M HEX WRENCH 12MM                     |
| 144        | P0720144 BOTTLE FOR OIL                    |
| 145        | P0720145 DRILL CHUCK B18                   |
| 146        | P0720146 PROTRACTOR BATTERY LITHIUM CR2032 |
| 147        | P0720147 SCALE BATTERY ALKALINE SR44       |



# Column Breakdown





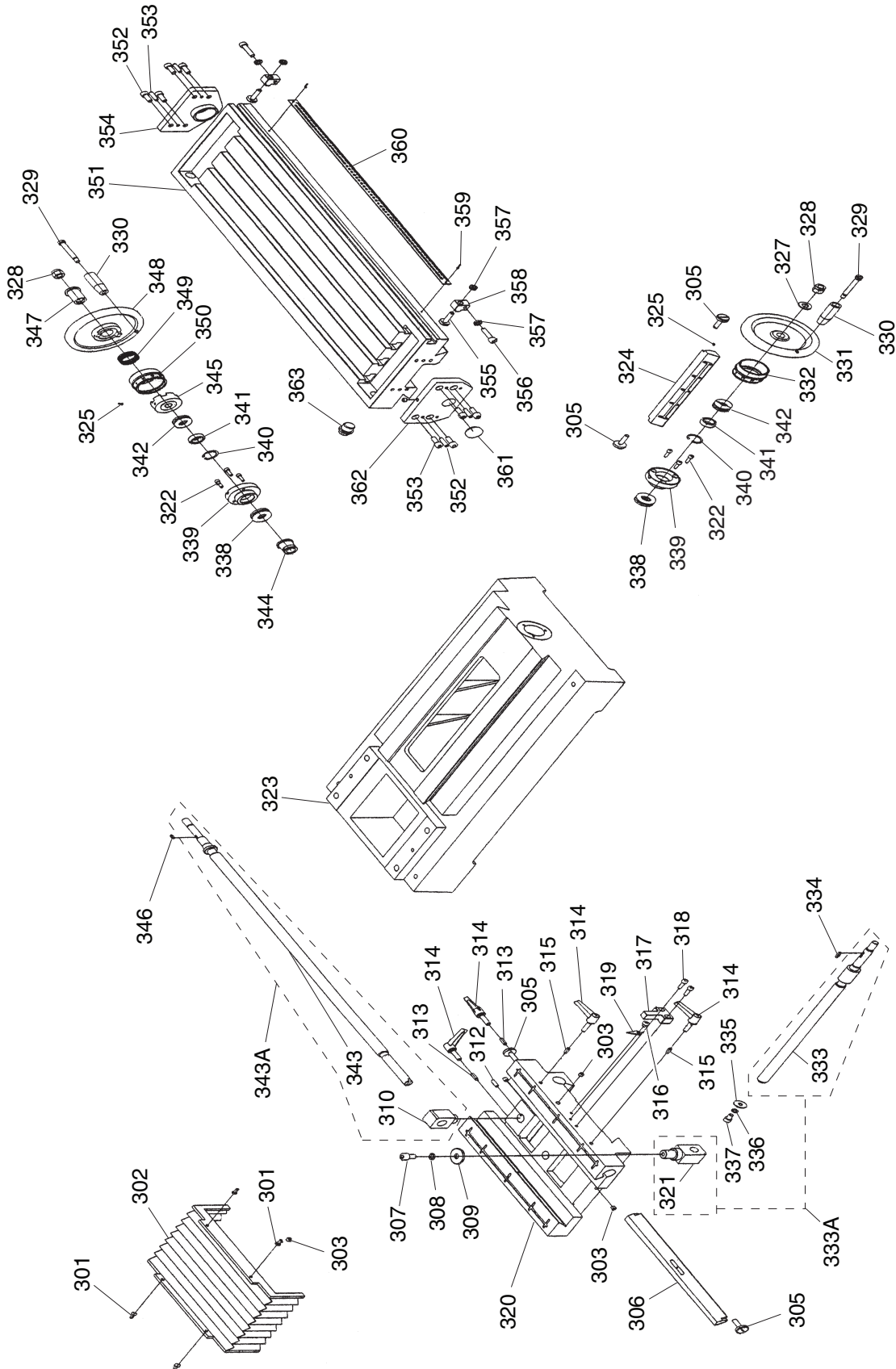
# Column Parts List

| REF  | PART #    | DESCRIPTION                     |
|------|-----------|---------------------------------|
| 201  | PS76M     | PHLP HD SCR M8-1.25 X 12        |
| 202  | PLW04M    | LOCK WASHER 8MM                 |
| 203  | PW01M     | FLAT WASHER 8MM                 |
| 204A | P0720204A | LEADSCREW W/NUT ASSEMBLY        |
| 204  | P0720204A | ELEVATION LEADSCREW             |
| 205  | P8102     | THRUST BEARING 8102             |
| 206  | P0720206  | BUSHING                         |
| 207  | P0720204A | LEADSCREW NUT                   |
| 208  | P8102     | THRUST BEARING 8102             |
| 209  | P0720209  | SPANNER NUT                     |
| 210  | PS56M     | PHLP HD SCR M4-.7 X 16          |
| 211  | P0720211  | BOTTOM COLUMN COVER             |
| 212  | PS17M     | PHLP HD SCR M4-.7 X 6           |
| 213  | P0720213  | TOP COLUMN COVER                |
| 214  | P0720214  | LEADSCREW COUPLER               |
| 215  | PS06M     | PHLP HD SCR M5-.8 X 20          |
| 216  | P0720098  | INT THREADED TAPER PIN 6 X 20   |
| 217  | PS05M     | PHLP HD SCR M5-.8 X 8           |
| 218  | P0720218  | CONTROL PANEL CIRCUIT BOARD     |
| 219  | PS07M     | PHLP HD SCR M4-.7 X 8           |
| 220  | P0720220  | CIRCUIT BOARD STAND-OFF SLEEVE  |
| 221  | P0720221  | MOTOR/INVERTER CIRCUIT BOARD    |
| 222  | P0720222  | S CAPACITOR 14M 450V            |
| 223  | P0720223  | CIRCUIT BREAKER                 |
| 224  | P0720224  | GIB SCREW                       |
| 226  | PS79M     | PHLP HD SCR M3-.5 X 8           |
| 227  | P0720227  | TRANSFORMER TDE 2232 110V/240V  |
| 228  | P0720228  | ELEVATION MOTOR JUNCTION BOX    |
| 229  | PS47M     | PHLP HD SCR M6-1 X 25           |
| 230  | P0720230  | ELEVATION MOTOR 1/12HP 110V 1PH |
| 231  | P0720231  | ELEVATION MOTOR MOUNTING PLATE  |
| 232  | P0720232  | COLUMN CASTING                  |
| 233  | P0720233  | STRAIN RELIEF M16 LT            |
| 234  | P0720234  | POWER CORD 14G 3C 8FT 5-15      |
| 235  | P0720235  | CORD CONDUIT PLASTIC LT         |

| REF  | PART #    | DESCRIPTION                   |
|------|-----------|-------------------------------|
| 236  | P0720236  | STRAIN RELIEF LT              |
| 237  | PW08M     | FLAT WASHER 16MM              |
| 238  | P0720238  | TAPER PIN 10 X 45             |
| 239  | PCAP192M  | CAP SCREW M16-2 X 55          |
| 240  | P0720240  | ELEVATION TRAVEL LIMIT SWITCH |
| 241  | PS51M     | PHLP HD SCR M4-.7 X 30        |
| 242  | PRIV003M  | STEEL FLUTED RIVET 2 X 4MM    |
| 243  | P0720243  | STRAIN RELIEF M12             |
| 244  | P0720244  | ELEVATION SCALE               |
| 245A | P0720245A | MAIN POWER SWITCH ASSEMBLY    |
| 245  | P0720245  | MAIN POWER SWITCH             |
| 246  | P0720246  | SWITCH PLATE                  |
| 247  | P0720247  | TOP WAY COVER PLATE           |
| 248  | P0720248  | STOP BLOCK                    |
| 249  | PCAP02M   | CAP SCREW M6-1 X 20           |
| 250  | PS03M     | PHLP HD SCR M6-1 X 8          |
| 251  | P0720251  | POINTER                       |
| 252  | PW03M     | FLAT WASHER 6MM               |
| 253  | P0720253  | TILT NUT                      |
| 254  | PLUBE002M | TAP-IN BALL OILER 8MM         |
| 255  | P0720255  | HEAD MOUNTING PLATE           |
| 256  | P0720256  | LOCK PLUNGER                  |
| 257  | P0720257  | COLUMN GIB                    |
| 258  | P0720258  | LOCK HANDLE ASSEMBLY          |
| 259  | P0720259  | T-BOLT M10-1.5 X 50           |
| 260  | PW04M     | FLAT WASHER 10MM              |
| 261  | PN02M     | HEX NUT M10-1.5               |
| 262  | P0720262  | CLAMPING SLEEVE               |
| 263  | P0720263  | TILT FLAT WASHER 10MM         |
| 264  | PLW06M    | LOCK WASHER 10MM              |
| 265  | PB56M     | CAP SCREW M10-1.5 X 20        |
| 266  | P0720266  | COLUMN WAY COVER              |
| 267  | P0720267  | BOTTOM WAY COVER PLATE        |
| 268  | P0720268  | FUSE 30A FAST-BLOW 1/4" X 1"  |



# Table Breakdown



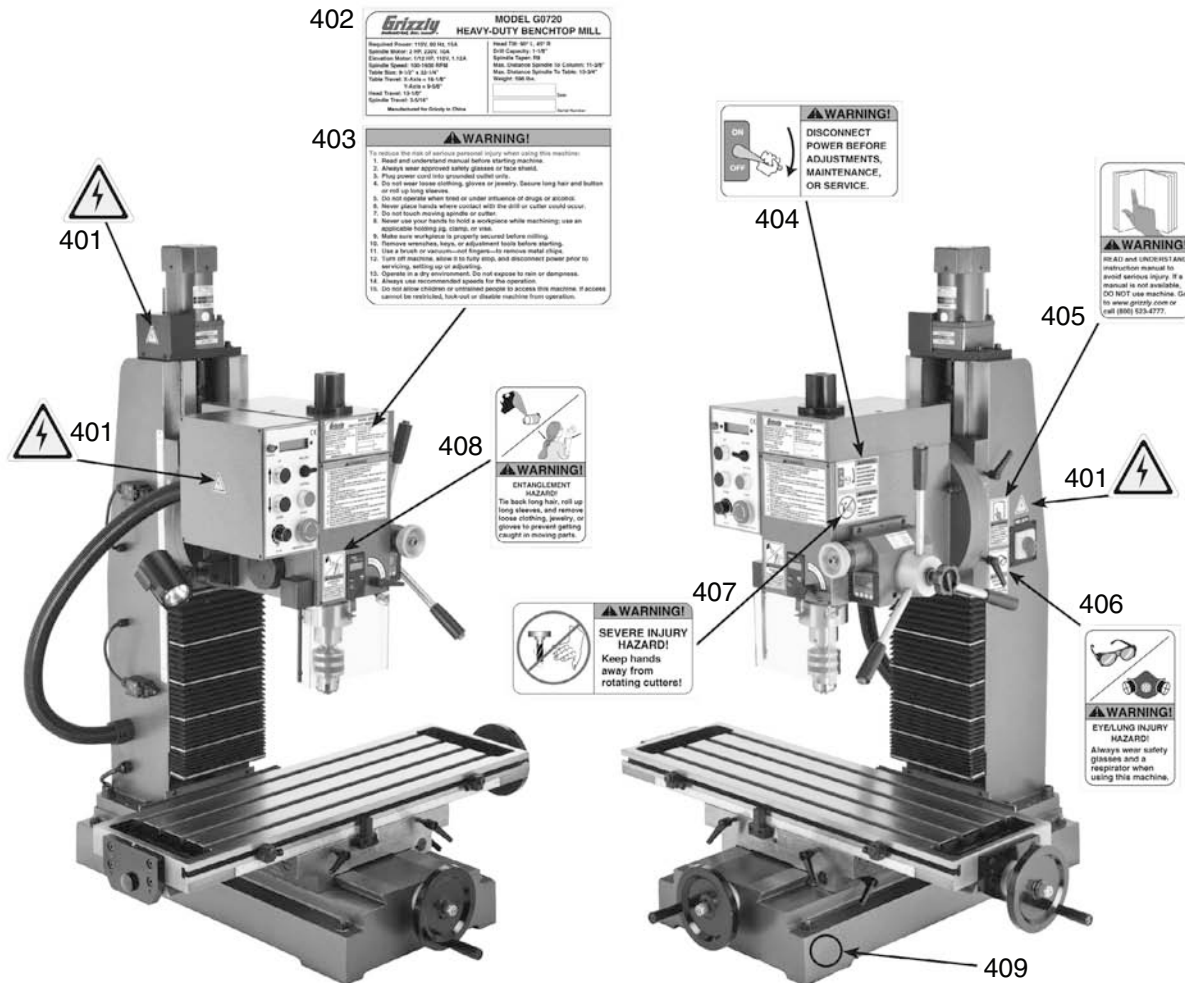
# Table Parts List

| REF  | PART #    | DESCRIPTION                |
|------|-----------|----------------------------|
| 301  | PS08M     | PHLP HD SCR M5-.8 X 12     |
| 302  | P0720302  | CROSS WAY COVER            |
| 303  | PLUBE002M | TAP-IN BALL OILER 8MM      |
| 305  | P0720305  | GIB SCREW                  |
| 306  | P0720306  | LONGINTUDINAL TABLE GIB    |
| 307  | PCAP130M  | CAP SCREW M10-1.5 X 16     |
| 308  | PLW06M    | LOCK WASHER 10MM           |
| 309  | PW04M     | FLAT WASHER 10MM           |
| 310  | P0720310  | LONGITUINAL LEADSCREW NUT  |
| 312  | PSS25M    | SET SCREW M6-1 X 20        |
| 313  | P0720313  | LOCK PLUNGER               |
| 314  | P0720314  | LOCK HANDLE ASSEMBLY       |
| 315  | P0720315  | LOCK PLUNGER               |
| 316  | PS03M     | PHLP HD SCR M6-1 X 8       |
| 317  | P0720317  | STATIONARY LIMIT BLOCK     |
| 318  | PCAP02M   | CAP SCREW M6-1 X 20        |
| 319  | P0720319  | POINTER                    |
| 320  | P0720320  | SADDLE CASTING             |
| 321  | P0720333A | CROSS LEADSCREW NUT        |
| 322  | PCAP24M   | CAP SCREW M5-.8 X 16       |
| 323  | P0720323  | BASE CASTING               |
| 324  | P0720324  | CROSS TABLE GIB            |
| 325  | P0720325  | CLIP                       |
| 327  | P0720327  | HANDWHEEL FLAT WASHER 12MM |
| 328  | PLN09M    | LOCK NUT M12-1.75          |
| 329  | P0720329  | HANDLE SCREW               |
| 330  | P0720330  | HANDWHEEL HANDLE           |
| 331  | P0720331  | CROSS HANDWHEEL            |
| 332  | P0720332  | CROSS GRADUATED DIAL       |
| 333A | P0720333A | CROSS LEADSCREW W/NUT      |
| 333  | P0720333A | CROSS LEADSCREW 8 TPI      |

| REF  | PART #    | DESCRIPTION                     |
|------|-----------|---------------------------------|
| 334  | PK37M     | KEY 4 X 4 X 16                  |
| 335  | PW01M     | FLAT WASHER 8MM                 |
| 336  | PLW04M    | LOCK WASHER 8MM                 |
| 337  | PCAP58M   | CAP SCREW M8-1.25 X 12          |
| 338  | P51203    | THRUST BEARING 51203            |
| 339  | P0720339  | BEARING FLANGE                  |
| 340  | PR20M     | INT RETAINING RING 28MM         |
| 341  | P6902ZZ   | BALL BEARING 6902ZZ             |
| 342  | P51202    | THRUST BEARING 51202            |
| 343A | P0720343A | LONGITUDINAL LEADSCREW W/NUT    |
| 343  | P0720343  | LONGITUDINAL LEADSCREW 8 TPI    |
| 344  | P0720344  | SLEEVE COPPER                   |
| 345  | P0720345  | CLUTCH                          |
| 346  | PK48M     | KEY 4 X 4 X 20                  |
| 347  | P0720347  | THREADED BUSHING                |
| 348  | P0720348  | LONGITUDINAL HANDWHEEL          |
| 349  | P0720349  | COMPRESSION SPRING              |
| 350  | P0720350  | LONGITUDINAL GRADUATED DIAL     |
| 351  | P0720351  | TABLE                           |
| 352  | P0720352  | INT THREADED TAPER PIN 6 X 26   |
| 353  | PCAP14M   | CAP SCREW M8-1.25 X 20          |
| 354  | P0720354  | RIGHT LONGITUDINAL BEARING SEAT |
| 355  | P0720355  | T-NUT M8-1.25 X 30              |
| 356  | PCAP40M   | CAP SCREW M8-1.25 X 35          |
| 357  | PN03M     | HEX NUT M8-1.25                 |
| 358  | P0720358  | ADJUSTABLE LIMIT BLOCK          |
| 359  | PRIV003M  | STEEL FLUTED RIVET 2 X 4MM      |
| 360  | P0720360  | LONGITUDINAL SCALE              |
| 361  | P0720361  | END CAP                         |
| 362  | P0720362  | LEFT LONGITUDINAL BEARING SEAT  |
| 363  | P0720363  | PLUG DIN910                     |



# Label Placement



| REF | PART #     | DESCRIPTION              |
|-----|------------|--------------------------|
| 401 | PLABEL-14  | ELECTRICITY LABEL        |
| 402 | P0720R402  | MACHINE ID LABEL         |
| 403 | P0720403   | MACHINE WARNING LABEL    |
| 404 | PLABEL-53C | DISCONNECT POWER WARNING |
| 405 | PLABEL-12C | READ MANUAL LABEL        |

| REF | PART #     | DESCRIPTION                   |
|-----|------------|-------------------------------|
| 406 | PLABEL-57A | EYE/LUNG HAZARD LABEL         |
| 407 | P0720407   | ROTATING CUTTER WARNING LABEL |
| 408 | PLABEL-55A | ENTANGLEMENT HAZARD LABEL     |
| 409 | PPAINT-01  | GRIZZLY GREEN TOUCH-UP PAINT  |

## WARNING

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





# WARRANTY CARD

Name \_\_\_\_\_

Street \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

Phone # \_\_\_\_\_ Email \_\_\_\_\_ Invoice # \_\_\_\_\_

Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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

1. How did you learn about us?

- Advertisement
- Card Deck
- Friend
- Website
- Catalog
- 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**



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name \_\_\_\_\_  
Street \_\_\_\_\_  
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

TAPE ALONG EDGES--PLEASE DO NOT STAPLE



# WARRANTY AND RETURNS

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

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

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

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

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

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

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