

Grizzly **Industrial, Inc.**®

24" CUT-OFF SAW MODEL G0549 INSTRUCTION MANUAL



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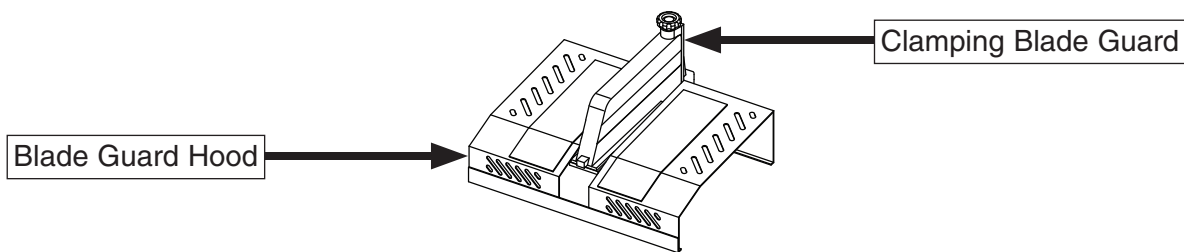
MODEL G0549 24" JUMP SAW MANUAL UPDATE (For Machines Manufactured After March, 2008)

The Model G0549 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

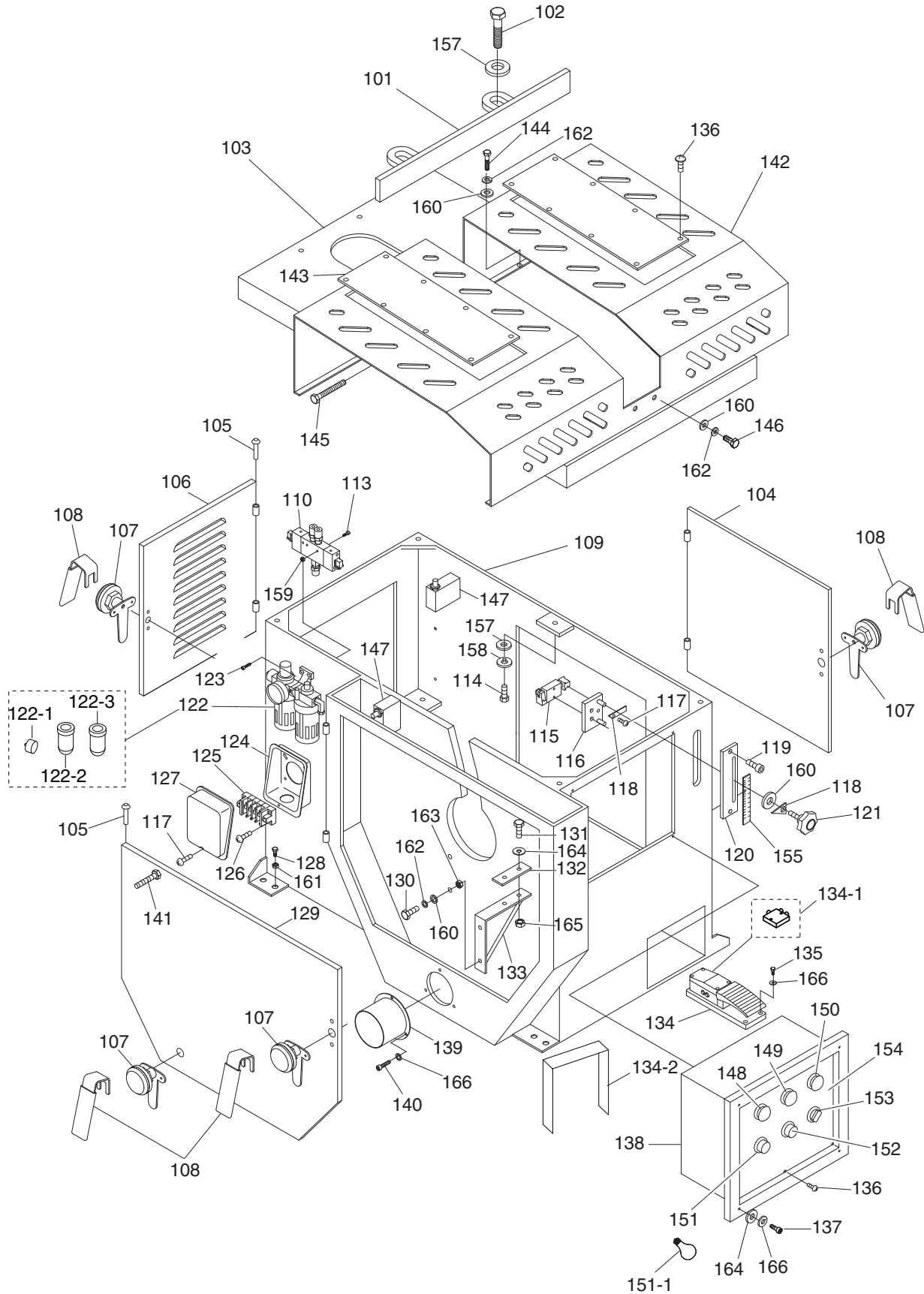


In addition to the safety instructions in your owner's manual for this machine, follow these rules regarding the blade guard hood and clamping blade guard:

- **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



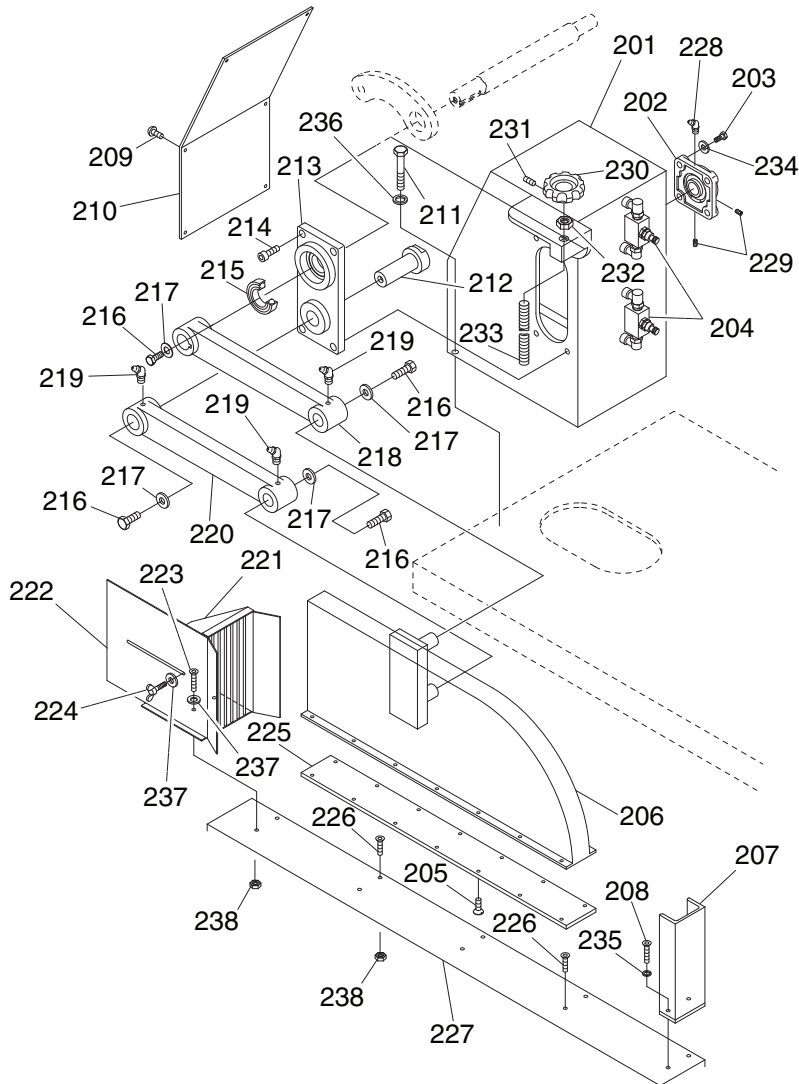
Cabinet Parts List

REF	PART #	DESCRIPTION
101	P0549101	FENCE
102	PB75M	HEX BOLT M12-1.75 X 35
103	P0549103	TABLE
104	P0549104	RIGHT SIDE DOOR
105	P0549105	HINGE PIN
106	P0549106	REAR DOOR
107	P0549107	SAFETY LOCK
108	P0549108	SAFETY LOCK HANDLE
109	P0549109	CABINET
110	P0549110	AIR VALVE
113	PS65M	PHLP HD SCR M4-.7 X 40
114	PB27M	HEX BOLT M12-1.75 X 30
115	P0549115	LIMIT SWITCH
116	P0549116	LIMIT SWITCH PLATE
117	PS06	PHLP HD SCR 10-24 X 3/8
118	P0549118	ELEVATION POINTER
119	PSB28M	CAP SCREW M6-1 X 15
120	P0549120	ELEVATION LOCK PLATE
121	P0549121	LOCK KNOB M8-1.25 X 30
122	P0549122	FILTER/LUBRICATOR/REGULATOR
122-1	P0549122-1	GAUGE
122-2	P0549122-2	OIL CUP
122-3	P0549122-3	WATER CUP
123	PSB02M	CAP SCREW M6-1 X 20
124	P0549124	TERMINAL BOX BASE
125	P0549125	TERMINAL BLOCK
126	PS03	PHLP HD SCR 10-24 X 1
127	P0549127	TERMINAL BOX COVER
128	PB51M	HEX BOLT M16-2 X 50
129	P0549129	LEFT SIDE DOOR
130	PB118M	HEX BOLT M8-1.25 X 45
131	PB47M	HEX BOLT M6-1 X 40
132	P0549132	RUBBER PAD
133	P0549133	SPINDLE SUPPORT BRACKET
134	P0549134	PEDAL SWITCH

REF	PART #	DESCRIPTION
134-1	P0549134-1	PEDAL CONTROLLER
134-2	P0549134-2	PEDAL GUARD
135	PB18M	HEX BOLT M6-1 X 15
136	PS38M	PHLP HD SCR M4-.7 X 10
137	PB10M	HEX BOLT M6-1 X 25
138	P0549138	CONTROL BOX ASSEMBLY
139	P0549139	DUST PORT
140	PSB28M	CAP SCREW M6-1 X 15
141	P0549141	SPECIAL BOLT M10-1.5 X 130
142	P0549142	BLADE GUARD HOOD
143	P0549143	ACRYLIC PLATE
144	PB09M	HEX BOLT M8-1.25 X 20
145	PB89	HEX BOLT 1/2-12 X 4-1/2
146	PB09M	HEX BOLT M8-1.25 X 20
147	P0549147	LIMIT SWITCH
148	P0549148	AIR INLET SWITCH
149	P0549149	AIR E-STOP BUTTON
150	P0549150	MANUAL SWITCH
151	P0549151	POWER SOURCE LIGHT
151-1	P0549151-1	BULB 220V
152	P0549152	SAW START BUTTON
153	P0549153	SAW STOP BUTTON
154	P0549154	PANEL
155	P0549155	SCALE
157	PW06M	FLAT WASHER 12MM
158	PLW05M	LOCK WASHER 12MM
159	PN04M	HEX NUT M4-.7
160	PW01M	FLAT WASHER 8MM
161	PN13M	HEX NUT M16-2
162	PLW04M	LOCK WASHER 8MM
163	PN03M	HEX NUT M8-1.25
164	PW03M	FLAT WASHER 6MM
165	PN01M	HEX NUT M6-1
166	PLW03M	LOCK WASHER 6MM



Head Breakdown

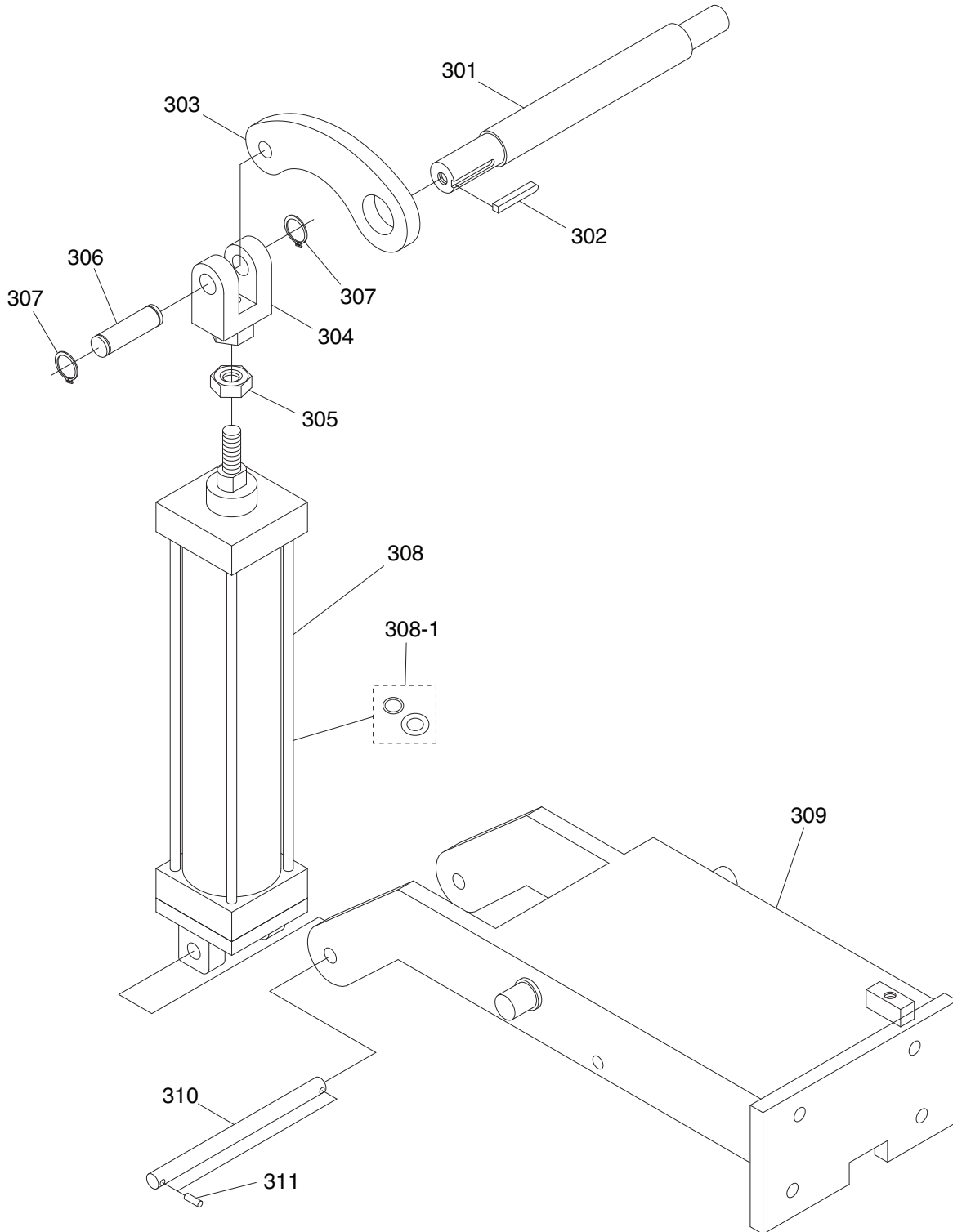


REF	PART #	DESCRIPTION
201	P0549201	HEAD COVER
202	PUCF205	BALL BEARING UCF205
203	PB24	HEX BOLT 3/8-16 X 1-1/4
204	P0549204	ADJUSTABLE AIR VALVE
205	PFH38M	FLAT HD SCR M6-1 X 16
206	P0549206	CLAMPING BLADE GUARD
207	P0549207	REAR SAFETY COVER
208	PB118M	HEX BOLT M8-1.25 X 45
209	PS68M	PHLP HD SCR M6-1 X 10
210	P0549210	HEAD REAR COVER
211	PB27M	HEX BOLT M12-1.75 X 30
212	P0549212	SUPPORT ARM SHAFT
213	P0549213	SQUARE BRACKET
214	PSB14	CAP SCREW 3/8-16 X 1
215	P6206	BALL BEARING 6206ZZ
216	PB53	HEX BOLT 1/2-12 X 1
217	P0549217	FENDER WASHER 1/2
218	P0549218	MAIN CRANK
219	P0549219	GREASE FITTING 1/8 X 45 DEG

REF	PART #	DESCRIPTION
220	P0549220	SUPPORT CRANK
221	P0549221	UPPER DUST HOOD
222	P0549222	ADJUSTABLE PLATE
223	PB71M	HEX BOLT M6-1 X 45
224	P0549224	WING BOLT M6-1 X 12
225	P0549225	RUBBER PLATE
226	PFH03M	FLAT HD SCR M6-1 X 40
227	P0549227	BAKELITE INSERT
228	P0549228	GREASE FITTING 1/16 X 90 DEG
229	PSS02M	SET SCREW M6-1 X 6
230	P0549230	ADJUSTMENT KNOB 3/4-10
231	PSS16M	SET SCREW M8-1.25 X 10
232	PN17	HEX NUT 3/4"-10
233	P0549233	STUD 3/4-10 X 6"
234	PLW04	LOCK WASHER 3/8
235	PLW04M	LOCK WASHER 8MM
236	PLW05M	LOCK WASHER 12MM
237	PW03M	FLAT WASHER 6MM
238	PN01M	HEX NUT M6-1



Air Cylinder

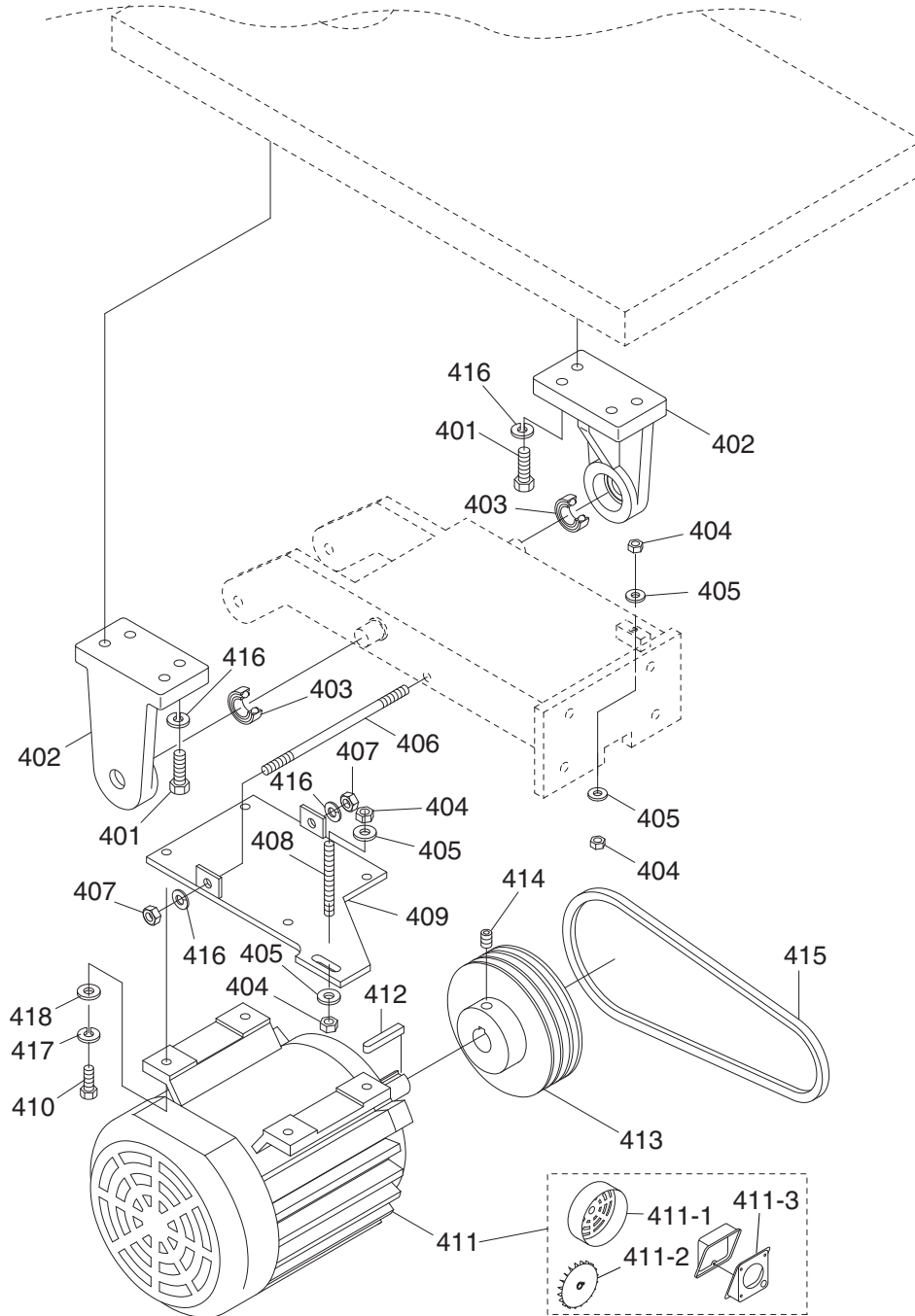


REF	PART #	DESCRIPTION
301	P0549301	MAIN CRANK SHAFT
302	PK86M	KEY 7 X 8 X 50
303	P0549303	ROCKER ARM
304	P0549304	ROD END CLEVIS
305	PN17M	HEX NUT M20-1.5
306	P0549306	COUPLING PIN

REF	PART #	DESCRIPTION
307	PR09M	EXT RETAINING RING 20MM
308	P0549308	AIR CYLINDER 80 X 300MM
308-1	P0549308-1	AIR CYLINDER SEAL KIT
309	P0549309	SUPPORT FRAME
310	P0549310	COUPLING PIN
311	P0549311	SPLINE PIN 5 X 35MM



Motor

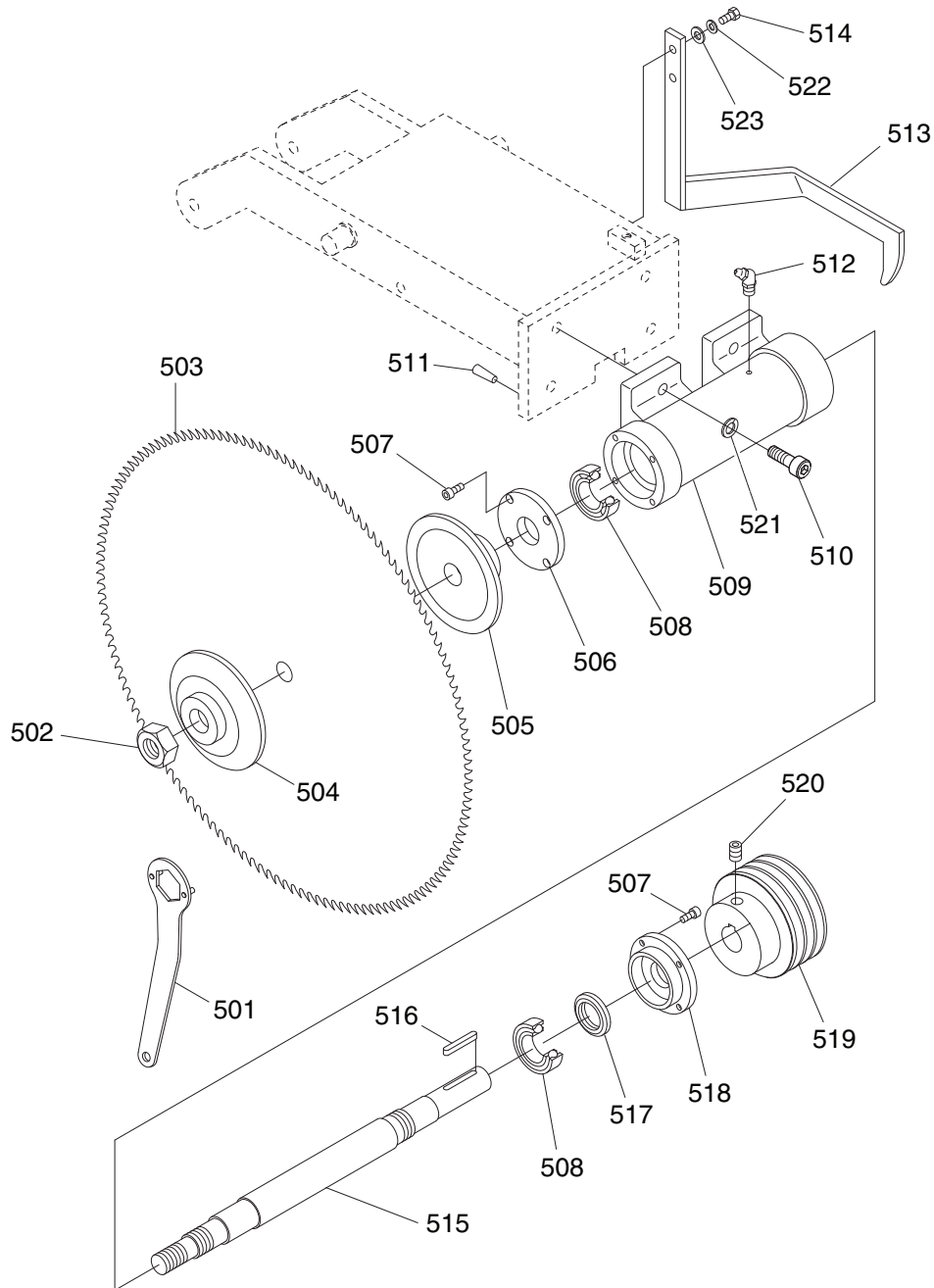


REF	PART #	DESCRIPTION
401	PB33M	HEX BOLT M12-1.75 X 50
402	P0549402	TABLE BRACKET
403	P6205	BALL BEARING 6205ZZ
404	PN13M	HEX NUT M16-2
405	PW08M	FLAT WASHER 16MM
406	P0549406	MOTOR MOUNT BAR M12-1.75
407	PN09M	HEX NUT M12-1.75
408	P0549408	MOTOR SCREW M16-2 X 150
409	P0549409	MOTOR PLATE
410	PB01M	HEX BOLT M10-1.5 X 30
411	P0549411	MOTOR 15HP 220/440V 3PH 60HZ

REF	PART #	DESCRIPTION
411-1	P0549411-1	MOTOR FAN COVER
411-2	P0549411-2	MOTOR FAN
411-3	P0549411-3	MOTOR WIRING JUNCTION BOX
412	PK87M	KEY 10 X 8 X 80
413	P0549413	MOTOR PULLEY
414	PSS13M	SET SCREW M10-1.5 X 12
415	P0549415	V-BELT MF6500
416	PLW05M	LOCK WASHER 12MM
417	PLW06M	LOCK WASHER 10MM
418	PW04M	FLAT WASHER 10MM



Blade Assembly

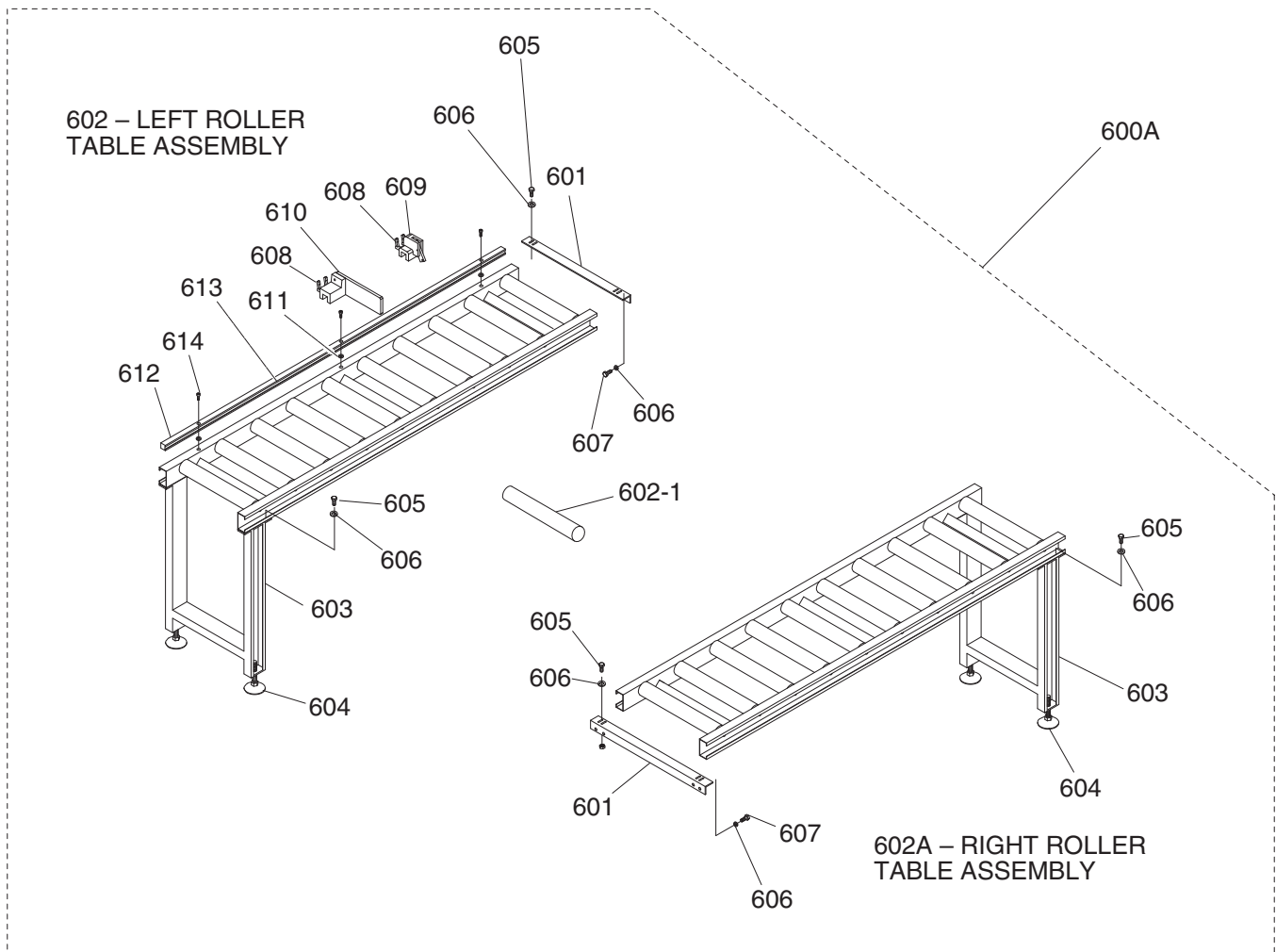


REF	PART #	DESCRIPTION
501	P0549501	ARBOR WRENCH
502	P0549502	ARBOR NUT 1-12
503	P0549503	BLADE 24 X 1 X 80T X 0.16
504	P0549504	OUTSIDE ARBOR FLANGE
505	P0549505	INSIDE ARBOR FLANGE
506	P0549506	FRONT END CAP
507	PSB02M	CAP SCREW M6-1 X 20
508	P6207	BALL BEARING 6207ZZ
509	P0549509	SPINDLE HOUSING
510	PSB92M	CAP SCREW M12-1.75 X 40
511	P0549511	TAPER PIN 4 X 40MM
512	P0549512	GREASE FITTING 1/4

REF	PART #	DESCRIPTION
513	P0549513	LIMIT SWITCH DOG
514	PB07M	HEX BOLT M8-1.25 X 25
515	P0549515	SPINDLE SHAFT
516	PK86M	KEY 7 X 8 X 50
517	P0549517	SPANNER NUT (LH) M35-16
518	P0549518	REAR END CAP
519	P0549519	ARBOR PULLEY
520	PSS75M	SET SCREW M10-1.5 X 16
521	PLW05M	LOCK WASHER 12MM
522	PLW04M	LOCK WASHER 8MM
523	PW01M	FLAT WASHER 8MM



Roller Tables

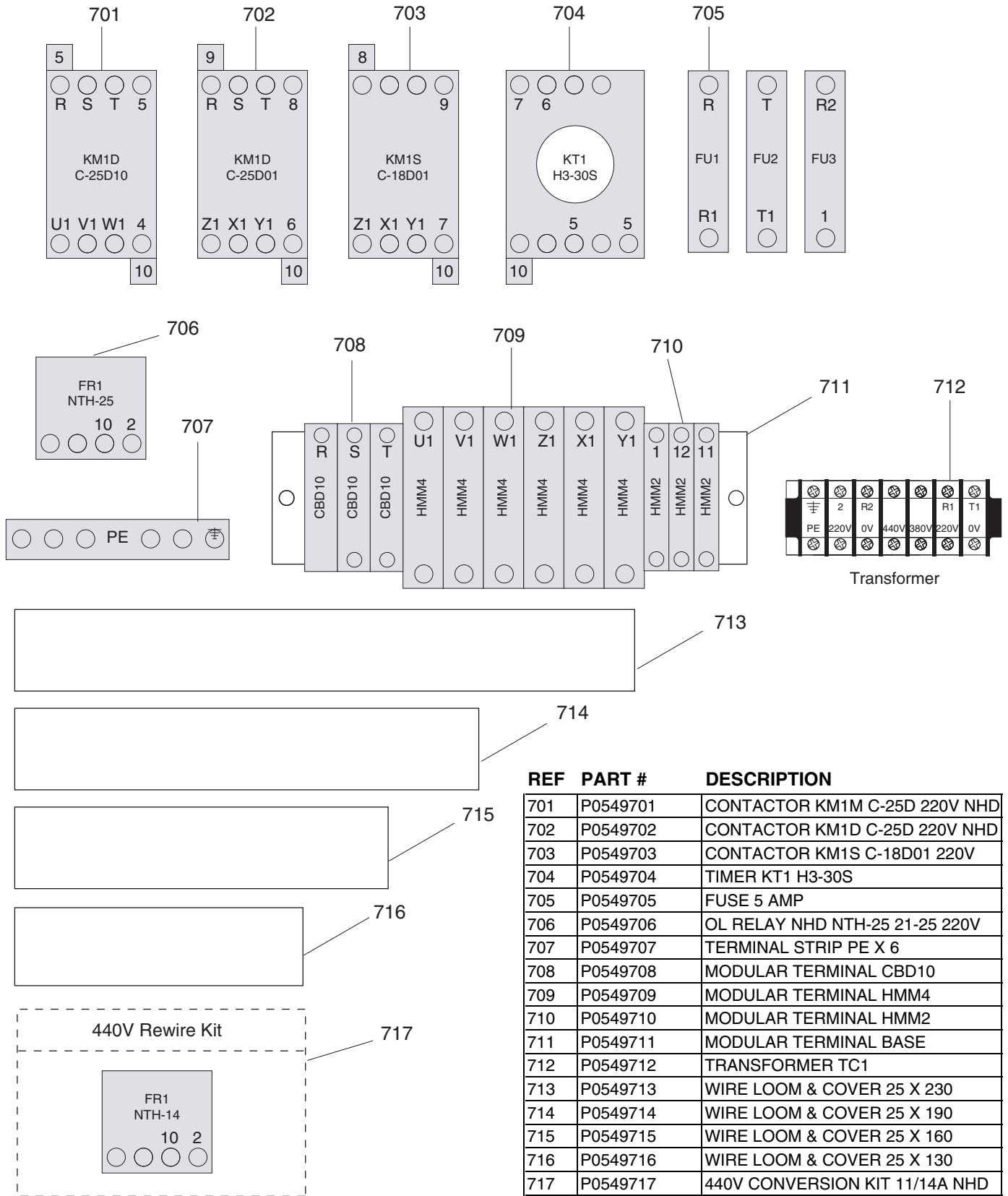


REF	PART #	DESCRIPTION
600A	P0549600A	LEFT & RIGHT ROLLER TABLE ASSY
601	P0549601	BRACKET
602	P0549602	LEFT ROLLER TABLE ASSEMBLY
602-1	P0549602-1	INDIVIDUAL ROLLER
602A	P0549602A	RIGHT ROLLER TABLE ASSEMBLY
603	P0549603	STAND
604	P0549604	ADJUSTMENT FOOT 5/8-11 X 4
605	PB09M	HEX BOLT M8-1.25 X 20
606	PW01M	FLAT WASHER 8MM

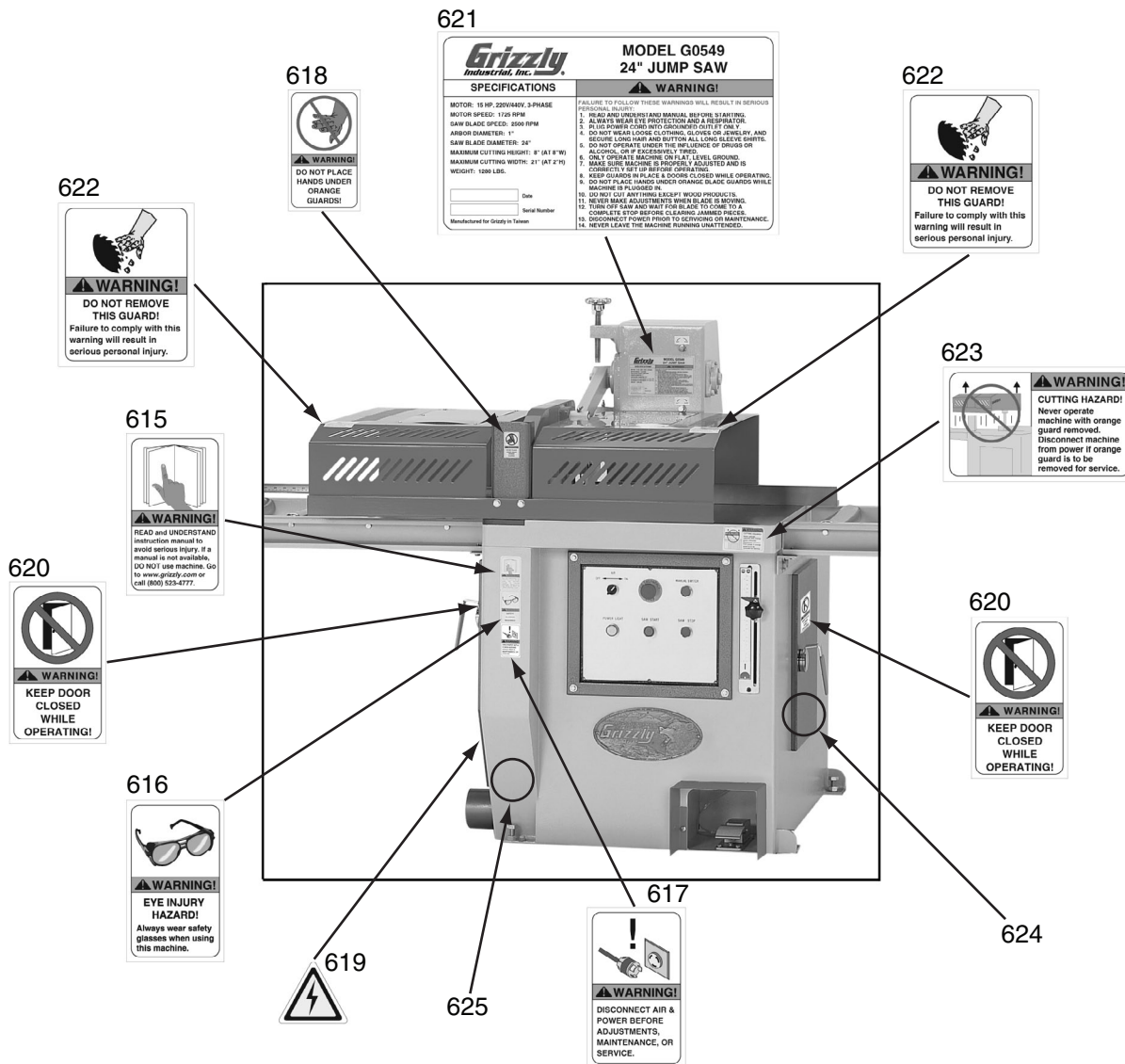
REF	PART #	DESCRIPTION
607	PB07M	HEX BOLT M8-1.25 X 25
608	P0549608	LOCK HANDLE M8-1.25 X 20
609	P0502025	QUICK STOP
610	P0549610	FIXED STOP
611	P0549611	SPECIAL FLAT WASHER 8MM
612	P0549612	SQUARE RAIL
613	P0549613	SCALE
614	PSB13M	CAP SCREW M8-1.25 X 30



Electrical Panel



Label Placement



621

Grizzly
Industrial, Inc.

MODEL G0549
24" JUMP SAW

WARNING!

SPECIFICATIONS

MOTOR: 10 HP, 200V/240V, 3-PHASE
MOTOR SPEED: 1725 RPM
SAW BLADE SPEED: 2500 RPM
ARBOR DIAMETER: 1"
SAW BLADE DIAMETER: 24"
MAXIMUM CUTTING HEIGHT: 8" (AT 18")
MAXIMUM CUTTING WIDTH: 21" (AT 18")
WEIGHT: 1280 LBS.

DATE: _____
SERIAL NUMBER: _____
Manufactured for Grizzly in Taiwan.

FAILURE TO FOLLOW THESE WARNINGS WILL RESULT IN SERIOUS PERSONAL INJURY!

1. WEAR AN EYE PROTECTION AND A RESPIRATOR.
2. PLUG POWER CORD INTO DISCONNECTED OUTLET ONLY.
3. DO NOT OPERATE UNDER CLOTHING, GLOVES OR JEWELRY, AND SECURE LONG HAIR AND BUTTON ALL LONG SLEEVE SHIRTS.
4. ONLY OPERATE MACHINE ON FLAT, LEVEL GROUND.
5. MAKE GUARD PLACEMENT ADJUSTMENTS WHILE OPERATING.
6. ONLY OPERATE MACHINE ON FLAT, LEVEL GROUND.
7. MAKE GUARD PLACEMENT ADJUSTMENTS WHILE OPERATING.
8. DO NOT PLACE HANDS UNDER ORANGE CLASP GUARDS WHILE MACHINE IS PLUGGED IN.
9. DO NOT PLACE HANDS UNDER WOODY PRODUCTS.
10. NEVER MAKE ADJUSTMENTS WHEN BLADE IS MOVING.
11. TURN OFF SAW AND WAIT FOR BLADE TO COME TO A COMPLETE STOP BEFORE CLEANING JAMMED PIECES.
12. DISCONNECT POWER PRIOR TO SERVICING OR MAINTENANCE.
13. NEVER LEAVE THE MACHINE RUNNING UNATTENDED.
14. NEVER LEAVE THE MACHINE RUNNING UNATTENDED.

REF	PART #	DESCRIPTION
615	PLABEL-12	READ MANUAL LABEL
616	PLABEL-11	SAFETY GLASSES LABEL
617	PLABEL-36	DISCONNECT POWER-DOOR LABEL
618	P0549618	HANDS UNDER GUARD LABEL
619	PLABEL-14	ELECTRICITY LABEL
620	PLABEL-30	CLOSE DOOR LABEL

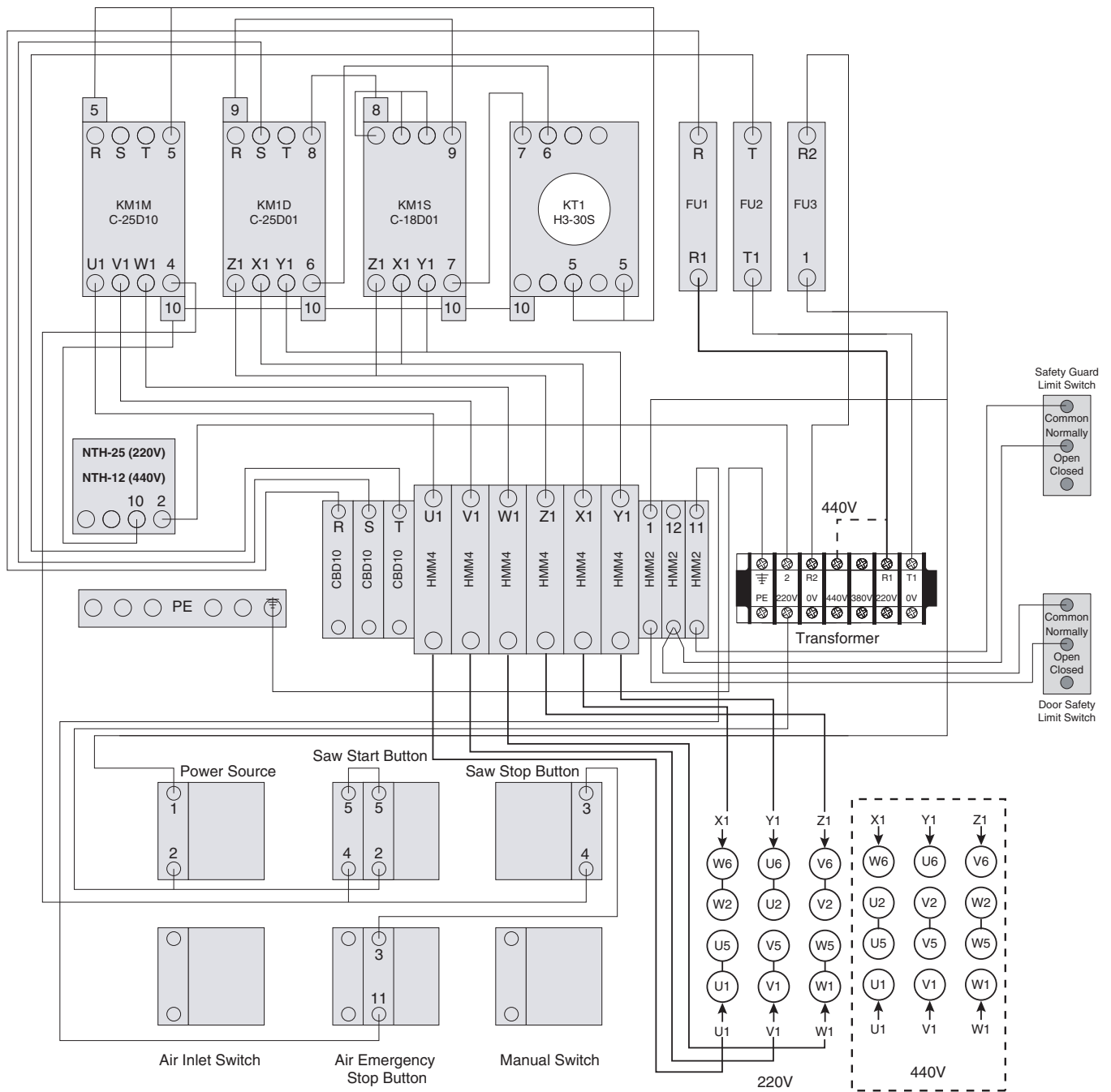
REF	PART #	DESCRIPTION
621	P0549621	MACHINE ID LABEL
622	P0549622	CUTTING HAZARD LABEL
623	P0549623	SAFETY GUARD LABEL
624	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
625	PPAINT-11	GRIZZLY PUTTY TOUCH-UP PAINT

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 G0549 can be converted for 440V 3-Phase operation. The procedure consists of changing the overload relay, and rewiring the transformer and motor.

Order the Model G0549 440V Conversion Kit (P/N P0549717) by calling our Customer Service at (800) 523-4777.

⚠️ 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 G0549 for 440V operation:

1. DISCONNECT SAW FROM POWER!
2. Open the electrical panel, then replace the overload relay with the one from the 440V conversion kit (see **Figure 4**).

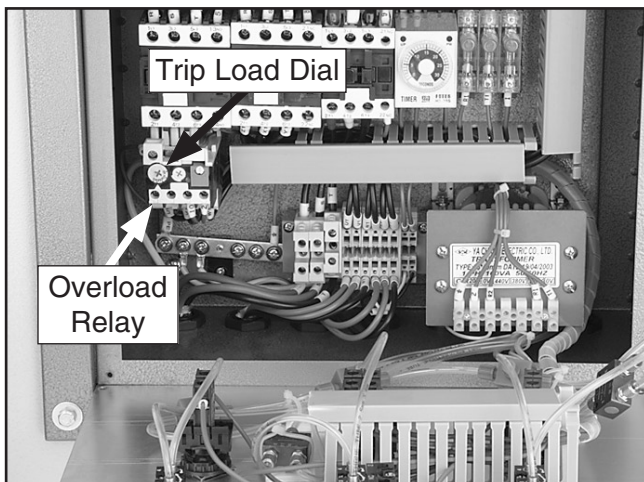


Figure 4. Model G0549 overload relay inside the electrical panel.

3. Move the wire that is connected to the R1 terminal on the transformer to the one above the 440V terminal, as illustrated in **Figure 5**.

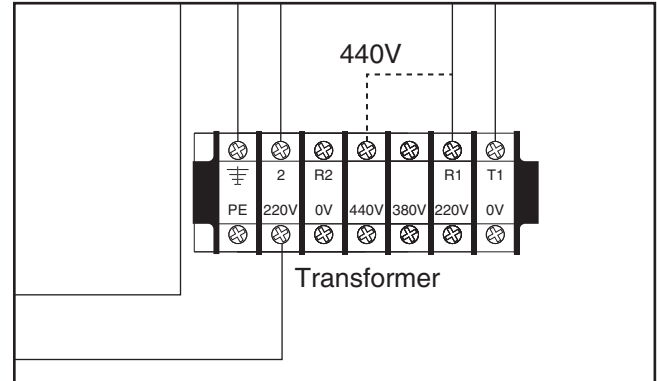


Figure 5. Rewiring the transform for 440V operation.

4. Make sure the trip load dial of the overload relay is set at 12 amps (see **Figure 4**).
5. Wire the motor as shown on the inside of the motor wiring junction box cover for 440V operation.

Note: The illustration in **Figure 6** 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.

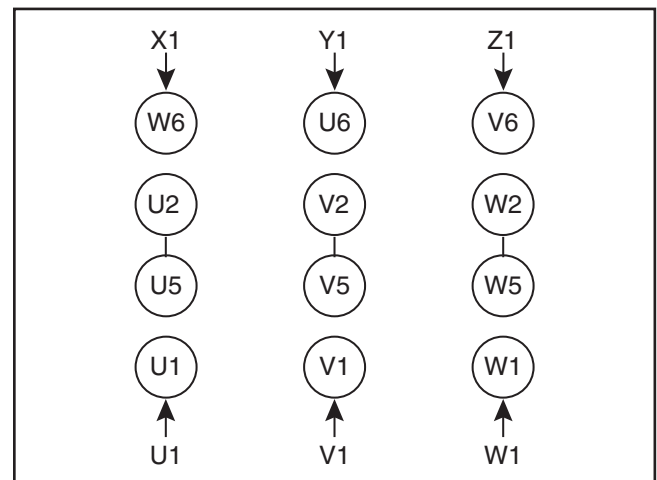


Figure 6. Model G0549 motor wiring for 440V operation.





MODEL G0549 24" CUT-OFF SAW MANUAL UPDATE

This machine has changed slightly from when the manual was originally written. It now includes a deluxe 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 workpiece holding mechanism must be left high enough to not interfere with the mechanism 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 G0549 owner's manual.

To operate the G0549:

1. Perform **Steps 1–3** on **Page 25** of the Model G0549 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.

Continued on next page 

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(FOR MODELS MANUFACTURED SINCE 4/10) #JB12659 PRINTED IN USA

3. Press and hold the foot pedal to engage the holding mechanism, which will press the stock 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.

Adjustment

The holding mechanism is adjustable to allow for cutting a variety of stock widths. For all operations, it must be positioned to push the stock against the fence when the pedal is pushed and provide adequate clearance to move the stock when the pedal is released.

To adjust the holding mechanism:

1. Loosen the two lock handles shown in **Figure 1**, then slide the actuator bracket to adjust the position of the holding mechanism. For narrow stock, slide it towards the fence. For wide stock, slide it away from the fence.

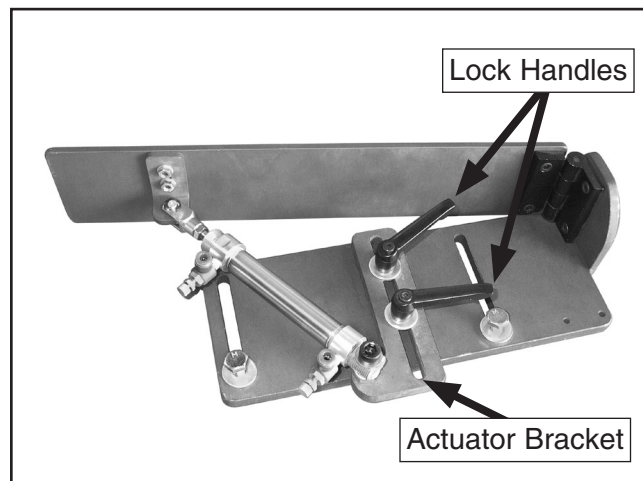
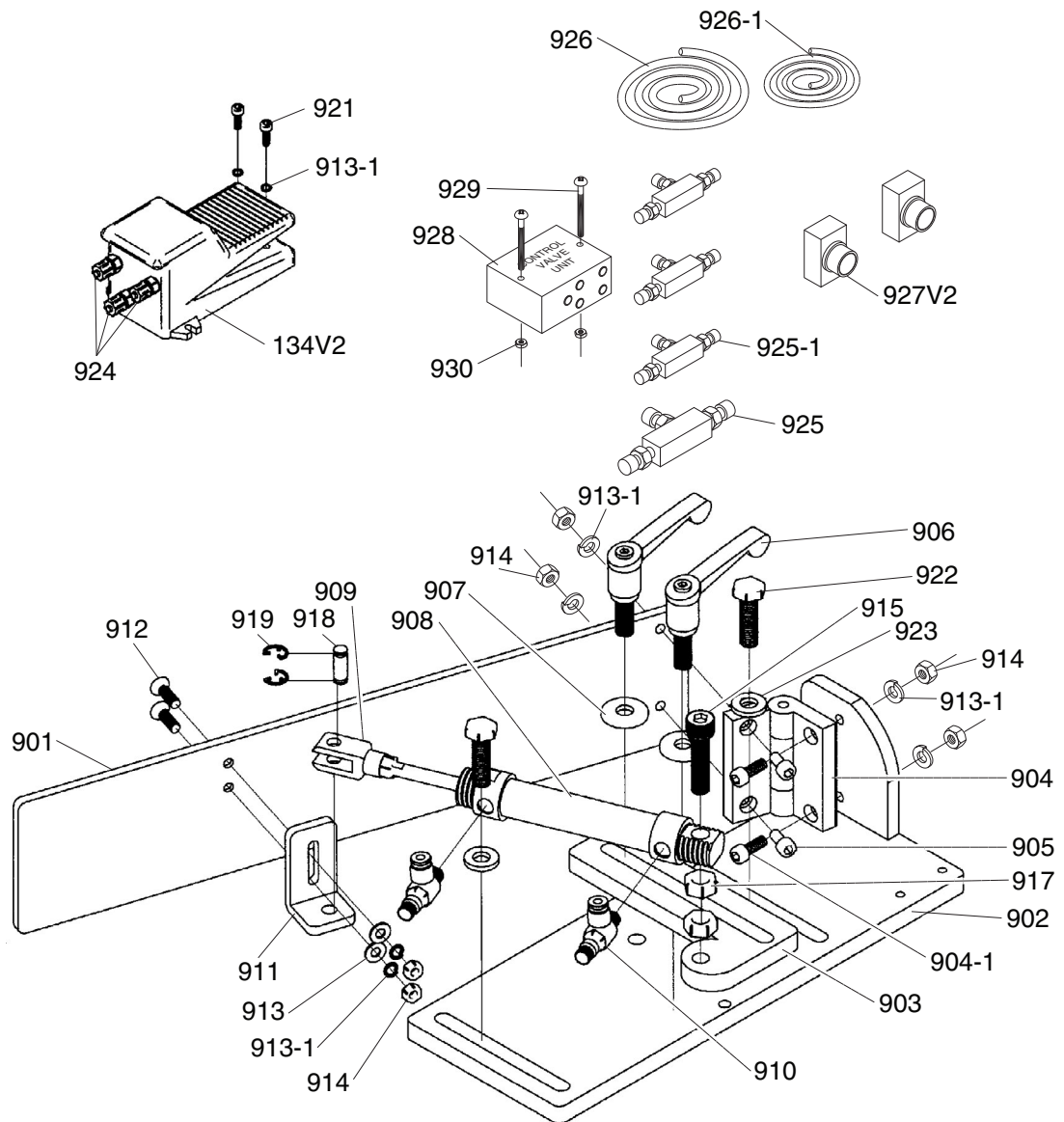


Figure 1. Holding mechanism.

2. Tighten the lock handles, then press the foot pedal to check the range of movement of the holding mechanism.
 - If the holding mechanism forces the stock against the fence when the pedal is pressed and provides adequate clearance when the pedal is released, the adjustment is correct. Otherwise, repeat **Steps 1–2**.

Holding Mechanism Breakdown

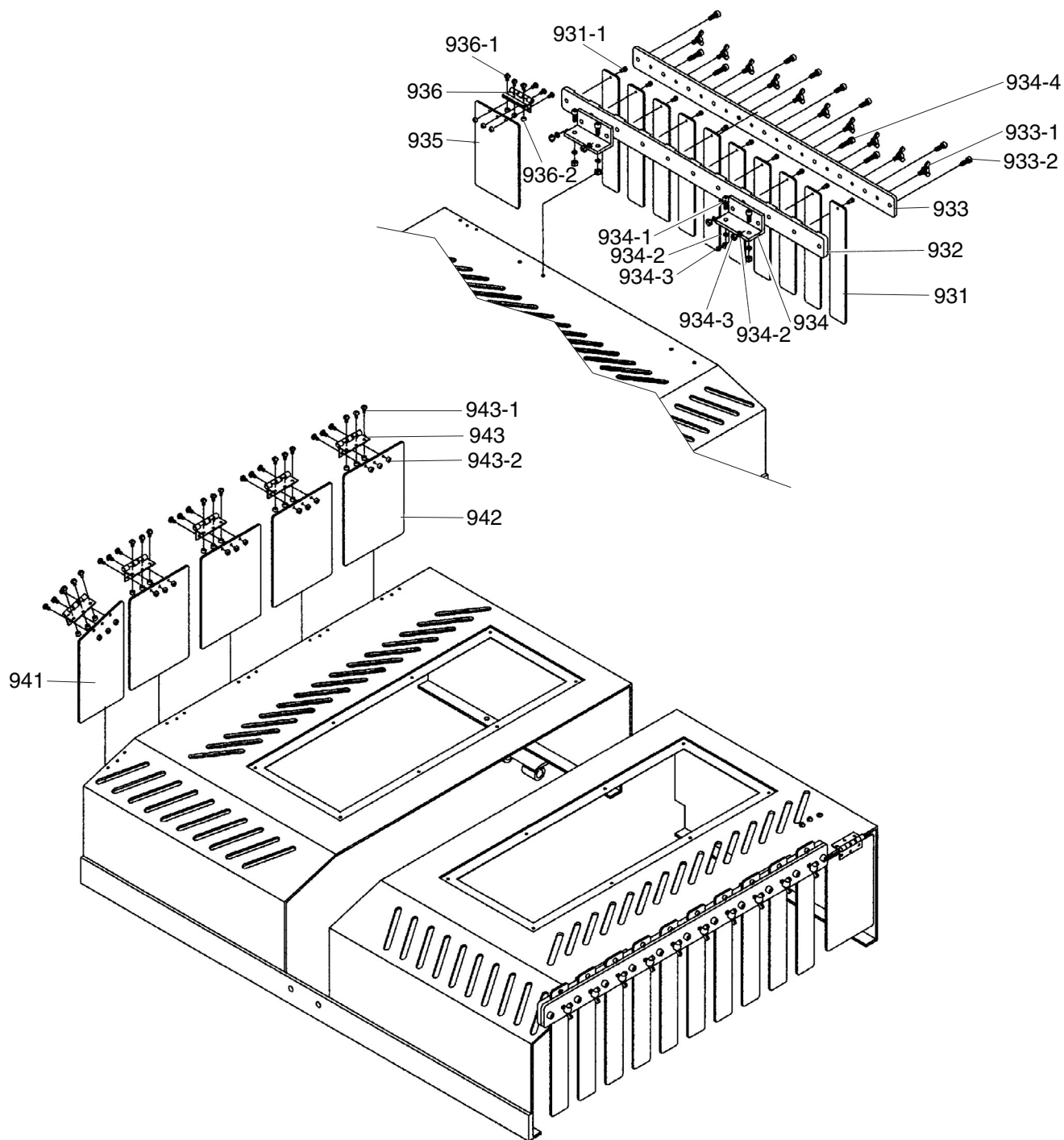


REF	PART #	DESCRIPTION
134V2	P0549134V2	PEDAL SWITCH V2.01.10
901	P0549901	CLAMP GATE
902	P0549902	MOUNTING BRACKET
903	P0549903	ADJUSTABLE PLATE
904	P0549904	HINGE
904-1	PCAP02M	CAP SCREW M6-1 X 20
905	PCAP01M	CAP SCREW M6-1 X 16
906	P0549906	LOCK HANDLE M10-1.5 X 25
907	PW04M	FLAT WASHER 10MM
908	P0549908	ACTUATOR CYLINDER
909	P0549909	ACTUATOR YOKE
910	P0549910	REGULATOR VALVE
911	P0549911	ACTUATOR BRACKET
912	PFH06M	FLAT HD SCR M6-1 X 20
913	PW03M	FLAT WASHER 6MM
913-1	PLW03M	LOCK WASHER 6MM
914	PN01M	HEX NUT M6-1

REF	PART #	DESCRIPTION
915	PCAP12M	CAP SCREW M8-1.25 X 40
917	PN03M	HEX NUT M8-1.25
918	P0502216	YOKE PIN 8 X 22
919	PEC015M	E-CLIP 8MM
921	PCAP01M	CAP SCREW M6-1 X 16
922	PB01M	HEX BOLT M10-1.5 X 30
923	PW04M	FLAT WASHER 10MM
924	P0549924	BRASS FITTING KIT
925	P0549925	LARGE T-FITTING 8MM
925-1	P0549925-1	SMALL T-FITTING 2.5MM
926	P0502224	AIR HOSE 6.5 X 10MM
926-1	P0502224-1	AIR HOSE 2.5 X 4MM
927V2	P0549927V2	START BUTTON ASSY V2.04.10
928	P0502226	CONTROL VALVE UNIT
929	P0502227	PHLP HD SCR M4-.7 X 55
930	PN04M	HEX NUT M4-.7



Deluxe Guard Breakdown



REF	PART #	DESCRIPTION
931	P0549931	STAKE GUARD
931-1	PCAP17M	CAP SCREW M4-.7 X 10
932	P0549932	INNER GUARD PLATE
933	P0549933	OUTER GUARD PLATE
933-1	P0502233-1	WING SCREW M6-1 X 12
933-2	PCAP26M	CAP SCREW M6-1 X 12
934	P0549934	GUARD MOUNT BRACKET
934-1	PCAP01M	CAP SCREW M6-1 X 16
934-2	PLW03M	LOCK WASHER 6MM
934-3	PN01M	HEX NUT M6-1

REF	PART #	DESCRIPTION
934-4	PCAP06M	CAP SCREW M6-1 X 25
935	P0549935	NOTCHED GUARD FLAP
936	P0502236	HINGE
936-1	PS07M	PHLP HD SCR M4-.7 X 8
936-2	PN04M	HEX NUT M4-.7
941	P0549941	ANGLED GUARD FLAP
942	P0549942	SQUARE GUARD FLAP
943	P0502236	HINGE
943-1	PS07M	PHLP HD SCR M4-.7 X 8
943-2	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 G0549 24" 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 G0549. 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 G0549 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

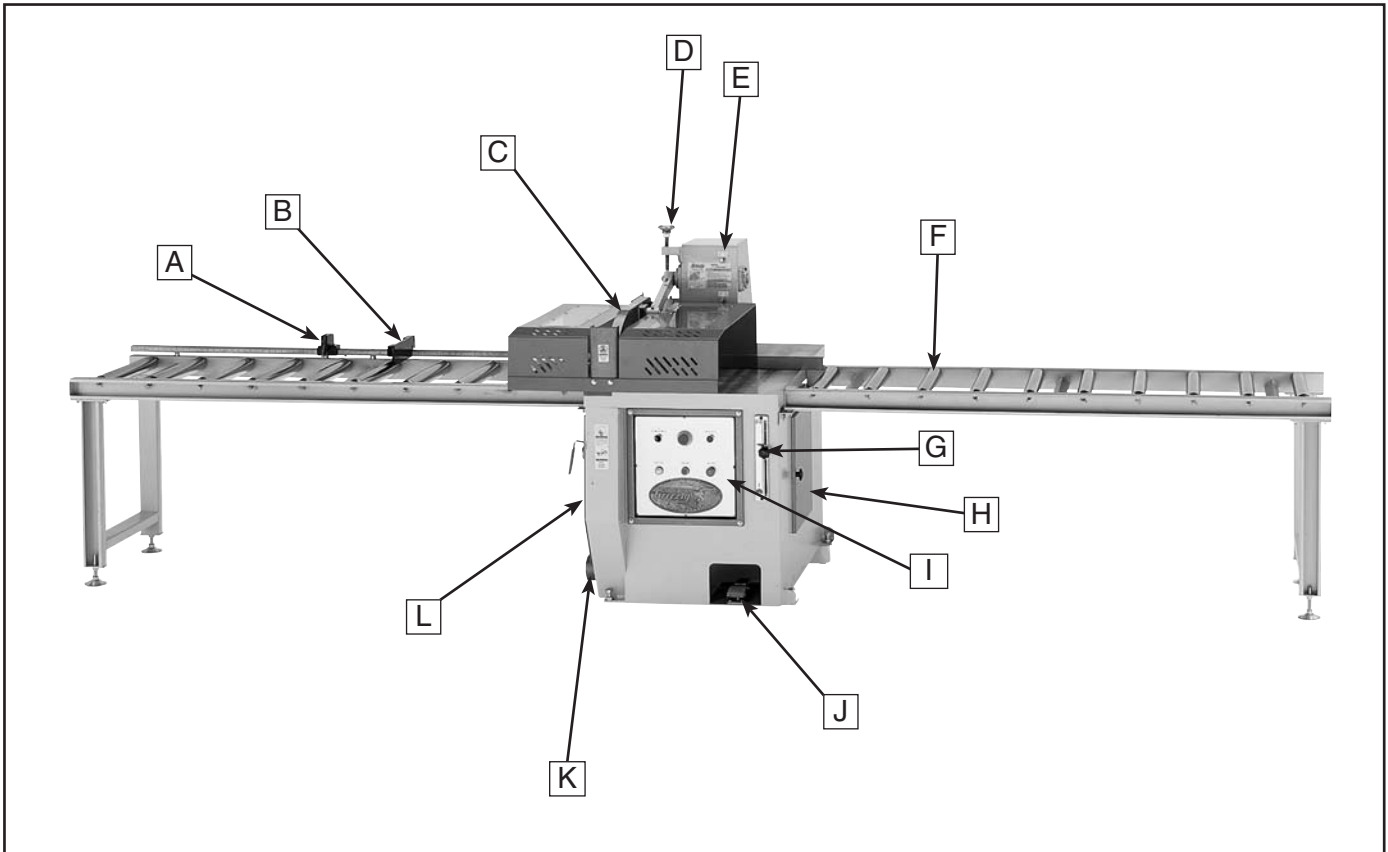


Figure 1. Front view of cut-off saw for identification.

- A. Flip Stop**—Adjusts along the outfeed roller assembly for repeat cuts; springs in/out of workpiece path as needed.
- B. Fixed Stop**—Adjusts along the outfeed roller assembly for repeat cuts.
- 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. Feed Rate Controls**—Adjusts the blade cycle speed in both up/down directions.
- F. Roller Table**—Supports long and heavy workpieces for easy positioning.
- G. Blade Height Adjuster**—Adjusts the height limit of the blade cycle.
- H. Cabinet Access Door**—Provides access to V-belt tensioning or internal service.
- I. Control Panel**—Starts and stops the blade, and switches the air pressure on/off.
- J. Foot Pedal**—Cycles the blade into the workpiece.
- K. 4" Dust Port**—Allows the machine to easily connect to a dust collector.
- L. Blade Access Door**—Used to inspect the blade and access the blade arbor nut for blade changes. Note—Only open when machine is disconnected from power.





MACHINE DATA SHEET

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

G0549 24" Cut-Off Saw

Design Type Floor Model

Overall Dimensions:

Table Size 28½" W x 45" D
 Table Height 32¼"
 Overall Width w/Extension Roller 186½"
 Overall Width w/o Extension Roller 28½"
 Overall Depth 45"
 Overall Height 55¼"
 Footprint w/Extension Roller 186½" W x 40¾" D
 Footprint w/o Extension Roller 29½" W x 40¾" D
 Shipping Weight (Both Crates) 1410 lbs.
 Machine Weight 1280 lbs.
 Crate 1 Size 36¾" W x 51¼" D x 56" H
 Crate 2 Size 23¼" W x 83½" D x 16¼" H

Capacities:

Cutting Capacity 2" x 21", 4" x 19", 6" x 15", 8" x 8"
 Maximum Cutting Length for Stop 78"
 Maximum Support to the Right of Blade 104½"
 Maximum Cutting Cycle Speed 45 Strokes Per Minute
 Saw Blade Size 20, 22, 24"
 Arbor Diameter 1"
 Saw Blade Speed 2000 RPM

Construction:

Table Precision Ground Cast Iron
 Cabinet Steel
 Fence Precision Ground Cast Iron
 Extension Roller Pre-Formed Steel
 Spindle Bearings Pre-lubricated Ball Bearings w/ Grease Fittings

Motor:

Type TEFC Induction
 Horsepower 15 HP
 Phase / Voltage 3-Phase / 220V/440V
 Amps 38/19A
 Cycle / RPM 60 Hertz / 1725 RPM
 Switch Magnetic w/Thermal Overload Protector
 Motor Bearings Shielded & Lubricated Ball Bearings

Features:

..... 2 – 79" Infeed & Outfeed Roller Extensions
 Safety Guard
 Swing Stop and Heavy-Duty Stop
 Foot Switch Start
 Easily Adjustable Clamp
 Convenient Cycle Speed Adjustment
 Quick-Stop Connect Fitting
 Supplied w/ a 24" 80 Tooth Blade

Specifications, while deemed accurate, are not guaranteed.

8/2004

SECTION 1: SAFETY


WARNING

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

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

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

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

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

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

WARNING

Safety Instructions for Machinery

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

WARNING

Safety Instructions for Machinery

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

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 29**.
- 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.
- 11. WOOD CUTTING ONLY!** This machine is not intended for metal cutting applications.

WARNING

Like all machines there is danger associated with the Model G0549. 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:

Motor at 220V, 3-Phase (Prewired)
Amp Draw.....38 Amps

Motor at 440V, 3-Phase (w/Conversion Kit)
Amp Draw..... 19 Amps



Circuit Breaker

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.

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.....40 Amps

440V, 3-Phase (w/Conversion Kit)
Circuit Breaker.....20 Amps

If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage load capacity. However, if the circuit is not overloaded 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 specifications for safe operation:

220V, 3-Phase (Prewired)
Cord Material..... Copper
Gauge..... 8
Recommended Length10'

440V, 3-Phase (w/Conversion Kit)
Cord Material..... Copper
Gauge..... 10
Recommended Length10'

NOTICE

Consult a qualified electrician for the correct power cord gauge when the cord length must exceed 10'; otherwise, damage may occur to the electrical components or motor of the machine.



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 or lockout the power supply.

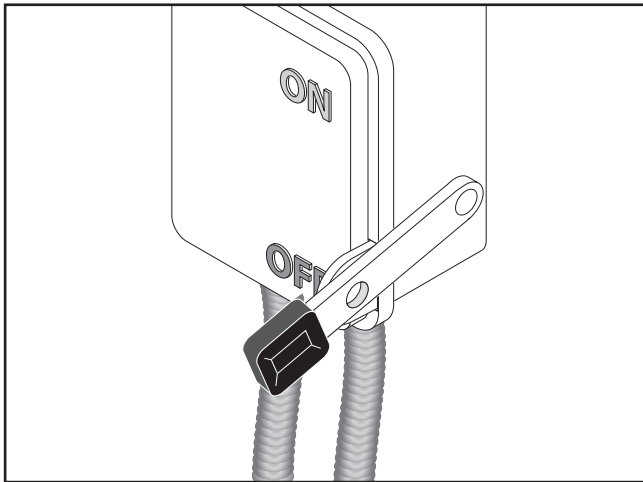
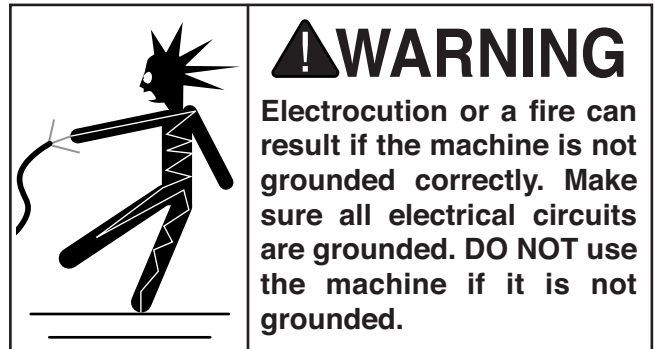


Figure 2. Locking shut-off lever.



Grounding



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.

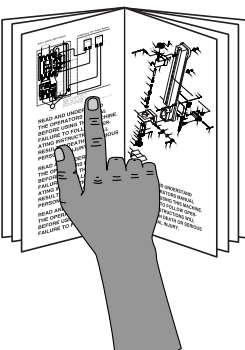


Extension Cords

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



!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!

Unpacking

The Model G0549 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.



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)	2
• 4" Hose Clamps	2
• 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
• Forklift.....	1
• Extra 13mm Wrench	1



Inventory

Use **Figures 3–6** and the list below to inventory the contents of your shipment. 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. Flip Stop	1
E. Fixed Stop	1
F. Foot Assemblies	4
G. Hardware Bag	1
—Hex Bolts M8-1.25 x 20	13
—Hex Bolts M8-1.25 x 25	4
—Flat Washers 8MM x 23 OD	4
—Flat Washers 8MM x 25 OD	4
—Flat Washers 8MM x 18 OD	9
—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 Bag	1
—Dust Port	1
—Cap Screws M6-1 x 16	3
—Lock Washers 6MM	3
M. Arbor Wrench	1
N. Door Lock Handles	2
O. Open End Wrench Set	1

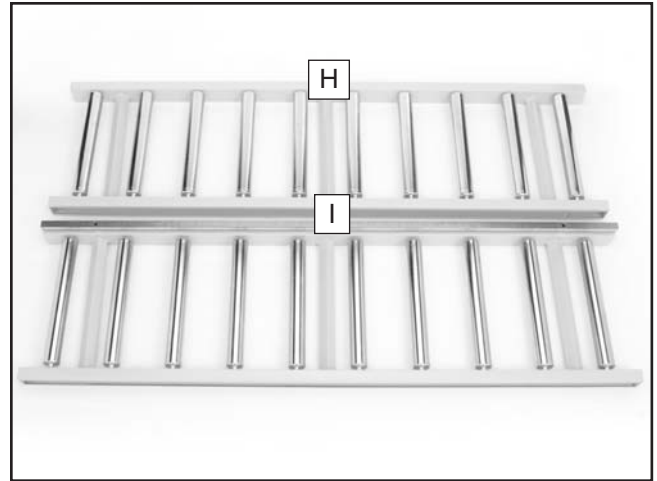


Figure 4. Roller assemblies.

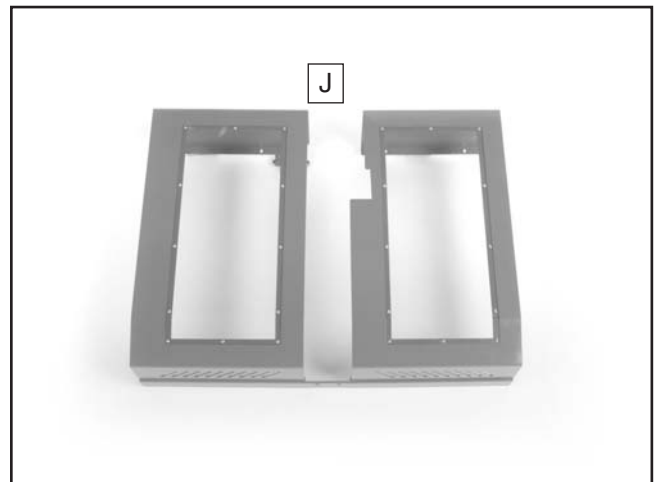


Figure 5. Safety guard.

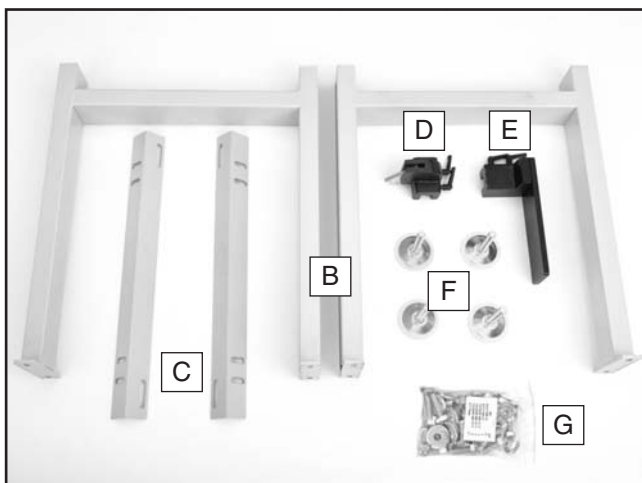


Figure 3. Roller table legs, brackets, feet, stops, and hardware bag.

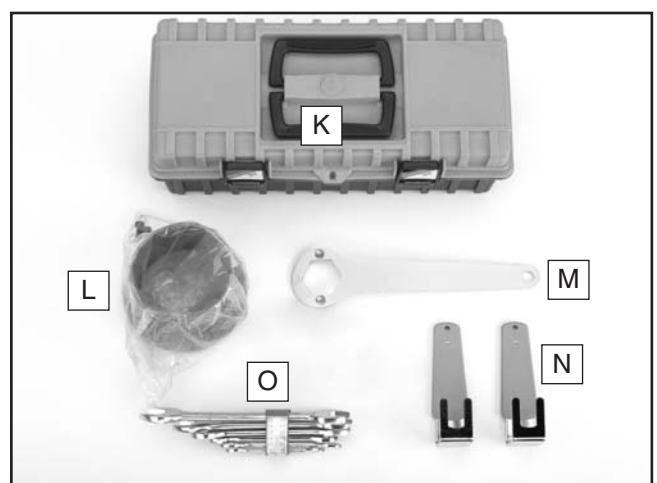


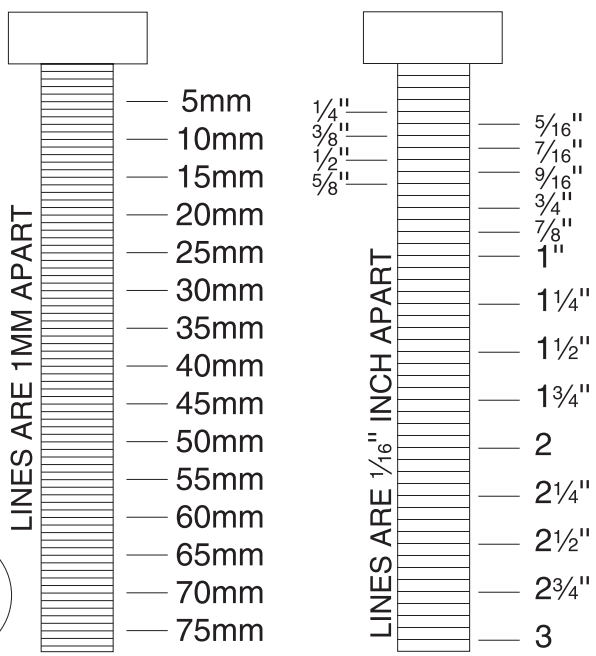
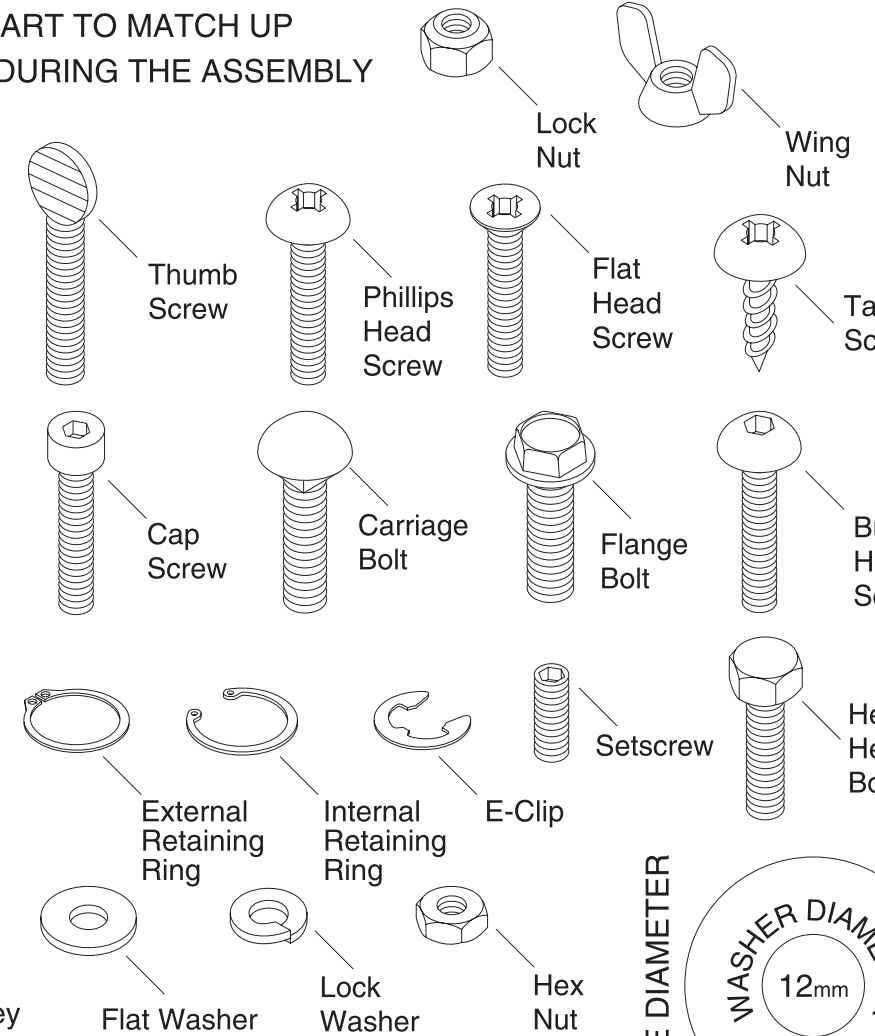
Figure 6. Tool box and contents.

Hardware Recognition Chart

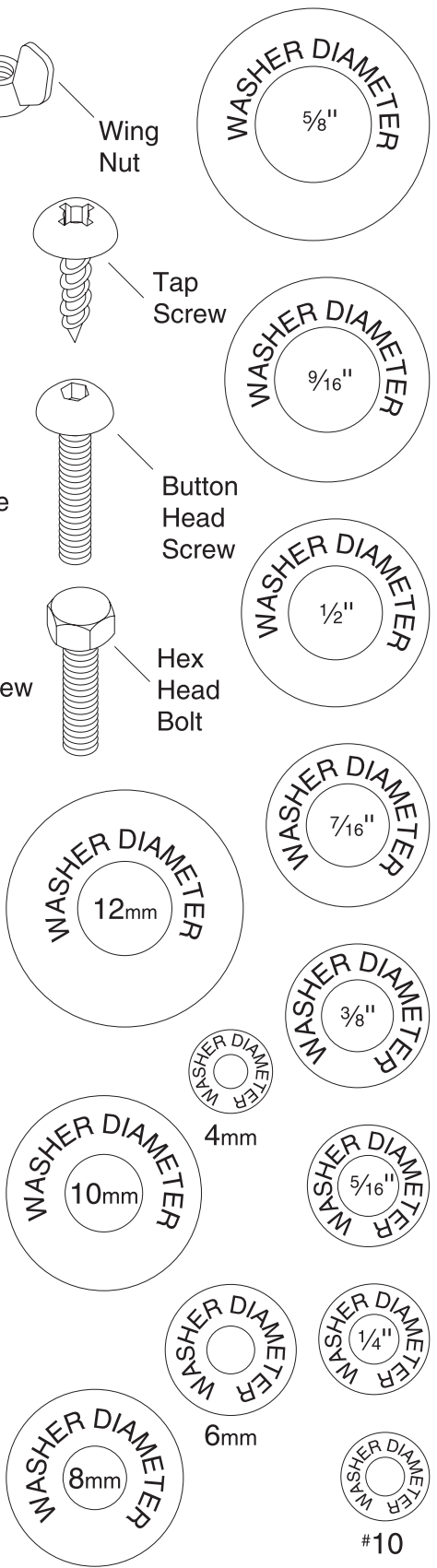
USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"
- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Site Considerations

Floor Load

The Model G0549 has a 1429 lb. shipping weight with a 186½" x 45" footprint. 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 G0549 footprint.

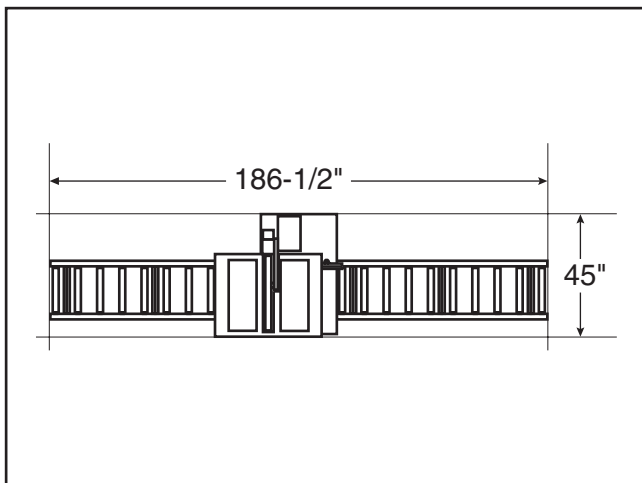


Figure 7. Model G0549 footprint.

	<p>!WARNING</p> <p>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.</p>
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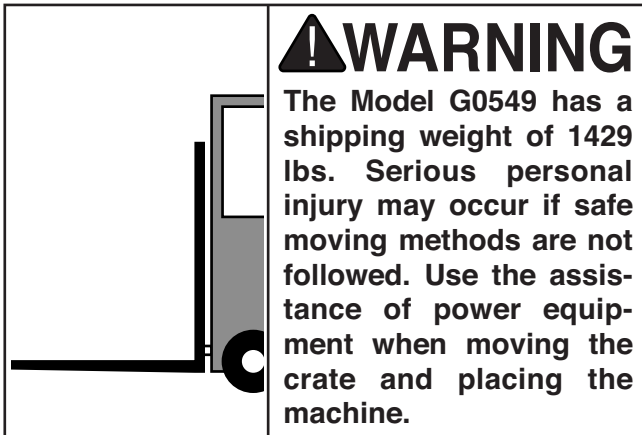


Clean Up

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



Placement



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. Using a forklift and the eyebolt mounted in the table, lift the cut-off saw and move it 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 x 23 OD.....	4
Flat Washers 8mm x 18 OD	8
Hex Nuts M8-1.25	12

Tools Needed:	Qty
Wrenches/Socket 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 four hex bolts and washers shown in **Figure 8**.



Figure 8. Bolts to be removed.

- 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 roller table after the machine is connected to the air compressor.



Figure 9. Mounting bracket attached to saw.

- Thread two foot assemblies into one of the roller table legs, as shown in **Figure 10**.



Figure 10. Threading foot into roller table leg.

- Using four of the hex bolts, 8mm x 18 OD flat washers, and hex nuts, attach the table leg/foot assembly to the left roller table assembly, as shown in **Figure 11**. (The left roller table has a rail along the edge.)

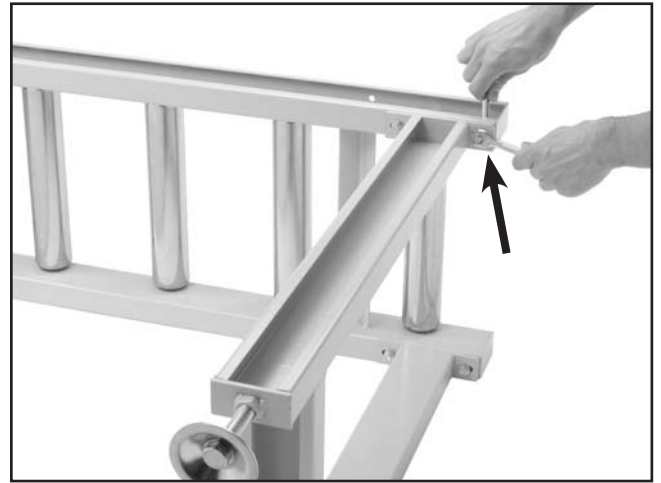


Figure 11. Attaching stand leg/foot assembly to roller table.

- Place the end of the roller table (opposite the leg assembly) on the mounting bracket that is attached to the saw.
- Use two hex bolts, 8mm x 23 OD washers, and nuts to secure the roller table to the mounting bracket (see **Figure 12**).



Figure 12. Roller table attached to mounting bracket.

- 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 one of the scribed lines (**Figure 14**) so it is square to the blade. Note—Choosing which scribed line to mount the fence to is a matter of anticipated workpiece size and personal preference.

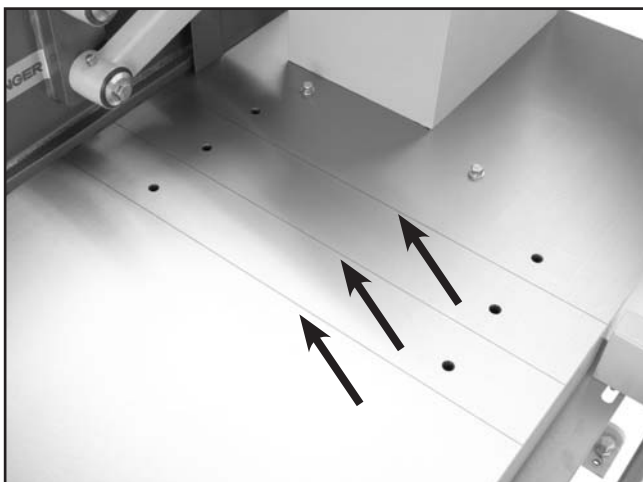


Figure 14. Scribed lines in table.

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.

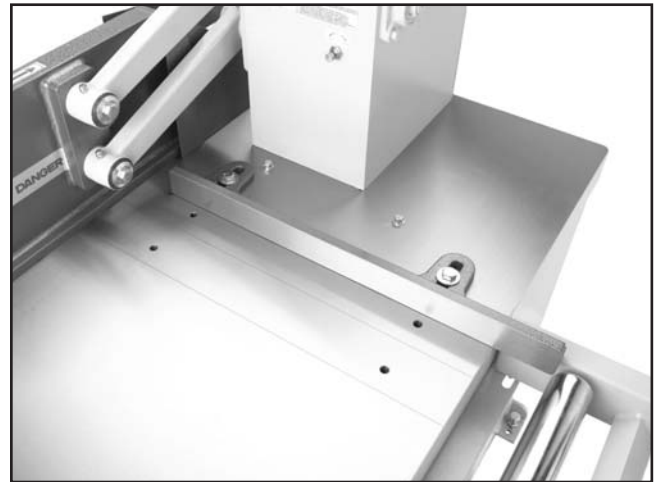


Figure 15. Fence mounted to table.

4. Align the fence with the scribed line and carefully tighten the bolts so the fence edge stays flush 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" when the foot pedal is pressed.

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 fittings 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. Locate the filter/lubricator/regulator on the left-hand side of the cabinet (see **Figure 16**).

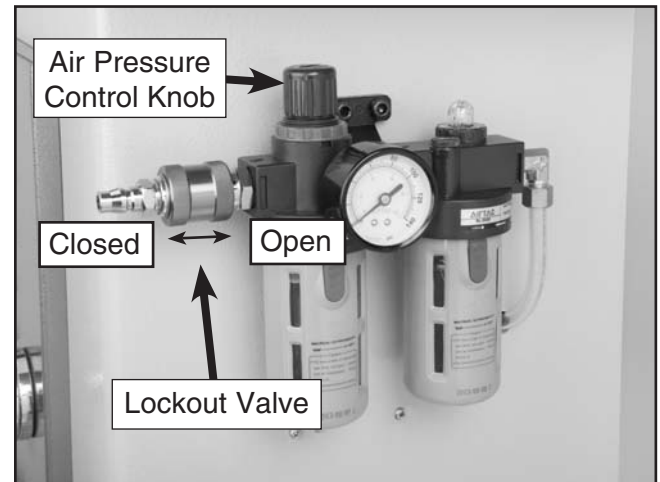


Figure 16. Filter/lubricator/regulator located on the left-hand side of the cabinet.

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, open the lockout valve, and turn the air system ON at the control panel.

—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.

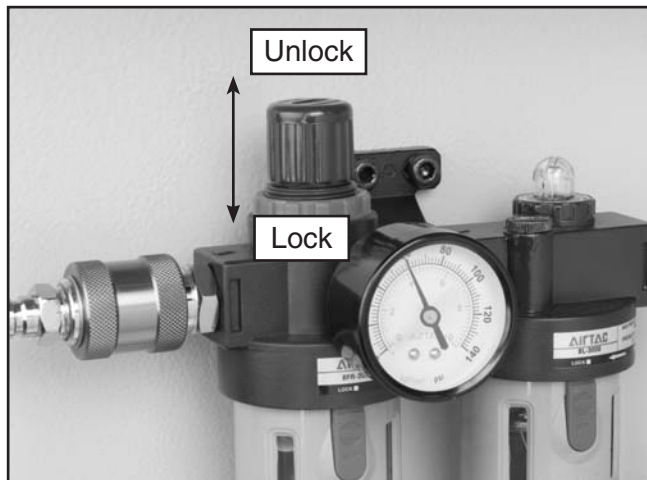


Figure 17. Air pressure regulated to 60 PSI at the gauge.

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. **DO NOT** use the saw until it is fixed. Refer to Troubleshooting (**page 52**) in this manual or call our technical support personnel at (570) 546-9663.

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

NOTICE

Keep lockout valve 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 must be adjusted even with the cast iron table. Accomplish this 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**). Note—You may have to repeat this process until the rollers are even with the saw table.



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

Also, 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 flush 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.

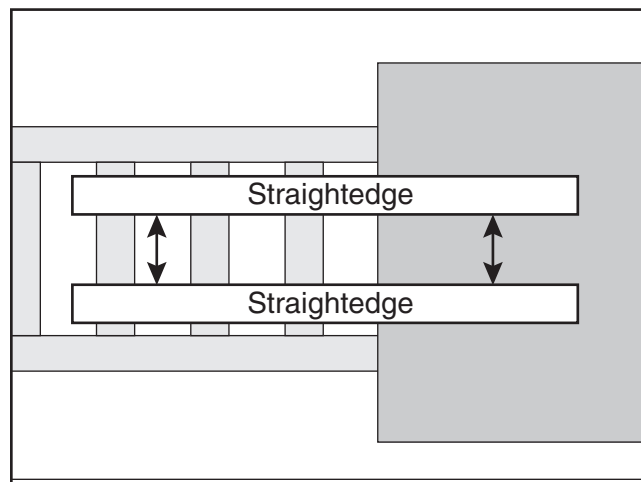


Figure 19. Straightedge positions for checking and adjusting front and back of roller table.

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

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**.

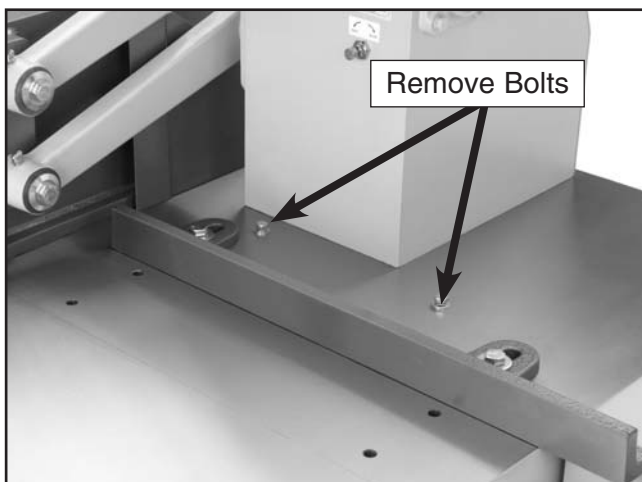


Figure 20. Bolts to be removed for safety guard.



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**.

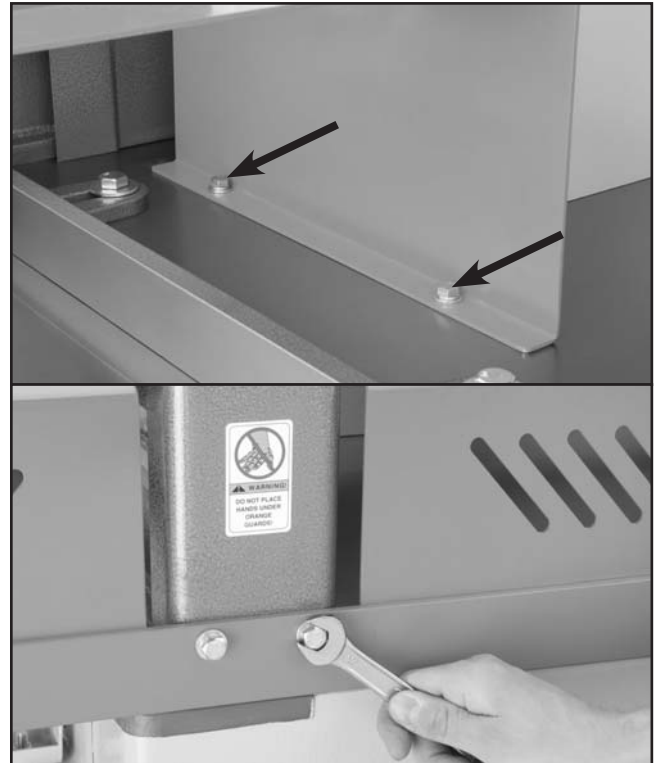


Figure 22. Installing guard with removed bolts.

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

Two dust ports (see **Figures 24 & 25**) are included for connection to your dust collection system. If your dust collection consists of primarily fixed lines, we recommend using small lengths of flexible hose to connect your machine to the fixed line. Note—If your existing dust lines are smaller than 4", upgrade to 4" or larger lines.

The minimum airflow to properly collect dust from this machine is 550 CFM. This means the dust collection lines 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**).

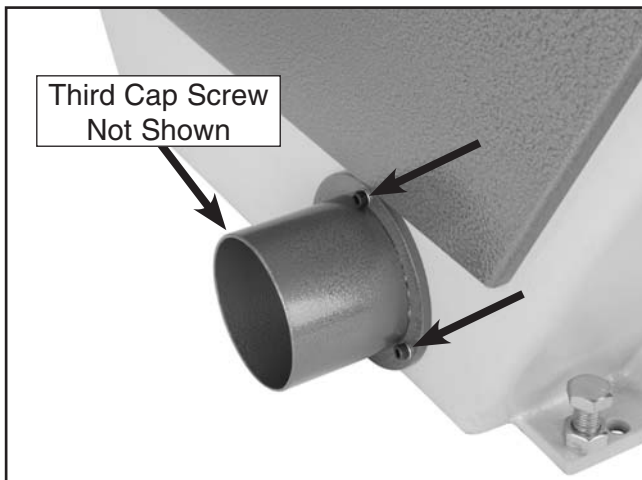


Figure 24. Dust port mounting locations on the lower dust port.



Figure 25. Upper dust port.

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

Note—**Figure 26** shows the dust port connected to 4" flexible hose with a hose clamp.

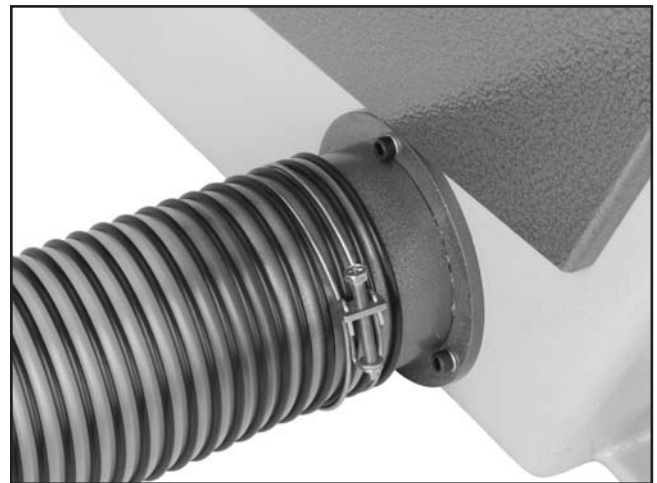


Figure 26. Flexible dust hose connected to dust port.



Stops

Hardware Needed:	Qty
Fixed Stop	1
Flip Stop	1

Two different stops are included with the cut-off saw—a fixed stop (**Figure 27**) and a flip stop (**Figure 28**). Both stops fit over the rail and lock in place with two knob bolts.

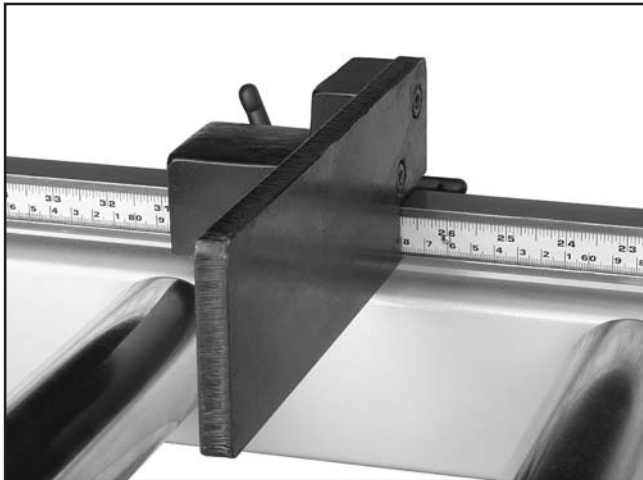


Figure 27. Fixed stop.



Figure 28. Flip stop.

To install the stops 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 29**) with the help of a qualified electrician.



Figure 29. 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 30**) 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 **Figure 31**.



Figure 30. Identifying right door.

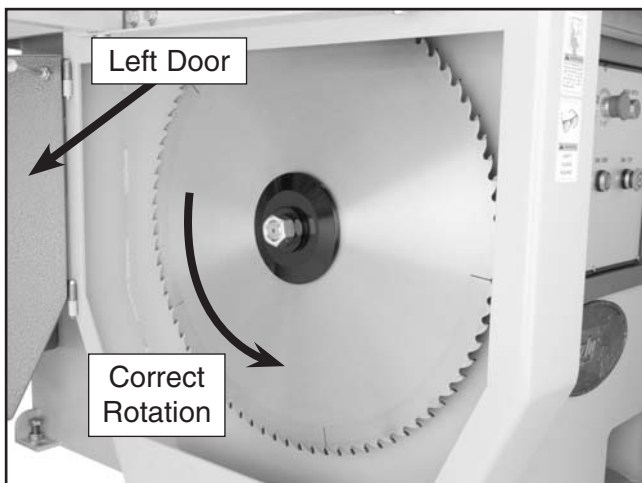


Figure 31. Checking blade rotation from left door.

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 out. 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 **left-side** door.

!WARNING

Placing hands inside of the cabinet while the machine is connected to power or air may result in severe cutting or crushing injuries. Keep hands outside of cabinet, unless the machine has been disconnected from power, the air has been locked out, and the blade has come to a complete stop.

5. View the blade to determine which direction it is spinning, then close the left 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 (refer to **Figure 29**) and start again at **step 3**.



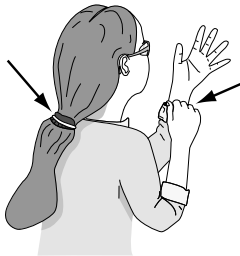
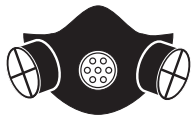
SECTION 4: OPERATIONS

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 to the length of the desired cut and place the workpiece against the stop (Figure 32).

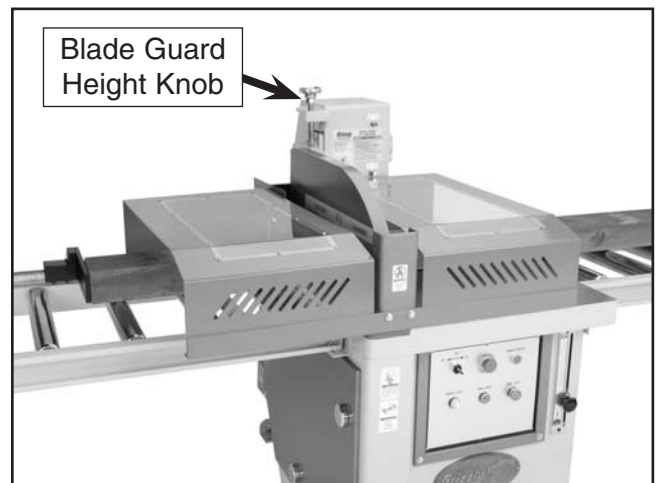


Figure 32. Workpiece prepared for cutting.

3. Using the blade guard height knob, lower the blade guard $\frac{1}{2}$ " 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 G0549 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 and air source!**
2. Open the left side cabinet door to expose the 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 blade flange, as shown in **Figure 33**. Note—The arbor bolt has right-hand threads (turn counterclockwise to loosen).



Figure 33. Cut-off saw blade.

CAUTION

The saw blade is very sharp and can cause personal injury. Always use caution when working on or around the saw blade.

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 pedal 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 is connected to two valves (see **Figure 34**) that allow you to adjust the upward and downward strokes of the blade. Always adjust both strokes evenly, so they cycle at approximately the same speed (this stroke timing will reduce cutting problems like workpiece burning or glazing).

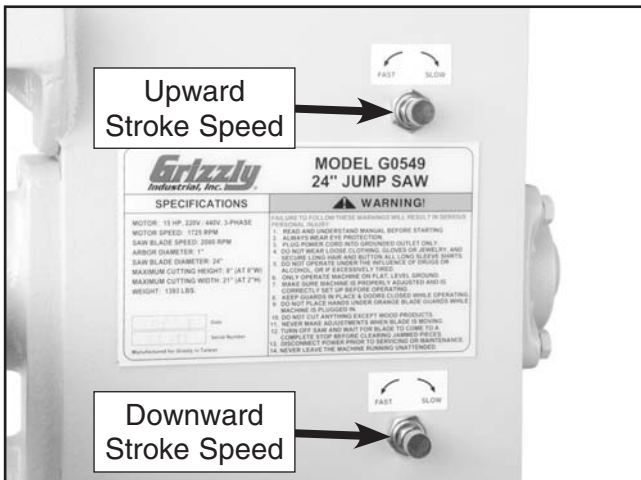


Figure 34. Air cylinder and adjustment valves.

To adjust the feed rate:

1. Turn the power off to the machine.
2. Adjust the upward stroke speed by turning the knob on the valve (counterclockwise=faster feed rate).
3. Tap the foot switch to test how the adjustment changed the upward stroke speed.
4. Repeat **step 2** until the desired upward stroke speed is established, then tighten the jam nut on the air valve knob so it does not move.
5. Adjust the downward stroke speed so it is approximately even with the upward stroke speed, then tighten the jam nut.
6. 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 1–6**.



Adjusting Blade Stroke Height

Besides adjusting the stroke speed, you can make blade cycles faster by adjusting the blade stroke to a shorter height.

To adjust the blade stroke height:

1. Loosen the lock knob shown in **Figure 35**.
2. Adjust the pointer on the scale so it is just above the height of your work.
3. Tighten the lock knob to secure the stroke height in place.



Figure 35. Blade stroke height lock knob.

SECTION 5: ACCESSORIES

H3281—100 Tooth Carbide 24" Blade
H3387—120 Tooth Carbide 24" Blade

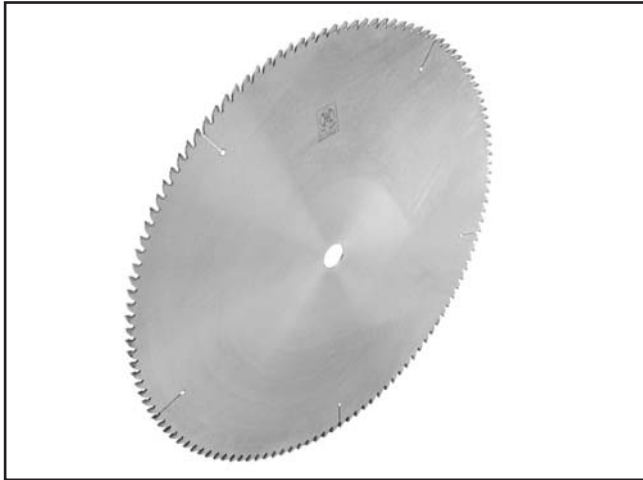


Figure 36. Model H3281 24" Blade.

P0549620A—G0549 440V Conversion Switch
Convert your prewired 220V machine to operate on 440V. Kit includes all the electrical components needed for a successful conversion.

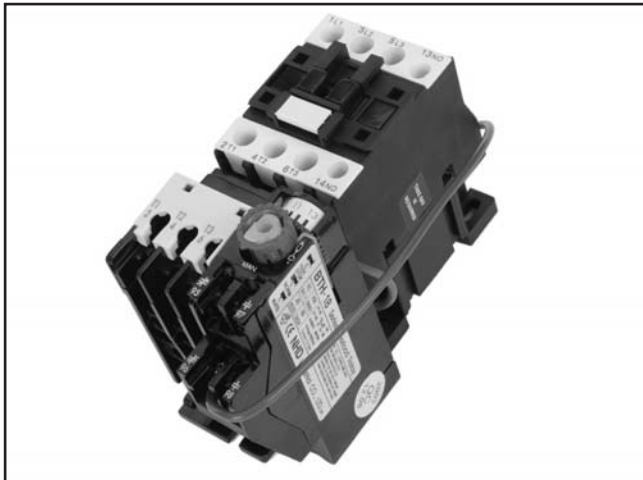


Figure 37. 440V Conversion Switch.

Call 1-800-523-4777 To Order

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 38. Model G2820 Pneumatic Tool Oil.

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 39. Our most popular safety glasses.

- 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.

- 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 41. Our most popular earmuffs.

- H3788—G96® Gun Treatment 12 oz Spray**
 - H3789—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.

Call 1-800-523-4777 To Order

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.

G7895—Citrus Degreaser

This citrus based degreaser is perfect for cleaning cosmoline off of new equipment. It also works for cleaning auto parts, tools, concrete, and porcelain surfaces. Natural, safe for the environment, and contains no CFC's.



Figure 38. G7895 Citrus Degreaser.

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.

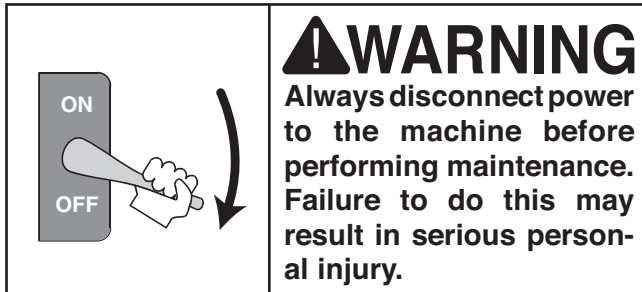
Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE

Schedule

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



Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Safety switch operates properly.

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 29 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 31), wipe dry, and apply a thin coat of general purpose grease.

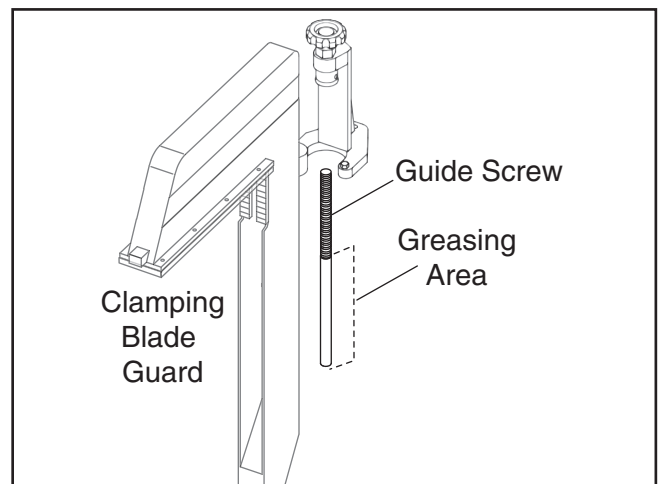


Figure 46. Guide screw greasing area.



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 32 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 the valve stem up to drain the water reservoir.

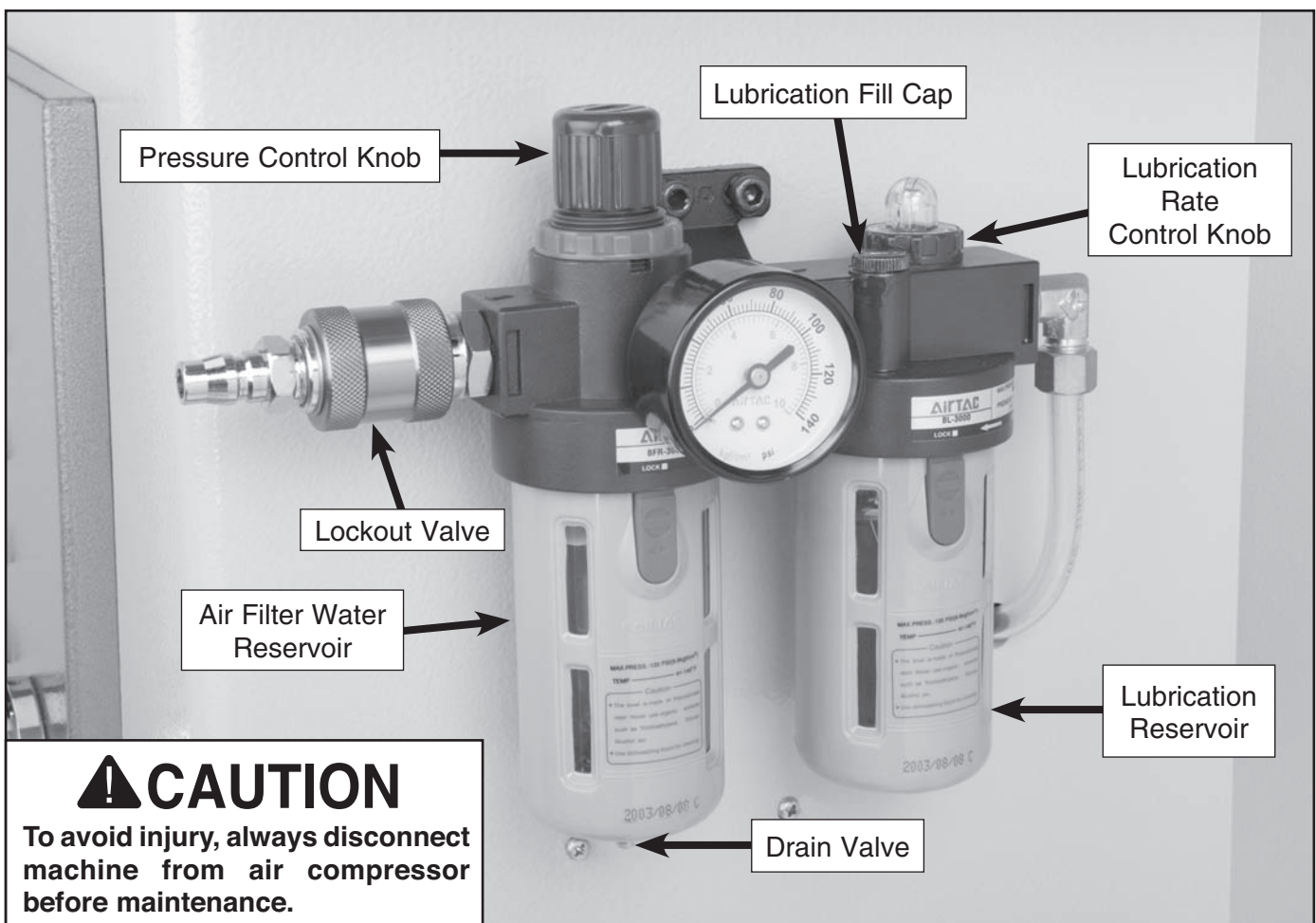


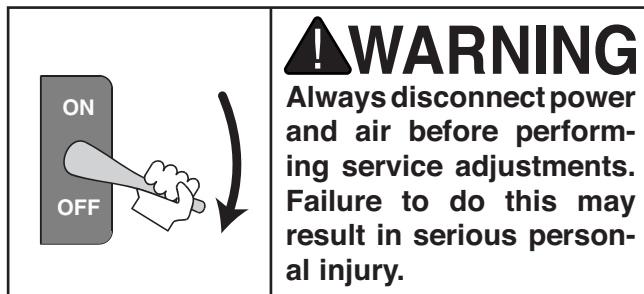
Figure 47. Filter/Lubricator/Regulator for cut-off saw air system.



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.



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 26MM	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 and air source!
2. Open the right-side cabinet door.
3. Loosen the motor mount nuts shown in **Figure 48**.

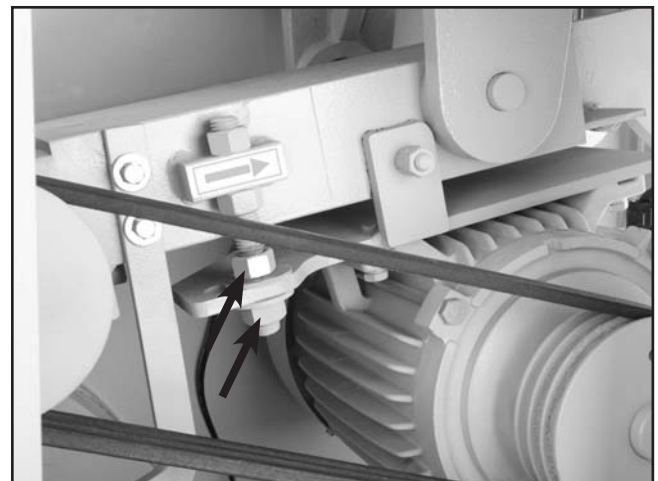


Figure 48. Motor mount nuts (1 of 2 shown).

4. Slide the motor toward the back of the saw, hold tension on the motor, and tighten the motor mount bolts.
5. Close the right-side cabinet door.



Adjusting Blade Release Switch

Tools Needed:	Qty
Small Flat Head Screwdriver.....	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.**
2. Loosen the screw that holds the blade release switch, adjust the switch slightly to the right, then retighten the 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 4x4.....	1

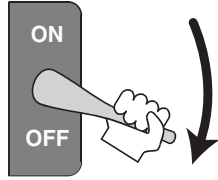
The fence must be perpendicular to the blade to ensure square cuts. If the scribe line on the table is not perpendicular to the blade, you can square the fence as described in this procedure.

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 →

	<p>⚠ WARNING This procedure is dangerous if attempted when power is connected to the saw. DO NOT perform this procedure with the saw connected to power!</p>
---	---

To square the fence to the blade:

1. **Disconnect saw from the power source!**
2. Position a 4x4 block of wood under the blade guard but out of the blade path.
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 26MM	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. Open the right-side cabinet door.
3. Loosen the motor mount nuts shown in **Figure 51**.

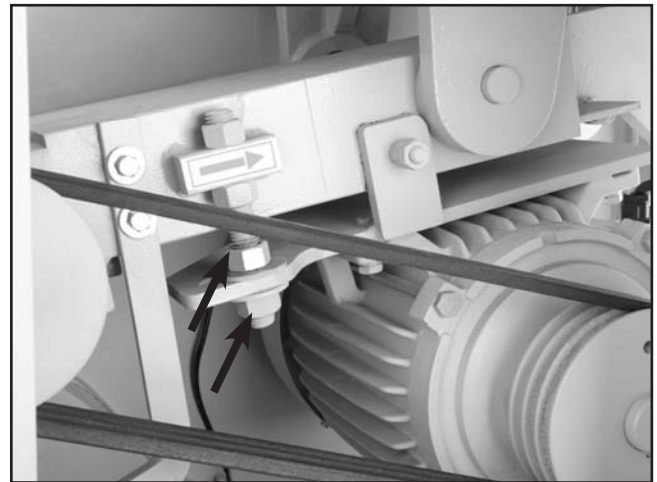


Figure 51. Motor mount nuts.

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 35**.



440V Conversion

The Model G0549 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.

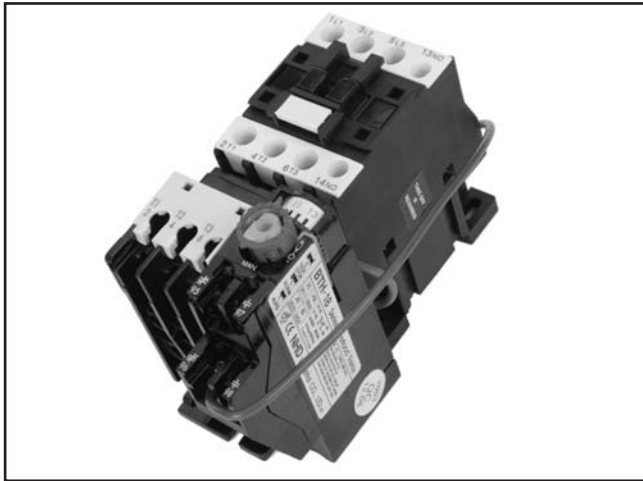


Figure 52. 440V conversion switch.

Order the Model G0549 440V Conversion Switch (P/N P0549620A) 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 qualified electrician before the saw is connected to the power source.

To rewire the Model G0549 to 440V 3-Phase:

1. **Disconnect saw from the power source!**
2. Open the electrical box.
3. Remove the 220V magnetic switch and from inside the switch box (**Figure 53**) and replace it with the 440V conversion switch.
4. Move the wire from 220V to 440V on the transformer.

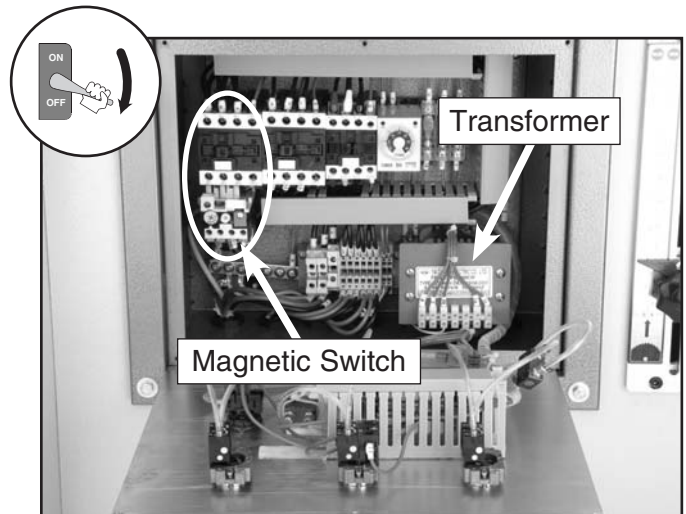


Figure 53. Magnetic switch inside the switch box.

5. Wire the motor as shown on the diagrams on the inside of the motor wire cover. Note—**Figures 54 & 55** below have been provided for your reference and were current at the time that this manual was written. However, always use the diagram on the wire cover that comes with your motor!

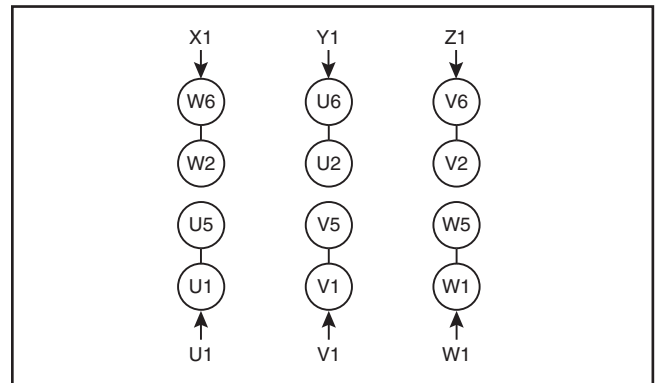


Figure 54. 220V motor wiring.

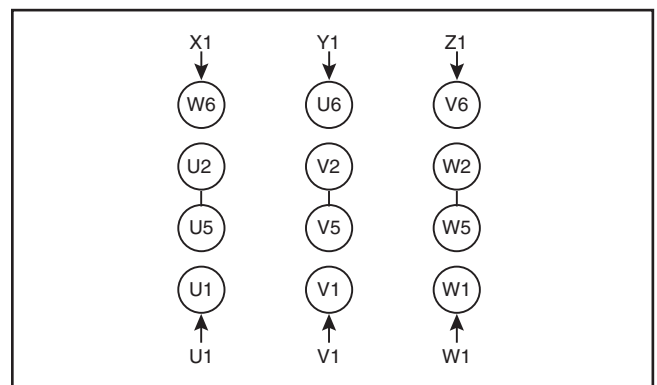
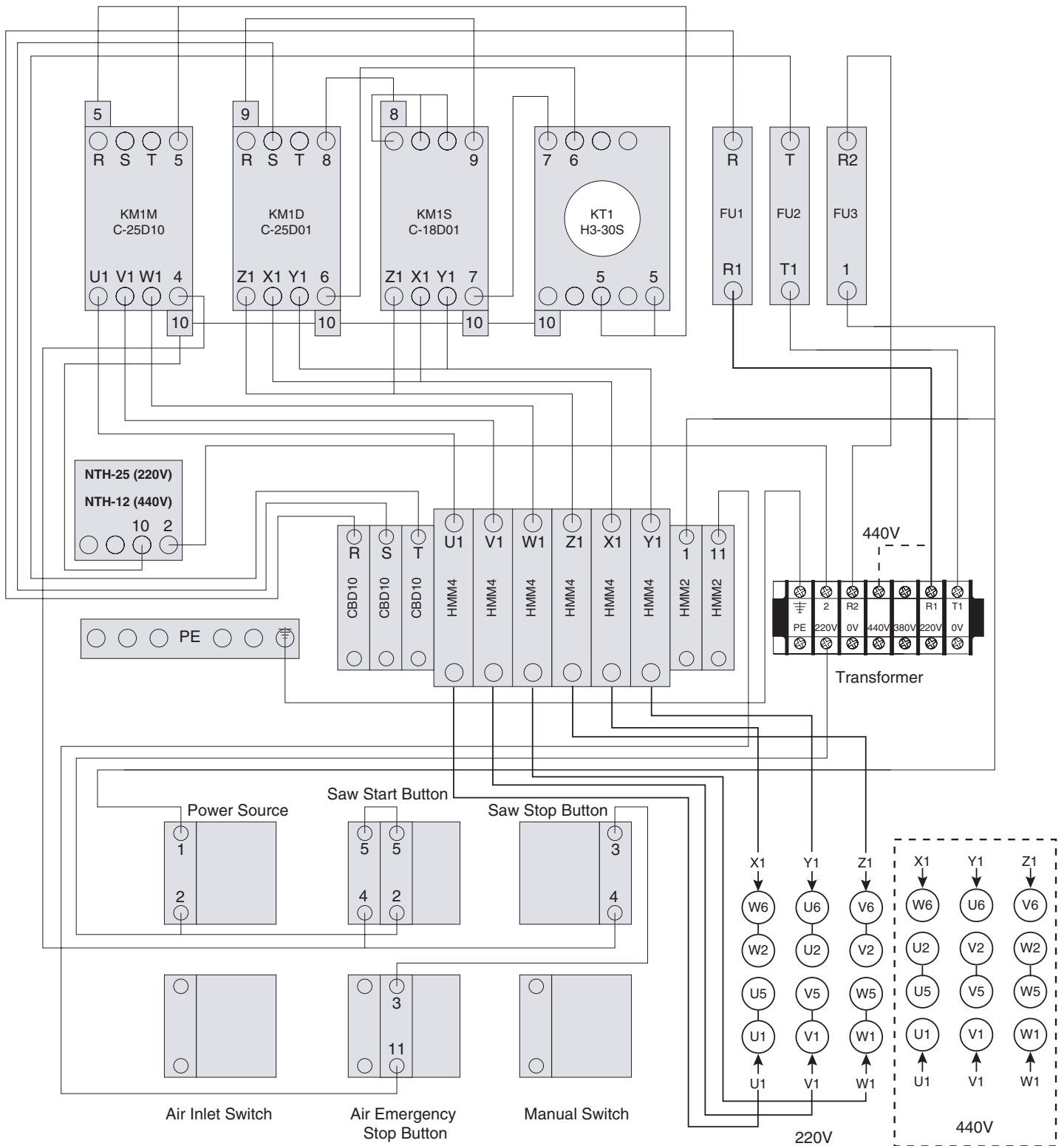


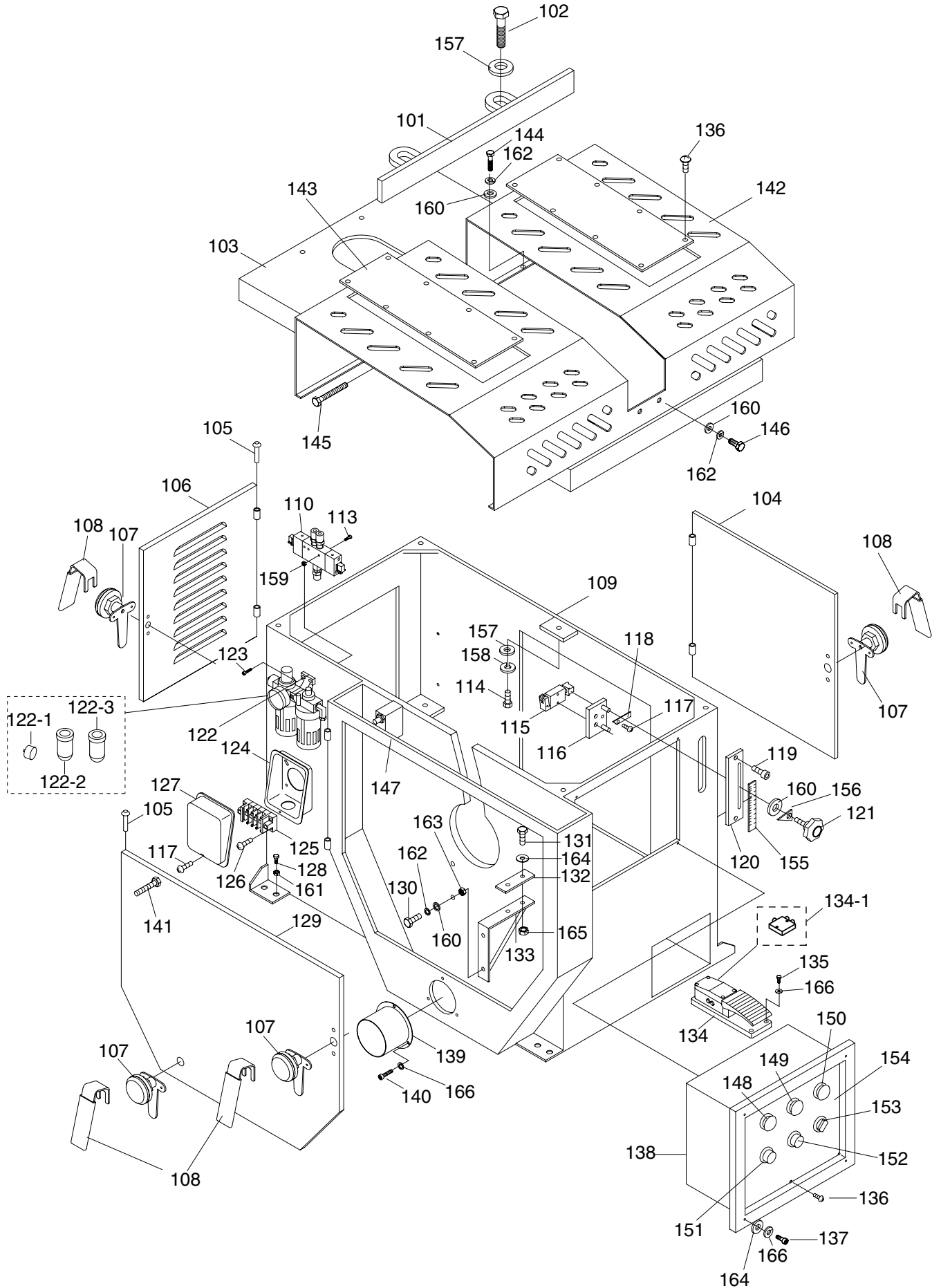
Figure 55. 440V motor wiring.



G0549 Wiring Diagram



G0549 Parts Breakdown

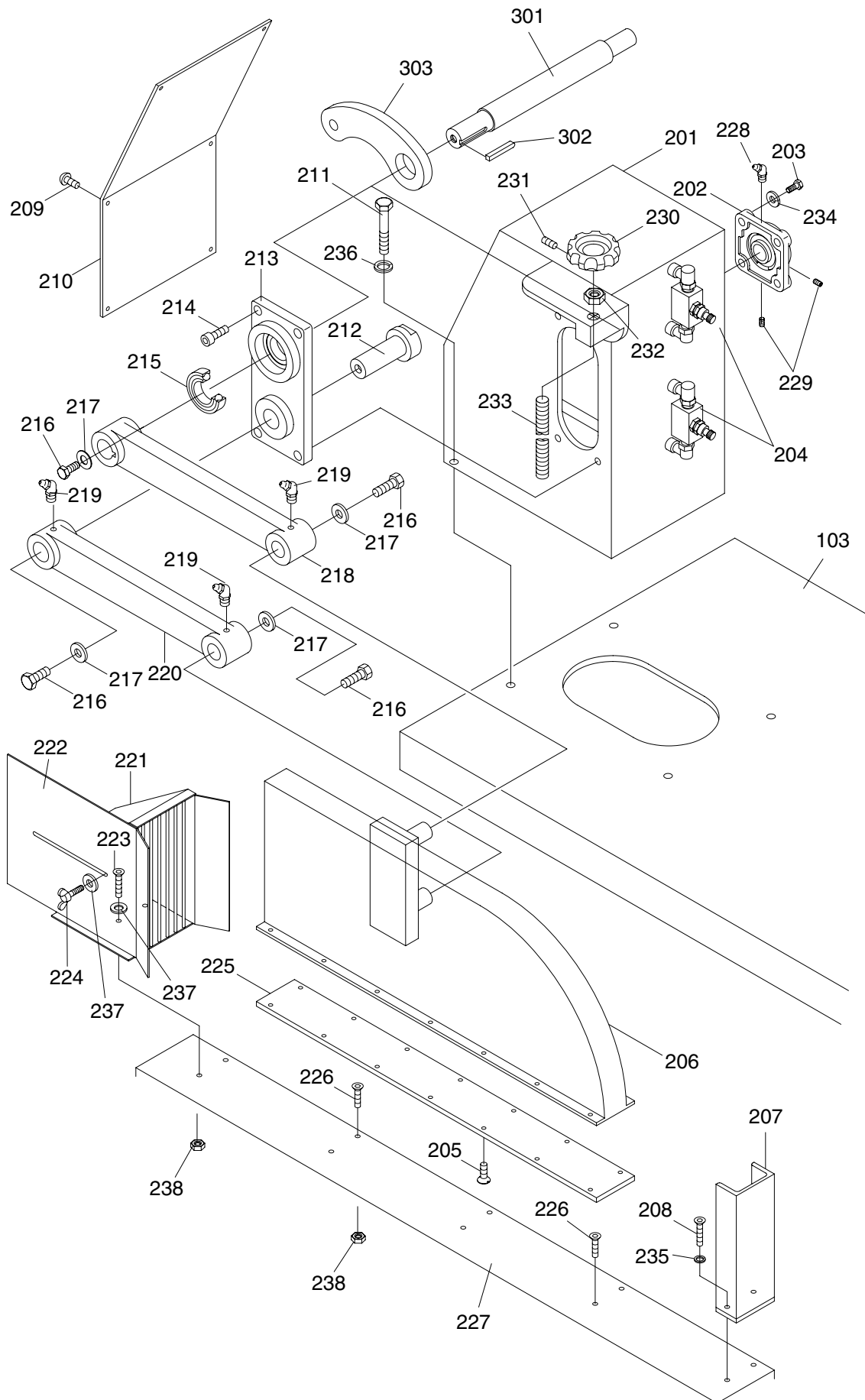


G0549

REF	PART #	DESCRIPTION
101	P0549101	FENCE
102	PB75M	HEX BOLT M12-1.75 X 35
103	P0549103	TABLE
104	P0549104	RIGHTSIDE DOOR
105	P0549105	HINGE PIN
106	P0549106	BACKSIDE DOOR
107	P0549107	SAFETY LOCK
108	P0549108	SAFETY LOCK HANDLE
109	P0549109	CABINET
110	P0549110	AIR VALVE
113	PS65M	PHLP HD SCR M4-.7 X 40
114	PB27M	HEX BOLT M12-1.75 X 30
115	P0549115	LIMIT SWITCH
116	P0549116	LIMIT SWITCH PLATE
117	PS06	PHLP HD SCR #10-24 X 3/8
118	P0549118	ELEVATION POINTER
119	PSB28M	CAP SCREW M6-1 X 15
120	P0549120	ELEVATION LOCK PLATE
121	P0549121	LOCK KNOB M8-1.25 X 30
122	P0549122	FILTER/LUBRICATE/REGULATE
122-1	P0549122-1	GAUGE
122-2	P0549122-2	OIL CUP
122-3	P0549122-3	WATER CUP
123	PSB02M	CAP SCREW M6-1 X 20
124	P0549124	TERMINAL BOX BASE
125	P0549125	TERMINAL BLOCK
126	PS03	PHLP HD SCR #10-24 X 1
127	P0549127	TERMINAL BOX COVER
128	PB51M	HEX BOLT M16-2 X 50
129	P0549129	LEFT SIDE DOOR
130	PB118M	HEX BOLT M8-1.25 X 45
131	PB47M	HEX BOLT M6-1 X 40
132	P0549132	RUBBER PAD
133	P0549133	SPINDLE SUPPORT BRACKET
134	P0549134	PEDAL SWITCH

REF	PART #	DESCRIPTION
134-1	P0549134-1	PEDAL CONTROLLER
135	PB18M	HEX BOLT M6-1 X 15
136	PS38M	PHLP HD SCR M4-.7 X 10
137	PB10M	HEX BOLT M6-1 X 25
138	P0549138	CONTROL BOX ASSEMBLY
139	P0549139	DUST PORT
140	PSB28M	CAP SCREW M6-1 X 15
141	P0549141	SPECIAL BOLT M10-1.5 X 130
142	P0549142	SAFETY GUARD
143	P0549143	ACRYLIC PLATE
144	PB09M	HEX BOLT M8-1.25 X 20
145	PB89	HEX BOLT 1/2-12 X 4 1/2
146	PB09M	HEX BOLT M8-1.25 X 20
147	P0549147	LIMIT SWITCH
148	P0549148	AIR INLET SWITCH
149	P0549149	AIR E-STOP BUTTON
150	P0549150	MANUAL SWITCH
151	P0549151	POWER SOURCE LIGHT
151-1	P0549151-1	BULB 220V
152	P0549152	SAW START BUTTON
153	P0549153	SAW STOP BUTTON
154	P0549154	PANEL
155	P0549155	SCALE
156	P0549156	ELEVATION POINTER
157	PW06M	FLAT WASHER 12MM
158	PLW05M	LOCK WASHER 12MM
159	PN04M	HEX NUT M4-.7
160	PW01M	FLAT WASHER 8MM
161	PN13M	HEX NUT M16-2
162	PLW04M	LOCK WASHER 8MM
163	PN03M	HEX NUT M8-1.25
164	PW03M	FLAT WASHER 6MM
165	PN01M	HEX NUT M6-1
166	PLW03M	LOCK WASHER 6MM

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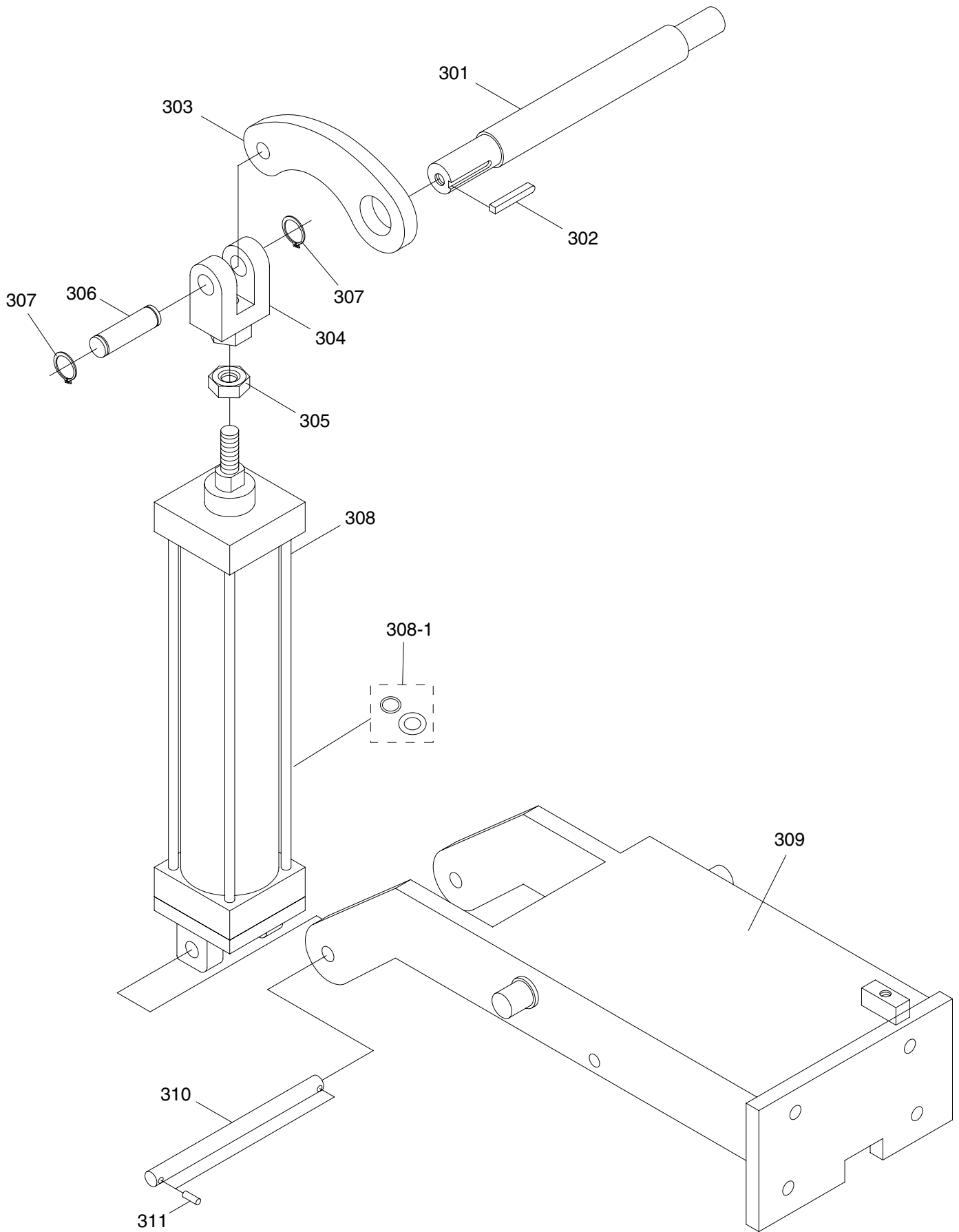


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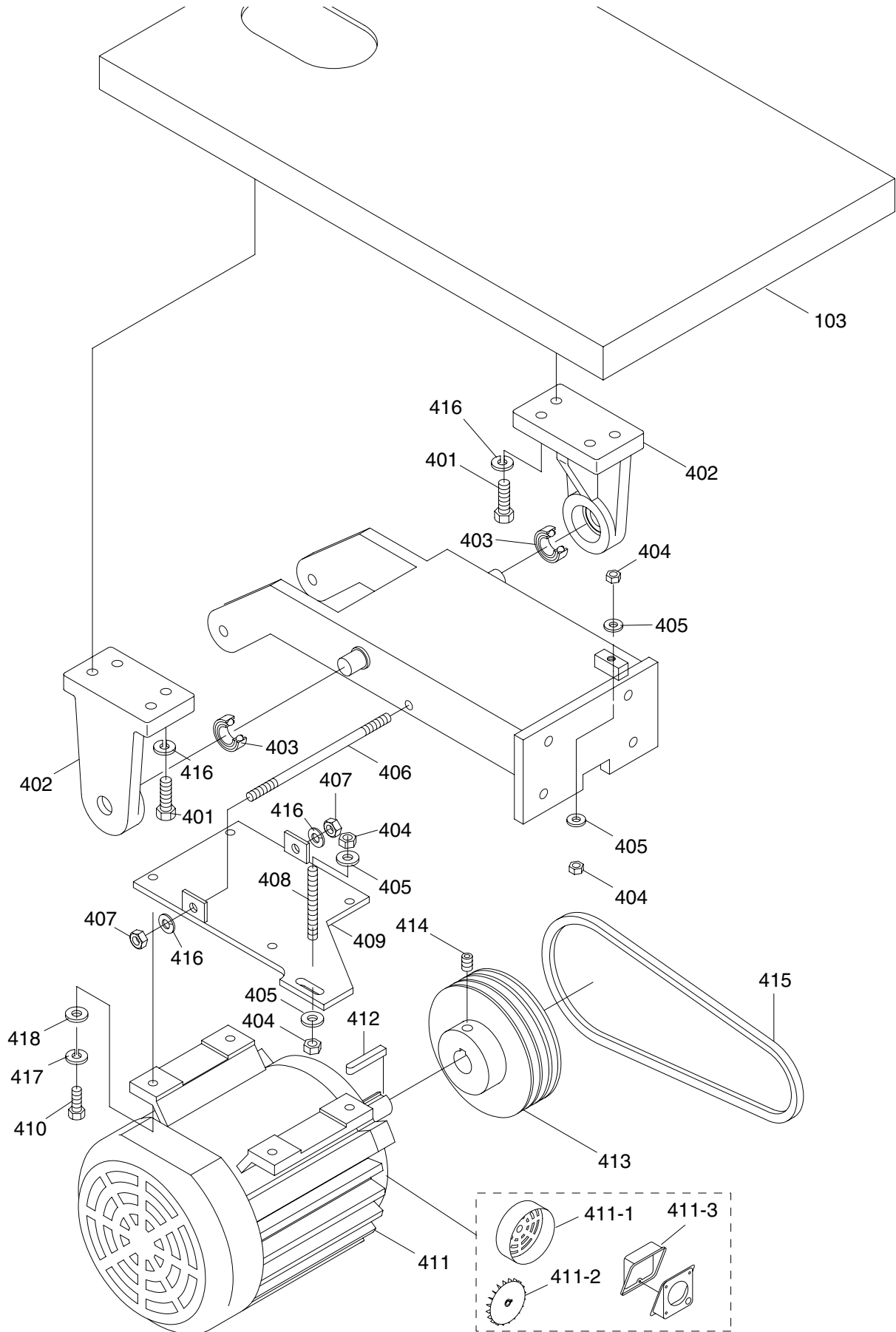
REF	PART #	DESCRIPTION
201	P0549201	UPPER SEAT
202	PUCF205	BEARING CASING UCF205
203	PB24	HEX BOLT 3/8-16 X 1 1/4
204	P0549204	ADJUSTABLE AIR VALVE
205	PFH40M	FLAT HD SCR M6-1 X 15
206	P0549206	BLADE GUARD
207	P0549207	SAFETY COVER
208	PB118M	HEX BOLT M8-1.25 X 45
209	PS65M	PHLP HD SCR M6-1 X 10
210	P0549210	UPPER SEAT REAR COVER
211	PB27M	HEX BOLT M12-1.75 X 30
212	P0549212	SUPPORT ARM SHAFT
213	P0549213	SQUARE BRACKET
214	PSB14	CAP SCREW 3/8-16 X 1
215	P6206	BALL BEARING 6206ZZ
216	PB53	HEX BOLT 1/2-12 X 1
217	P0549217	FENDER WASHER 1/2
218	P0549218	MAIN CRANK
219	P0549219	GREASE FITTING 1/8 X 45°

REF	PART #	DESCRIPTION
220	P0549220	SUPPORT CRANK
221	P0549221	UPPER DUST HOOD
222	P0549222	ADJUSTABLE PLATE
223	PB71M	HEX BOLT M6-1 X 45
224	P0549224	WING BOLT M6-1 X 12
225	P0549225	RUBBER PLATE
226	PFH03M	FLAT HD SCR M6-1 X 40
227	P0549227	BAKELITE INSERT
228	P0549228	GREASE FITTING 1/16 X 90°
229	PSS02M	SET SCREW M6-1 X 6
230	P0549230	ADJUSTMENT KNOB 3/4-10
231	PSS16M	SET SCREW M8-1.25 X 10
232	PN17	HEX NUT 3/4-10
233	P0549233	STUD 3/4 X 6"
234	PLW04	LOCK WASHER 3/8
235	PLW04M	LOCK WASHER 8MM
236	PLW05M	LOCK WASHER 12MM
237	PW03M	FLAT WASHER 6MM
238	PN01M	HEX NUT M6-1

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G0549

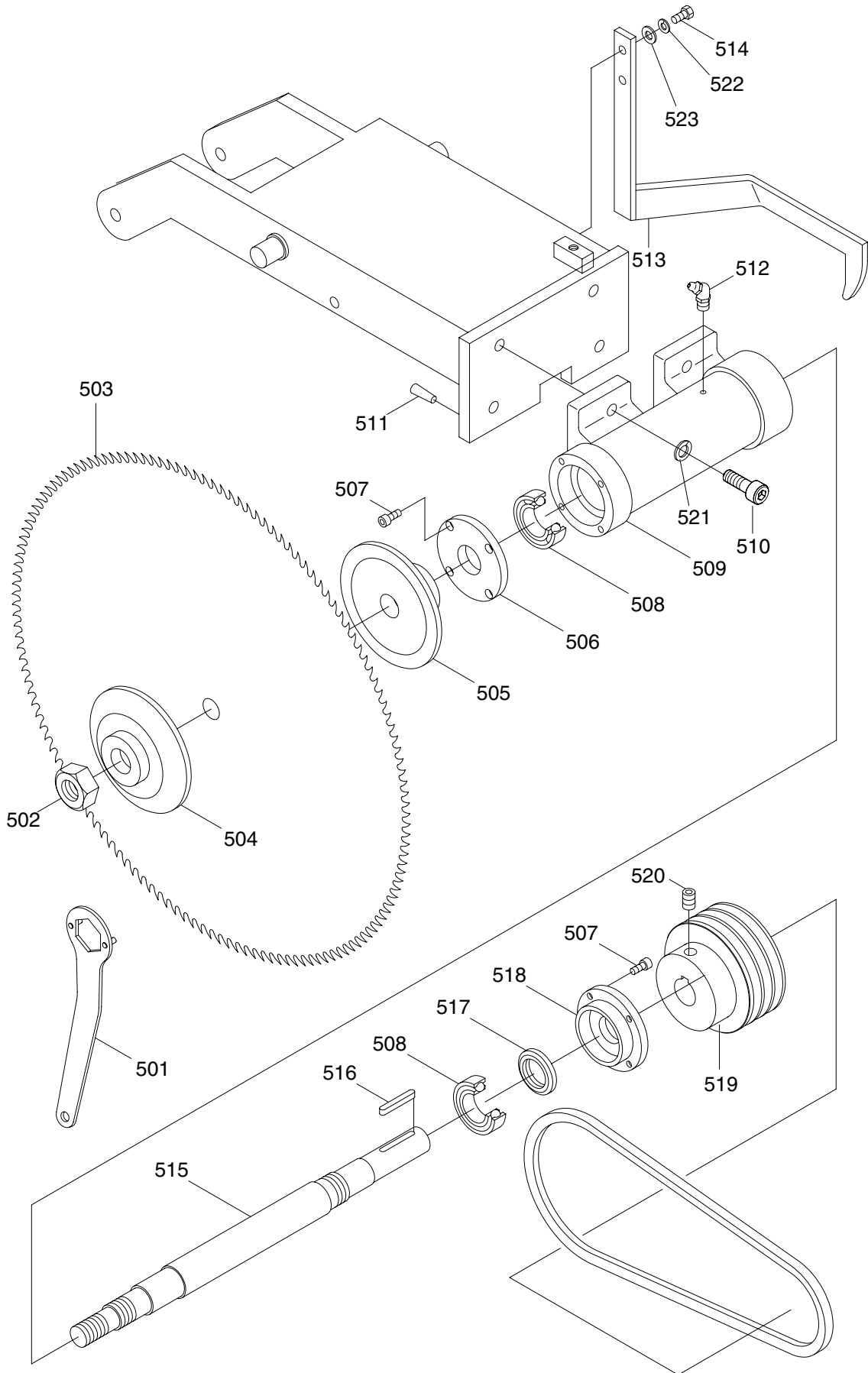


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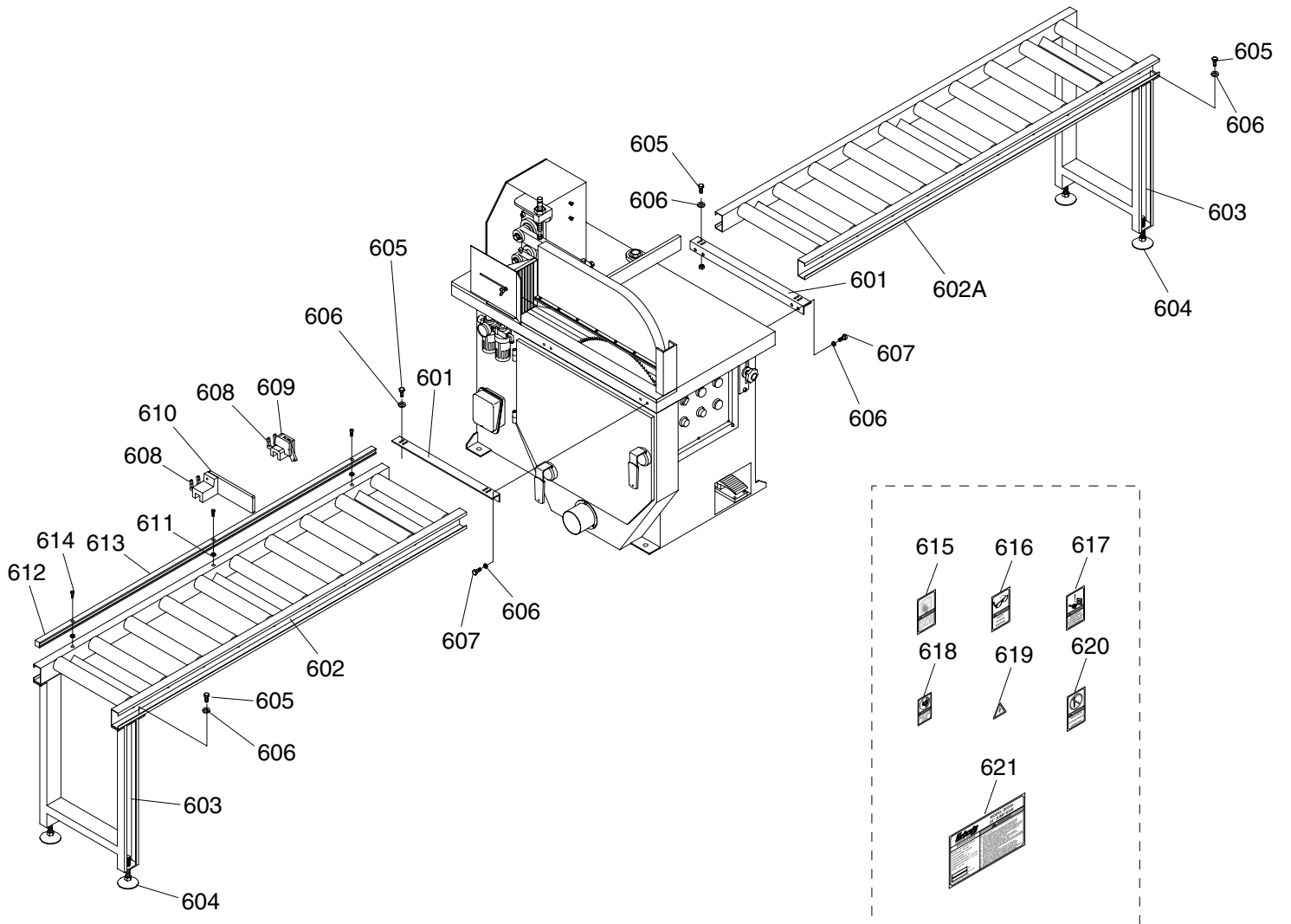
REF	PART #	DESCRIPTION
301	P0549301	MAIN CRANK SHAFT
302	PK86M	KEY 7 X 8 X 50
303	P0549303	ELEVATION PLATE
304	P0549304	ROD END CLEVIS
305	PN17M	HEX NUT M20-1.5
306	P0549306	COUPLING PIN
307	PR09M	EXT. RETAINING RING 20MM
308	P0549308	AIR CYLINDER 80 X 300MM
308-1	P0549308-1	AIR CYLINDER SEAL KIT
309	P0549309	SUPPORT FRAME
310	P0549310	COUPLING PIN
311	P0549311	SPLINE PIN 5 X 35MM

REF	PART #	DESCRIPTION
401	PB33M	HEX BOLT M12-1.75 X 50
402	P0549402	BRACKET
403	P6205	BALL BEARING 6205ZZ
404	PN13M	HEX NUT M16-2
405	PW08M	FLAT WASHER 16MM
406	P0549406	MOTOR MOUNT BAR M12-1.75
407	PN09M	HEX NUT M12-1.75
408	P0549408	MOTOR SCREW 3/4-10 X 6
409	P0549409	MOTOR PLATE
410	PB01M	HEX BOLT M10-1.5 X 30
411	P0549411	MOTOR 15HP
411-1	P0549411-1	MOTOR FAN COVER
411-2	P0549411-2	MOTOR FAN
411-3	P0549411-3	WIRING BOX
412	PK87M	KEY 10 X 8 X 80
413	P0549413	MOTOR PULLEY
414	PSS13M	SET SCREW M10-1.5 X 12
415	P0549415	V-BELT MF6500
416	PLW05M	LOCK WASHER 12MM
417	PLW06M	LOCK WASHER 10MM
418	PW04M	FLAT WASHER 10MM

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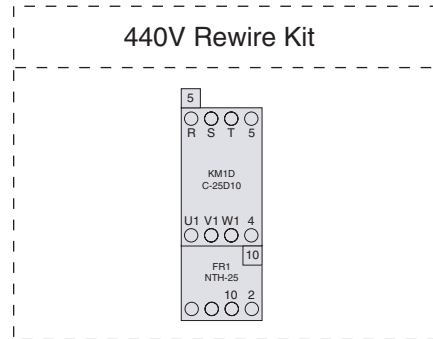
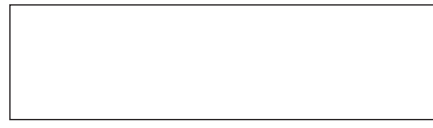
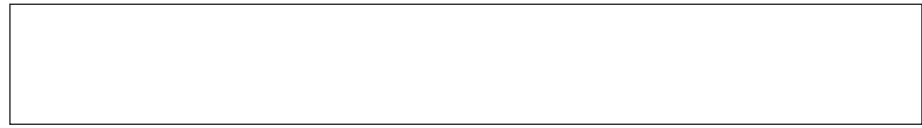
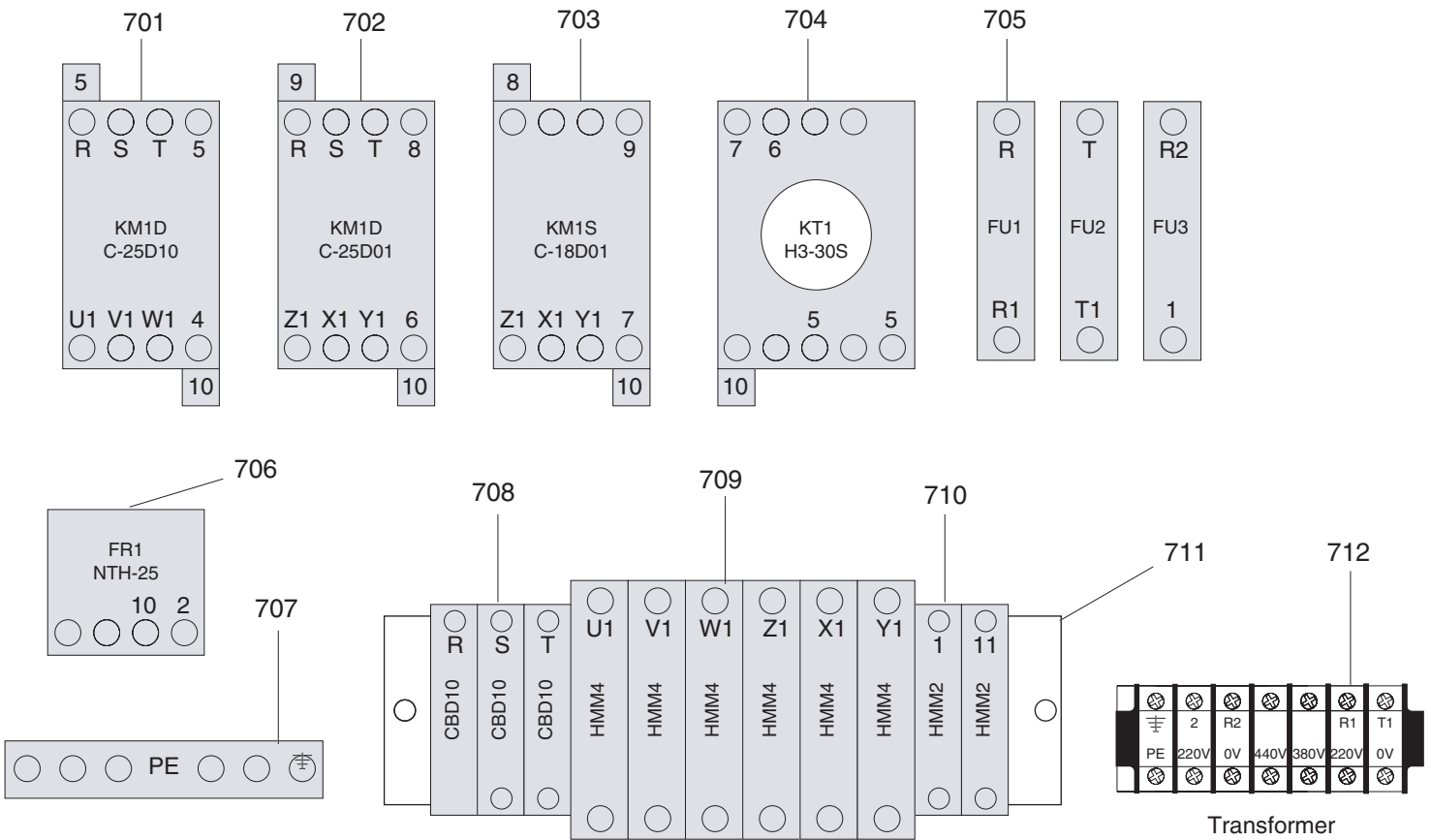


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REF	PART #	DESCRIPTION
501	P0549501	ARBOR WRENCH
502	P0549502	ARBOR NUT 1-12
503	P0549503	BLADE 24 X 1 X 80T X 0.16
504	P0549504	BLADE HUB
505	P0549505	ARBOR FLANGE
506	P0549506	FRONT COVER
507	PSB02M	CAP SCREW M6-1 X 20
508	P6207	BALL BEARING 6207ZZ
509	P0549509	SPINDLE HOUSING
510	PSB92M	CAP SCREW M12-1.75 X 40
511	P0549511	TAPER PIN 4 X 40MM
512	P0549512	GREASE FITTING 1/4
513	P0549513	LIMIT SWITCH DOG
514	PB07M	HEX BOLT M8-1.25 X 25
515	P0549515	SPINDLE SHAFT
516	PK86M	KEY 7 X 8 X 50
517	P0549517	LOCKING NUT (LH)
518	P0549518	REAR COVER
519	P0549519	ARBOR PULLEY
520	PSS76M	SET SCREW M10-1.5 X 15
521	PLW05M	LOCK WASHER 12MM
522	PLW04M	LOCK WASHER 8MM
523	PW01M	FLAT WASHER 8MM

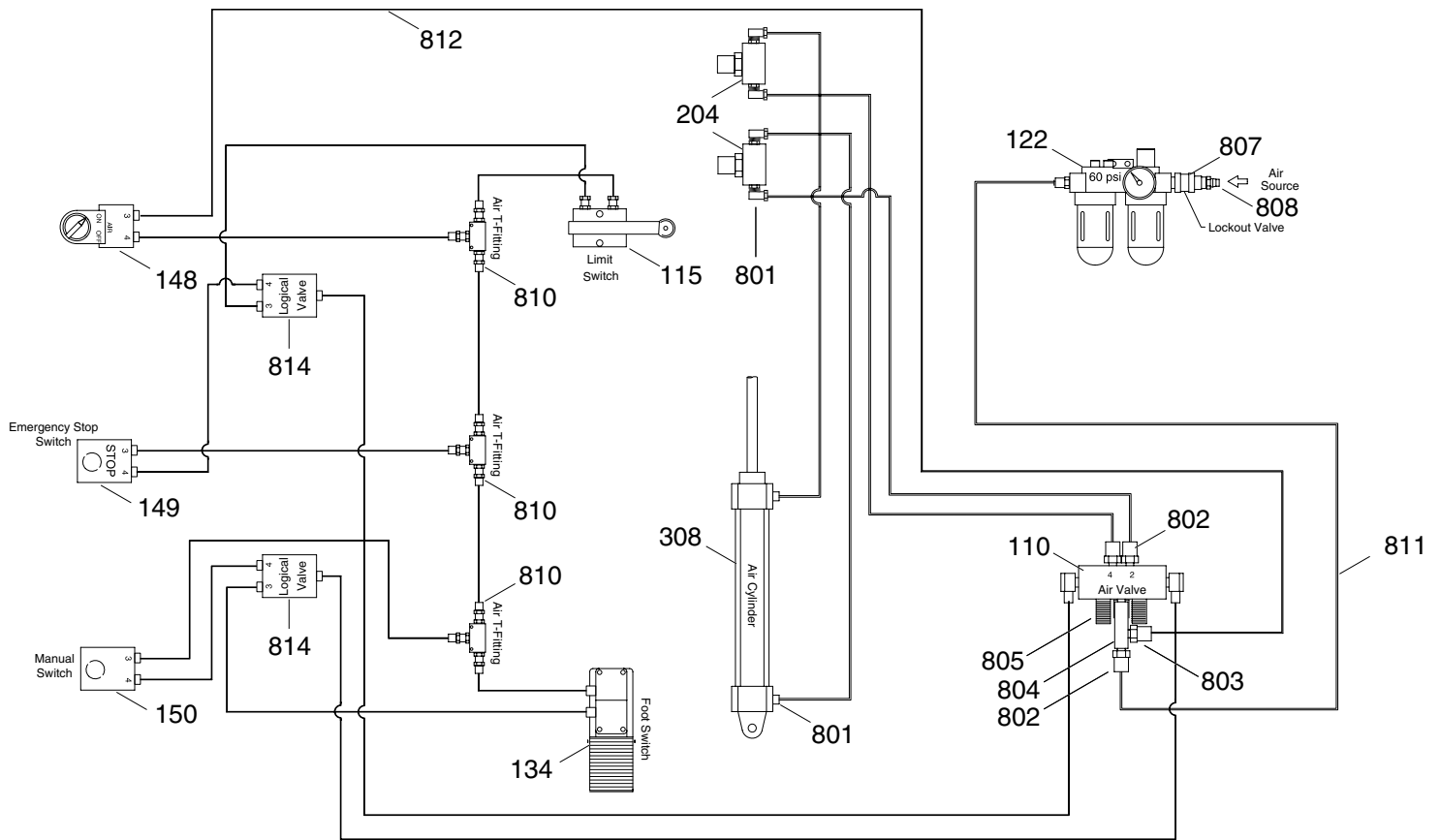
REF	PART #	DESCRIPTION
601	P0549601	BRACKET
602	P0549602	LEFT ROLLER CONVEYOR
602A	P0549602A	RIGHT ROLLER CONVEYOR
603	P0549603	STAND
604	P0549604	ADJUSTMENT FOOT 5/8-11 X 4
605	PB09M	HEX BOLT M8-1.25 X 20
606	PW01M	FLAT WASHER 8MM
607	PB07M	HEX BOLT M8-1.25 X 25
608	P0549608	LOCK HANDLE M8-1.25 X 20
609	P0549609	FLIP STOP
610	P0549610	FIXED STOP
611	P0549611	SQUARE WASHER
612	P0549612	SQUARE RAIL
613	P0549613	SCALE
614	PSB13M	CAP SCREW M8-1.25 X 30
615	PLABEL-12	READ MANUAL LABEL
616	PLABEL-11	WEAR SAFETY GLASSES LABEL
617	PLABEL-36	UNPLUG 220V LABEL
618	P0549618	HANDS UNDER GUARD LABEL
619	PLABEL-14	ELECTRICITY LABEL
620	PLABEL-30	KEEP DOOR CLOSED LABEL
621	P0549621	MACHINE ID LABEL

G0549 Electrical Panel Parts



REF	PART #	DESCRIPTION
701	P0549701	CONTACTOR KM1M C-25D10
702	P0549702	CONTACTOR KM1D C25D01
703	P0549703	CONTACTOR KM1S C-18D01
704	P0549704	TIMER KT1 H3-30S
705	P0549705	FUSE 5 AMP
706	P0549706	OVERLOAD FR1 NTH-25 SET 22
707	P0549707	TERMINAL STRIP PE X 6
708	P0549708	MODULAR TERMINAL CBD10
709	P0549709	MODULAR TERMINAL HMM4
710	P0549710	MODULAR TERMINAL HMM2
711	P0549711	MODULAR TERMINAL BASE
712	P0549712	TRANSFORMER TC1
713	P0549713	WIRE LOOM & COVER 25 X 230
714	P0549714	WIRE LOOM & COVER 25 X 190
715	P0549715	WIRE LOOM & COVER 25 X 160
716	P0549716	WIRE LOOM & COVER 25 X 130
717	P0549620A	440V REWIRE KIT

G0549 Air System Parts



REF	PART #	DESCRIPTION
801	P0549801	AIR ELBOW 3/8 MPT X 10MM
802	P0549802	AIR FITTING 1/4 MPT X 10MM
803	P0549803	AIR ELBOW 1/4 MPT X 4MM
804	P0549804	T-FITTING PT 1/4(F) X 1/4(F) X 1/4(F)
805	P0549805	AIR MUFFLER 1/8 MPT
807	P0549807	AIR STOP VALVE 3/8 MPT X 3/8
808	P0549808	AIR COUPLER 3/8 MPT
810	P0549810	TUBE FITTING UNION-T X 4MM
811	P0549811	AIR HOSE 6.5 X 10 X 1800MM (CTF)
812	P0549812	AIR HOSE 2.5 X 4 X 2500MM (CTF)
814	P0549814	LOGICAL VALVE

Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor will not start.	<ol style="list-style-type: none"> 1. Low voltage. 2. Open circuit in motor or loose connections. 	<ol style="list-style-type: none"> 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.	<ol style="list-style-type: none"> 1. Short circuit in line cord or plug. 	<ol style="list-style-type: none"> 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).	<ol style="list-style-type: none"> 1. Power line overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long. 3. General overloading of power company facilities. 	<ol style="list-style-type: none"> 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.	<ol style="list-style-type: none"> 1. Motor overloaded. 2. Air circulation through the motor restricted. 	<ol style="list-style-type: none"> 1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> 1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded. 	<ol style="list-style-type: none"> 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.	<ol style="list-style-type: none"> 1. Two of the power wires are reversed. 	<ol style="list-style-type: none"> 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.	<ol style="list-style-type: none"> 1. V-belt loose. 2. V-belt worn out. 	<ol style="list-style-type: none"> 1. Tighten V-belt (page 35). 2. Replace V-belt (page 37).
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> 1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective. 	<ol style="list-style-type: none"> 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 37).
Vibration when running or cutting.	<ol style="list-style-type: none"> 1. Loose or damaged blade. 2. Worn arbor bearings. 	<ol style="list-style-type: none"> 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).	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. Increase air pressure. 2. Add lubrication to the lubricator cup (see page 33). 3. Clean/lubricate the guide screw (page 32). 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#P0549308-1), or replace entire cylinder (part#P0549308).
Wood cuts slow or smokes during cut.	<ol style="list-style-type: none"> 1. Worn or dull blade. 2. Blade installed backwards. 3. Blade spinning backwards due to reversed wires at terminal strip. 	<ol style="list-style-type: none"> 1. Replace blade (see page 26). 2. Check blade rotation as described in "Test Run" on page 24, making sure teeth point counterclockwise. 3. Switch two of the current carrying wires at the terminal strip.
Rough or poor quality cuts.	<ol style="list-style-type: none"> 1. Feed rate set too high. 	<ol style="list-style-type: none"> 1. Reduce feed rate (see page 27).
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean out dust port. 2. Three options: —Check dust lines for leaks or clogs. —Shorten distance, or length of hose, between dust collector and machine. —Install a stronger dust collector.
Air leaks from air system components.	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 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?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend
<input type="checkbox"/> Catalog	<input type="checkbox"/> Card Deck
<input type="checkbox"/> World Wide Web	
<input type="checkbox"/> Other _____	
2. Which of the following magazines do you subscribe to.

<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Cabinetmaker
<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Family Handyman
<input type="checkbox"/> Today's Homeowner	<input type="checkbox"/> Fine Homebuilding
<input type="checkbox"/> WOOD	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Home Handyman	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Journal of Light Construction	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Woodworker
<input type="checkbox"/> Popular Science	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Workbench
<input type="checkbox"/> Other _____	
3. Which of the following woodworking/remodeling shows do you watch?

<input type="checkbox"/> Backyard America	<input type="checkbox"/> The New Yankee Workshop
<input type="checkbox"/> Home Time	<input type="checkbox"/> This Old House
<input type="checkbox"/> Woodwright's Shop	
<input type="checkbox"/> Other _____	
4. What is your annual household income?

<input type="checkbox"/> \$20,000-\$29,999	<input type="checkbox"/> \$60,000-\$69,999
<input type="checkbox"/> \$30,000-\$39,999	<input type="checkbox"/> \$70,000-\$79,999
<input type="checkbox"/> \$40,000-\$49,999	<input type="checkbox"/> \$80,000-\$89,999
<input type="checkbox"/> \$50,000-\$59,999	<input type="checkbox"/> \$90,000 +
5. What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 50-59
<input type="checkbox"/> 30-39	<input type="checkbox"/> 60-69
<input type="checkbox"/> 40-49	<input type="checkbox"/> 70 +
6. How long have you been a woodworker?

<input type="checkbox"/> 0 - 2 Years	<input type="checkbox"/> 8 - 20 Years
<input type="checkbox"/> 2 - 8 Years	<input type="checkbox"/> 20+ Years
7. How would you rank your woodworking skills?

<input type="checkbox"/> Simple	<input type="checkbox"/> Advanced
<input type="checkbox"/> Intermediate	<input type="checkbox"/> Master Craftsman
8. What stationary woodworking tools do you own? Check all that apply.

<input type="checkbox"/> Air Compressor	<input type="checkbox"/> Panel Saw
<input type="checkbox"/> Bandsaw	<input type="checkbox"/> Planer
<input type="checkbox"/> Drill Press	<input type="checkbox"/> Power Feeder
<input type="checkbox"/> Drum Sander	<input type="checkbox"/> Radial Arm Saw
<input type="checkbox"/> Dust Collector	<input type="checkbox"/> Shaper
<input type="checkbox"/> Horizontal Boring Machine	<input type="checkbox"/> Spindle Sander
<input type="checkbox"/> Jointer	<input type="checkbox"/> Table Saw
<input type="checkbox"/> Lathe	<input type="checkbox"/> Vacuum Veneer Press
<input type="checkbox"/> Mortiser	<input type="checkbox"/> Wide Belt Sander
<input type="checkbox"/> Other _____	
9. How many of your woodworking machines are Grizzly? _____
10. Which benchtop tools do you own? Check all that apply.

<input type="checkbox"/> 1" x 42" Belt Sander	<input type="checkbox"/> 6" - 8" Grinder
<input type="checkbox"/> 5" - 8" Drill Press	<input type="checkbox"/> Mini Lathe
<input type="checkbox"/> 8" Table Saw	<input type="checkbox"/> 10" - 12" Thickness Planer
<input type="checkbox"/> 8" - 10" Bandsaw	<input type="checkbox"/> Scroll Saw
<input type="checkbox"/> Disc/Belt Sander	<input type="checkbox"/> Spindle/Belt Sander
<input type="checkbox"/> Mini Jointer	
<input type="checkbox"/> 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.

<input type="checkbox"/> Belt Sander	<input type="checkbox"/> Orbital Sander
<input type="checkbox"/> Biscuit Joiner	<input type="checkbox"/> Palm Sander
<input type="checkbox"/> Circular Saw	<input type="checkbox"/> Portable Planer
<input type="checkbox"/> Detail Sander	<input type="checkbox"/> Saber Saw
<input type="checkbox"/> Drill/Driver	<input type="checkbox"/> Reciprocating Saw
<input type="checkbox"/> Miter Saw	<input type="checkbox"/> Router
<input type="checkbox"/> 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: _____

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