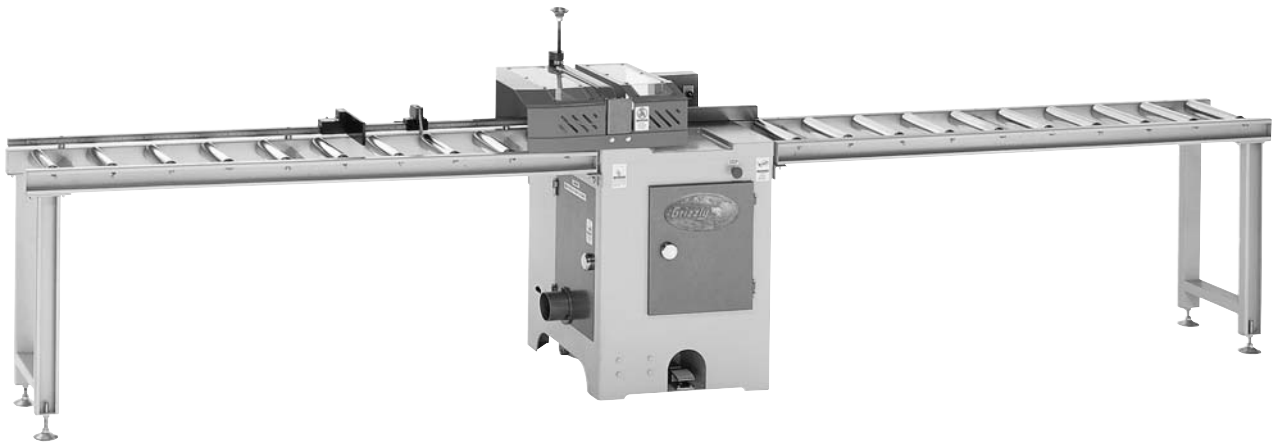
Grizzly Industrial, Inc.®

18" CUT-OFF SAW

MODEL G0502

INSTRUCTION MANUAL



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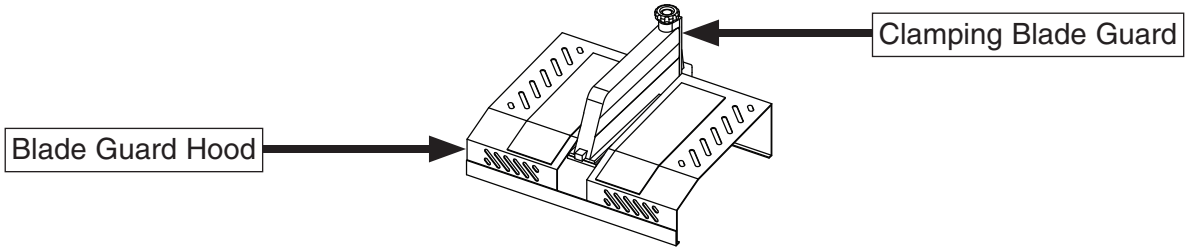
MODEL G0502
18" JUMP SAW
MANUAL UPDATE
(For Machines Manufactured After March, 2008)

The Model G0502 Jump Saw has changed from when the manual was originally written. We have added a limit switch for the glade guard hood and a guard over the foot pedal. The 440V conversion information has also been updated. The new parts breakdowns, parts lists, wiring diagrams, and 440V conversion instructions are included in this update.

Before operating your new machine, you MUST read and understand this manual update AND the original manual to reduce the risk of injury from improper use or setup. Pay special attention to the warning information included below regarding the blade guard.

If you need additional help with any of these procedures, contact our Tech Support at (570) 546-9663 or by email at techsupport@grizzly.com.

⚠WARNING



In addition to the safety instructions in your owner's manual for this machine, follow these rules regarding the blade guard hood and clamping blade guard:

- **ALWAYS disconnect power to the machine BEFORE making adjustments to the clamping blade guard to avoid the risk of unexpected startup, which could result in serious personal injury.**
- **ALWAYS properly adjust the clamping blade guard for the workpiece thickness so that it operates safely and efficiently.**
- **The clamping blade guard moves down with great force and can easily crush your hands. ALWAYS keep your hands and body parts away from this guard before pressing the foot pedal.**
- **NEVER have the machine connected to power when the glade guard hood is removed.**
- **DO NOT modify the glade guard hood or clamping blade guard. DO NOT interfere with their operation in any way.**

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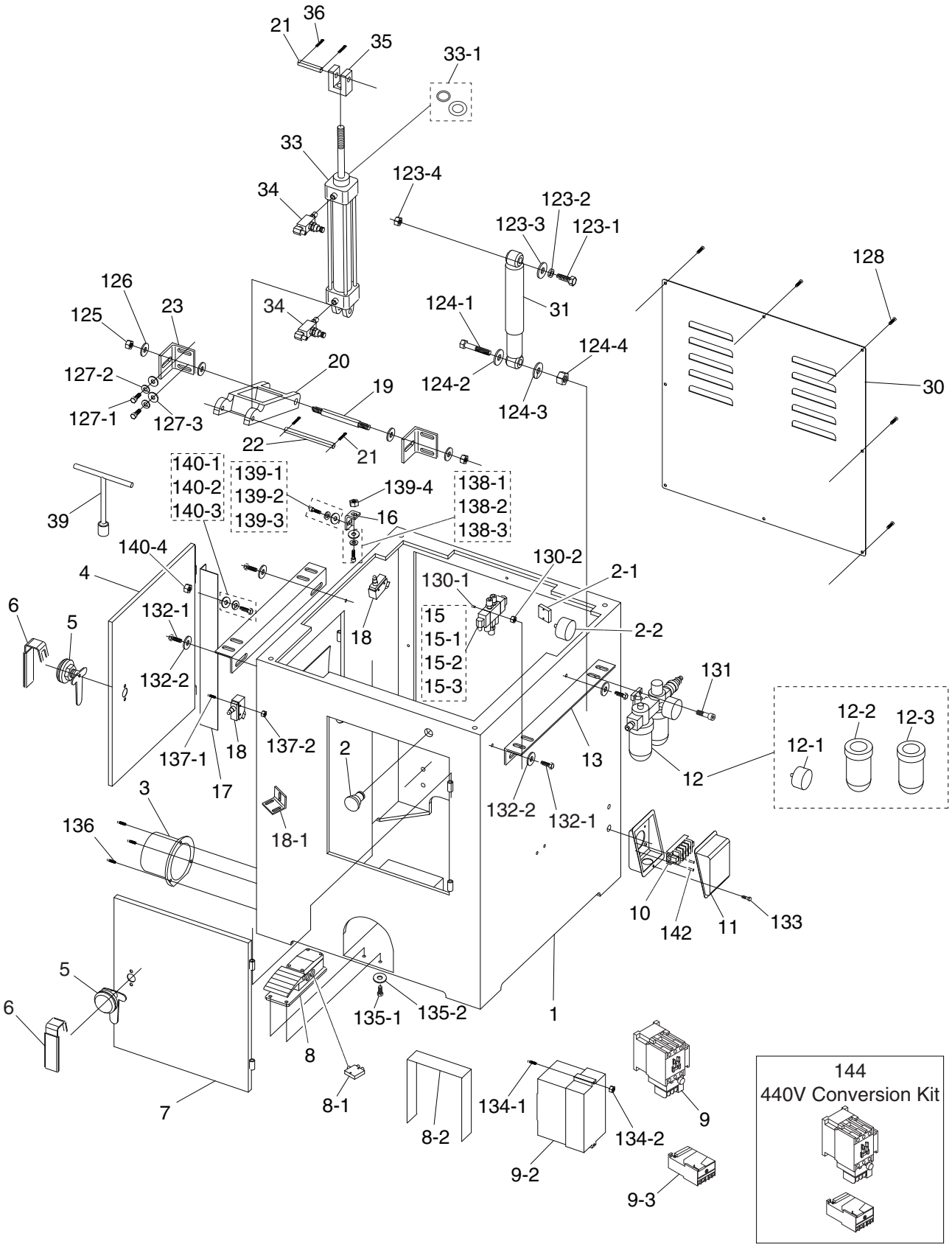
Cabinet Breakdown

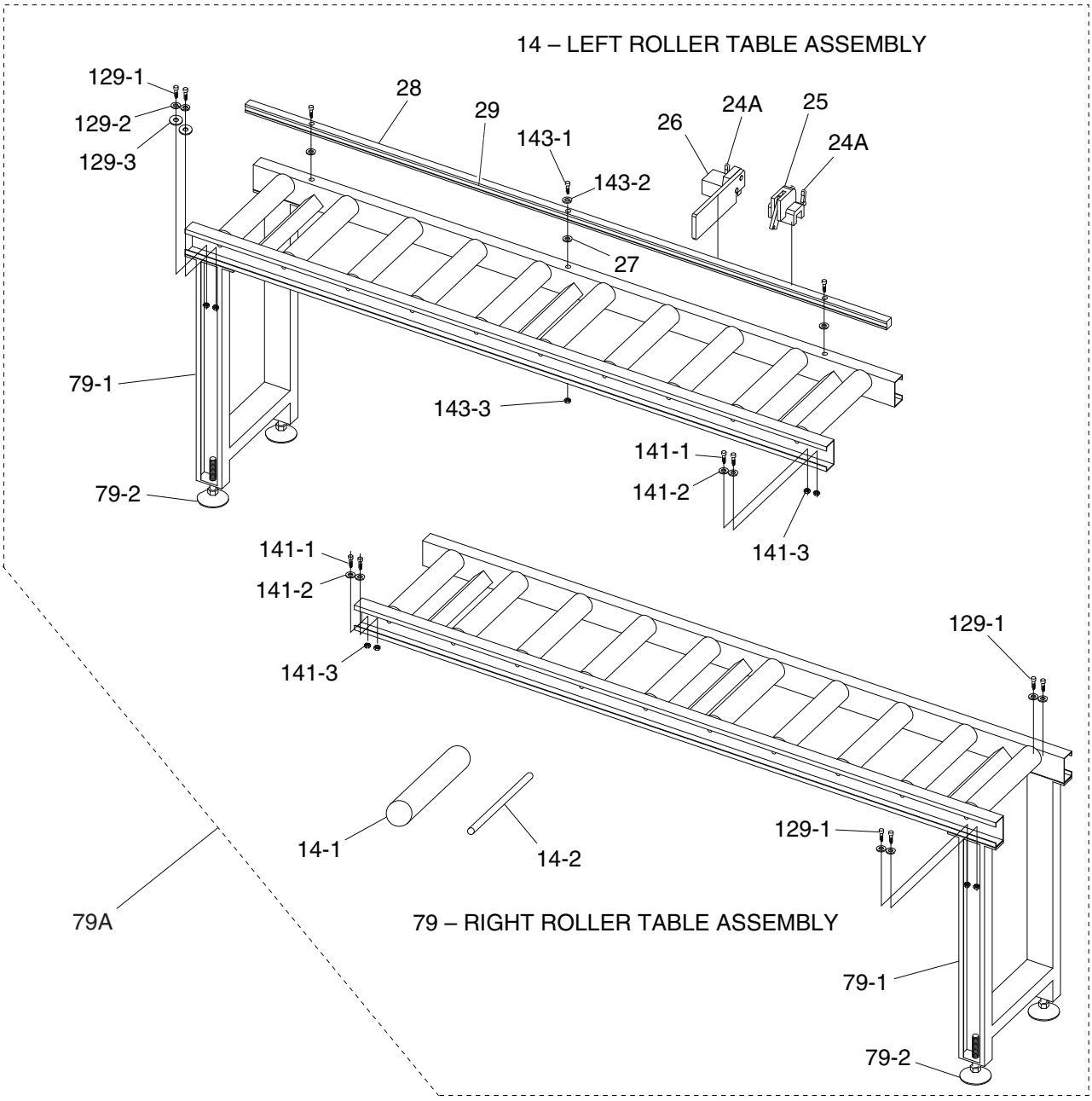


Cabinet Parts List

REF	PART #	DESCRIPTION
1	P0502001	CABINET
2	P0502002	EMERGENCY STOP SWITCH
2-1	P0502002-1	B-CONTACTOR
2-2	P0502002-2	COVER FOR B-CONTACTOR
3	P0502003	DUST PORT
4	P0502004	SIDE DOOR
5	P0502005	DOOR LOCK
6	P0502006	LOCK HANDLE
7	P0502007	FRONT DOOR
8	P0502008	PEDAL
8-1	P0502008-1	PEDAL CONTROLLER S3B-M5
8-2	P0502008-2	PEDAL GUARD
9	P0502009	MAG SWITCH NHD MS-35D 220V
9-2	P0502009-2	SWITCH HOUSING
9-3	P0502009-3	OL RELAY
10	P0502010	TERMINAL BLOCK
11	P0502011	ELECTRICAL BOX
12	P0502012	FILTER/LUBRICATOR/REGULATOR
12-1	P0502012-1	GAUGE
12-2	P0502012-2	OIL CUP
12-3	P0502012-3	WATER CUP
13	P0502013	CONNECTING PLATE
15	P0502015	SOLENOID VALVE
15-1	P0502015-1	AIR LINE ELBOW
15-2	P0502015-2	AIR FITTING 1/8PT X 4MM HOSE
15-3	P0502015-3	MUFFLER 1/8PT
16	P0502016	BRACKET
17	P0502017	LIMIT SWITCH STOP
18	P0502018	LIMIT SWITCH
18-1	P0502018-1	LIMIT SWITCH BRACKET
19	P0502019	STUD 5/8-11 X 161MM
20	P0502020	SUPPORT FRAME
21	P0502021	ROLL PIN 3 X 35
22	P0502022	COUPLING PIN 1/2 X 5-1/2
23	P0502023	SUPPORT ANGLE STEEL
30	P0502030	BACK DOOR
31	P0502031	CUSHION ARM
33	P0502033	AIR CYLINDER
33-1	P0502033-1	2-PC SEAL KIT
34	P0502034	PRESSURE REGULATING VALVE
35	P0502035	ROD END CLEVIS
36	P0502036	CLEVIS PIN 1/2" X 2"

REF	PART #	DESCRIPTION
39	P0502039	SOCKET T-WRENCH 19MM
123-1	PB33M	HEX BOLT M12-1.75 X 50
123-2	PLW05M	LOCK WASHER 12MM
123-3	PW06M	FLAT WASHER 12MM
123-4	PN09M	HEX NUT M12-1.75
124-1	PB92	HEX BOLT 1/2-12 X 3-1/2
124-2	PLW07	LOCK WASHER 1/2
124-3	PW01	FLAT WASHER 1/2
124-4	PN06	HEX NUT 1/2"-13
125	PN24M	HEX NUT M12-1.25
126	PW06M	FLAT WASHER 12MM
127-1	PB32M	HEX BOLT M10-1.5 X 25
127-2	PLW06M	LOCK WASHER 10MM
127-3	PW04M	FLAT WASHER 10MM
128	PS68M	PHLP HD SCR M6-1 X 10
130-1	P0502130-1	FLANGE SCREW M4-.7 X 40
130-2	PN04M	HEX NUT M4-.7
131	PSB02M	CAP SCREW M6-1 X 20
132-1	PB09M	HEX BOLT M8-1.25 X 20
132-2	PW01M	FLAT WASHER 8MM
133	PB87	HEX BOLT 10-24 X 3/8
134-1	PSB02M	CAP SCREW M6-1 X 20
134-2	PN01M	HEX NUT M6-1
135-1	PB83M	HEX BOLT M6-1 X 16
135-2	PLW03M	LOCK WASHER 6MM
136	PSB01M	CAP SCREW M6-1 X 16
137-1	PB04M	HEX BOLT M6-1 X 10
137-2	PN01M	HEX NUT M6-1
138-1	PB09M	HEX BOLT M8-1.25 X 20
138-2	PLW04M	LOCK WASHER 8MM
138-3	PW01M	FLAT WASHER 8MM
139-1	PB83M	HEX BOLT M6-1 X 16
139-2	PLW03M	LOCK WASHER 6MM
139-3	PW03M	FLAT WASHER 6MM
139-4	PN01M	HEX NUT M6-1
140-1	PSB04M	CAP SCREW M6-1 X 10
140-2	PLW03M	LOCK WASHER 6MM
140-3	PW03M	FLAT WASHER 6MM
140-4	PN01M	HEX NUT M6-1
142	PB03	HEX BOLT 5/16-18 X 1
144	P0502144	440V CONVERSION KIT NHD

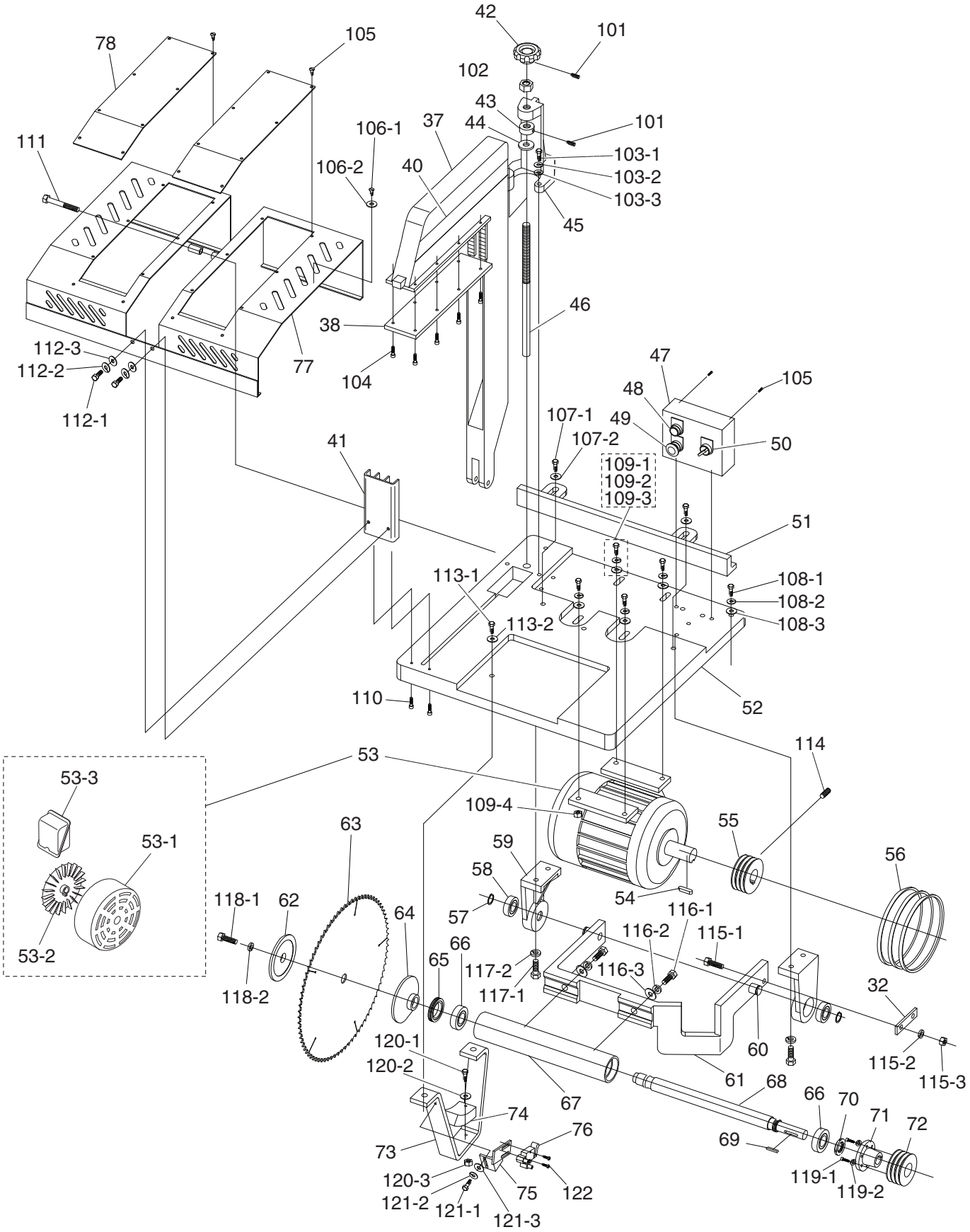
Roller Tables



REF	PART #	DESCRIPTION
14	P0502014	LEFT ROLLER TABLE ASSEMBLY
14-1	P0502014-1	INDIVIDUAL ROLLER
14-2	P0502014-2	ROLLER SHAFT
24A	P0502024A	LOCK HANDLE M8-1.25 X 20
25	P0502025	QUICK STOP
26	P0502026	FIXED STOP
27	P0502027	SPECIAL WASHER 8MM
28	P0502028	SQUARE RAIL
29	P0502029	SCALE
79	P0502079	RIGHT ROLLER TABLE ASSEMBLY
79-1	P0502079-1	ROLLER TABLE LEG STAND

REF	PART #	DESCRIPTION
79-2	P0549604	ADJUSTMENT FOOT 5/8-11 X 4
79A	P0502079A	LEFT & RIGHT ROLLER TABLE ASSY
129-1	PB07M	HEX BOLT M8-1.25 X 25
129-2	PLW04M	LOCK WASHER 8MM
129-3	PW01M	FLAT WASHER 8MM
141-1	PB07M	HEX BOLT M8-1.25 X 25
141-2	PW01M	FLAT WASHER 8MM
141-3	PN03M	HEX NUT M8-1.25
143-1	PSB13M	CAP SCREW M8-1.25 X 30
143-2	PLW04M	LOCK WASHER 8MM
143-3	PN03M	HEX NUT M8-1.25

Head & Motor Breakdown

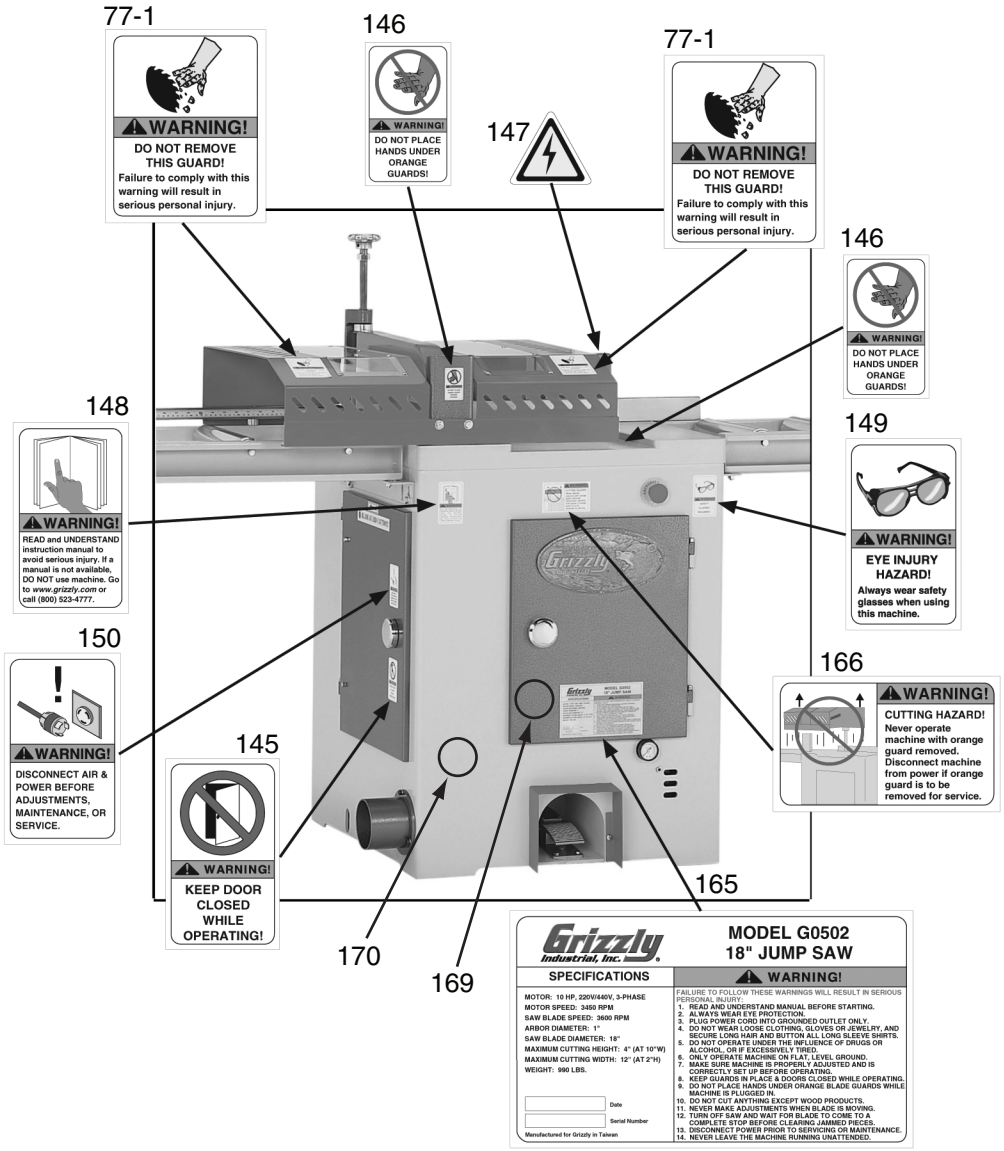


Head & Motor Parts List

REF	PART #	DESCRIPTION
32	P0502032	CONNECTING LINK
37	P0502037	CLAMPING BLADE GUARD
38	P0502038	RUBBER PLATE
40	P0502040	DANGER LABEL
41	P0502041	SAFETY GUARD
42	P0502042	LOCK KNOB
43	P0502043	SPECIAL LOCK NUT 3/4-10 X 15MM
44	P0502044	RUBBER RING
45	P0502045	ADJUSTABLE SEAT
46	P0502046	GUIDE SCREW 3/4-10 X 410MM
47	P0502047	SWITCH BOX
48	P0502048	ON BUTTON
49	P0502049	STOP BUTTON
50	P0502050	AIR INLET SWITCH
51	P0502051	FENCE
52	P0502052	TABLE
53	P0502053	MOTOR 10HP 220/440V 3 PH 60HZ
53-1	P0502053-1	MOTOR FAN COVER
53-2	P0502053-2	MOTOR FAN
53-3	P0502053-3	MOTOR WIRING JUNCTION BOX
54	P0502054	KEY 10 X 8 X 40
55	P0502055	MOTOR PULLEY
56	PVM33	V-BELT 3L330 (QTY 1)
57	P0502057	SPECIAL EXT RETAINING RING
58	P6205	BALL BEARING 6205ZZ
59	P0502059	MOTOR BRACKET
60	P0502060	BUSHING
61	P0502061	SUSPENSION BRACKET
62	P0502062	OUTSIDE ARBOR FLANGE
63	P0502063	SAW BLADE 120T
64	P0502064	INSIDE ARBOR FLANGE
65	P0502065	SPANNER NUT 2-7/16-16
66	P6206	BALL BEARING 6206ZZ
67	P0502067	QUILL
68	P0502068	MAIN SPINDLE
69	P0502069	KEY 1/4 X 1/4 X 1-9/16
70	P0502070	SPANNER NUT 13/16-16 LH
71	P0502071	TAPPER FLANGE
72	P0502072	DRIVE PULLEY
73	P0502073	LOWER BRACKET
74	P0502074	LOWER DAMPER
75	P0502075	LIMIT SWITCH BRACKET
76	P0502076	LIMIT SWITCH
77	P0502077	BLADE GUARD HOOD
78	P0502078	ACRYLIC PLATE

REF	PART #	DESCRIPTION
101	PSS16M	SET SCREW M8-1.25 X 10
102	PN17	HEX NUT 3/4"-10
103-1	PB31M	HEX BOLT M10-1.5 X 40
103-2	PLW06M	LOCK WASHER 10MM
103-3	PW04M	FLAT WASHER 10MM
104	PS14M	PHLP HD SCR M6-1 X 12
105	PS38M	PHLP HD SCR M4-.7 X 10
106-1	PB09M	HEX BOLT M8-1.25 X 20
106-2	PLW04M	LOCK WASHER 8MM
107-1	PB27M	HEX BOLT M12-1.75 X 30
107-2	PW06M	FLAT WASHER 12MM
108-1	PB09M	HEX BOLT M8-1.25 X 20
108-2	PLW04M	LOCK WASHER 8MM
108-3	PW01M	FLAT WASHER 8MM
109-1	PB120M	HEX BOLT M10-1.5 X 65
109-2	PLW06M	LOCK WASHER 10MM
109-3	PW04M	FLAT WASHER 10MM
109-4	PN02M	HEX NUT M10-1.5
110	PSB02M	CAP SCREW M6-1 X 20
111	PB89	HEX BOLT 1/2-12 X 4-1/2
112-1	PB09M	HEX BOLT M8-1.25 X 20
112-2	PLW04M	LOCK WASHER 8MM
112-3	PW01M	FLAT WASHER 8MM
113-1	PB35M	HEX BOLT M12-1.75 X 40
113-2	PLW05M	LOCK WASHER 12MM
114	PSS01M	SET SCREW M6-1 X 10
115-1	PB35M	HEX BOLT M12-1.75 X 40
115-2	PLW05M	LOCK WASHER 12MM
115-3	PB35M	HEX NUT M12-1.75
116-1	PB33M	HEX BOLT M12-1.75 X 50
116-2	PLW05M	LOCK WASHER 12MM
116-3	PW06M	FLAT WASHER 12MM
117-1	PB31M	HEX BOLT M10-1.5 X 40
117-2	PLW06M	LOCK WASHER 10MM
118-1	PB44	HEX BOLT 1/2-20 X 3/4
118-2	PLW07	LOCK WASHER 1/2
119-1	PB10M	HEX BOLT M6-1 X 25
119-2	PLW03M	LOCK WASHER 6MM
120-1	PB47M	HEX BOLT M6-1 X 40
120-2	PW03M	FLAT WASHER 6MM
120-3	PN01M	HEX NUT M6-1
121-1	PB08M	HEX BOLT M6-1 X 20
121-2	PLW03M	LOCK WASHER 6MM
121-3	PW03M	FLAT WASHER 6MM
122	PSB15M	CAP SCREW M5-.8 X 20

Label Placement



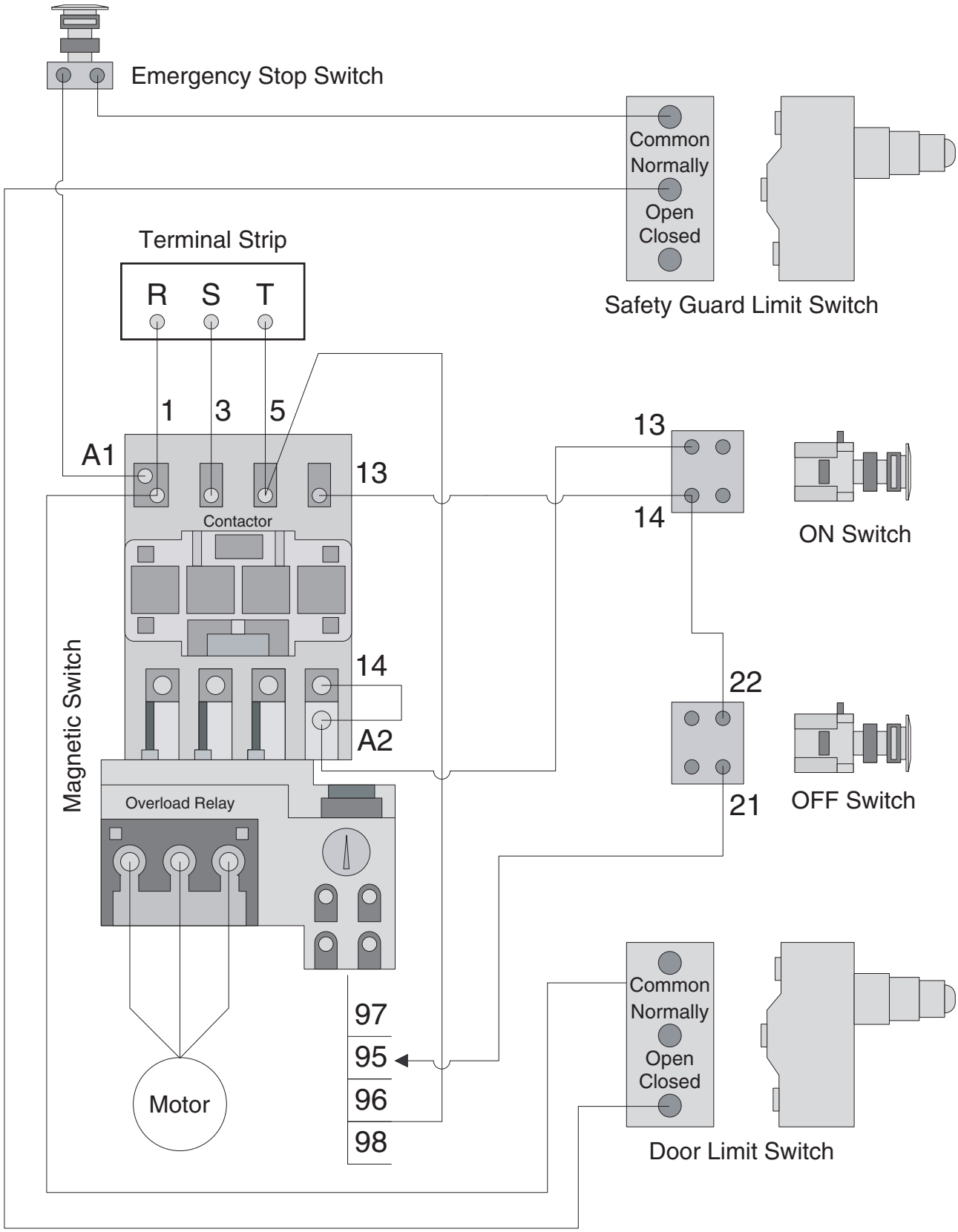
REF	PART #	DESCRIPTION
77-1	P0549623	BLADE GUARD LABEL
145	PLABEL-30	CLOSE DOOR LABEL
146	P0502146	HAND/BLADE GUARD LABEL
147	PLABEL-14	ELECTRICITY LABEL
148	PLABEL-12	READ MANUAL LABEL
149	PLABEL-11	SAFETY GLASSES LABEL

REF	PART #	DESCRIPTION
150	PLABEL-36	DISCONNECT POWER-DOOR LABEL
165	P0502165	MACHINE ID/WARNING LABEL
166	P0549622	BLADE GUARD LABEL
169	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
170	PPAINT-11	GRIZZLY PUTTY 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 to order new labels.

Wiring Diagram



440V Conversion

The Model G0502 can be converted for 440V 3-Phase operation. The procedure consists of changing the contactor and overload relay (see **Figure 1**), and rewiring the motor.

Order the Model G0502 440V Conversion Kit (P/N P0502144) by calling our Customer Service at (800) 523-4777.

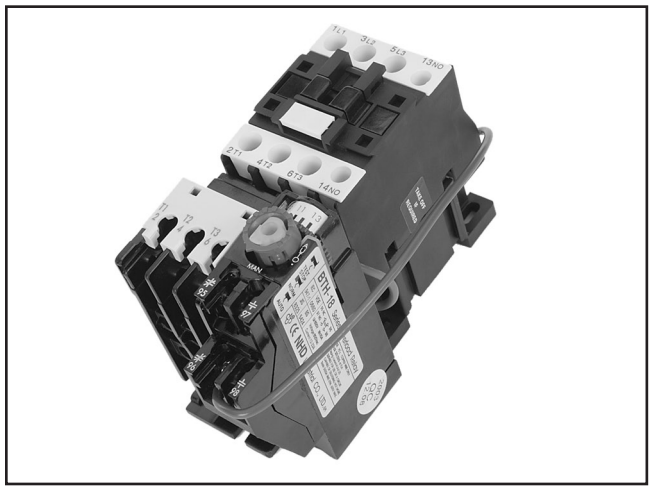


Figure 1. Model G0502 440V conversion kit.

⚠WARNING

The 440V conversion procedure requires moderate electrical skill and knowledge, and the rewiring must be inspected by a licensed electrician before the saw is connected to power. Heed this warning to avoid the risk of serious personal injury from electrocution or damage to the saw.

To convert the Model G0502 for 440V operation:

1. DISCONNECT SAW FROM POWER!

2. Open the electrical box, then replace the 220V contactor and overload relay with the ones in the conversion kit (see **Figure 2**).

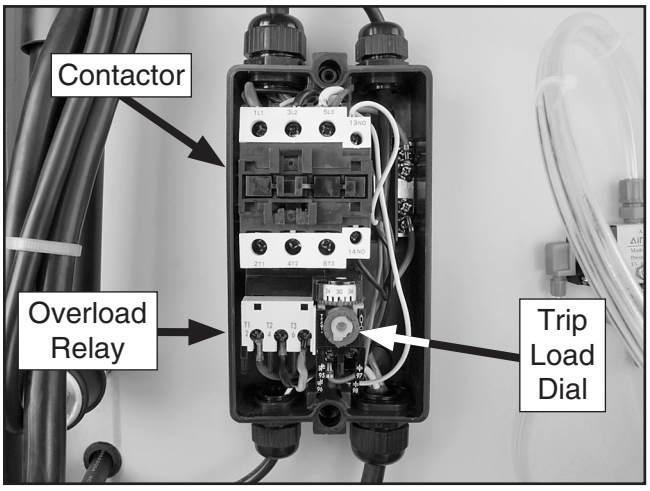


Figure 2. Model G0502 contactor and overload relay.

3. Make sure the trip load dial of the overload relay is set at 10 amps.

4. Wire the motor as shown on the inside of the motor wiring junction box cover for 440V operation.

Note: *The illustration in **Figure 3** is provided for your reference and was current at the time that this manual update was printed. However, always use the diagram on the wiring junction box cover that comes with your motor.*

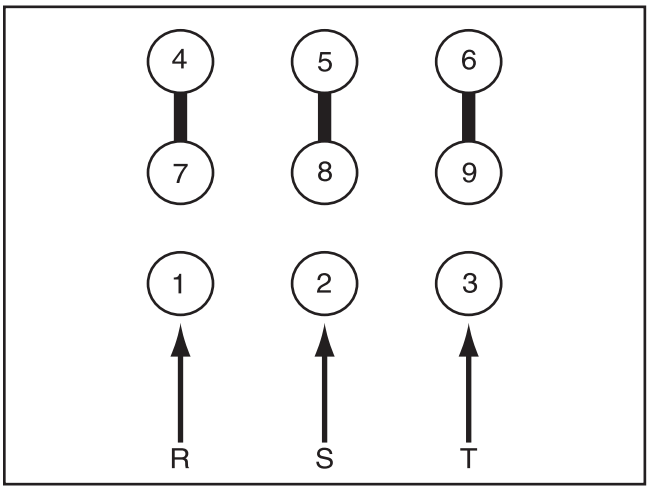


Figure 3. Model G0502 motor wiring for 440V operation.

MODEL G0502
18" CUT-OFF SAW
MANUAL UPDATE

This machine has changed slightly from when the manual was originally written. It now includes a more comprehensive blade guard, a workpiece holding mechanism, and dual start buttons to prevent access to the blade during operations. This update includes instructions for setting up the guard before each use and operating the machine with its new components, and a parts breakdown and list for the new components.

Before operating the machine, you MUST read and understand this manual update AND the original manual to reduce the risk of injury from improper use or setup. Since this update covers changes made to the machine after the owner's manual was printed, you MUST keep this update with your owner's manual for future reference. *If you have questions, contact Tech Support at (570) 546-9663 or by email at techsupport@grizzly.com.*

New Blade Guard

We improved the blade guard by installing a stake-type guard on the infeed side and one-way hinged guard flaps on the outfeed side.

To prepare the blade guard for operation:

1. Place the workpiece on the machine against the fence and approximately 1" away from the guard.

2. For each guard stake, loosen the wing screw, then adjust the height approximately 1" above the stock you plan to cut. This will allow adequate clearance for inserting the stock but help keep fingers or hands out of the cutting area.

   Note: *The two guard stakes above the actuator bracket must be left high enough to not interfere with the actuator during operation.*

Operation

When properly assembled, the changes to the machine help keep hands away from the blade during operation; however, this requires different procedures from those described in the Model G0502 owner's manual.

To operate the G0502:

1. Perform **Steps 1–3** on **Page 25** of the Model G0502 manual to prepare the machine and stock for operation. Make sure to place the end of the stock firmly against the stop and the side of the stock against the fence.

2. Press the START button on the control panel to turn the motor ***ON***, then allow the saw blade to reach full speed.

3. Press and hold the foot pedal to engage the holding mechanism, which will press the workpiece against the fence and help keep it from moving when your hands are removed from the stock.

4. Simultaneously press both START buttons on the front of the cabinet to cycle the blade.

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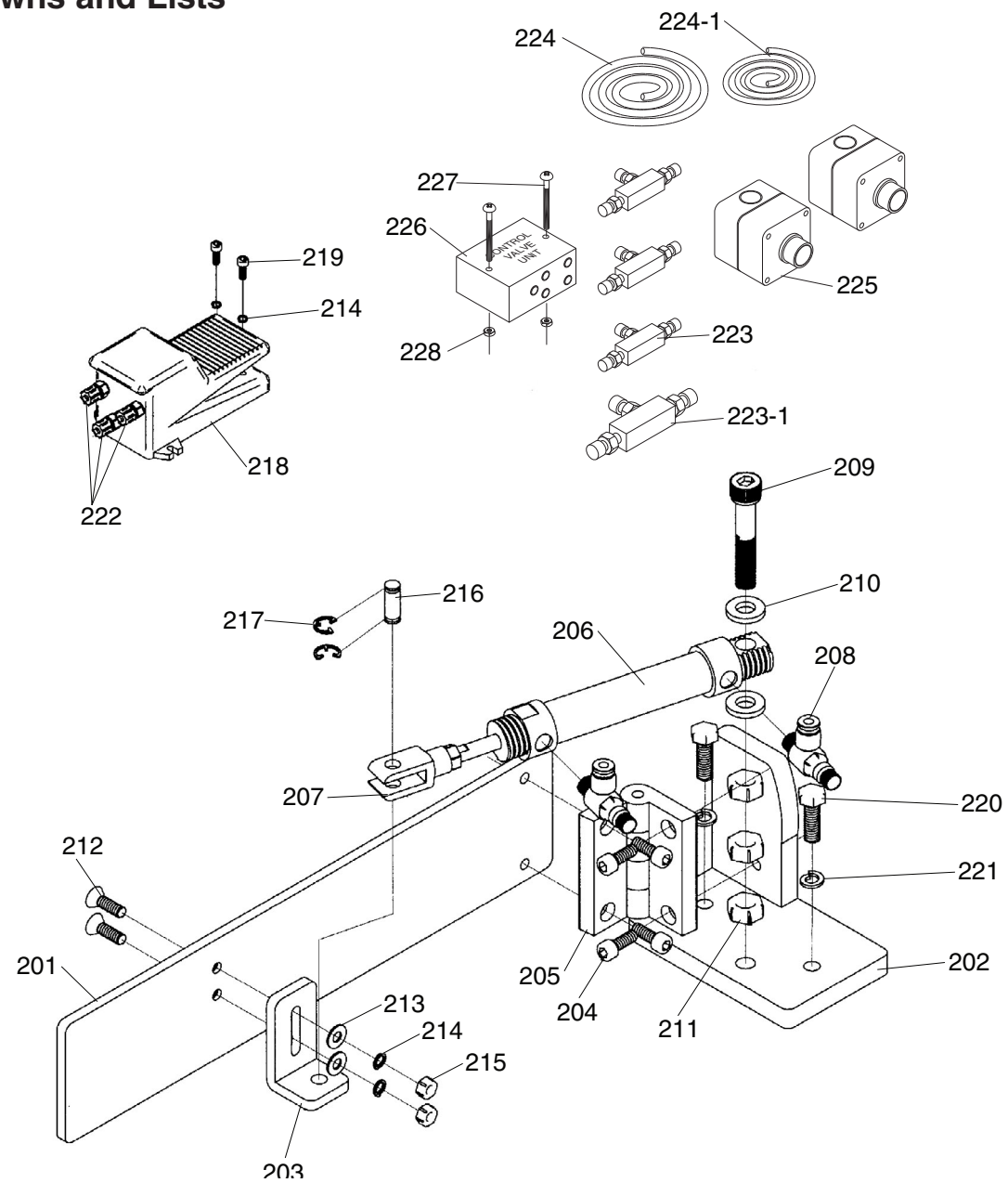
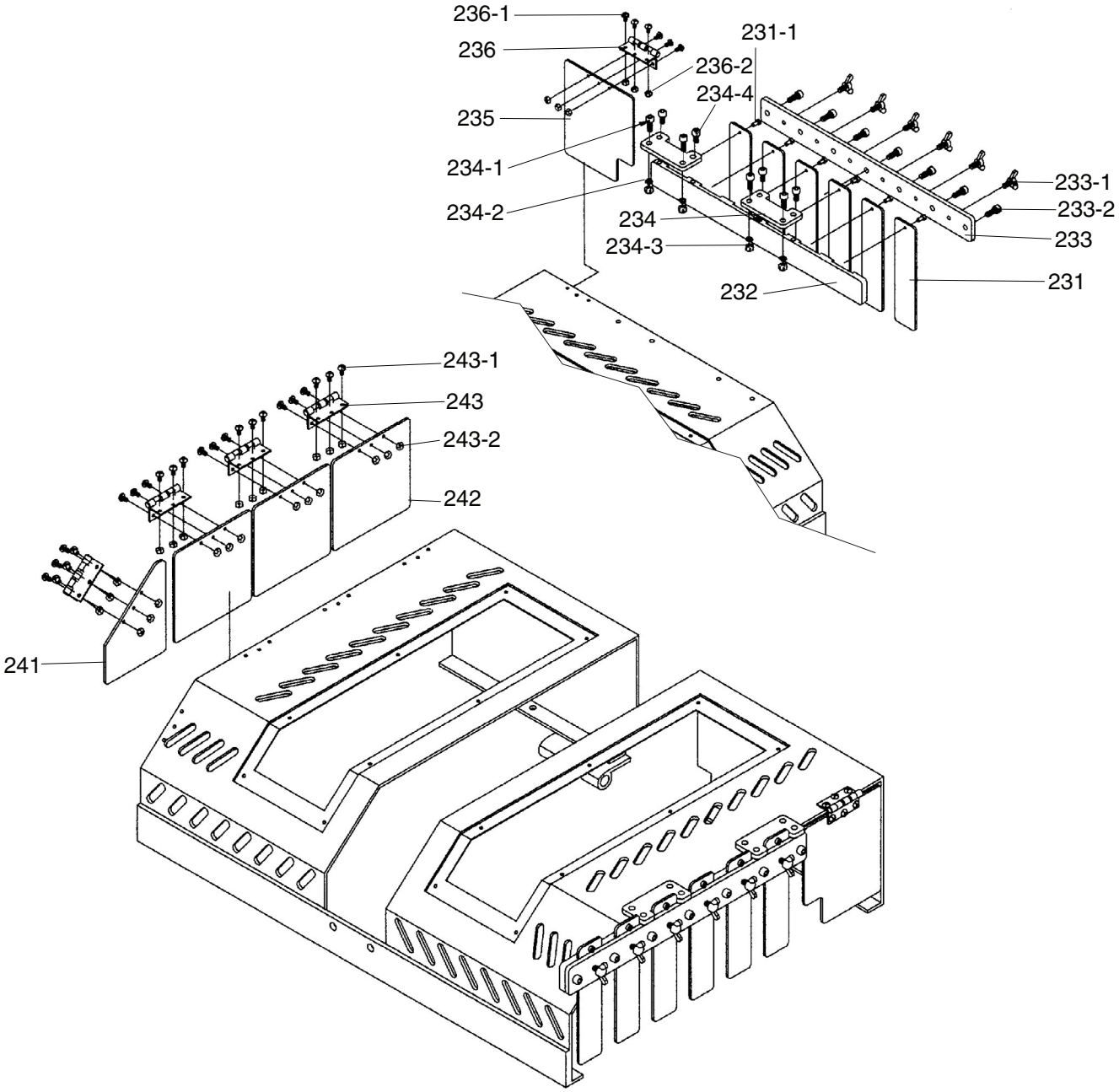
Parts Breakdowns and Lists



REF	PART #	DESCRIPTION
201	P0502201	CLAMP GATE
202	P0502202	MOUNTING BRACKET
203	P0502203	ACTUATOR BRACKET
204	PCAP01M	CAP SCREW M6-1 X 16
205	P0502205	HINGE
206	P0502206	ACTUATOR CYLINDER
207	P0502207	CYLINDER YOKE
208	P0502208	REGULATOR VALVE
209	PCAP05M	CAP SCREW M8-1.25 X 50
210	PW01M	FLAT WASHER 8MM
211	PN03M	HEX NUT M8-1.25
212	PFH06M	FLAT HD SCR M6-1 X 20
213	PW03M	FLAT WASHER 6MM
214	PLW03M	LOCK WASHER 6MM
215	PN01M	HEX NUT M6-1

REF	PART #	DESCRIPTION
216	P0502216	YOKE PIN 8 x 22
217	PEC015M	E-CLIP 8MM
218	P0502218	PEDAL ASSEMBLY
219	PCAP01M	CAP SCREW M6-1 X 16
220	PB07M	HEX BOLT M8-1.25 X 25
221	PLW04M	LOCK WASHER 8MM
222	P0502222	BRASS FITTING KIT
223	P0502223	T-FITTING 2.5MM
223-1	P0502223-1	T-FITTING 4MM
224	P0502224	AIR HOSE 4 X 6MM
224-1	P0502224-1	AIR HOSE 2.5 X 4MM
225	P0502225	START BUTTON ASSEMBLY
226	P0502226	CONTROL VALVE UNIT
227	P0502227	PHLP HD SCR M4-.7 X 55
228	PN04M	HEX NUT M4-.7



REF	PART #	DESCRIPTION
231	P0502231	STAKE GUARD
231-1	PCAP17M	CAP SCREW M4-.7 X 10
232	P0502232	INNER GUARD PLATE
233	P0502233	OUTER GUARD PLATE
233-1	P0502233-1	WING SCREW M6-1 X 14
233-2	PCAP27M	CAP SCREW M6-1 X 14
234	P0502234	GUARD MOUNT BRACKET
234-1	PCAP01M	CAP SCREW M6-1 X 16
234-2	PLW03M	LOCK WASHER 6MM
234-3	PN01M	HEX NUT M6-1

REF	PART #	DESCRIPTION
234-4	PCAP26M	CAP SCREW M6-1 X 12
235	P0502235	NOTCHED GUARD FLAP
236	P0502236	HINGE
236-1	PS07M	PHLP HD SCR M4-.7 X 8
236-2	PN04M	HEX NUT M4-.7
241	P0502241	ANGLED GUARD FLAP
242	P0502242	SQUARE GUARD FLAP
243	P0502243	HINGE
243-1	PS07M	PHLP HD SCR M4-.7 X 8
243-2	PN04M	HEX NUT M4-.7

WARNING

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

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

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

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INTRODUCTION

Foreword

We are proud to offer the Model G0502 18" cut-off saw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0502. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0502 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

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

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

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

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

Identification

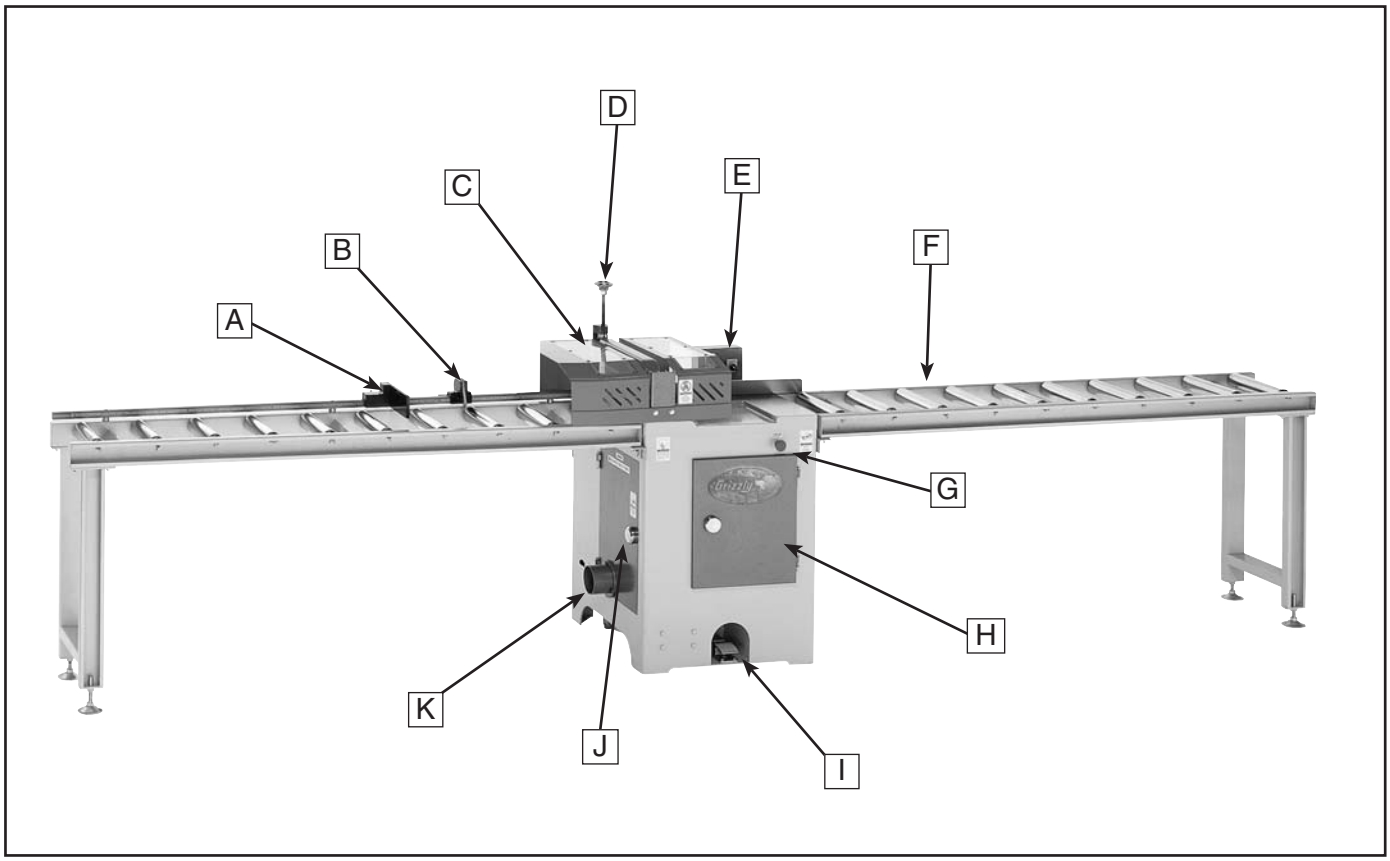


Figure 1. Front view of cut-off saw for identification.

A. Fixed Stop—Adjusts along the outfeed roller assembly for repeat cuts.

B. Flip Stop—Adjusts along the outfeed roller assembly for repeat cuts; springs in/out of workpiece path as needed.

C. Fully Enclosed Blade Guard—Protects the operator from blade contact during normal use.

D. Blade Guard Height Knob—Adjusts the height that the blade guard will raise when the air system is pressurized.

E. Control Panel—Starts and stops the blade, and switches the air pressure on/off.

F. Roller Table—Supports long and heavy workpieces for easy positioning.

G. Emergency Off Button—Easy access location for turning saw OFF and stopping the air power.

H. Air System Access Door—Used to inspect and adjust the air system to ensure proper operation.

I. Foot Pedal—Pneumatically controlled pedal cycles the blade to raise into the workpiece.

J. Blade Access Door—Used to inspect the blade and access the blade arbor nut for blade changes. Only open when machine is disconnected from power.

K. 4" Dust Port—Allows the machine to easily connect to a dust collector.

MACHINE DATA SHEET

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

G0502 18" Cut-Off Saw

Design Type ..... Floor Model

Overall Dimensions:

- Table Size ..... 26" W x 27" D
- Table Height ..... 34½"
- Overall Width w/Extension Roller ..... 184½"
- Overall Width w/o Extension Roller ..... 33"
- Overall Depth ..... 33½"
- Overall Height ..... 50¼"
- Footprint w/Extension Roller ..... 182" W x 27" D
- Footprint w/o Extension Roller ..... 25½" W x 27" D
- Shipping Weight (Both Crates) ..... 1188 lbs.
- Machine Weight ..... 990 lbs.
- Crate 1 Size ..... 30½" W x 32½" D x 53" H
- Crate 2 Size ..... 82½" W x 20" D x 17" H

Capacities:

- Cutting Capacity ..... 2" H x 12" W, 3" H x 11" W, 4" H x 10" W
- Maximum Cutting Length ..... 78"
- Maximum Cutting Cycle Speed ..... 81 Strokes Per Minute
- Saw Blade Size ..... 18"
- Arbor Diameter ..... 1"
- Saw Blade Speed ..... 3600 RPM

Construction:

- Table ..... Precision Ground Cast Iron
- Cabinet ..... Steel
- Fence ..... Precision Ground Cast Iron
- Extension Roller ..... Pre-Formed Steel
- Spindle Bearings ..... Ball Bearings, Sealed and Lubricated for Life

Motor:

- Type ..... TEFC Induction
- Horsepower ..... 10 HP
- Phase / Voltage ..... Three-Phase / 220V/440V
- Amps 25/12.5A
- Cycle / RPM ..... 60 Hertz / 3450 RPM
- Switch ..... 220V Magnetic w/Thermal Overload Protector
- Bearings ..... Shielded & Lubricated Ball Bearings

Features:

- ..... 78" Infeed & Outfeed Roller Extension
- ..... Safety Guard
- ..... Swing Stop and Heavy-Duty Stop
- ..... Foot Switch Start
- ..... Emergency Button For Cutting Release
- ..... Easily Adjustable Clamp
- ..... Convenient Cycle Speed Adjustment
- ..... Quick-Stop Connect Fitting

Specifications, while deemed accurate, are not guaranteed.

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

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

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

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

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

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

⚠WARNING

Safety Instructions for Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
4. **NEVER USE IN DANGEROUS ENVIRONMENT**. DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY**. All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **NEVER FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

⚠WARNING
Safety Instructions for Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DO NOT OVER-REACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

18. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** DO NOT leave tool until it comes to a complete stop.

19. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

20. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

21. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING
Additional Safety Instructions for Cut-Off Saws

1. **BLADE GUARD.** Always use the blade guard on all cutting operations. DO NOT remove it!

2. **HANDS OUTSIDE BLADE GUARD.** Keep hands outside of blade guard area when saw blade is running.

3. **WORKPIECE CONTROL.** Make sure the workpiece is placed in a stable position on the table before cutting.

4. **SAFETY WEAR.** Use safety glasses, a respirator, and hearing protection every time you operate this machine. See Section 5: Accessories on **page 28**.

5. **JAMMED WORKPIECE CUTOFFS.** Turn off saw blade and disconnect machine from the power source before clearing a jammed cutoff piece.

6. **STALLED BLADE.** Turn the saw off before attempting to "free" a stalled saw blade.

7. **DAMAGED SAW BLADES.** Never use blades that have been dropped or damaged; otherwise, serious personal injury could occur.

8. **INTERNAL ADJUSTMENTS.** Always disconnect the saw from the power source before making adjustments inside the cabinet.

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

10. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

⚠WARNING

Like all machines there is danger associated with the Model G0502. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

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

SECTION 2: CIRCUIT REQUIREMENTS

Motor Amp Draw

The following list shows the amp draw for the motor when running at the two possible voltages it is designed for:

Motor at 220V, 3-Phase (Prewired)
Amp Draw.....25 Amps

Motor at 440V, 3-Phase (w/Conversion Kit)
Amp Draw.....12.5 Amps

Circuit Breaker

Use the following guidelines when choosing a circuit breaker (circuit breakers rated any higher are not adequate to protect the circuit):

220V, 3-Phase (Prewired)
Circuit Breaker.....30 Amps

440V, 3-Phase (w/Conversion Kit)
Circuit Breaker.....15 Amps

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

If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified electrician.

Minimum Cord Size

A power cord is not included with this machine because the proper cord will vary, depending on the operation voltage. The cord you choose must, at the minimum, meet the following specs for safe operation:

220V, 3-Phase (Prewired)
Cord.....4 Wire
Gauge..... 8
Maximum Length.....15'

440V, 3-Phase (w/Conversion Kit)
Cord.....4 Wire
Gauge..... 10
Maximum Length.....15'

NOTICE

Consult a qualified electrician for the correct power cord gauge when the cord length must exceed 15'; otherwise, damage may occur to the electrical components and the machine may not work correctly.

Cord Connection

Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking shut-off lever (**Figure 2**) near the machine as a way to quickly disconnect the power.

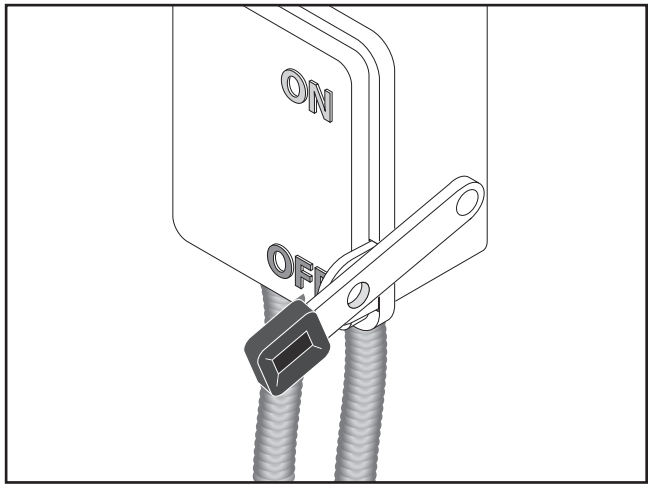
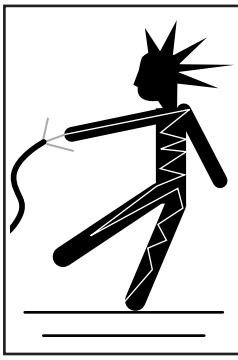


Figure 2. Locking shut-off lever.

Grounding



⚠WARNING

Electrocution or a fire can result if the machine is not grounded correctly. Make sure all electrical circuits are grounded. DO NOT use the machine if it is not grounded.

In the event of an electrical short, grounding provides electric current a path of least resistance to reduce the risk of electrical shock to the operator. Ground the power cord and this machine in accordance with all local codes and ordinances.

Operating this machine when it is not properly grounded can result in electric shock or electrocution.

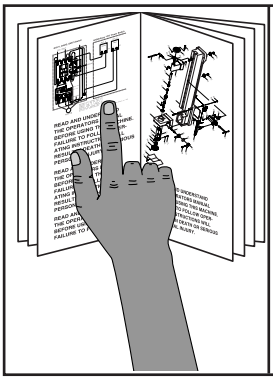
Extension Cords

Because of the high amperage draw from this machine, we do not recommend the use of extension cords. Instead, position your equipment near installed wiring to eliminate the need for extension cords.

SECTION 3: SET UP

About this Section

The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.



⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire set up process!

Items Needed For Set Up

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

DESCRIPTION	QTY
• Straightedge 4' (or longer)	1
• Safety Glasses (for each person)	1
• Dust Collection System	1
• 4" Dust Hose (length as needed)	1
• 4" Hose Clamp	1
• Air Compressor	1
• Air Hose (length as needed)	1
• Male Air Fitting 3/8" NPT	1
• Female Air Fitting to Match Male	1
• Piece of 2x4 (at least 2' long)	1

Unpacking

The Model G0502 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

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

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

Inventory

Use **Figures 3–4** and the list below to inventory the hardware and components for the Model G0502. If you have any questions, please call our customer service at (570) 546-9663.

DESCRIPTION	QTY
A. Main Saw Assembly (not shown)	1
B. Roller Table Legs	2
C. Mounting Brackets	2
D. Fixed Stop	1
E. Flip Stop	1
F. Foot Assemblies	4
G. Hardware Bag	1
1. Hex Bolts M8-1.25 x 20	13
2. Hex Bolts M8-1.25 x 25	4
3. Flat Washers 8MM Ø23 T2	4
4. Flat Washers 8MM Ø25 T3	4
5. Flat Washers 8MM Ø18 T2	9
6. Hex Nuts M8-1.25	13
H. Roller Table—Left	1
I. Roller Table—Right	1
J. Safety Guard	1
K. Tool Box	1
L. Dust Port Hook-Up	1
M. Cap Screws M6-1 x 16	3
N. Lock Washers 6MM	3
O. Allen Wrench 5MM	1
P. Door Lock Handles	2
Q. Arbor Wrench 19MM	1
R. Open End Wrench 11/13MM	1
S. Open End Wrench 19/21MM	1

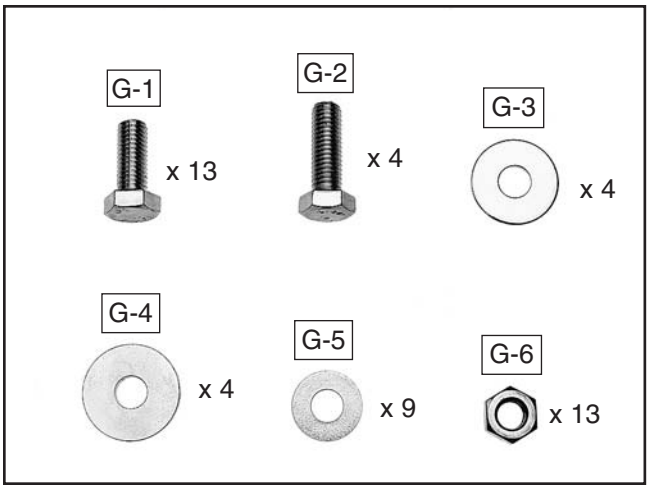


Figure 4. Hardware bag contents.

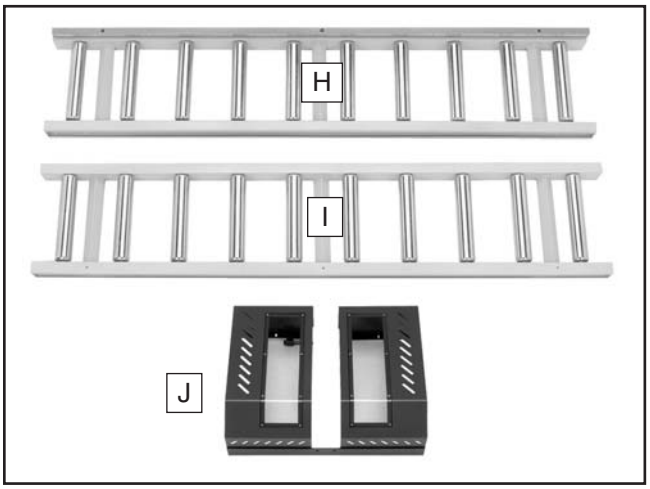


Figure 5. Roller and guard assemblies.

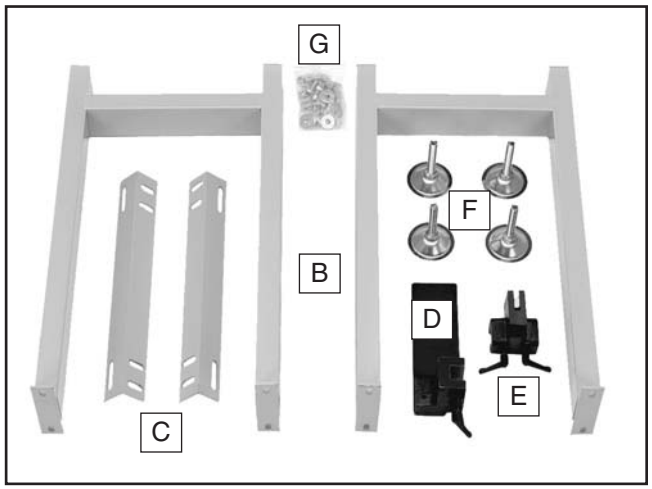


Figure 3. Roller table legs, braces, feet and stops.

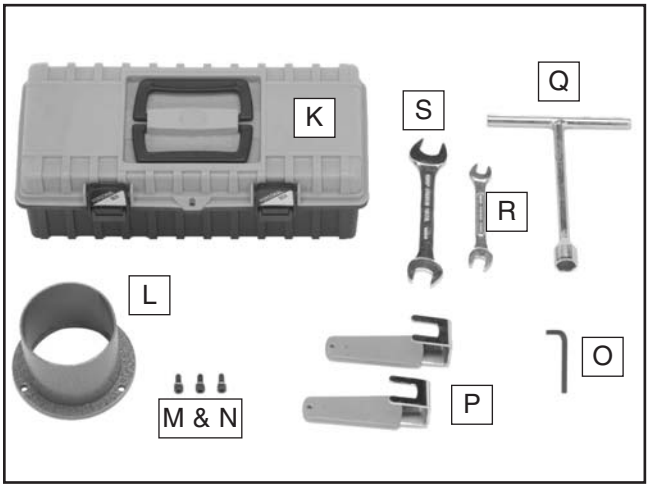
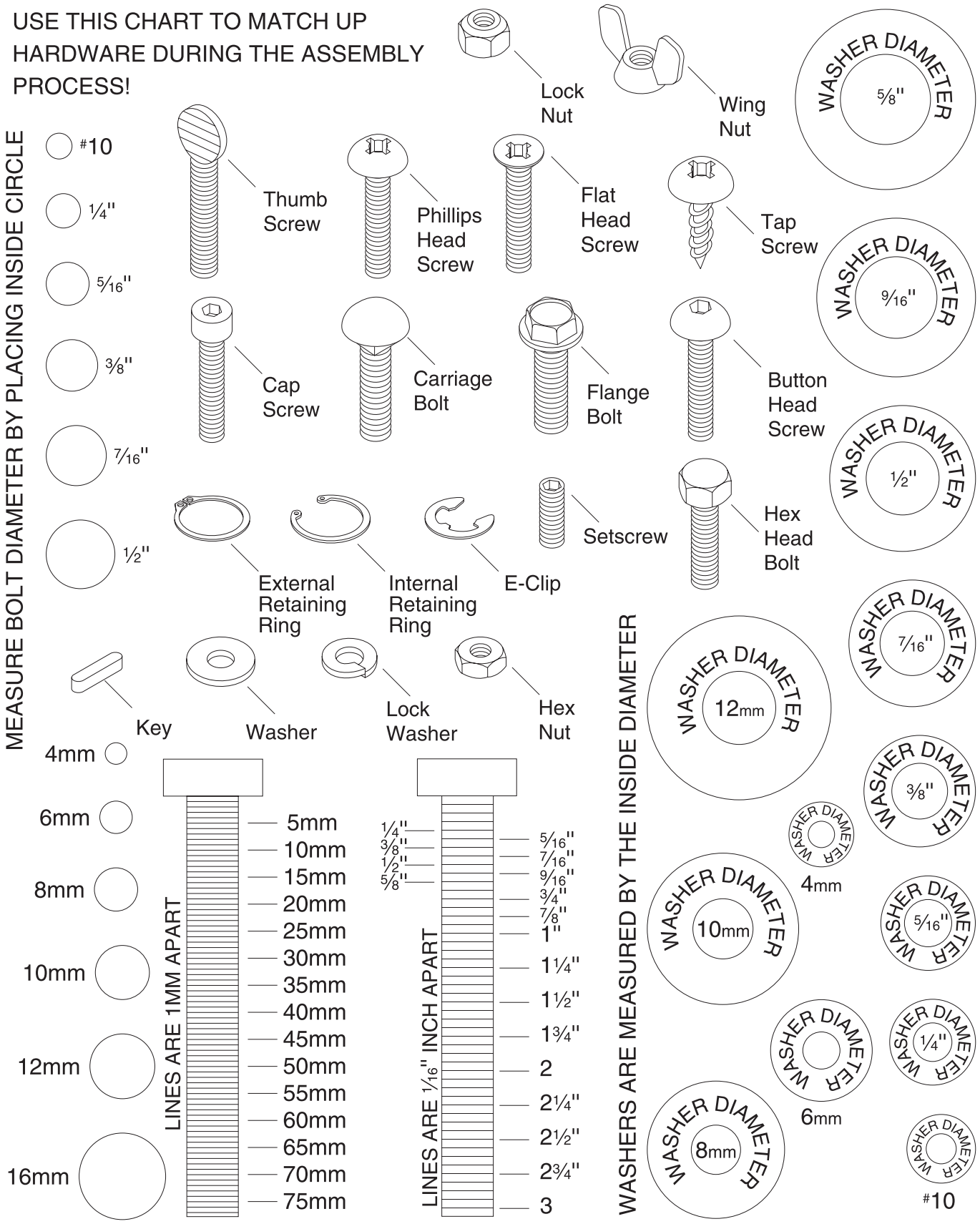


Figure 6. Tool box contents.

Hardware Recognition Chart



Site Considerations

Floor Load
The shipping weight for the Model G0502 is 1029 lbs. Most commercial floors are suitable for your new machine. Some floors may require additional reinforcement to support the combined weight of the machine, the operator, and the workpiece.

Working Clearances
Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 7** for the Model G0502 footprint.

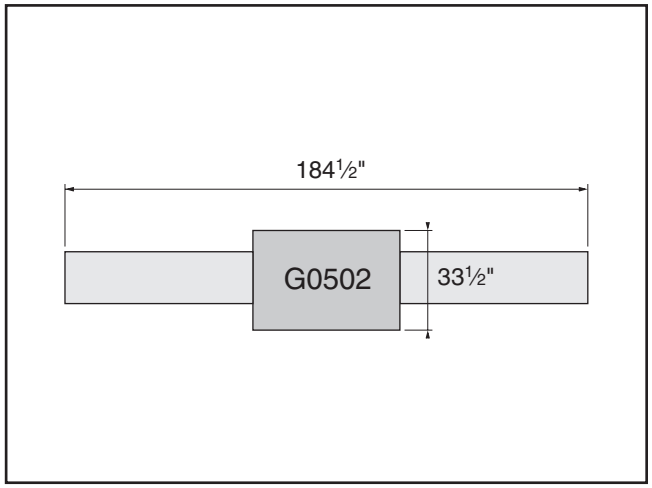
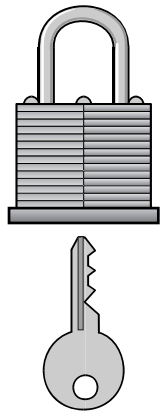


Figure 7. Model G0502 footprint.



⚠WARNING

Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.

Clean Up

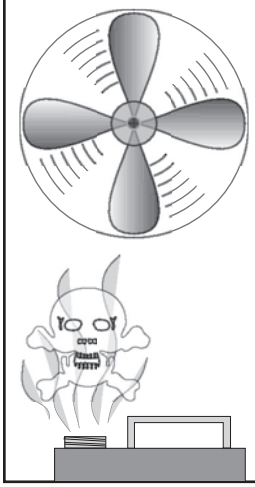
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your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

⚠WARNING

Gasoline and petroleum products have low flash points and could explode if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.

⚠WARNING

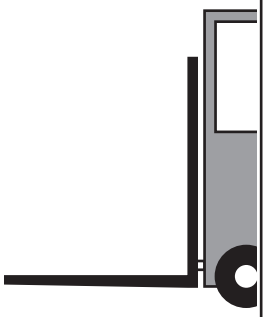
Smoking near solvents could ignite an explosion or fire and cause serious injury. DO NOT smoke while using solvents.



⚠WARNING

Lack of ventilation while using solvents could cause serious personal health risks, fire, or environmental hazards. Always work in a well ventilated area to prevent the accumulation of dangerous fumes. Supply the work area with a constant source of fresh air.

Placement



⚠WARNING

The Model G0502 has a shipping weight of 1029 lbs. Serious personal injury may occur if safe moving methods are not followed. Use the assistance of power equipment when moving the crate and placing the machine.

To place the saw base unit:

1. Remove the top of the crate from the base unit.

2. Using the door lock handles, open the cabinet doors to access the lag screws that secure the base unit to the bottom of the crate.

3. Unbolt the four lag screws from the base unit and crate bottom.

4. Use a forklift and the eyebolt mounted in the table to move the cut-off saw to the desired location.

Roller Tables

Hardware Needed:	**Qty**
Roller Table Legs	2
Mounting Brackets	2
Roller Table—Left	1
Roller Table—Right	1
Foot Assemblies	4
Hex Bolts M8-1.25 x 20	12
Flat Washers 8MM	12
Hex Nuts M8-1.25	12

Tools Needed:	**Qty**
Wrenches/Sockets 13MM	2

To assemble the roller tables and attach them to the cut-off saw:

1. Starting at the left-hand side of the saw, remove the two hex bolts and washers shown in **Figure 8**.

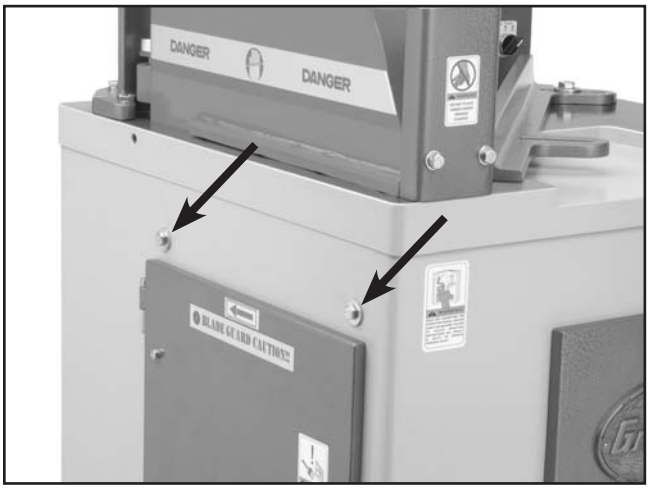


Figure 8. Bolts to be removed.

2. Using the removed bolts from **step 1**, attach one of the mounting brackets to the saw, as shown in **Figure 9**.

   —Do not fully tighten the bolts at this time. They will be used to adjust the height of the stand after the machine is connected to air.

Figure 9. Attaching mounting bracket to saw.

3. Thread two foot assemblies into one of the stand legs, as shown in **Figure 10**.

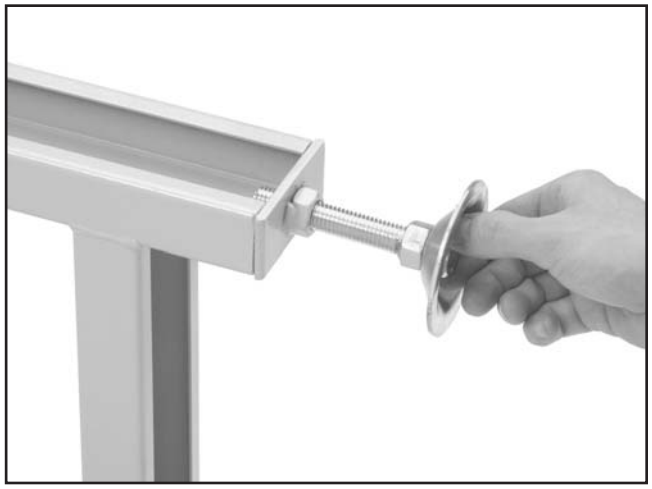


Figure 10. Threading foot into stand leg.

4. Using four of the hex bolts, flat washers, and hex nuts, attach the stand leg/foot assembly to the left roller assembly, as shown in **Figure 11**. (The left roller table has a rail along the edge.)

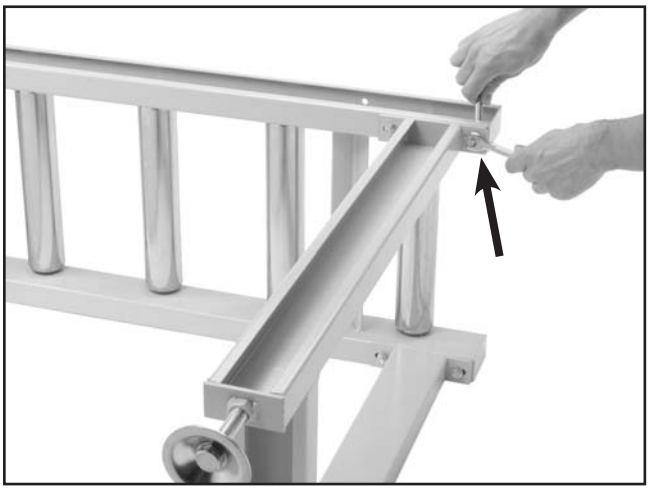


Figure 11. Attaching stand leg/foot assembly to roller table.

5. Place the end of the roller table (opposite the leg assembly) on the mounting bracket that is attached to the saw.

6. Use two hex bolts, washers, and nuts to secure the roller table to the mounting bracket (see **Figure 12**).

Figure 12. Roller table attached to mounting bracket.

7. Repeat **steps 1-6** for the right-hand side roller table.

Fence

Tools Needed: **Qty**
Wrench/Socket 19MM 1

For shipping purposes, the fence is mounted backwards on the table, as shown in **Figure 13**.

Figure 13. Fence in shipping position.

The fence must be removed from the table, turned around, and mounted along the scribed line (**Figure 14**) so it is square to the blade.

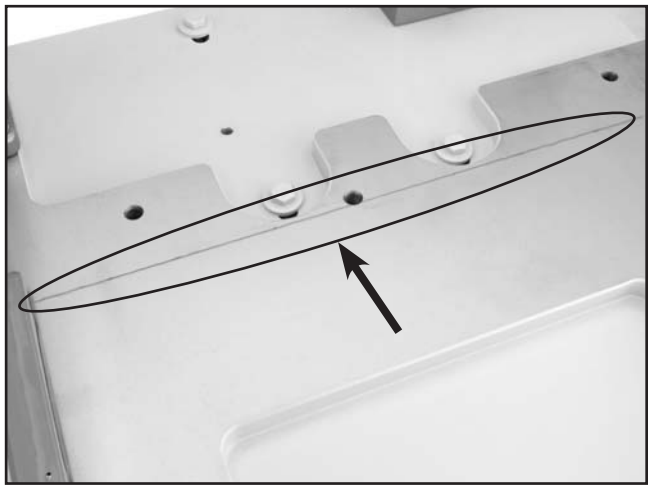


Figure 14. Scribed line in table.

To install the fence correctly:

1. Remove the hex bolt that holds the fence to the saw table.

2. Remove the second hex bolt from the saw table that is the same size as the hex bolt removed in **step 1**.

3. Attach the fence to the table with the two hex bolts, as shown in **Figure 15**, but do not tighten the bolts.

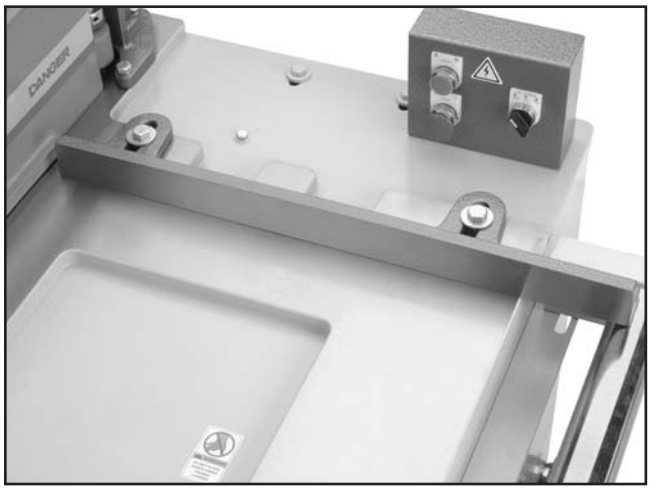


Figure 15. Fence mounted to table.

4. Align the fence with the scribed line and carefully tighten the bolts so the fence stays even with the scribed line.

Connecting/Testing Air System

The cut-off saw has an internal air system that operates the blade guard and makes the blade "jump."

At this point in the setup, the air must be connected to the cut-off saw to move the blade guard up for further adjustments.

⚠CAUTION

Working on pressurized air lines may cause an explosion, possibly blowing small fragments in your face or eyes. Always shut off and relieve the air pressure before working on air fittings.

If the quick-connect coupler on your air hose does not match the factory installed male plug, then replace it with a 3/8" NPT thread male plug that will match your coupler style.

After the connection is made and the air system is pressurized, you should test the air system for proper operation.

To connect/test the cut-off saw air system:

1. Open the front cabinet door and locate the filter/lubricator/regulator inside the cabinet (see **Figure 16**).

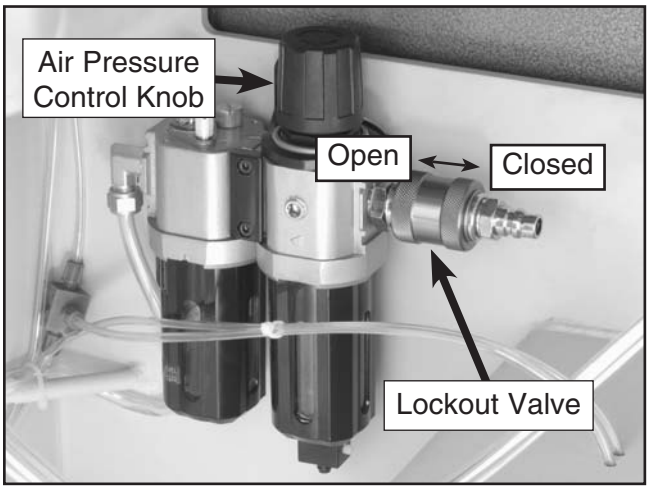


Figure 16. Filter/lubricator/regulator located inside cabinet.

2. Install a male quick-connect fitting that matches the quick-connect socket you use with your air compressor system.

3. Slide the lockout valve toward the filter/lubricator/regulator to open the air line.

4. Connect the air line to the regulator and turn on/pressurize the air line.

   —The blade guard will now move up and you will hear a "thump." This is normal.

5. Pull the pressure control knob up to unlock it, turn the knob to regulate the air pressure to 60 PSI (**Figure 17**), and push the pressure control knob down to lock it again.

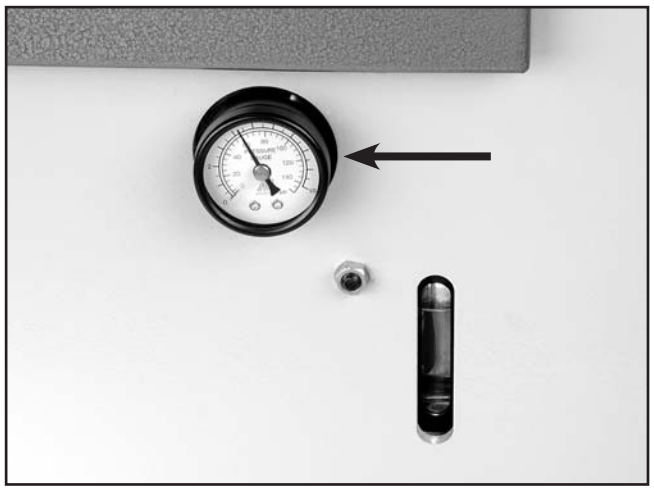


Figure 17. Air pressure regulated to 60 PSI at the gauge located on the outside of the cabinet.

NOTICE

Regulating the air pressure above 90 PSI may cause damage to the air system or regulator. DO NOT exceed 90 PSI!

6. Open the door on the left-hand side of the cabinet to view the blade.

7. Test the air system by quickly pressing and releasing the foot pedal.

   —If the guard lowers first and the blade raises second, the air system is working properly and no further tests are necessary. Proceed to **step 8**.

   —If the blade guard **does not** lower but the blade still raises, or if the blade raises before the guard lowers, then the air system is malfunctioning and the saw should not be used until it is fixed. Refer to Troubleshooting (**page 44**) in this manual or call our technical support personnel at (801) 546-9663.

8. Lock out the air system by sliding the lockout valve away from the regulator.

NOTICE

The lockout valve should remain closed until air pressure is needed. This will reduce wear and tear on the air system components.

Adjusting Roller Table Height

Tools Needed:	Qty
Straightedge (4' minimum length)	1
Wrench/Socket 13MM	1

The roller tables should be adjusted so they are even with the cast iron table. This procedure is accomplished by placing a straightedge across the cast iron table, and adjusting the mounting bracket bolts and feet until the roller table is even with the straightedge (see **Figure 18**). Usually this consists of checking and adjusting many times until the rollers are even with the saw table.

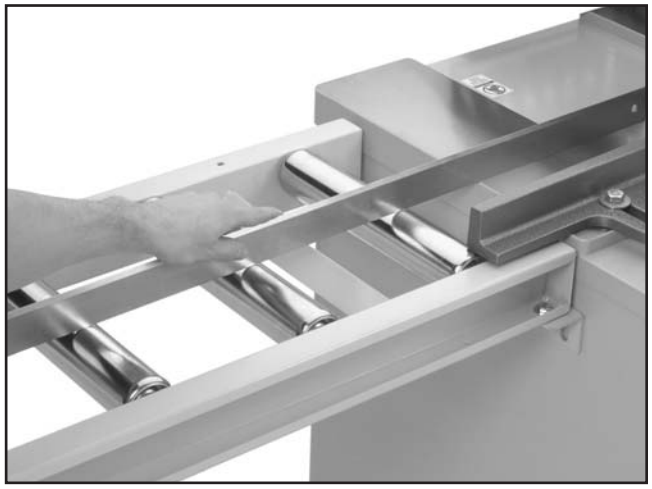


Figure 18. Using a straightedge to align the rollers even with the table.

The air must be connected to the saw to raise the blade guard so the straightedge can go across the table on the left side of the saw.

To adjust the roller table even with the table:

1. Using the straightedge as a guide, evenly adjust both sides of the mounting bracket until the roller closest to the table is even with the table, then snug the mounting bracket bolts.

2. With the straightedge partially across the table and rollers, determine if the end of the roller table needs to move up or down.

3. Evenly adjust both roller table feet in the direction determined in **step 2**.

4. Repeat **steps 2 & 3** until the roller table is even with the saw table, then proceed to **step 5**.

5. Fine tune the stand height by checking and adjusting the sides of the roller tables (see **Figure 19**) until the both sides of the rollers are even with the table.

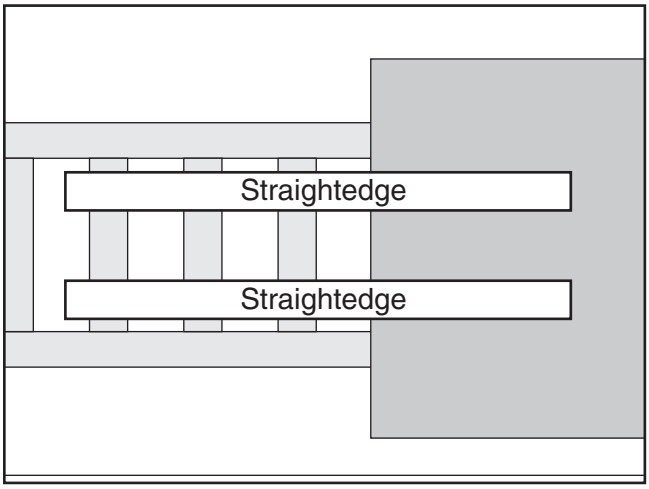


Figure 19. Straightedge positions for checking and adjusting front and back of roller table.

6. Tighten the mounting bracket bolts and the jam nuts on the feet to lock the stand height into position.

7. Repeat **steps 1–6** with the other roller table.

Safety Guard

Hardware Needed:	Qty
Safety Guard	1
Hex Bolt M12-1.75 X 75	1

Tools Needed:	Qty
Wrench/Socket 13MM	1
Wrench/Socket 19MM	2

The safety guard mounting bolts are already installed on the machine when shipped. The safety guard installation involves removing those bolts, then using them to attach the safety guard.

To install the safety guard:

1. Remove the bolts shown in **Figures 20 & 21**.

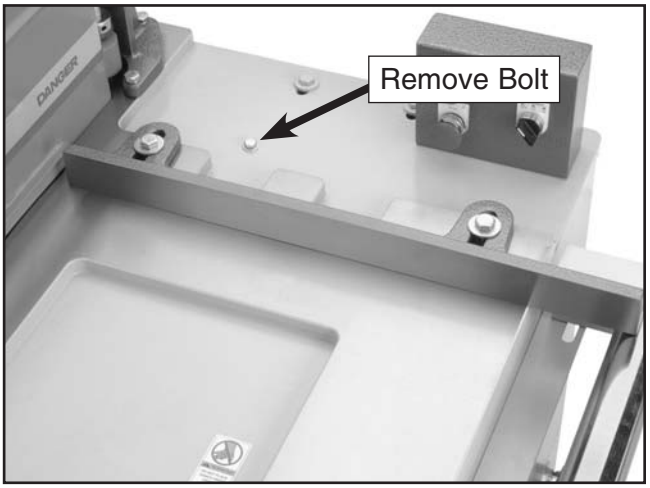


Figure 20. Bolt to be removed for safety guard.

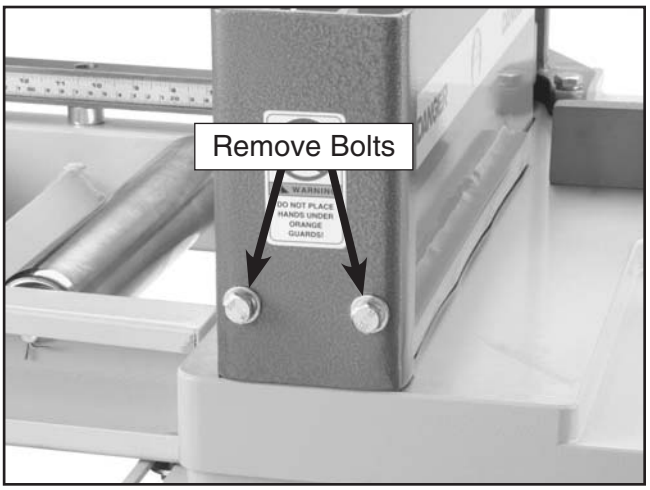


Figure 21. Bolts to be removed for safety guard.

2. Secure the safety guard to the saw with the bolts from their original locations, as shown in **Figure 22**.

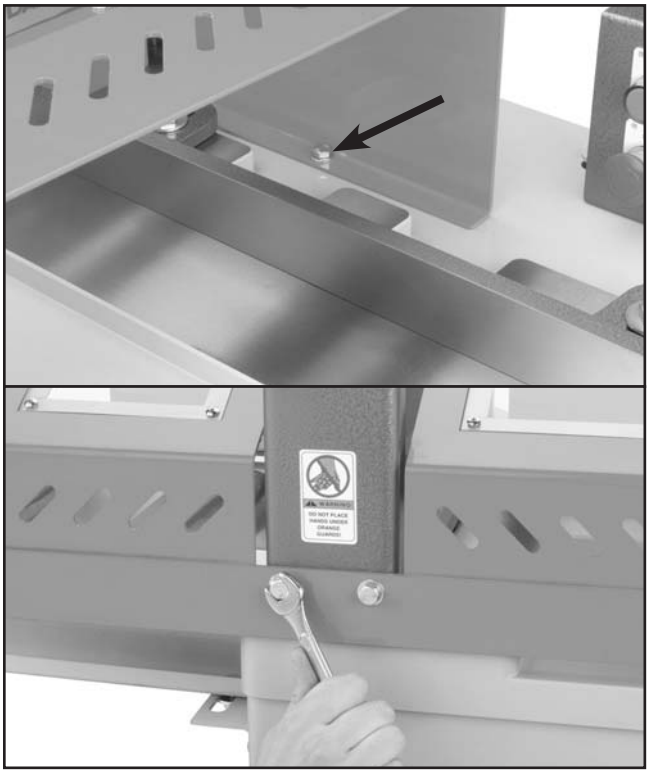


Figure 22. Installing guard with removed bolts.

3. Secure the left-hand side of the safety guard to the saw with the hex bolt through the welded bracket (see **Figure 23**).

Figure 23. Left side of safety guard secured through welded bracket.

Dust Collection

Hardware Needed:	Qty
Dust Port 4"	1
Cap Screws M6-1 x 16	3
Lock Washers 6MM	3

Tools Needed:	Qty
Hex Wrench 5MM	1

A dust port is included for connection to your dust collection system. If your dust collection consists of primarily fixed lines, we recommend using a small length of flexible hose to connect your machine to the fixed line. Note—If your existing dust line is smaller than 4", upgrade to a 4" or larger line.

The minimum airflow to properly collect dust from this machine is 550 CFM. This means the dust collection line you connect to your machine must meet this requirement at the point where the hose and the dust port connect. Note—Do not confuse this number with the rated CFM of the dust collector.

To connect the cut-off saw to a dust collection system:

1. Use the three cap screws and lock washers to secure the included dust port to the saw base (see **Figure 24**).

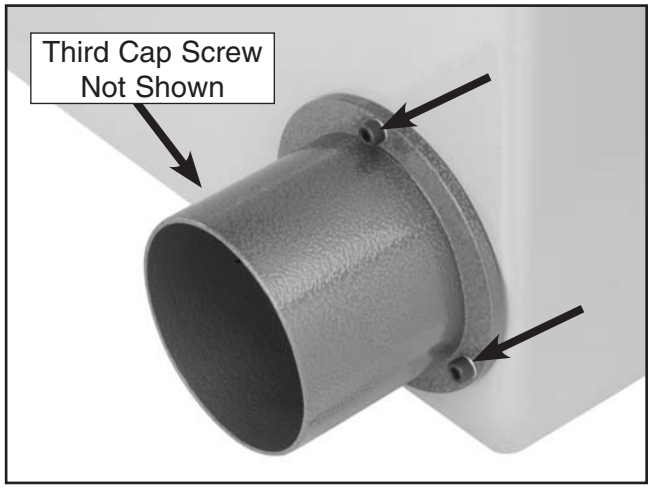


Figure 24. Dust port mounting locations.

2. Connect your dust hose to the dust port with a typical fastening method for your type of dust line.

   Note—**Figure 25** shows the dust port connected to 4" flexible hose with a hose clamp.

Figure 25. Flexible dust hose connected to dust port.

Stops

Hardware Needed: **Qty**
Fixed Stop 1
Flip Stop 1

Two different stops are included with the cut-off saw—a fixed stop (**Figure 26**) and a flip stop (**Figure 27**). Both stops fit over the rail and lock in place with two knob bolts.

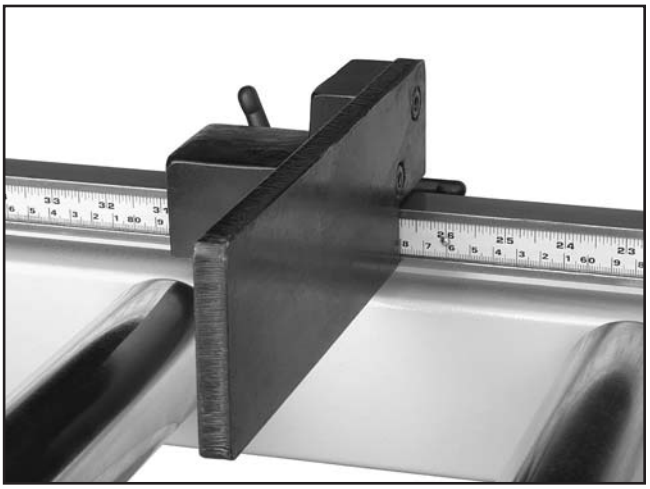


Figure 26. Fixed stop.

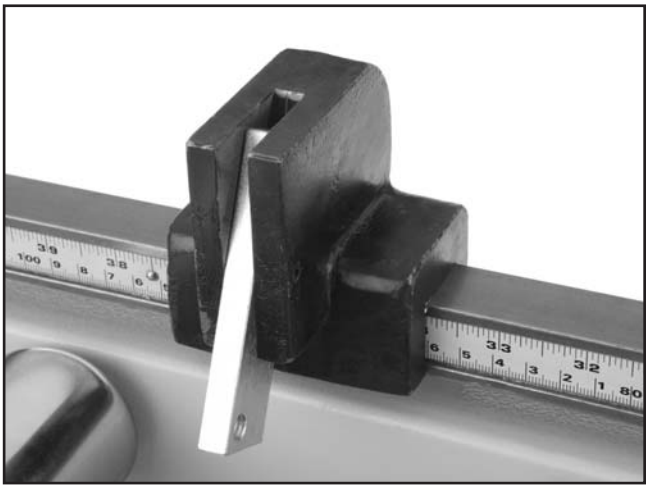


Figure 27. Flip stop.

To install stop blocks on the rails:

1. Unthread the two knob bolts on the stops.

2. Fit stop block groove over rails, and tighten in the desired position.

Power Cord

To connect a power cord to the cut-off saw:

1. Read through Section 2: Circuit Requirements to double-check that your electric circuit follows the safety and circuit requirements, and that the power cord you use meets the minimum requirements for this machine.

2. Remove the cover from the electrical wiring box.

3. Feed the cord through the strain relief, and tighten the strain relief. Note—Make sure the strain relief is tightened against the outside sleeve of the cord, not the individual wires.

4. Connect the cord wires to the main terminal (**Figure 28**) with the help of an experienced electrician.

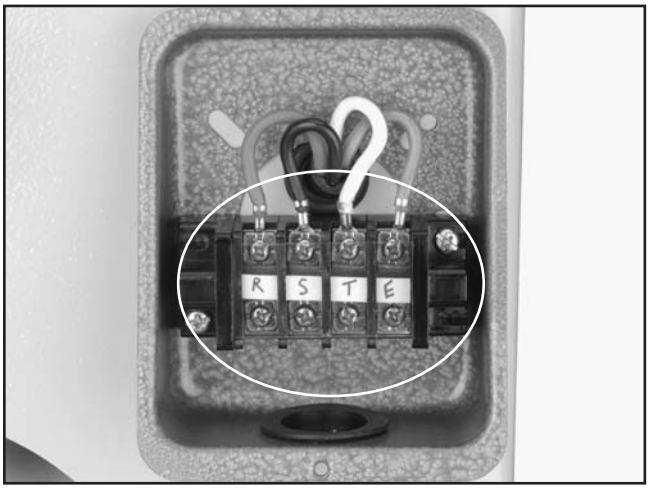


Figure 28. Main terminal located inside the electrical wiring box, on the outside of the cabinet.

5. Replace the cover on the electrical wiring box.

6. Hard wire the power cord directly to the circuit box. We recommend installing a shut off box near the machine as a way to quickly turn off power in an emergency or during maintenance and repairs.

Test Run

The purpose of the test run is to make sure the machine is wired correctly (blade spins in the correct direction) and that there are no problems before making the first cut.

Because the blade is hidden inside the cabinet and covered by the guard during the operation, the air system access door (**Figure 29**) must be briefly opened while the blade is spinning to ensure the blade is rotating in the correct direction. The correct direction of the blade rotation is toward the back of the saw and can be verified by the sticker shown in **Figure 30**.

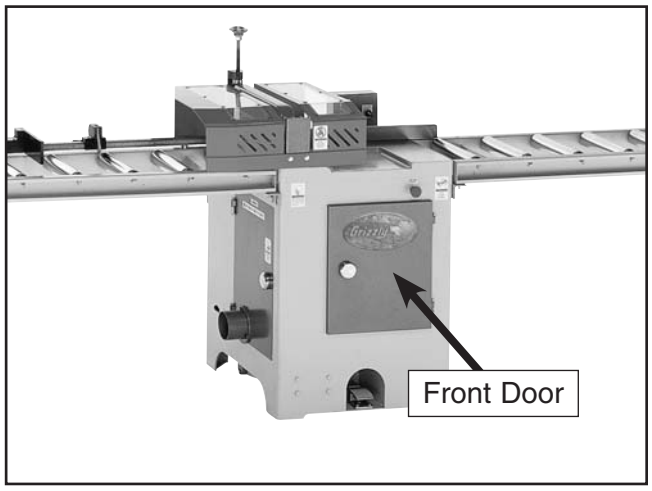


Figure 29. Identifying front door.

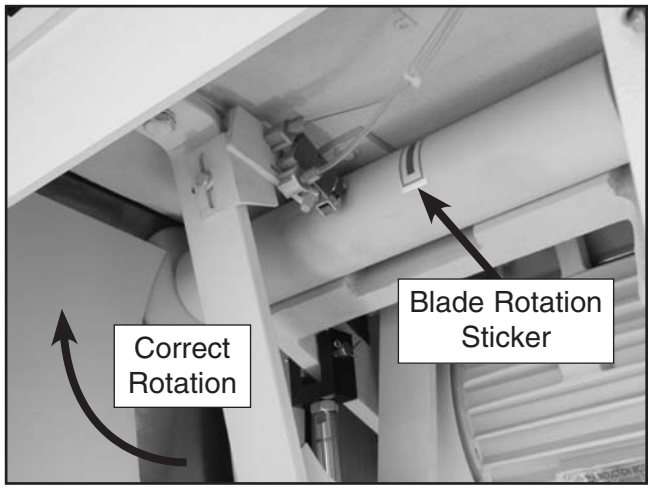


Figure 30. Checking blade rotation from front door.

To test run the saw:

1. Put on safety glasses and make sure any bystanders are out of the way and are also wearing safety glasses.

2. At the front of the control panel, rotate the red EMERGENCY STOP button until it springs up. The control panel is now live and any buttons you push will react accordingly.

3. Press the START button. The motor should start and run smoothly.

4. Press the STOP BUTTON and open the **front** door.

5. View the blade to determine which direction it is spinning, then close the front door.

   — If the blade was spinning in the correct direction, then the saw is ready for operation.

   — If the blade did not spin in the correct direction, press the red EMERGENCY STOP button and shut off the power going to the saw. Reverse any two of the current carrying wires (not the ground) at the main terminal and start again at **step 3**.

⚠WARNING

Opening the SIDE door while the motor is running directly exposes the operator to the moving blade, which could cause severe personal injury including loss of fingers. NEVER open the SIDE cabinet door while blade is spinning or the machine is connected to power!

⚠WARNING

Placing hands inside of the cabinet while the machine is connected to power, or the blade is spinning, may cause severe cutting or crushing injuries. Keep hands outside of cabinet, unless the machine has been disconnected from power and the blade is NOT spinning.

SECTION 4: OPERATIONS

Safe Operation

Your safety is important. Please review Section 1: Safety before operating this saw. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and no amount of safety instructions can replace good common sense.

⚠WARNING

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



⚠WARNING

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

NOTICE

The following section was designed to give instructions on the basic operations of this machine. However, it is in no way comprehensive of all of the machine's applications. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your machine.

Cutting

To make a cut:

1. Open the lockout valve at the air regulator and close the door, and turn the AIR POWER switch located on the control panel ON.

2. Set the stop block to the length of the desired cut and place the workpiece against it (**Figure 31**).

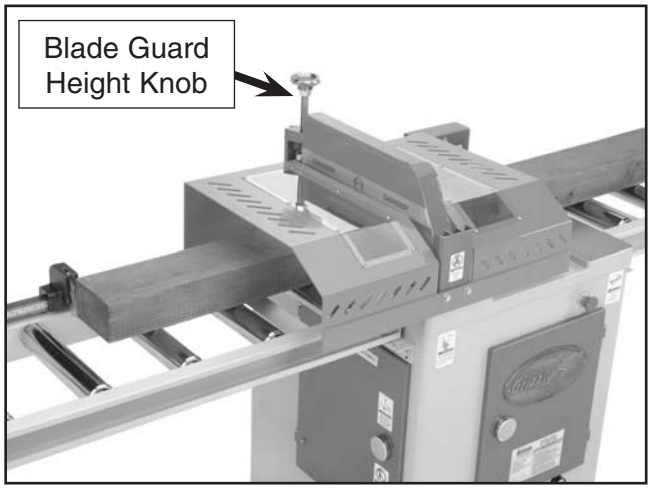


Figure 31. Workpiece prepared for cutting.

3. Using the blade guard height knob, lower the blade guard ½" above the workpiece.

4. Press the START button and allow the saw blade to reach full speed.

5. Tap the foot pedal to cycle the blade. DO NOT hold the foot pedal down—just tap it!

⚠WARNING

The clamp and cut action of the saw could easily trap your hand and cut it off without time to pull away. Never place your hands inside of the blade guard area when the saw blade is running!

Changing Blades

Tools Needed: **Qty**
Arbor Wrench 1
Wood Block (2" x 2" x 6" Long, not included) ... 1

The Model G0502 will perform best when a high quality, sharp blade is used. Therefore, whenever the blade starts to get dull, we recommend having it resharpened or replacing it with a new blade.

Replacing the blade consists of blocking it with a scrap piece of wood, removing the arbor bolt and installing the new blade.

To change the blade:

1. **Disconnect saw from the power source!**

2. Open the left side cabinet door to expose the blade, as shown in **Figure 32**.

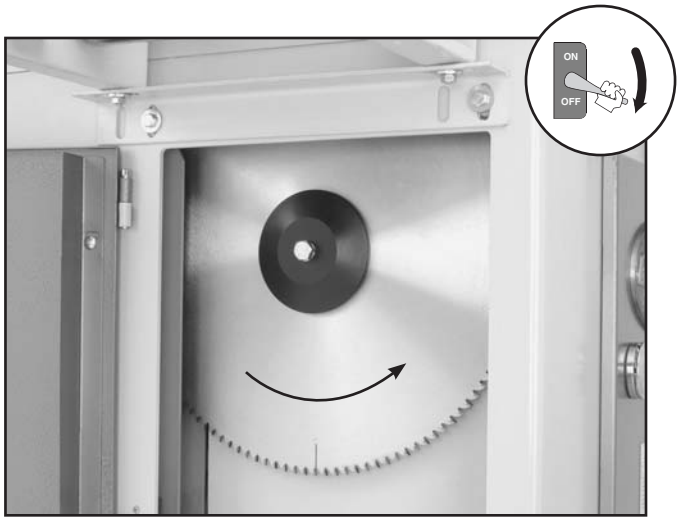


Figure 32. Cut-off saw blade.

⚠CAUTION

The saw blade is very sharp and can cause personal injury. Always wear thick leather gloves when working on or around the saw blade.

3. Pinch the wood block between the blade and the inside of the cabinet so it cannot turn counterclockwise, and remove the arbor bolt and hub. Note—The arbor bolt has right-hand threads (turn counterclockwise to loosen).

4. Note which direction the blade teeth point, then remove the blade.

5. Install the new blade so the teeth point in the correct direction, and reinstall the hub and arbor bolt.

Adjusting Feed Rate

When the foot switch is pressed and released, the blade cycles up and down. The upward stroke is the feed rate and the downward stroke is the blade return. Both of these strokes are easily adjustable and should be adjusted to the type of wood you are cutting.

As a general rule, use a slower feed rate for hardwoods and a faster feed rate for soft woods. Too fast of a feed rate will produce rough cuts and greatly diminish the life of the blade. Too slow of a feed rate will burn the wood and increase the rate of pitch build-up. Finding the right feed rate for your type of wood always requires a small amount of trial and error.

The air cylinder inside the cabinet has two valves mounted on it (see **Figure 33**) that allow the user to adjust the upward and downward strokes of the blade. Always adjust both strokes evenly, so they cycle at approximately the same speed (this will reduce cutting problems like workpiece burning or glazing).

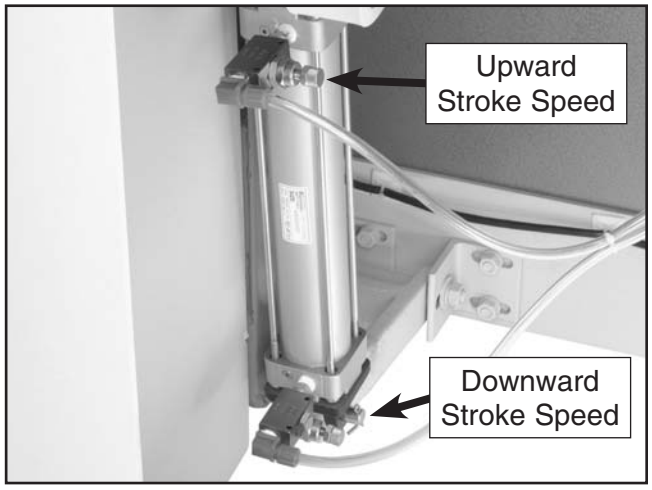
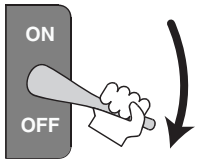


Figure 33. Air cylinder and adjustment valves.



⚠WARNING

When power is connected to the machine, it may start unexpectedly, causing serious personal injury. Always disconnect power when working inside of the cabinet.

To adjust the feet rate:

1. **Disconnect saw from the power source!**
2. Open the front cabinet door.
3. Adjust the upward stroke speed by turning the knob on the valve (counterclockwise=faster feed rate).

⚠CAUTION

The air cylinder may pinch or crush your hand if you are holding the adjustment knob and press the foot switch at the same time. Make sure all hands are outside of the cabinet when you push the foot switch during this procedure.

4. Tap the foot switch to test how the adjustment changed the upward stroke speed.
5. Repeat **step 3** until the desired upward stroke speed is established, then tighten the jam nut on the air valve knob so it does not move.
6. Adjust the downward stroke speed so it is approximately even with the upward stroke speed, then tighten the jam nut.
7. Close the cabinet door.
8. Turn on the main power switch, and make a test cut with the type of wood that will be regularly used.

   —If the feed rate is satisfactory, then you are finished adjusting the feed rate.

   —If the feed rate is not satisfactory, then repeat **steps 1–7**.

SECTION 5: ACCESSORIES

G0523—6' Roller Table Add-On
Extend one side of your cut-off saw roller table an extra six feet. Includes one pair of legs and feet, and easily mounts without drilling or tapping.

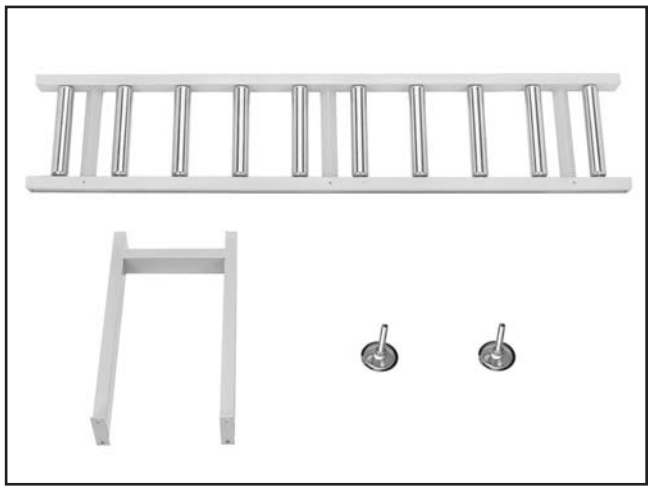


Figure 34. G0523 6' Roller Table.

G0522—6' Roller Table Add-On Pair
Extend both sides of your cut-off saw roller table an extra six feet. Includes stop block rail, legs and feet, and easily mounts without drilling or tapping.

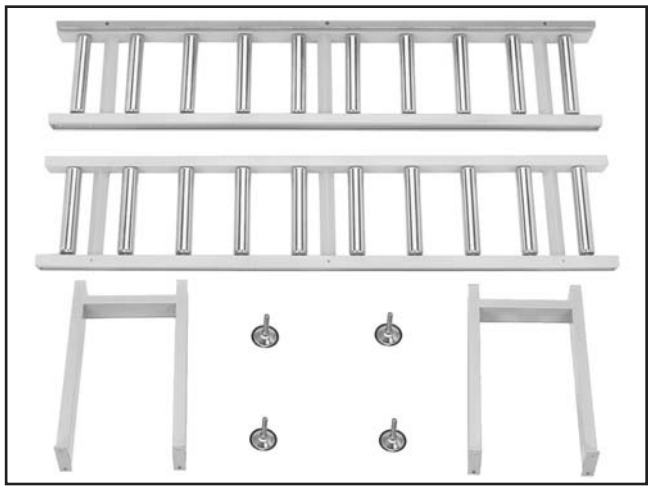


Figure 35. G0522 6' Roller Table Pair.

H3281—100 Tooth Carbide 18" Blade
H3387—120 Tooth Carbide 18" Blade

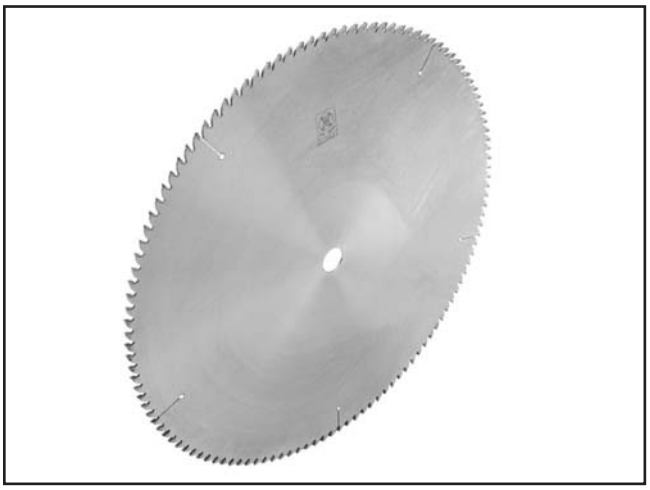


Figure 36. Model H3281 18" Blade.

P0502009-1—G0502 440V Conversion Switch
Convert your prewired 220V machine to operate on 440V. Kit includes all the electrical components needed for a successful conversion.

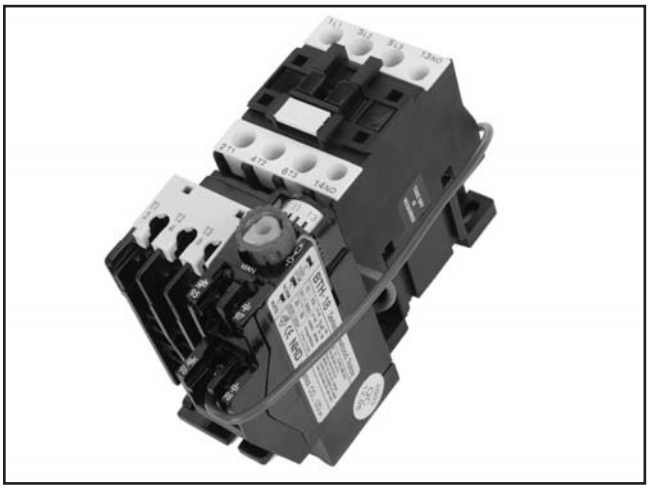


Figure 37. 440V Conversion Switch.

G7984—Face Shield
H1298—Dust Sealed Safety Glasses
H1300—UV Blocking, Clear Safety Glasses
H2347—Uvex® Spitfire Safety Glasses
H0736—Shop Fox® Safety Glasses
Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

Figure 38. Our most popular safety glasses.

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

Figure 39. Our most popular earmuffs.

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

Figure 40. Half-mask respirator and disposable cartridge filters.

G2820—Pneumatic Tool Oil 8 oz Bottle
Use the right oil! This pneumatic tool oil offers outstanding heat displacement and friction reduction without eating away at delicate air components like detergent motor oils. Stock up with extra bottles to avoid costly downtime.

Figure 41. Model G2820 Pneumatic Tool Oil.

H3788—G96® Gun Treatment 12 oz Spray
H3788—G96® Gun Treatment 4.5 oz Spray
This triple action gun treatment cleans, lubricates and protects all metal parts. Contains solvents that completely remove all traces of rust and corrosion and leaves no gummy residue.

Figure 42. G96® Gun Treatment spray.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
Used on cast iron table surfaces and other unpainted metal surfaces to reduce rust and corrosion. This product is perfect for keeping tables clean, especially during long-term storage.

Figure 43. SLIPIT® gel and spray.

G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
This ozone friendly protective spray penetrates deep and really holds up against corrosive environments. Lubricates metals for months and is safe for use on most paints, plastics, and vinyls.

Figure 44. Boeshield® T-9 spray.

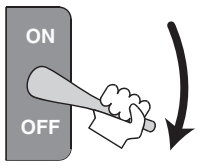
G1955—OxiSolv® Blade & Bit Cleaner
Used to clean the gummy pitch and residue from saw blades and router bits, this high quality cleaner will make blades and bits last longer while improving cutting action.

Figure 45. G1955 OxiSolv® spray.

SECTION 6: MAINTENANCE

Schedule

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



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

Daily Check:
- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance:
- Drain water in air filter collection cups.
- Check/adjust lubrication level in lubricator.
- Clean/grease hold down shaft.

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

Ball Bearings

Ball bearings in this saw are permanently sealed and lubricated. Lubrication is not necessary. If the bearing wears out, find the part number in the back of this manual and call our customer service line at (800) 523-4777 to order a new one.

Unpainted Cast Iron

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

Keep tables rust-free with regular applications of products like , G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Section 5: Accessories on **page 28** for more details).

Guide Screw

The unthreaded part of the guide screw (**Figure 46**) will become dirty and dry as the saw is used.
To maintain proper movement of the clamping blade guard, clean the unthreaded part of the guide screw with Oxisolv® (see **page 30**), wipe dry, and apply a thin coat of general purpose grease.

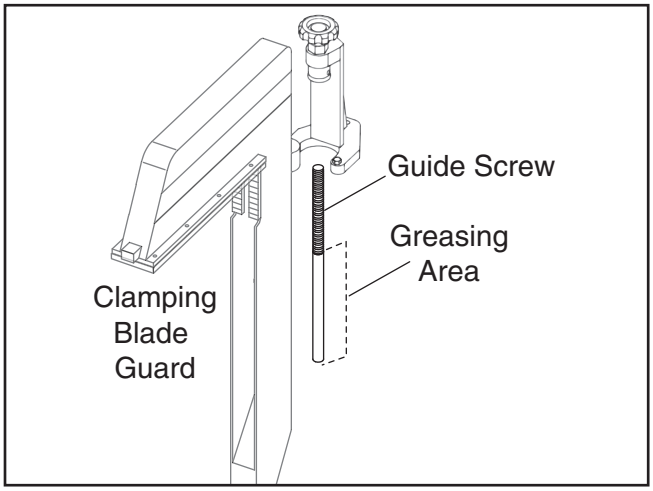


Figure 46. Guide screw greasing area.

Air System Maintenance

The filter/lubricator/regulator is the centerpiece of the air system in the cut-off saw. From this unit you can regulate the air pressure coming into the air lines, lock out the air pressure entirely, adjust the rate of automatic lubrication, refill the system lubricant, and drain the water from the air filter water reservoir.

Use the schedule on page 31 with the list below and the photo in Figure 47 to perform the air system maintenance:

- **Lubrication Fill Cap**—Remove this cap to refill the lubrication reservoir with pneumatic tool oil only.
- **Pressure Control Knob**—Pull the knob up to unlock for adjustments; push the knob down to lock.
- **Lubrication Rate Control Knob**—The lubricator is factory set to provide one drop of lubrication for every 4–8 blade cycles. Turn clockwise to decrease and counterclockwise to increase the lubrication rate. Notice—Stopping the lubrication rate will lead to premature air system failure.
- **Lockout Valve**—Slide away from filter/lubricator/regulator to stop air pressure.
- **Air Filter Water Reservoir**—Monitor the water level and empty with the drain valve before full. Only clean with warm soapy water because the plastic may become clouded if you use solvents.
- **Lubrication Reservoir**—Monitor this level; refill with pneumatic tool oil before it is empty.
- **Drain Valve**—Press in the valve stem to drain the water reservoir.

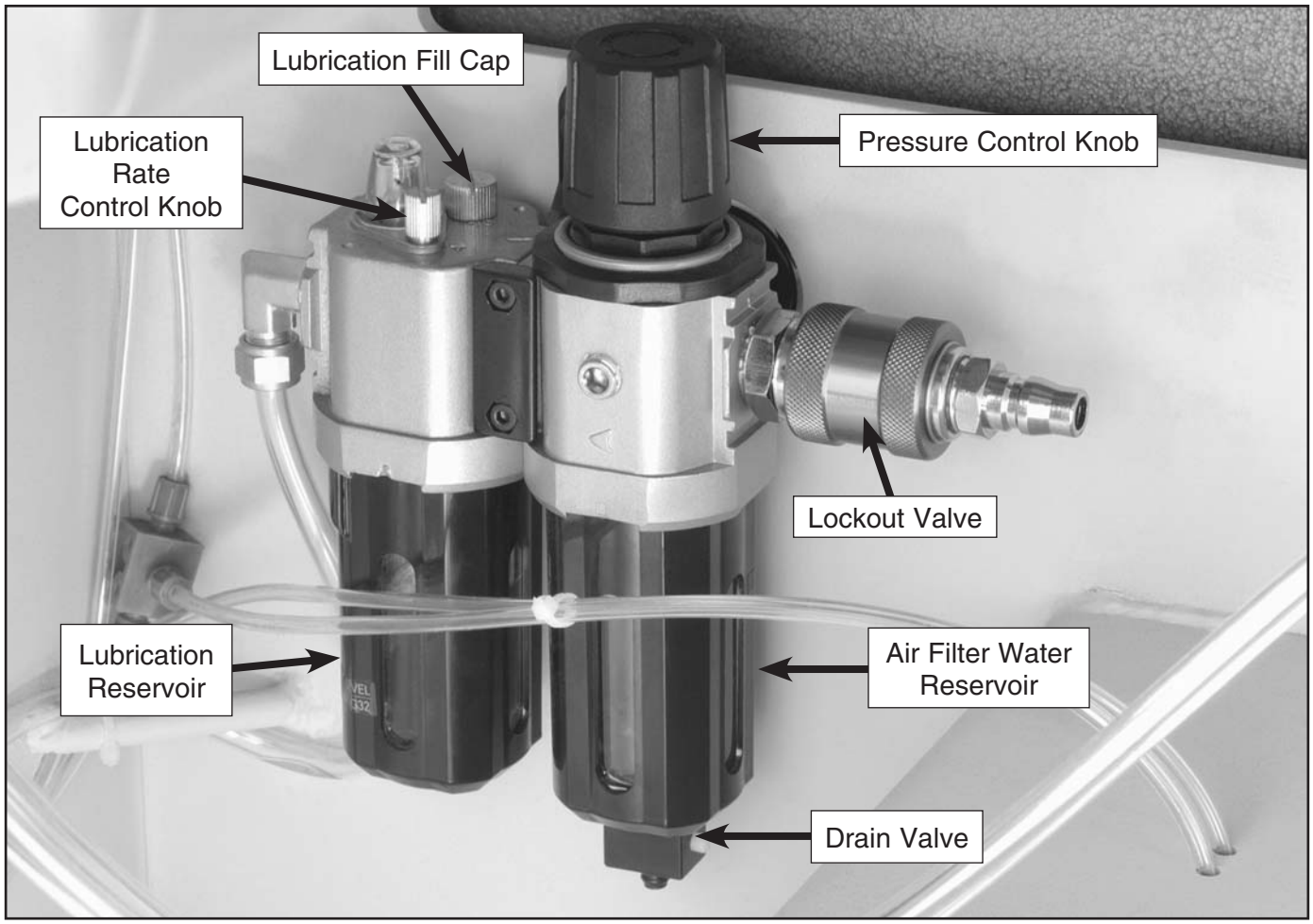


Figure 47. Filter/Lubricator/Regulator for cut-off saw air system.

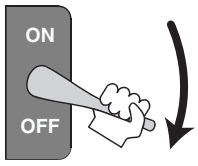
Maintenance Log

Date	Approximate Hours Of Use	Maintenance Performed

SECTION 7: SERVICE

About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.



⚠WARNING

Always disconnect power to the machine before performing service adjustments. Failure to do this may result in serious personal injury.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Tightening V-Belts

Tools Needed:	**Qty**
Wrench/Socket 17MM	2
Phillips Head Screwdriver	1
Assistant (not included)	1

The V-belts are tightened by sliding the motor backward on the motor mount. This procedure is easier if done with the help of an assistant.

To tighten the V-belts:

1. **Disconnect saw from the power source!**

2. Remove the cover from the back of the cabinet.

3. Loosen the motor mount bolts shown in **Figure 48**.

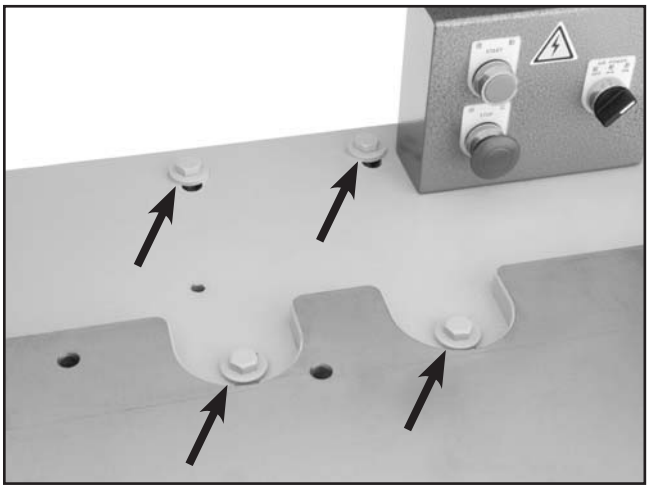


Figure 48. Motor mount bolts.

4. Slide the motor toward the back of the saw, hold tension on the motor, and tighten the motor mount bolts.

5. Replace the cover from the back of the cabinet.

Adjusting Blade Release Switch

Tools Needed: **Qty**
Hex Wrench 4MM 1

The blade release switch (**Figure 49**) signals the air system to lower the blade and raise the guard during a normal cycle. A normal cycle starts with tapping the pedal—not holding it down—then the guard moves down and the blade up.

If, after a normal cycle, the blade stays up and the guard stays down, the blade release switch may not be positioned correctly. In most cases, adjusting the position of this switch will fix the problem.

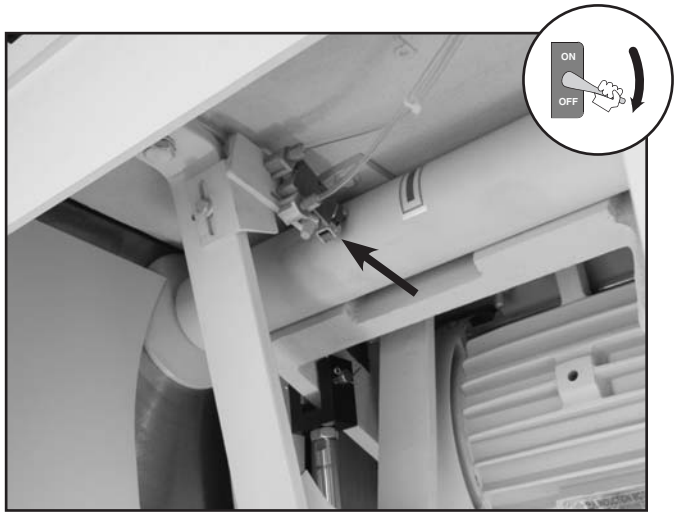


Figure 49. Blade release switch.

To adjust the blade release switch:

1. **Disconnect the saw from the power source and air compressor (see page 32**).

2. Loosen the cap screw that holds the blade release switch, adjust the switch backwards slightly, then retighten the cap screw and close the door.

3. Connect air/power and test the blade cycle.

   —Repeat **steps 1–3** until the blade guard no longer sticks in the down position during normal operation.

Squaring Fence to Blade (w/o Scribe)

Tools Needed: **Qty**
Square (not included) 1
Wrench/Socket 19MM 1
Piece of 2x4 approximately 6" long 1

The fence must be perpendicular to the blade to ensure square cuts. If the scribe line on the table is not perpendicular to the blade, you can square the fence as described in this procedure.

This procedure involves blocking the blade guard open and raising the blade with the foot pedal to place the square on the fence and blade for adjustments (see **Figure 50**).

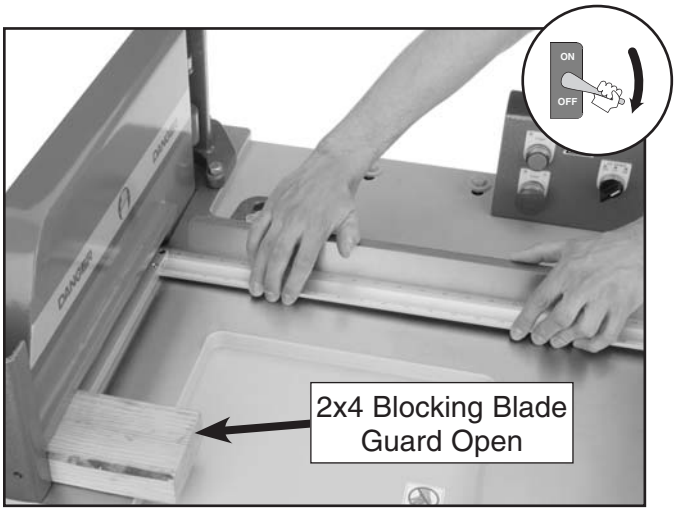
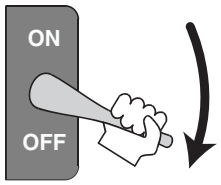


Figure 50. Adjusting fence perpendicular to the blade.

Continued on next page ⟶



⚠WARNING
This is an extremely dangerous procedure if attempted with power connected to the saw. DO NOT perform this procedure with the saw connected to power!

To square the fence to the blade:

1. **Disconnect saw from the power source!**
2. Position a 6" tall block of wood under the blade guard but out of the blade path. (A 6" long piece of 2x4 works great for this.)
3. Loosen the fence mounting bolts.
4. Press and hold the foot pedal to raise the blade up.

   —The block of wood should prevent the blade guard from covering the blade so you have clear access to the non-spinning blade.
5. Using the square as a guide, position the fence so it is perpendicular to the blade.
6. Tighten the fence bolts, and recheck the fence position to make sure that it did not move during tightening.

Changing V-Belts

Tools Needed:	**Qty**
Wrench/Socket 17MM	2
Phillips Head Screwdriver	1
Assistant (not included)	1

Replacing the V-belts involves sliding the motor forward to detension the belts, then rolling the V-belts off the pulleys and rolling the new V-belts on. This procedure is easier if done with the help of an assistant.

To tighten the V-belts:

1. **Disconnect saw from the power source!**
2. Remove the cover from the back of the cabinet.
3. Loosen the motor mount bolts shown in **Figure 51**.

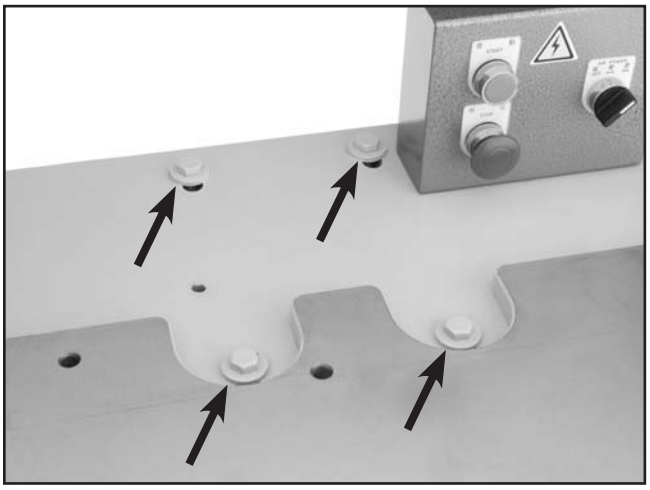


Figure 51. Motor mount bolts.

4. Slide the motor toward the front of the saw as far as it will go.
5. Roll the old V-belts off of the pulleys, and roll the new V-belts onto the pulleys.
6. Tension the V-belt as described on **page 34**.

440V Conversion

The Model G0502 can be rewired for 440V 3-phase operation. This rewiring job consists of disconnecting the cut-off saw from the power source, installing the 440V conversion switch (**Figure 52**), and rewiring the motor.

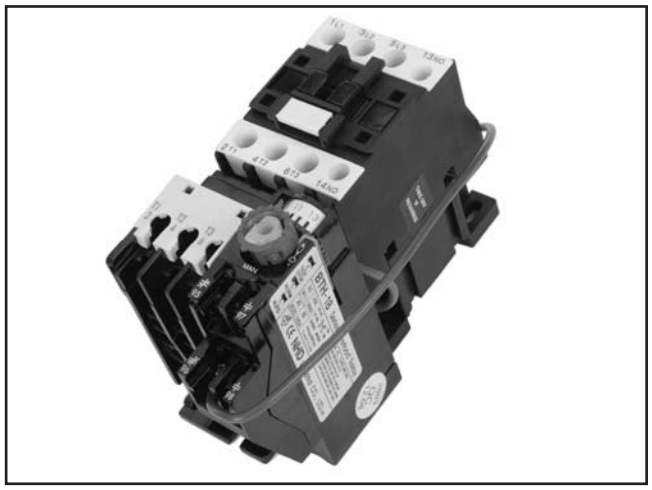


Figure 52. 440V Conversion Switch.

Order the Model G0502 440V Conversion Switch (P/N P0502009-1) by calling our customer service number at (800) 523-4777.

This procedure takes moderate electrical skill and the rewiring job must be inspected by a licensed electrician before the saw is connected to the power source.

To rewire the Model G0502 to 440V 3-Phase:

1. **Disconnect saw from the power source!**

2. Open the electrical box.

3. Remove the 220V magnetic switch from inside the switch box (**Figure 53**) and replace it with the 440V conversion switch.

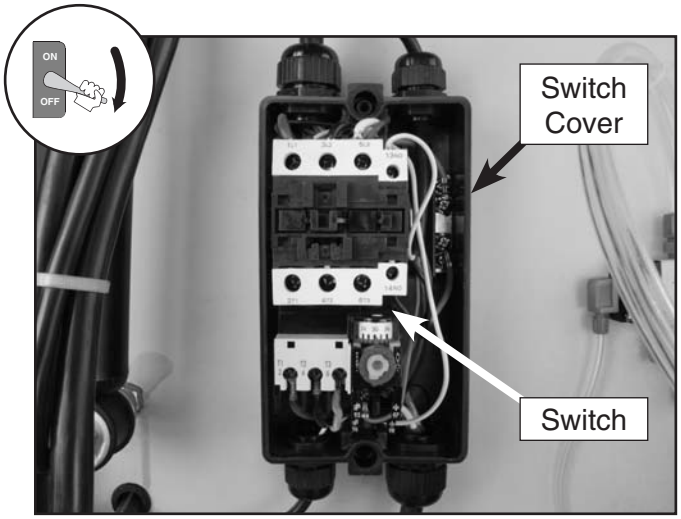


Figure 53. Magnetic switch inside the switch box.

4. Wire the motor as shown on the diagrams on the inside of the motor wire cover. Note—**Figure 54** below has been provided for your reference and was current at the time that this manual was written. However, always use the diagram on the wire cover that comes with your motor!

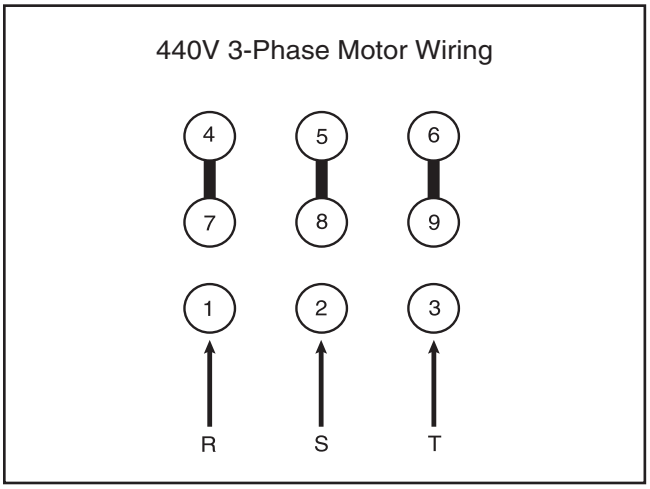
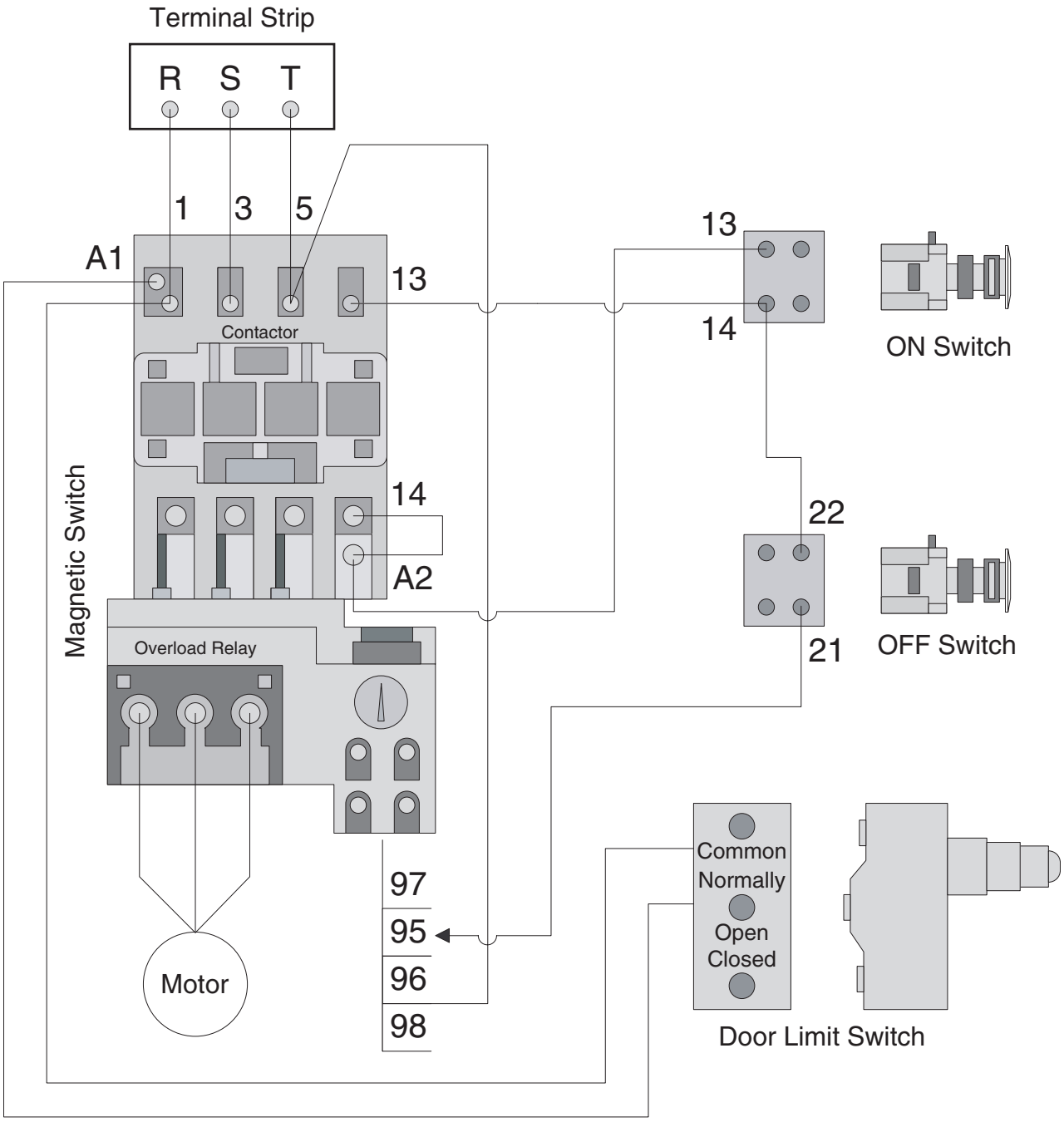
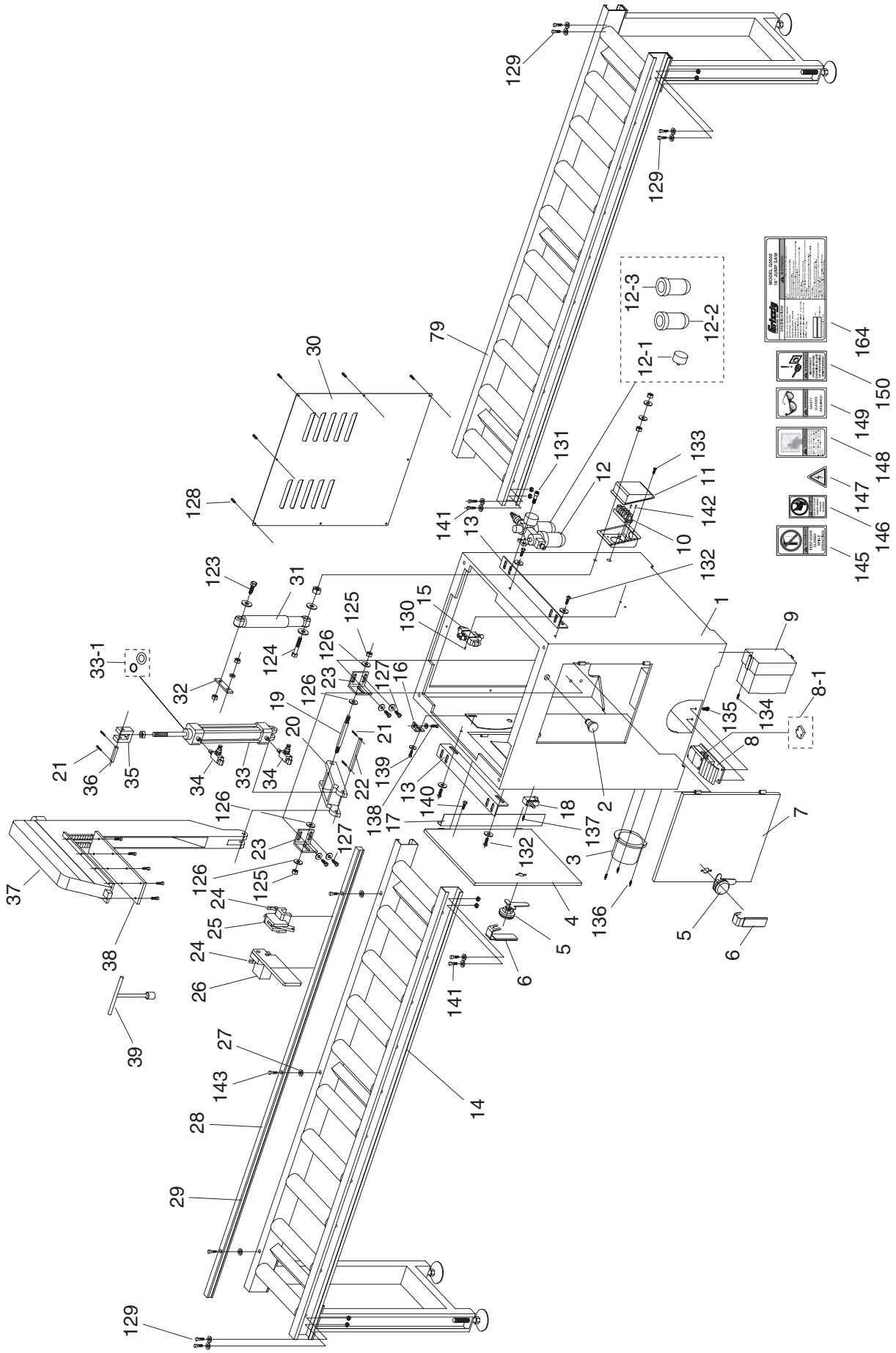


Figure 54. 440V motor wiring chart.

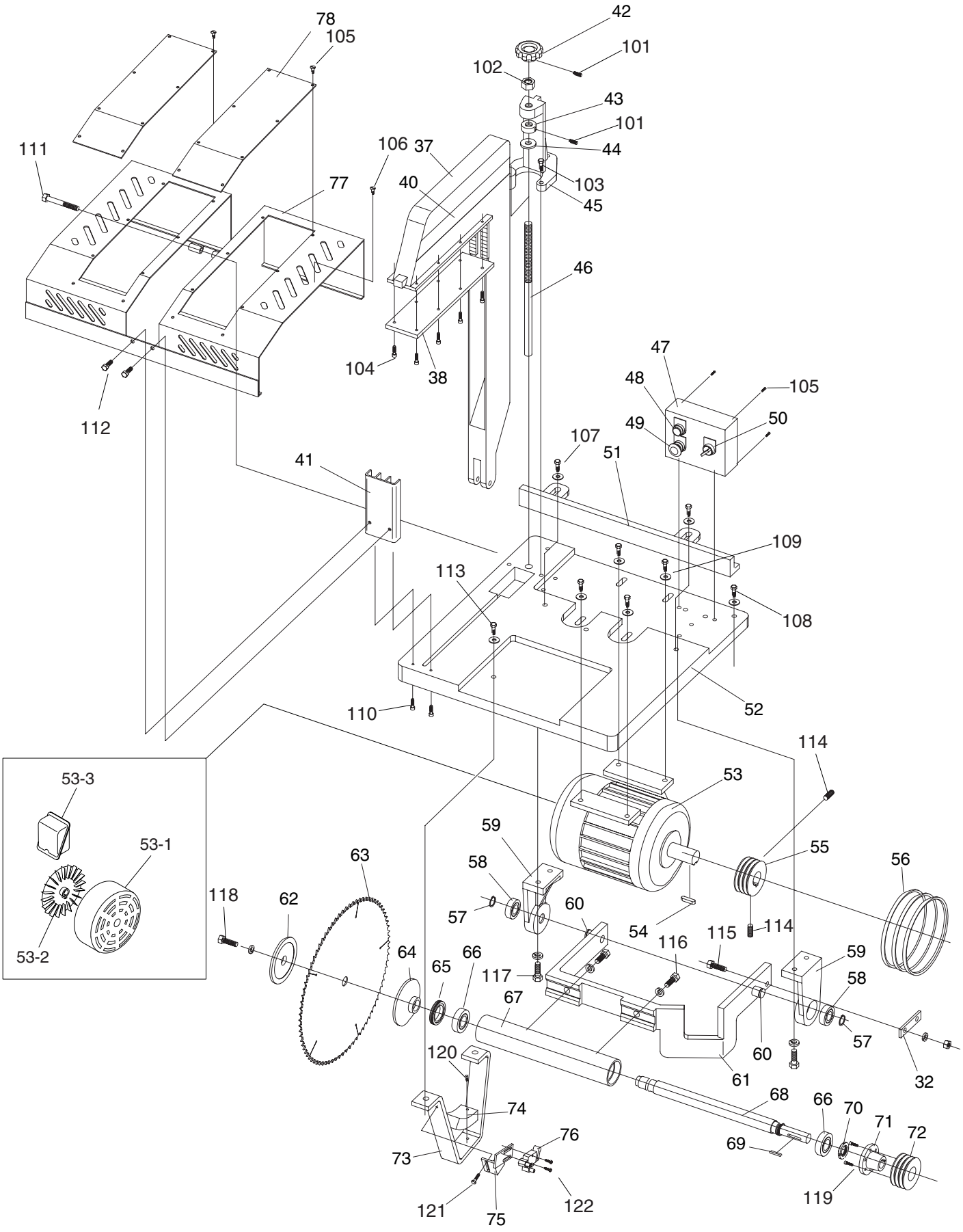
G0502 Wiring Diagram



G0502 Parts Breakdown



G0502



G0502

REF	PART #	DESCRIPTION
1	P0502001	CABINET
2	P0502002	EMERGENCY STOP SWITCH
3	P0502003	DUST PORT
4	P0502004	SIDE DOOR
5	P0502005	DOOR LOCK
6	P0502006	DOOR HANDLE KEY
7	P0502007	FRONT DOOR
8	P0502008	PEDAL UNIT
8-1	P0502008-1	PEDAL CONTROLLER S3B-M5
9	P0502009	SWITCH NHD MS-35D 220V 30A
9-1	P0502009-1	440V CONVERSION KIT
10	P0502010	WIRE CONNECTING PLATE
11	P0502011	ELECTRICAL BOX
12	P0502012	FILTER/LUBE/REGULATOR
12-1	P0502012-1	GAUGE
12-2	P0502012-2	OIL CUP
12-3	P0502012-3	WATER CUP
13	P0502013	MOUNTING BRACKET
14	P0502014	LEFT ROLLER TABLE
15	P0502015	SOLENOID VALVE
15-1	P0502015-1	MALE ELBOW 1/8PT X 4MM
15-2	P0502015-2	AIR FITTING 1/8PT X 4MM HOSE
15-3	P0502015-3	MUFFLER 1/8PT
15-4	P0502015-4	T-ELBOW NPT 1/4 X 1/8 X 1/8
16	P0502016	BRACKET
17	P0502017	LIMIT SWITCH STOP
18	P0502018	DOOR LIMIT SWITCH
19	P0502019	STUD 5/8-11 X 5/8
20	P0502020	SUPPORT FRAME
21	PRP69M	ROLL PIN 3 X 35MM
22	P0502022	COUPLING 1/2 X 5-1/2
23	P0502023	SUPPORT ANGLE STEEL
24	P0502024	LOCK LEVER M8-1.25 X 20
25	P0502025	QUICK STOP
26	P0502026	FIXED STOP
27	P0502027	SQUARE SPACER
28	P0502028	SQUARE RAIL
29	P0502029	SCALE
30	P0502030	BACK DOOR
31	P0502031	CUSHION
32	P0502032	CONNECTING LINK
33	P0502033	AIR CYLINDER
33-1	P0502033-1	SEAL KIT (2 PCS)
34	P0502034	PRESSURE REG VALVE
35	P0502035	ROD END CLEVIS
36	P0502036	CLEVIS PIN 1/2 X 2

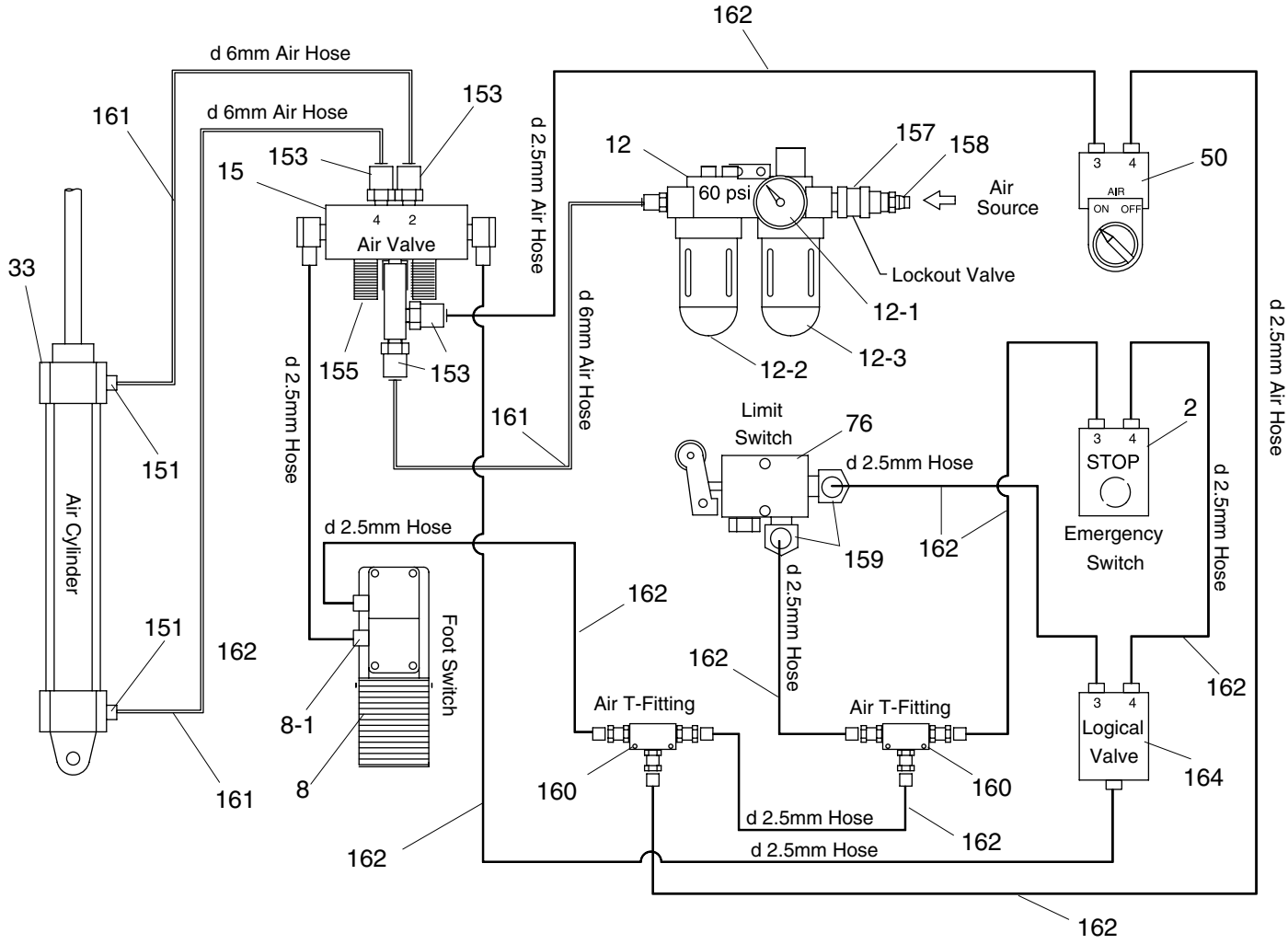
REF	PART #	DESCRIPTION
37	P0502037	CLAMPING BLADE GUARD
38	P0502038	RUBBER PLATE
39	P0502039	SOCKET WRENCH 19MM
40	P0502040	CLAMP GUARD DANGER LABEL
41	P0502041	BRACKET
42	P0502042	FEMALE KNOB 3/4-10
43	P0502043	LOCK COLLAR 3/4-10
44	P0502044	RUBBER RING
45	P0502045	ADJUSTABLE SEAT
46	P0502046	GUIDE SCREW 3/4-10 X 15-3/4
47	P0502047	SWITCH BOX
48	P0502048	ON BUTTON
49	P0502049	STOP BUTTON
50	P0502050	AIR INLET SWITCH
51	P0502051	FENCE
52	P0502052	TABLE
53	P0502053	MOTOR, 10 HP 220/440 3-PHASE
53-1	P0524111-1	MOTOR COVER
53-2	P0524111-2	MOTOR FAN
53-3	P0524111-3	MOTOR WIRE COVER
54	PK85M	KEY 10 X 8 X 40
55	P0502055	3 GROOVE MOTOR PULLEY
56	PVM33	V-BELT 3L330
57	PR11M	EXT RETAINING RING 25MM
58	P6205	BEARING 6205ZZ
59	P0502059	BRACKET
60	P0502060	SHAFT
61	P0502061	SUSPENSION BRACKET
62	P0502062	ARBOR FLANGE (OUTSIDE)
63	P0502063	18” SAW BLADE
64	P0502064	ARBOR FLANGE (INSIDE)
65	P0502065	SPANNER LOCK NUT 2-7/16-16
66	P6206	BEARING 6206
67	P0502067	QUILL
68	P0502068	MAIN SPINDLE
69	PK17	KEY 1/4 X 1/4 X 1-9/16
70	P0502070	SPANNER LOCK NUT 13⁄16-16LH
71	P0502071	TAPPER FLANGE
72	P0502072	3 GROOVE DRIVE PULLEY
73	P0502073	LOWER BRACKET
74	P0502074	LOWER DAMPER
75	P0502075	LIMIT SWITCH BRACKET
76	P0502076	BLADE RELEASE LIMIT SWITCH
77	P0502077	SAFETY GUARD
78	P0502078	ACRYLIC PLATE
79	P0502079	RIGHT ROLLER TABLE

G0502

REF	PART #	DESCRIPTION
101	PSS16M	SETSCREW M8-1.25 X 10
102	PN17	HEX NUT 3/4-10
103-1	PB31M	HEX BOLT M10-1.5 X 40
103-2	PLW06M	LOCK WASHER 10MM
103-3	PW04M	FLAT WASHER 10MM
104	PS14M	FLAT HD SCR M6-1.0 X 12
105	PS38M	PHLP HD SCR M4-0.7 X 10
106-1	PB09M	HEX BOLT M8-1.25 X 20
106-2	PLW04M	LOCK WASHER 8MM
107-1	PB68M	HEX BOLT M12-1.75 X 30
107-2	PW06M	FLAT WASHER 12MM
108-1	PB09M	HEX BOLT M8-1.25 X 20
108-2	PLW04M	LOCK WASHER 8MM
108-3	PW01M	FLAT WASHER 8MM
109-1	PB120M	HEX BOLT M10-1.5 X 65
109-2	PLW06M	LOCK WASHER 10MM
109-3	PW04M	FLAT WASHER 10MM
109-4	PN02M	HEX NUT M10-1.5
110	PSB02M	CAP SCREW M6-1.0 X 20
111	P0502111	HEX BOLT 1/2-12 X 4-1/4
112-1	PB09M	HEX BOLT M8-1.25 X 20
112-2	PLW04M	LOCK WASHER 8MM
112-3	PW01M	FLAT WASHER 8MM
113-1	PB101M	HEX BOLT M12-1.75 X 40
113-2	PLW05M	LOCK WASHER 12MM
114	PSS01M	SETSCREW M6-1.0 X 10
115-1	PB101M	HEX BOLT M12-1.75 X 40
115-2	PLW05M	LOCK WASHER 12MM
115-3	PB35M	HEX NUT M12-1.75
116-1	PB33M	HEX BOLT M12-1.75 X 50
116-2	PLW05M	LOCK WASHER 12MM
116-3	PW06M	WASHER 12MM
117-1	PB31M	HEX BOLT M10-1.5 X 40
117-2	PLW06M	LOCK WASHER 10MM
118-1	PB44	HEX BOLT 1/2-12 X 20
118-2	PLW07	LOCK WASHER 1/2”
119-1	PB10M	HEX BOLT M6-1.0 X 25
119-2	PLW03M	LOCK WASHER 6MM
120-1	PB47M	HEX BOLT M6-1.0 X 40
120-2	PW03M	WASHER 6MM
120-3	PN01M	HEX NUT M6-1.0
121-1	PB08M	HEX BOLT M6-1 X 20
121-2	PLW03M	LOCK WASHER 6MM
121-3	PW03M	WASHER 6MM
122	PSB15M	CAP SCREW M5-0.8 X 20
123-1	PB33M	HEX BOLT M12-1.75 X 50
123-2	PLW05M	LOCK WASHER 12MM
123-3	PW06M	FLAT WASHER 12MM
123-4	PN09M	HEX NUT M12-1.75
124-1	PB92	HEX BOLT 1/2-12 X 3-1/2

REF	PART #	DESCRIPTION
124-2	PLW07	LOCK WASHER 1/2”
124-3	PW01	FLAT WASHER 1/2”
124-4	PN06	HEX NUT 1/2-12
125	PN24M	HEX NUT M12-1.75
126	PW06M	FLAT WASHER 12MM
127-1	PB32M	HEX BOLT M10-1.5 X 25
127-2	PLW06M	LOCK WASHER 10MM
127-3	PW04M	FLAT WASHER 10MM
128	PS68M	PHLP HD SCR M6-1.0 X 10
129-1	PB07M	HEX BOLT M8-1.25 X 25
129-2	PLW04M	LOCK WASHER 8MM
129-3	PW01M	FLAT WASHER 8MM
130-1	PS16	PHLP HD SCR 6-32 X 1-1/4
130-2	PN12	HEX NUT 6-32
131	PSB02M	CAP SCREW M6-1.0 X 20
132-1	PB09M	HEX BOLT M8-1.25 X 20
132-2	PW01M	FLAT WASHER 8MM
133	PB87	HEX BOLT 3/16-24 X 10
134-1	PSB02M	CAP SCREW M6-1.0 X 20
134-2	PN01M	HEX NUT M6-1.0
135-1	PB83M	HEX BOLT M6-1.0 X 16
135-2	PLW03M	LOCK WASHER 6MM
136	PSB01M	CAP SCREW M6-1.0 X 16
137-1	PS16	PHLP HD SCR 6-32 X 1-1/4
137-2	PN12	HEX NUT 6-32
138-1	PB09M	HEX BOLT M8-1.0 X 20
138-2	PLW04M	LOCK WASHER 8MM
138-3	PW01M	FLAT WASHER 8MM
139-1	PB83M	HEX BOLT M6-1.0 X 16
139-2	PB83M	LOCK WASHER 6MM
139-3	PW03M	FLAT WASHER 6MM
139-4	PN01M	HEX NUT M6-1.0
140-1	PSB04M	CAP SCREW M6-1.0 X 10
140-2	PLW03M	LOCK WASHER 6MM
140-3	PW03M	WASHER 6MM
140-4	PN01M	HEX NUT M6-1.0
141-1	PB07M	HEX BOLT M8-1.25 X 25
141-2	PW01M	FLAT WASHER 8MM
141-3	PN03M	HEX NUT M8-1.25
142	PB03	PHILLIP HEAD SCREW 5/16 X 25
143-1	PSB13M	CAP SCREW M8-1.25 X 30
143-2	PLW04M	LOCK WASHER 8MM
143-3	PN03M	HEX NUT M8-1.25
145	PLABEL-30	DOOR CLOSED LABEL
146	P0502146	HAND/BLADE GUARD LABEL
147	PLABEL-14	ELECTRICITY LABEL
148	PLABEL-12	READ MANUAL LABEL
149	PLABEL-11	SAFETY GLASSES LABEL
150	PLABEL-36	UNPLUG LABEL
164	P0502164	MACHINE ID/WARNING LABEL

G0502 Air System



REF	PART #	DESCRIPTION
151	P0502151	AIR ELBOW (M) 1/4PT X 8MM
152	P0502152	AIR FITTING (M) 1/8PT X 8MM
153	P0502153	AIR ELBOW (M) 1/8PT X 4MM
154	P0502154	T-FITTING 1/8PT(M) X 1/8(F) X 1/8(F)
155	P0502155	AIR MUFFLER (M) 1/8PT
156	P0502156	AIR ELBOW (M) 3/8PT X 8MM
157	P0502157	AIR STOP VALVE (M) 3/8PT X 3/8
158	P0502158	AIR COUPLER (M) 3/8PT
159	P0502159	AIR FITTING (M) 1/8PT X 4MM
160	P0502160	TUBE FITTING UNION-T X 4MM
161	P0502161	AIR HOSE DIA. 6MM X DIA. 8MM
162	P0502162	AIR HOSE 2.5MM X 4MM
163	P0502163	AIR MUFFLER MALE 1/8PT
164	P0502164	LOGICAL VALVE

Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug.	1. Repair or replace cord or plug for damaged insulation and shorted wires.
Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).	1. Power line overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long. 3. General overloading of power company facilities.	1. Reduce load on power line. 2. Increase wire sizes or reduce length of the circuit. 3. Request a power check from the power company.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Main blade runs backwards.	1. Two of the power wires are reversed.	1. Switch two of the current carrying wires at the terminal strip.
Blade slows when cutting. Blade makes a squealing noise, especially on start-up.	1. V-belt loose. 2. V-belt worn out.	1. Tighten V-belt (**page 34**). 2. Replace V-belt (**page 36**).
Loud repetitious noise coming from machine.	1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective.	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belts (**page 36**).
Vibration when running or cutting.	1. Loose or damaged blade. 2. Worn arbor bearings.	1. Tighten or replace blade. 2. Check/replace arbor bearings.

Troubleshooting

Symptom	Possible Cause	Possible Solution
Blade cycles too slow—can't adjust (if already maxed out).	1. Low air pressure. 2. No lubrication in air system. 3. Guide screw dry/dirty. 4. Compressor too small or too far away. 5. Air leak in system. 6. Air cylinder worn out or damaged.	1. Increase air pressure. 2. Add lubrication to the lubricator cup (see **page 32**). 3. Clean/lubricate the guide screw (**page 31**). 4. Connect to a bigger air compressor, or move air compressor closer. 5. Refer to troubleshooting symptom "Air Leaks from air system components". 6. Repair cylinder with seal kit (part#P0502033-1), or replace entire cylinder (part#P0502033).
Wood cuts slow or smokes during cut.	1. Worn or dull blade. 2. Blade installed backwards. 3. Blade spinning backwards due to reversed wires at terminal strip.	1. Replace blade (see **page 26**). 2. Check blade rotation as described in "Test Run" on **page 24** and reverse blade if necessary. 3. Switch two of the current carrying wires at the terminal strip.
Rough or poor quality cuts.	1. Feed rate set too high.	1. Reduce feed rate (see **page 27**).
Sawdust buildup inside cabinet.	1. Clogged dust port. 2. Low CFM (airflow) from dust collection system.	1. Clean out dust port. 2. Three options: —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a stronger dust collector.
Air leaks from air system components.	1. Air pressure has been left on for long periods of inactive machine use. 2. Air pressure has been turned up too high. 3. Normal wear.	1. Replace/repair leaking component and develop a habit of locking out air when saw is not being used for long periods. 2. Replace/repair leaking component and don't turn air up beyond 90 PSI. 3. Replace or repair component.

WARRANTY & RETURNS

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

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

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

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

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

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

WARRANTY CARD

Name_____

Street_____

City _____ State_____Zip_____

Phone Number_____E-Mail_____FAX_____

MODEL #_____**Serial #** _____ Order #_____

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
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other_____

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

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other_____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Bandsaw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___Table Saw
___Vacuum Veneer Press
___Wide Belt Sander

___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" Table Saw
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander

___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other_____

13. What machines/supplies would you like Grizzly Industrial to carry?

_____

_____

14. What new accessories would you like Grizzly Industrial to carry?

_____

_____

15. What other companies do you purchase your tools and supplies from?

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

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

___Yes ___No

19. 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