

# **Grizzly** **Industrial, Inc.**®

## **MODEL G0622** **4" x 6" METAL CUTTING** **BANDSAW** **OWNER'S MANUAL** *(For models manufactured since 09/17)*



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

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## **WARNING!**

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

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

**The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.**

**The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.**



## **WARNING!**

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

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

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

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# INTRODUCTION

## Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support  
1815 W. Battlefield  
Springfield, MO 65807  
Phone: (570) 546-9663  
Email: techsupport@grizzly.com

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

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


## Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at [www.grizzly.com](http://www.grizzly.com).

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

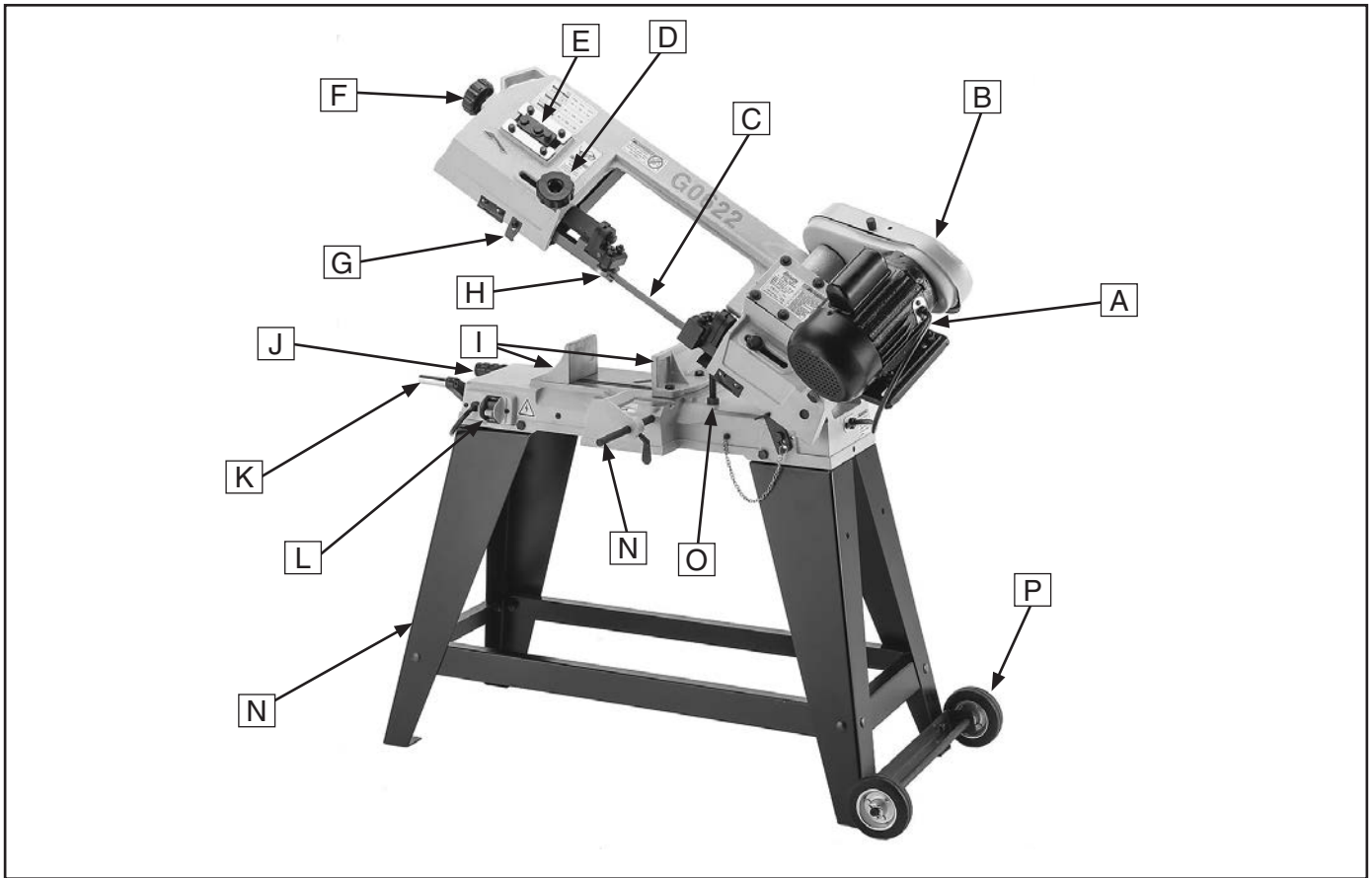
		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety is correctly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not operate if fatigued, drowsy, or under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
Manufactured for Grizzly in Taiwan			

Manufacture Date

Serial Number



# Identification



**Figure 1.** Model G0622 controls and features.

- A. Motor
- B. Pulley Cover
- C. Blade
- D. Blade Guard Adjustment Knob
- E. Blade Tracking Mechanism
- F. Blade Tension Knob
- G. Auto-Off Tab
- H. Blade Guide Bearing Assemblies
- I. Vise Jaws
- J. Feed Adjustment Handle
- K. Vise Crank
- L. Power Switch
- M. Stand
- N. Work Stop
- O. Horizontal Stop
- P. Stand Wheels





# MACHINE DATA SHEET

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

## MODEL G0622 4" X 6" 3/4 HP METAL-CUTTING BANDSAW

### Product Dimensions:

Weight..... 117 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 34 x 14 x 38 in.  
Footprint (Length x Width)..... 34 x 14 in.

### Shipping Dimensions:

Type..... Cardboard Box  
Content..... Machine  
Weight..... 122 lbs.  
Length x Width x Height..... 39 x 13 x 15 in.  
Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz  
Prewired Voltage..... 110V  
Full-Load Current Rating..... 5A  
Minimum Circuit Size..... 15A  
Connection Type..... Cord & Plug  
Power Cord Included..... Yes  
Power Cord Length..... 6-1/2 ft.  
Power Cord Gauge..... 18 AWG  
Plug Included..... Yes  
Included Plug Type..... 5-15  
Switch Type..... Toggle Safety Switch w/Removable Key & Automatic Shut-Off

### Motors:

#### Main

Horsepower..... 3/4 HP  
Phase..... Single-Phase  
Amps..... 5A  
Speed..... 1725 RPM  
Type..... TEFC Capacitor-Start Induction  
Power Transfer..... V-Belt Drive  
Bearings..... Shielded & Permanently Lubricated  
Centrifugal Switch/Contacts Type..... Internal

### Main Specifications:

#### Operation Info

Blade Speeds..... 78, 108, 180 FPM  
Std. Blade Length..... 64-1/2 in.  
Blade Length Range..... 1/2 in.



### Cutting Capacities

Cutting Height.....	6 in.
Angle Cuts.....	1 - 45 deg.
Vise Jaw Depth.....	6-1/2 in.
Vise Jaw Height.....	3-1/4 in.
Max. Capacity Rectangular Height at 90 Deg.....	4-1/2 in.
Max. Capacity Rectangular Width at 90 Deg.....	6 in.
Max. Capacity Round at 90 Deg.....	4-1/2 in.
Max. Capacity Rectangular Height at 45 Deg.....	4-1/2 in.
Max. Capacity Rectangular Width at 45 Deg.....	3-1/2 in.
Max. Capacity Round at 45 Deg.....	3-1/2 in.
Max. Capacity Rectangular Height at 60 Deg.....	4-1/2 in.
Max. Capacity Rectangular Width at 60 Deg.....	5 in.
Max. Capacity Round at 60 Deg.....	4-1/2 in.

### Construction

Table.....	Cast Iron
Upper Wheel.....	Cast Iron
Lower Wheel.....	Cast Iron
Body.....	Cast Iron
Base.....	Cast Iron
Stand.....	Pre-formed Steel
Wheel Cover.....	Pre-Formed Steel
Paint Type/Finish.....	Urethane Hammertone

### Other

Wheel Size.....	7-3/8 in.
Blade Guides Upper.....	Ball Bearing
Blade Guides Lower.....	Ball Bearing
Mobile Base.....	Built-In

### Table Info

Table Size Length.....	10-1/4 in.
Table Size Width.....	6-3/4 in.
Table Size Thickness.....	1-1/4 in.
Floor To Cutting Area Height.....	33 in.

### Other Specifications:

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	30 Minutes
Serial Number Location .....	ID on Body Frame
ISO 9001 Factory .....	No
Certified by a Nationally Recognized Testing Laboratory (NRTL) .....	No

### Features:

Horizontal and Vertical Operation  
Automatic Shut-Off  
3/4 HP Motor  
Work Stop



# SECTION 1: SAFETY

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

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



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



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



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

**NOTICE**

Alerts the user to useful information about proper operation of the machine to avoid machine damage.

## Safety Instructions for Machinery

### **WARNING**

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

**TRAINED OPERATORS ONLY.** Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

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

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

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

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

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





# WARNING

**WEARING PROPER APPAREL.** Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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

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

**USE CORRECT TOOL FOR THE JOB.** Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

**AWKWARD POSITIONS.** Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

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

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

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

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

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

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

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

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

**DAMAGED PARTS.** Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

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

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



# Additional Safety for Horizontal Metal Bandsaws

## WARNING

Serious injury or death can occur from getting fingers, hair, or clothing entangled in rotating or moving parts or making direct contact with the moving blade. To minimize risk of injury, anyone operating this machine **MUST** completely heed hazards and warnings below.

**BLADE CONDITION.** Do not operate with dull, cracked, or badly worn blade. Inspect blades for cracks and missing teeth before each use.

**HAND PLACEMENT.** Never position hands or fingers in line with the cut or under bandsaw head-stock while lowering or operating. Hands could be cut or crushed.

**BLADE GUARD POSITION.** Adjust blade guard as close to workpiece as possible before cutting to minimize operator exposure to unused portion of blade.

**ENTANGLEMENT HAZARDS.** Do not operate this saw without blade guard in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.

**BLADE REPLACEMENT.** When replacing blades, disconnect the machine from power, wear gloves to protect hands and safety glasses to protect eyes.

**HOT SURFACES.** Contact with hot surfaces from machine components, ejections of hot chips, swarf, and the workpiece itself can cause burns.

**WORKPIECE HANDLING.** Always properly support workpiece with table, vise, or some type of support fixture. Always secure workpiece in vise before cutting. Never hold the workpiece with your hands during a cut.

**UNSTABLE WORKPIECES.** Avoid cutting workpieces that cannot be properly supported or clamped in a vise or jig, because they can unexpectedly move while cutting and draw the operator's hands into the blade causing serious personal injury. Examples are chains, cables, round or oblong-shaped workpieces, and those with internal or built-in moving or rotating parts, etc.

**FIRE HAZARD.** Use **EXTREME CAUTION** if cutting magnesium. Using the wrong cutting fluid could lead to chip fire and possible explosion.

**CUTTING FLUID SAFETY.** Cutting fluids are poisonous. Always follow manufacturer's cutting-fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid invites slipping hazards.

## WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## CAUTION

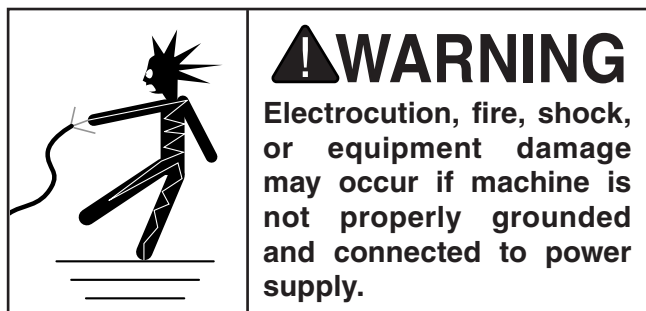
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



# SECTION 2: POWER SUPPLY

## Availability

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



## Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

### Full-Load Current Rating at 110V..... 5 Amps

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

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

## **! WARNING**

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

## 110V Circuit Requirements

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

**Nominal Voltage ..... 110V–120V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 15 Amps**

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

## **! CAUTION**

**For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.**

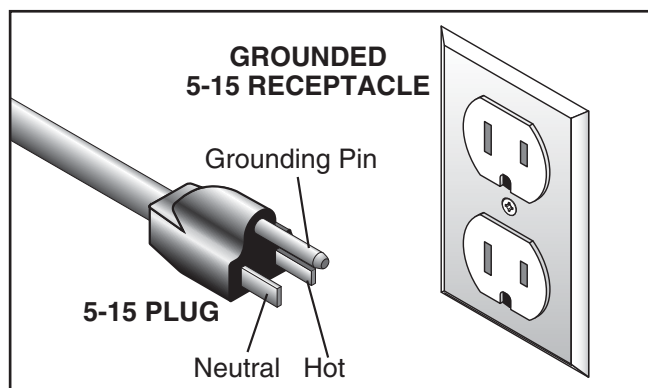
**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel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



## Grounding & Plug Requirements

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

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!



**Figure 2.** Typical 5-15 plug and receptacle.

**⚠ CAUTION**

**SHOCK HAZARD!**

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

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

## Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

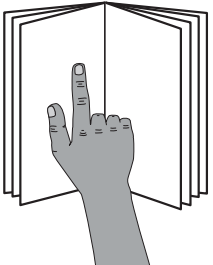
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

**Minimum Gauge Size .....14 AWG**  
**Maximum Length (Shorter is Better).....50 ft.**



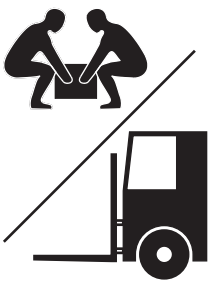
# SECTION 3: SETUP



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



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



**!WARNING**  
**HEAVY LIFT!**  
Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

## Needed for SetUp

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

Description	Qty
• Safety Glasses .....	1 Per Person
• Open End Wrench 10mm.....	1
• Open End Wrench 14mm.....	1
• Sawhorses.....	2
• Assistant for Lifting.....	1
• Cleaning Supplies ( <b>Page 13</b> ).....	1
• Pliers.....	1
• Straightedge 12" Minimum .....	1

## Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

**IMPORTANT:** Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. ***You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.***



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



# Inventory

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

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

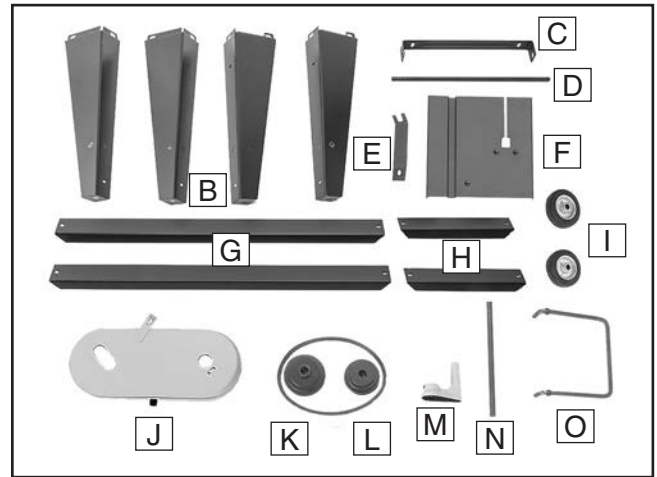


Figure 3. Model G0622 Inventory.

Inventory: (Figure 3)	Qty
A. Bandsaw (not shown) .....	1
B. Stand Legs .....	2
C. Wheel Mounting Bracket .....	1
D. Axle .....	1
E. Table Support.....	1
F. Table.....	1
G. Long Braces .....	2
H. Short Braces .....	2
I. Wheels .....	1
J. Pulley Cover .....	1
K. V-Belt.....	1
L. Pulleys with Keys.....	2
M. Work Stop.....	1
N. Work Stop Rod.....	1
O. Transport Handle.....	1

## Hardware Bag (not shown)

- Hex Wrench 4mm (Work Stop) ..... 1
- Hex Bolts M8-1.25 x 25 (Saw to Stand) ..... 8
- Hex Nuts M8-1.25 (Saw to Stand)..... 8
- Flat Washers 8mm (Saw to Stand) ..... 8
- Lock Washers 8mm (Saw to Stand)..... 8
- Carriage Bolts M8-1.25 x 16 (Stand) ..... 8
- Flat Washers 8mm (Stand) ..... 8
- Lock Washers 8mm (Stand)..... 8
- Hex Nuts M8-1.25 (Stand) ..... 8
- Hex Bolts M6-1 x 12 (Bracket/Legs)..... 2
- Flat Washers 6mm (Bracket/Legs)..... 4
- Lock Washers 6mm (Bracket/Legs) ..... 2
- Hex Nuts M6-1 (Bracket/Legs) ..... 2
- Cotter Pins M4 x 30 (Axle & Handle) ..... 4
- Flat Head Screw M6-1 x 12..... 1
- Fender Washer 6mm..... 1
- Hex Nut M6-1 ..... 1

## **NOTICE**

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



# Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

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

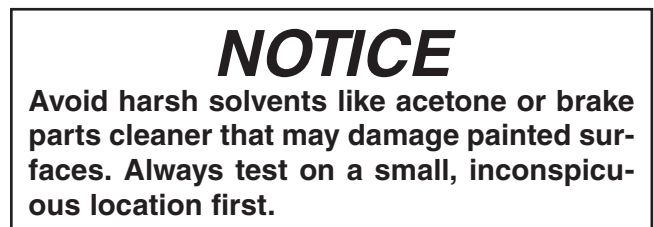
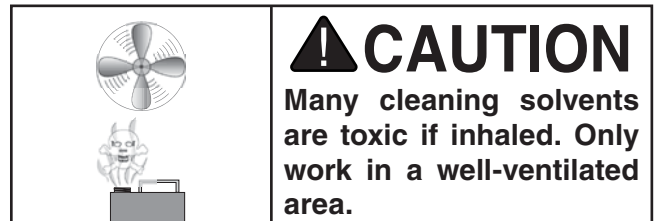
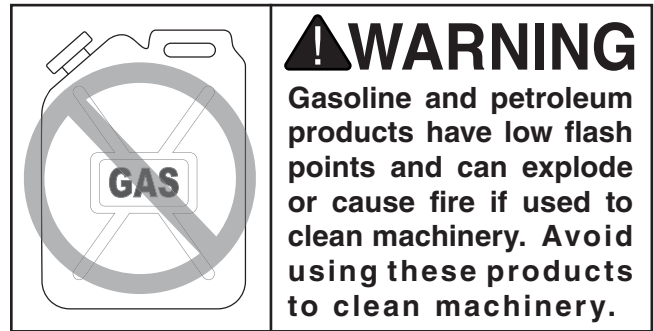
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## Before cleaning, gather the following:

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

## Basic steps for removing rust preventative:

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



## T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from the **non-painted** parts of the machine during clean up.



Figure 4. T23692 Orange Power Degreaser.



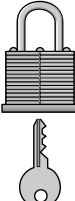
# Site Considerations

## Weight Load

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

## Space Allocation

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

	<p><b>⚠ CAUTION</b> Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
---	---

## Physical Environment

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

## Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

## Lighting

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

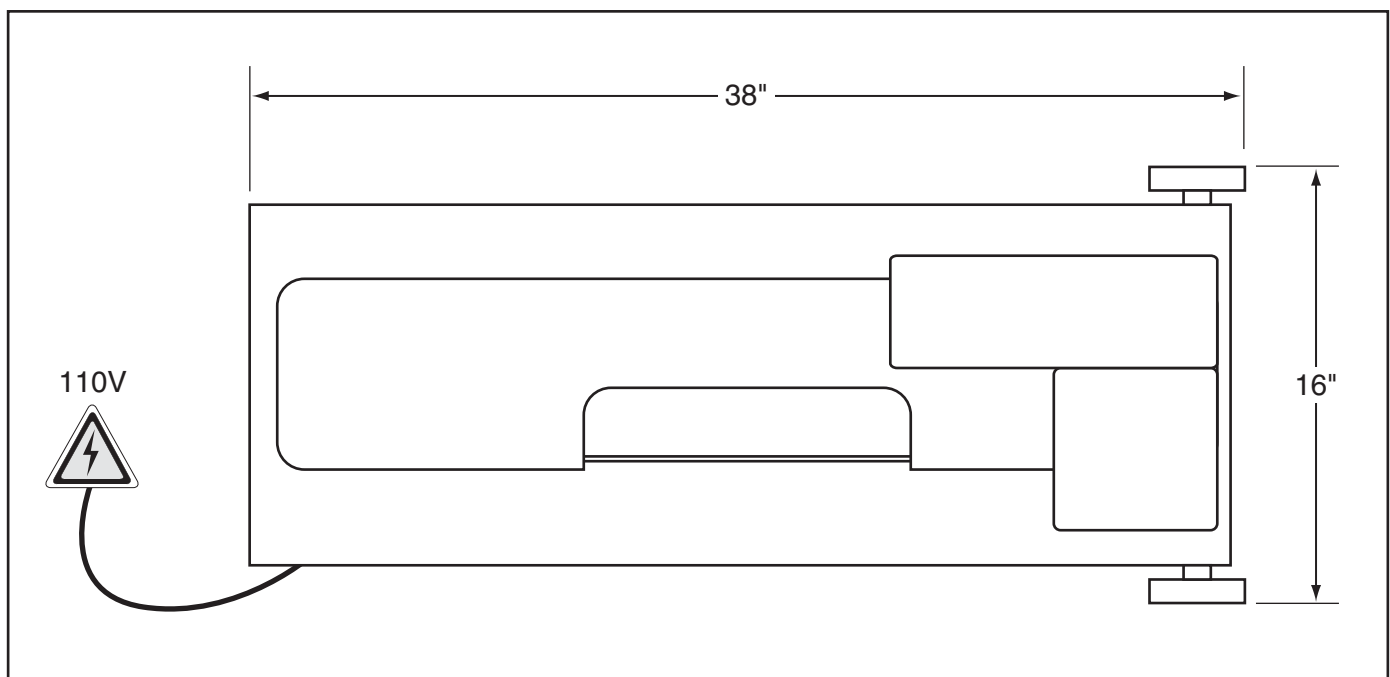


Figure 5. Minimum working clearances.





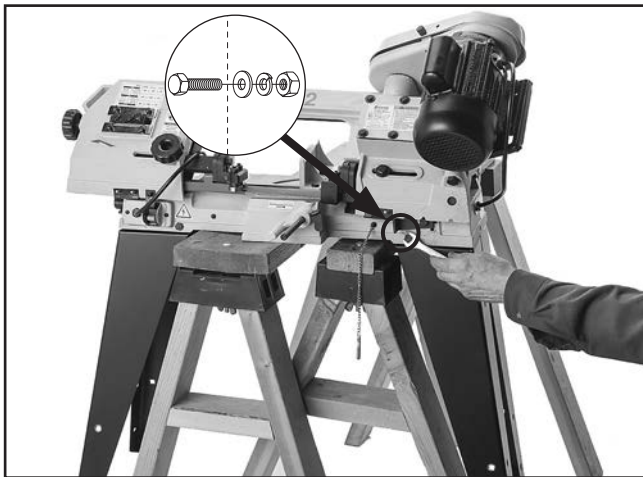
# Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to Needed for Setup and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

## To assemble the bandsaw:

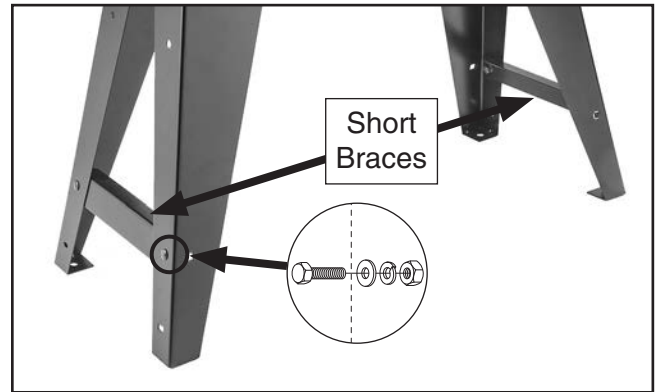
1. Install head-locking pin (refer to Page 22).
2. With help of an assistant, lift bandsaw onto a pair of closely spaced sawhorses or other suitable support (see **Figure 6**).
3. Attach legs to bandsaw with (8) M8-1.25 x 25 hex bolts, (8) 8mm flat washers, (8) 8mm lock washers, and (8) M8-1.25 hex nuts (see **Figure 6**).

**Note:** At this time, tighten with a 14mm wrench or socket just enough to secure the parts. Final tightening will take place when the stand is fully assembled.



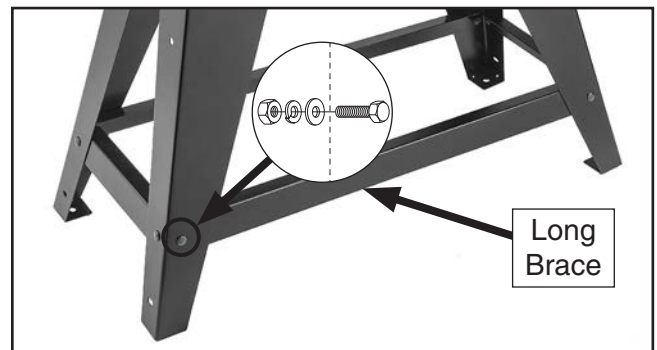
**Figure 6.** Attaching legs to bandsaw.

4. Attach short brace to legs with (4) M8-1.25 x 16 carriage bolts, (4) 8mm flat washers, (4) 8mm lock washers, and (4) M8-1.25 hex nuts (see **Figure 7**).



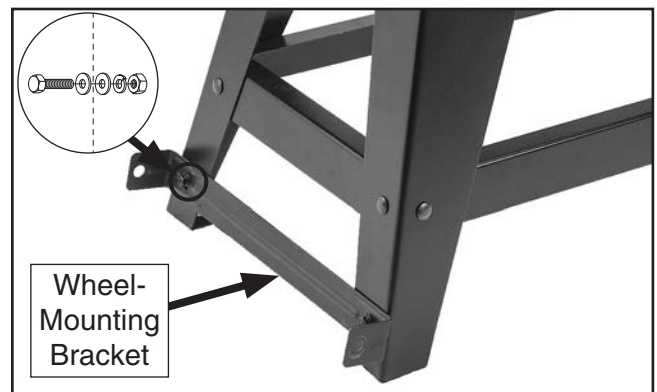
**Figure 7.** Short braces attached to legs.

5. Remove bandsaw from sawhorses and attach long braces to legs with (4) M8-1.25 x 16 carriage bolts, (4) 8mm flat washers, (4) 8mm lock washers, and (4) M8-1.25 hex nuts (see **Figure 8**).



**Figure 8.** Long braces attached to legs.

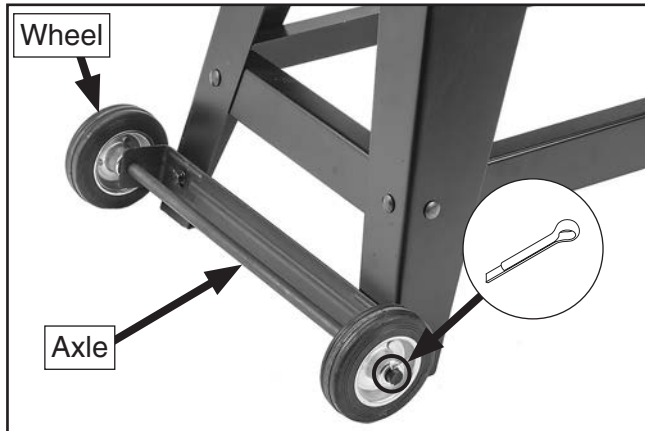
6. Attach wheel-mounting bracket to bottom of two legs with (2) M6-1 x 12 hex bolts, (4) 6mm flat washers, (2) 6mm lock washers, and (2) M6-1 hex nuts, as shown in **Figure 9**.



**Figure 9.** Wheel-mounting bracket attached to legs.



7. Slide axle through holes in wheel-mounting bracket (see **Figure 10**).
8. Slide wheels onto axle on outside of mounting brackets, and secure them with (2) cotter pins (see **Figure 10**).



**Figure 10.** Wheels attached to axle.

9. On opposite side of stand, insert handle into holes and secure with (2) cotter pins (see **Figure 11**).



**Figure 11.** Cotter pins installed in handle.

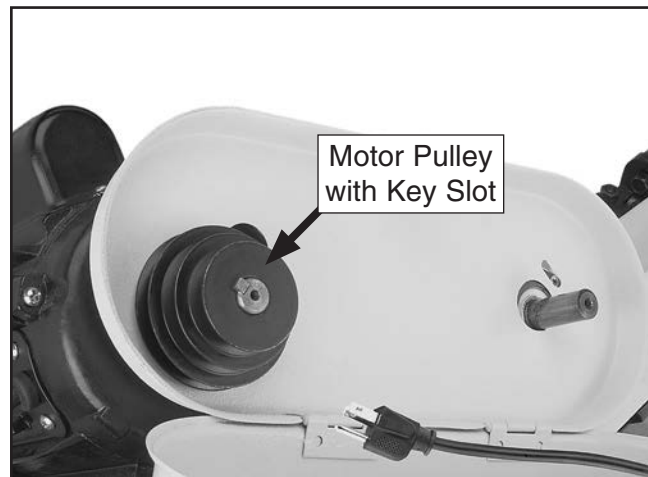
10. Check to see if bandsaw is relatively level, then final tighten all bolts and nuts.

11. Place pulley cover over motor and gear shafts, and secure it with pre-installed M6-1 x 12 Phillips head screws and 12mm flat washers, as shown in **Figure 12**.



**Figure 12.** Installing pulley cover.

12. Open pulley cover, then insert keys into the slots on pulley shafts.
13. Slide the large-diameter motor pulley onto the motor shaft (see **Figure 13**).

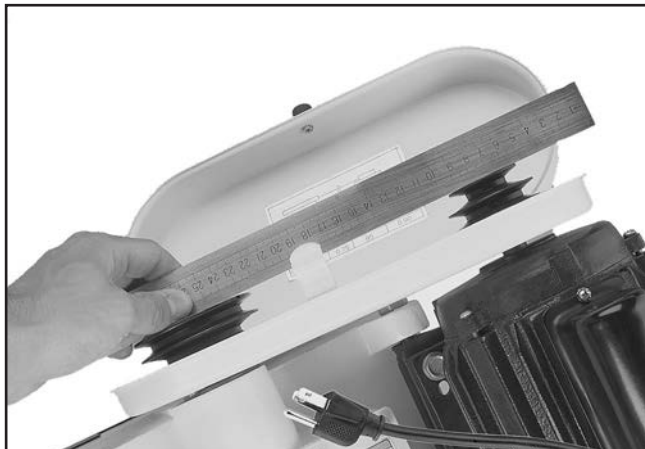


**Figure 13.** Installing motor pulley.

14. Install worm gear pulley with small-diameter wheel on shaft closest to gear box.

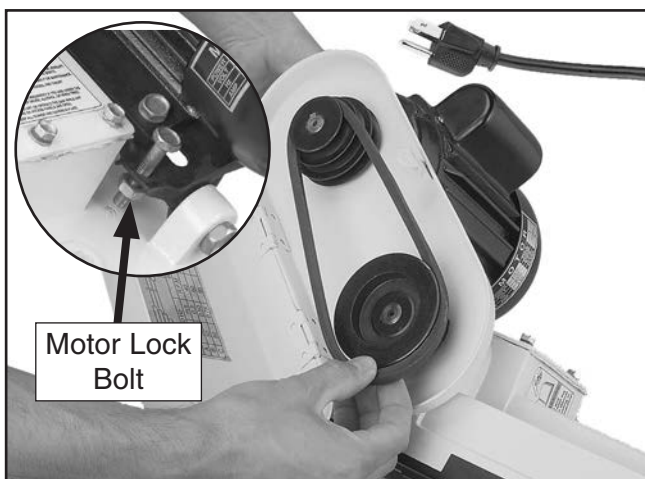


15. Use a straightedge to check alignment of the pulley wheels, as shown in **Figure 14**, and adjust them as needed.



**Figure 14.** Checking pulley alignment.

16. When the pulley wheels are aligned, tighten the set screws on both pulleys.
17. Unthread motor lock bolt, then pivot motor up and slide the V-belt into pulley grooves, as shown in **Figure 15**.



**Figure 15.** V-belt installation.

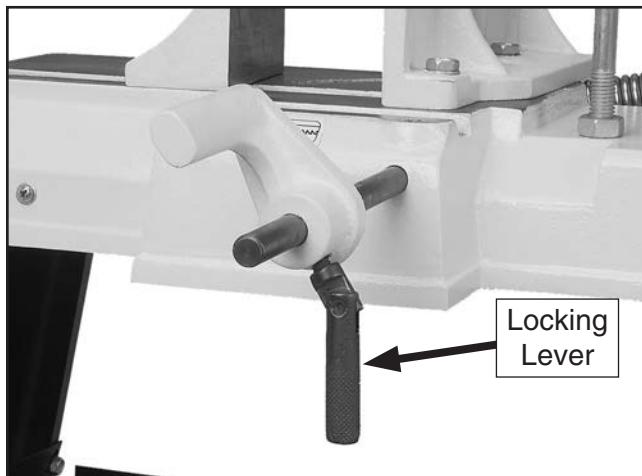
18. Release motor, letting its weight tension V-belt, then thread motor lock bolt against the side of bandsaw.

19. Install work stop shaft into side of bandsaw then lock it in place by tightening the set screw, as shown in **Figure 16**.



**Figure 16.** Installing work stop shaft.

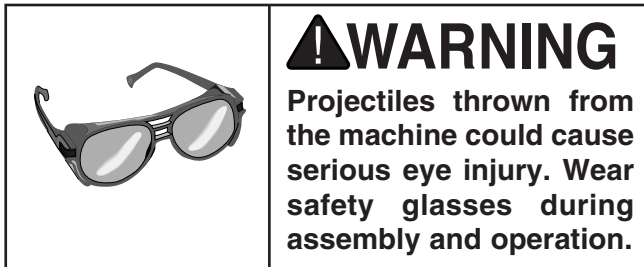
20. Slide work stop onto end of the shaft and lock it into position with locking lever, as shown in **Figure 17**.



**Figure 17.** Work stop locking lever.



# Test Run



## Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Connect the bandsaw to power.
4. Put on safety glasses and secure loose clothing or long hair.
5. Remove head-locking pin and raise the bandsaw by the handle.
6. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run (**Figure 18**). The bandsaw should run smoothly with little or no vibration.

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

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



**Figure 18.** ON/OFF switch.

# Recommended Adjustments

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

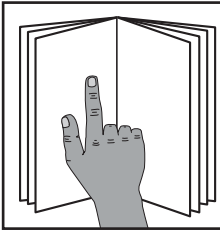
Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE ADJUSTMENTS**.

## Factory adjustments that should be verified:

1. Blade Tracking (**Page 34**).
2. Squaring the Blade (**Page 35**).
3. Blade Guide Bearings (**Page 36**).



# SECTION 4: OPERATIONS

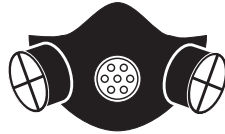


## **!WARNING**

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

## **!WARNING**

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.



## **!WARNING**

**Electrocution Hazard.** The motor and switch on this bandsaw are not protected against liquids. Do not use water-based cutting fluids with this bandsaw.

## **NOTICE**

If you are not experienced with this type of machine, **WE STRONGLY RECOMMEND** that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

## Operation Overview

This overview gives you the basic process that happens during an operation with this machine. Familiarize yourself with this process to better understand the remaining parts of the **Operation** section.

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

1. Prepares the workpiece for cutting.
2. Raises the head.
3. Securely clamps the workpiece in the vise and adjusts the vise angle for the operation.
4. Checks/adjusts the V-belt position on the pulleys to ensure the correct cutting speed for the workpiece.
5. Adjusts the spring tension for the correct feed rate.
6. Makes sure the workpiece and bandsaw are stable and there are no obstructions for the cut.
7. Wears safety glasses.
8. Starts the machine and waits for the blade to reach full speed.
9. Slowly lowers the head until the blade makes contact with the workpiece, then releases the head so that the spring-controlled feed rate continues to lower the blade into the workpiece until the cut is finished.
10. Stops the machine, raises the head, and removes the workpieces.



# Operation Tips

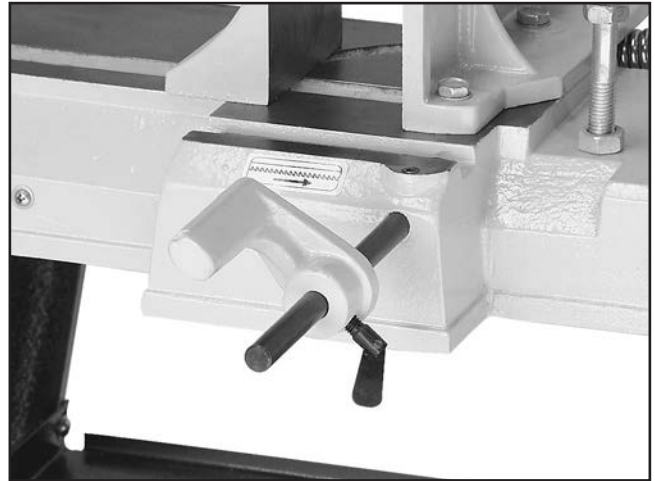
The following tips will help you safely and effectively operate your bandsaw and help you get the maximum life out of your saw blades.

## Horizontal Cutting

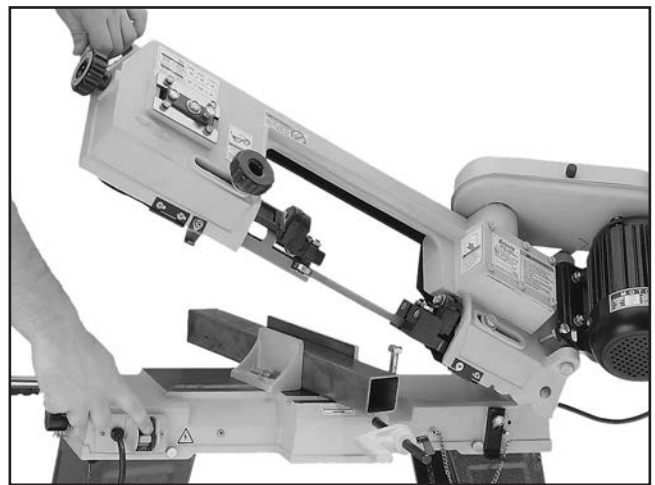
- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length (see **Figure 19**).
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 20**).
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate (refer to the **Metal Chip Inspection Chart** on **Page 27**).
- If the chips are burned, reduce the blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!

## Vertical Cutting

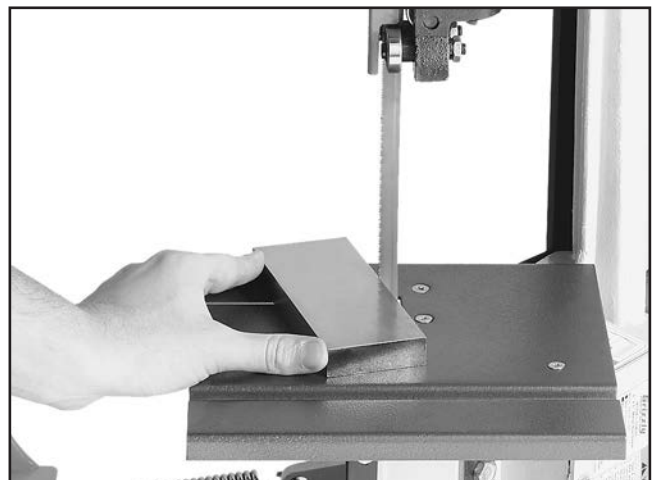
- Workpieces that cannot be properly supported or stabilized without a vise should not be cut in the vertical position. Examples are chains, cables, round or oblong-shaped workpieces, workpieces with internal or built-in moving or rotating parts, etc.
- Make sure that the vertical table assembly is securely fastened to the bandsaw frame so it will adequately support the workpiece.
- Always keep your fingers away from the blade and always hold the workpiece securely in your hand (**Figure 21**).
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.



**Figure 19.** Work stop.



**Figure 20.** Proper starting position.



**Figure 21.** Using the vertical set-up.

## **NOTICE**

**Loosen blade tension at the end of each day to prolong blade life.**

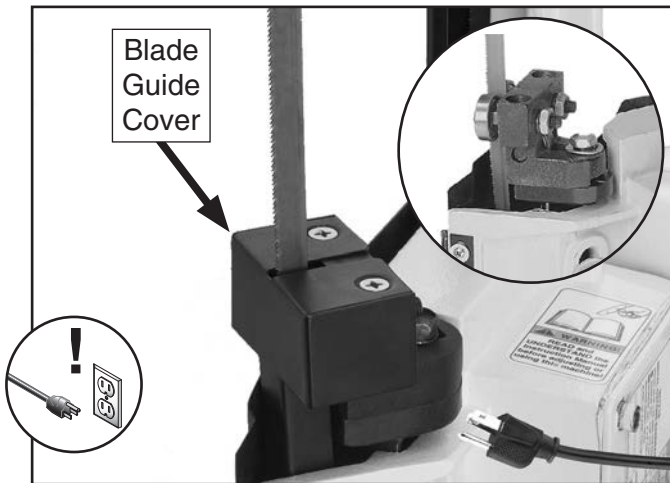


# Vertical Operation

The Model G0622 can easily be set up for vertical cutting operations.

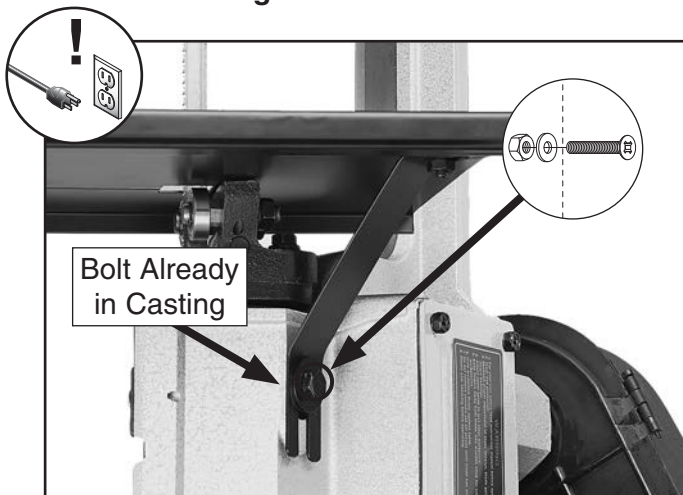
## To assemble the bandsaw for vertical cutting:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the two flat head screws and the blade guide cover shown in **Figure 22**.



**Figure 22.** Blade guide cover.

3. Install the table and replace the two screws removed in **Step 2**.
4. Install the table bracket with (1) M6-1 x 12 flat head screw, (1) 6mm fender washer, (1) M6-1 hex nut, and pre-installed hex bolt, as shown in **Figure 23**.

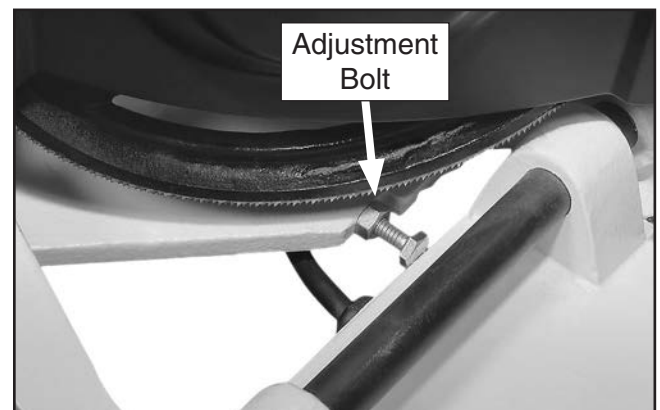


**Figure 23.** Table and bracket installed.

5. Place a level on the table, as shown in **Figure 24**, then use the adjustment bolt shown in **Figure 25** to make the table level.



**Figure 24.** Adjusting table level.

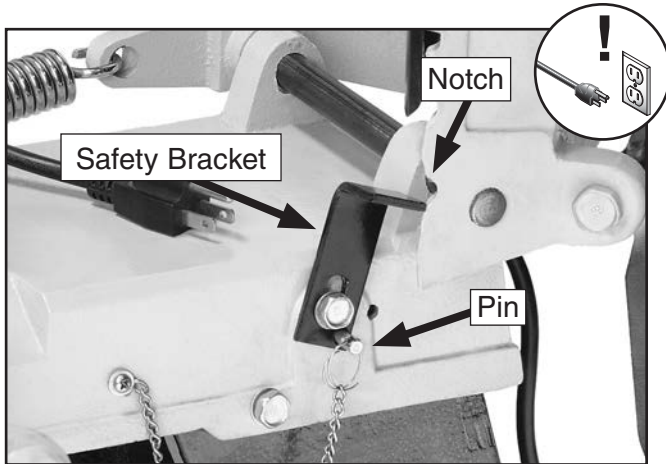


**Figure 25.** Adjustment bolt.



6. Install the safety bracket and lock it in place with the pin shown in **Figure 26** to keep the saw from falling.

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



**Figure 26.** Safety bracket.

## Head Locking Pin

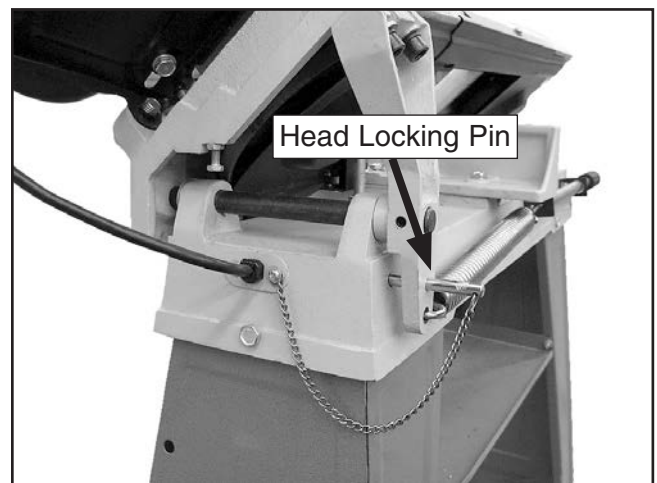
### **! WARNING**

The head locking pin secures the head in the down, horizontal position. You **MUST** secure the head with the locking pin before moving the machine to prevent the head unexpectedly springing up causing the machine to tip or fall. Otherwise, serious personal injury or property damage could occur.

The head locking pin safely secures the head in the down position. To ensure the head does not unexpectedly spring up and tip the bandsaw over, this locking pin must be properly inserted when the bandsaw is not in use or before moving it.

#### To use the head locking pin:

1. DISCONNECT BANDSAW FROM POWER!
2. Fully lower the head down, then insert the locking pin through the holes in the head pivot arm and base, as shown in **Figure 27**.



**Figure 27.** Head locking pin correctly inserted.

3. Before connecting the machine to power, remove the locking pin.





# Vise

## ⚠ CAUTION

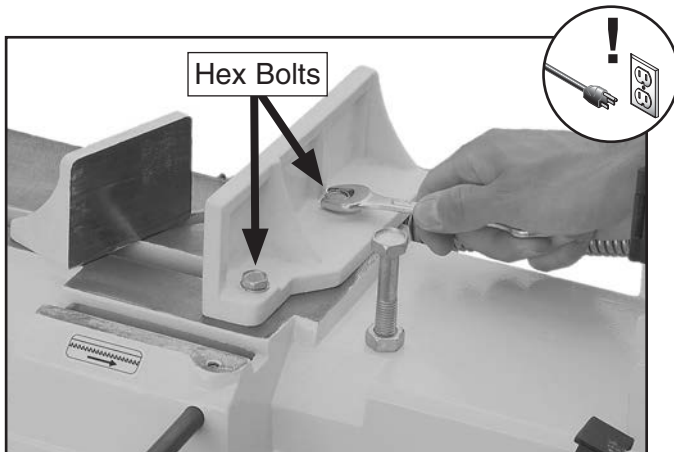
Always turn the saw *OFF* and allow the blade to come to a complete stop before using the vise! Failure to follow this caution may lead to injury.

The vise can hold material up to six inches wide and be set to cut angles from 0° to 60°.

Tools Needed	Qty
Wrench or Socket 12mm.....	1
Machinist Square.....	1

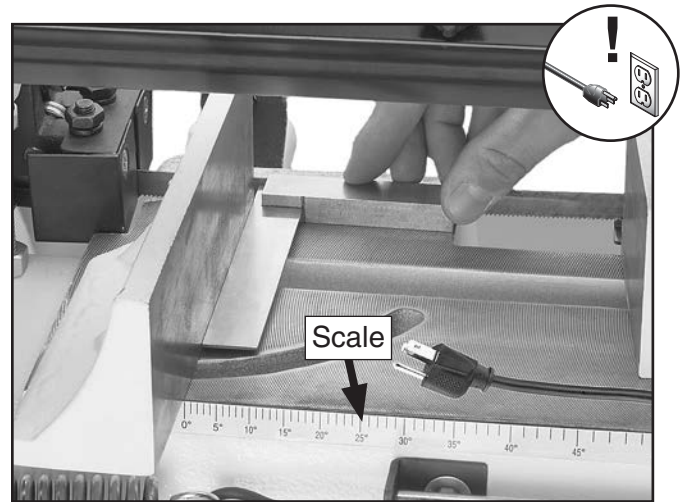
### To use the vise:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the two hex bolts shown in **Figure 28**.



**Figure 28.** Setting vise angle.

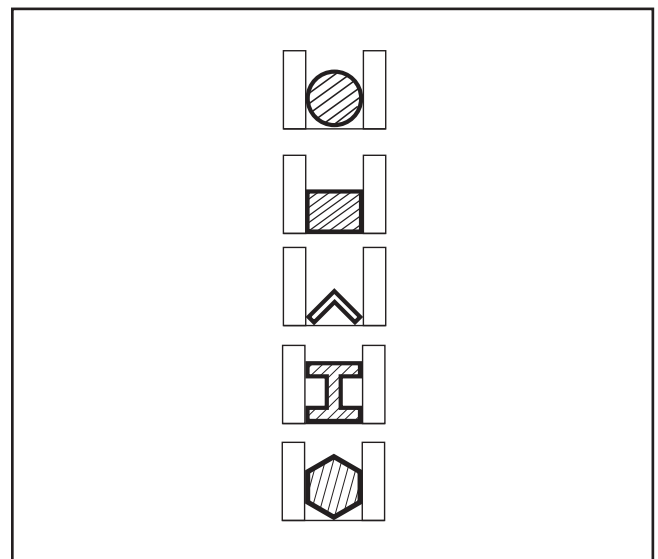
3. Use the scale as a guide to set your angle or use a machinist square to set the angle of the vise, as shown in **Figure 29**.



**Figure 29.** Squaring vise to blade.

4. Tighten the hex bolts.
5. Loosen the hex bolt on the opposite jaw so the jaw can float, then match the angle of the workpiece and re-tighten the hex bolt.
6. Tighten the vise against the workpiece.

**Note:** *Figure 30* shows the correct methods of holding different workpiece shapes.



**Figure 30.** Workholding options by material shape.

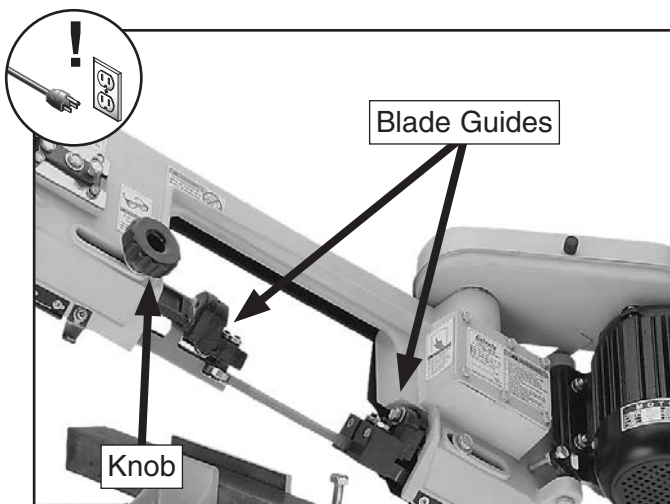


# Blade Guides

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

## To adjust the blade guides:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the knob shown in **Figure 31** and slide the blade guide as close to the workpiece as possible, then re-tighten the knob.



**Figure 31.** Blade guides.

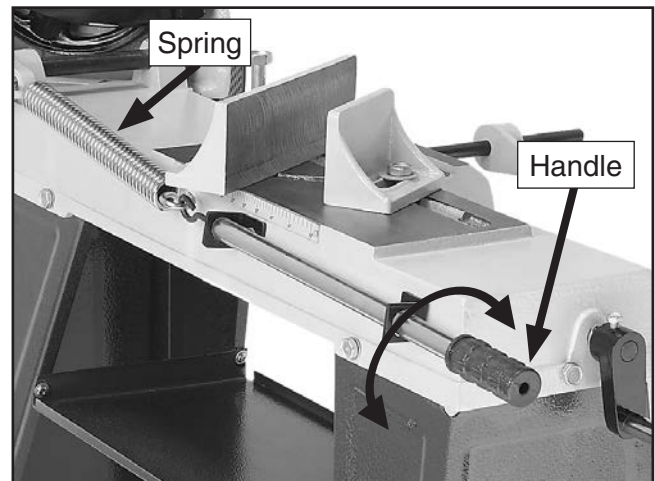
# Feed Rate

The feed rate is controlled by the spring and handle shown in **Figure 32**.

## To adjust the feed rate:

**Slower:** Twist the handle clockwise to add tension to the spring.

**Faster:** Twist the handle counterclockwise to remove tension from the spring.

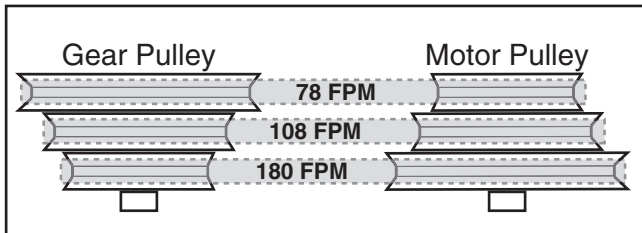


**Figure 32.** Feed rate adjustment.



# Blade Speed

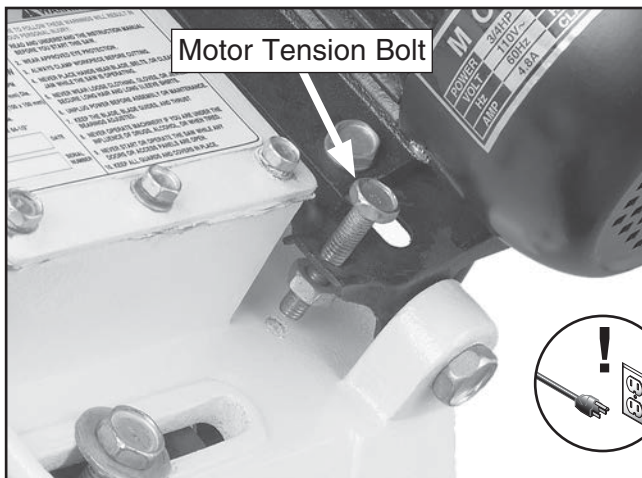
The bandsaw is capable of operating at 78, 108, or 180 FPM (Feet Per Minute). The speed can easily be adjusted by changing the V-belt placement. **Figure 33** shows an illustration for pulley positions for each speed.



**Figure 33.** Pulley & V-belt configuration.

## To change the blade speeds:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the motor tension bolt to allow the motor to pivot (**Figure 34**).

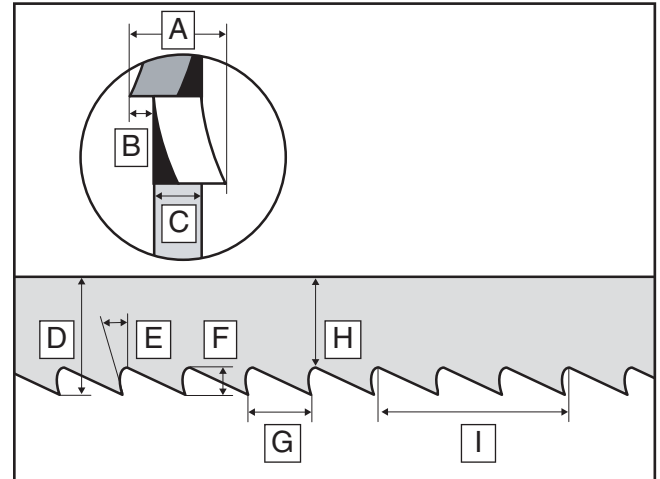


**Figure 34.** Motor tension bolt.

3. Raise the motor to relieve the belt tension and position the belt in the desired pulley alignment.
4. Release the motor and let its weight tension the belt.
5. Tighten the motor tension bolt back against the frame of the bandsaw.

# Blade Terminology

Selecting the right blade for the cut requires a knowledge of various blade characteristics. Use the illustration in **Figure 35** and the following descriptions to better understand blade characteristics.



**Figure 35.** Bandsaw blade terminology.

- A. Kerf:** The amount of material removed by the blade during cutting.
- B. Tooth Set:** The amount each tooth is bent left or right from the blade.
- C. Gauge:** The thickness of the blade.
- D. Blade Width:** The widest point of the blade measured from the tip of the tooth to the back edge of the blade.
- E. Tooth Rake:** The angle of the tooth from a line perpendicular to the length of the blade.
- F. Gullet Depth:** The distance from the tooth tip to the bottom of the curved area (gullet).
- G. Tooth Pitch:** The distance between tooth tips.
- H. Blade Back:** The distance between the bottom of the gullet and the back edge of the blade.
- I. TPI:** The number of teeth per inch measured from gullet to gullet.



# Blade Selection

## Blade Size

The Model G0622 accepts only 1/2" x 0.025 x 64 1/2" blades.

## Tooth Pitch

Usually measured as TPI (Teeth Per Inch), tooth pitch determines the size/number of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster.

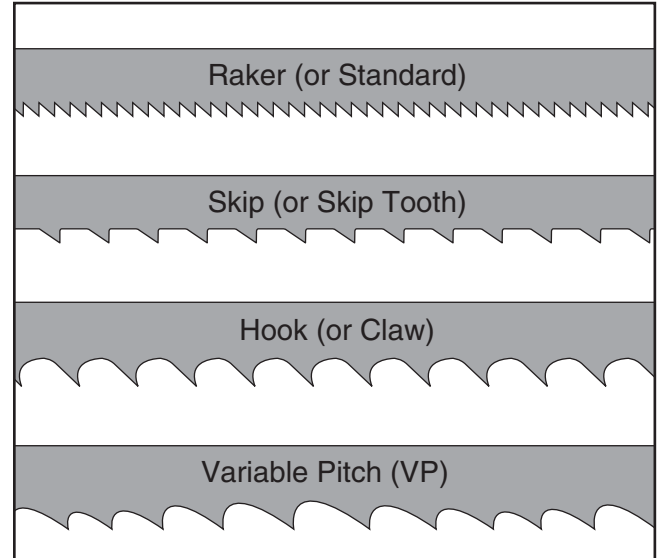
As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder metals and coarse pitched blades on softer metals. When selecting blades, refer to **Figure 36** for recommended blade tooth (TPI) and speed (FPM) based on the workpiece material.

Material	TPI	FPM
Tool Steel Stainless Steel Bearing Bronze	24	78
Mild Steel Hard Brass Bronze	18	108
Soft Brass Aluminum Other Light Metals	14	180

**Figure 36.** Model G0622 Blade chart.

## Tooth Style

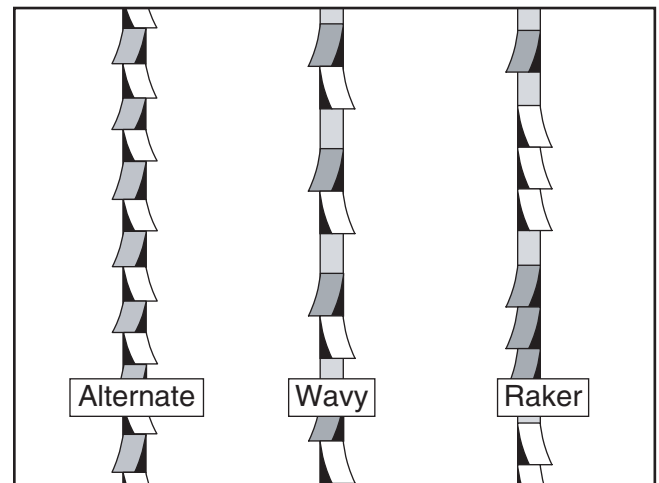
When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as “Tooth Style.” Many blade manufacturers offer variations of the four basic styles shown in **Figure 37**.



**Figure 37.** Bandsaw blade tooth types.

## Tooth Set

Three of the most common tooth sets are alternate, wavy, and raker (see **Figure 38**).






**Figure 38.** Bandsaw tooth sets.



# Metal Chip Inspection Chart

The best method of evaluating the performance of your metal cutting operation is to inspect the chips that are formed from cutting. Refer to the chart below for chip inspection guidelines.

Chip Appearance	Chip Description	Chip Color	Blade Speed	Feed Pressure	Additional Actions
	Thin & Curled	Silver	<b>Good</b>	<b>Good</b>	
	Hard, Thick & Short	Brown or Blue	Decrease	Decrease	Lubricate with a small amount of oil
	Hard, Strong & Thick	Brown or Blue	Decrease	Decrease	Lubricate with a small amount of oil
	Hard, Strong & Thick	Silver or Light Brown	<b>Good</b>	Decrease Slightly	Check Blade Pitch
	Hard & Thin	Silver	Increase	Decrease	Check Blade Pitch
	Straight & Thin	Silver	<b>Good</b>	Increase	
	Powdery	Silver	Decrease	Increase	
	Curled Tight & Thin	Silver	<b>Good</b>	Decrease	Check Blade Pitch

**Figure 39.** Chip inspection chart.



# SECTION 5: ACCESSORIES

## **! WARNING**

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

## **NOTICE**

Refer to our website or latest catalog for additional recommended accessories.

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

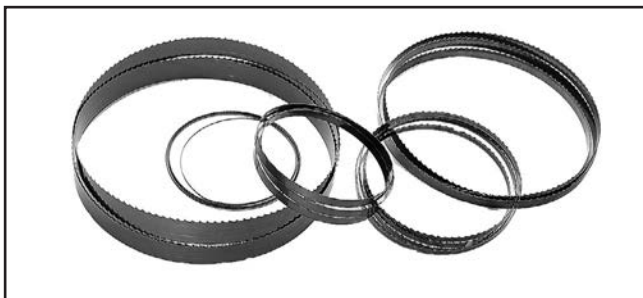


Figure 40. Blades

## Basic Eye Protection

- T32323—Woodturners Face Shield
- T32401—EDGE Brazeau Safety Glasses, Clear
- T32402—EDGE Khor G2 Safety Glasses, Tint
- T32404—EDGE Mazeno Safety Glasses, Clear



Figure 41. Assortment of basic eye protection.

## T10499—1.2 KVA Blade Welder

Make your own bandsaw blades from inexpensive band stock, or repair what you already have with this blade welder. Features blade shear, grinder, and annealing. Operates on 115V, 15A power supply. For  $\frac{1}{8}$ – $\frac{1}{2}$ " blade widths.



Figure 42. T10499 Blade Welder.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



### H5408—Blade Tensioning Gauge

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



Figure 43. H5408 Blade Tensioning Gauge.

### SB1365—South Bend Way Oil-ISO 68

Engineered for the high pressure exerted on horizontal or vertical ways and slides. Protects against rust and corrosion. Ensures stick-free, smooth motion which maximizes finishes and extends the life of your machine. Won't gum up! 12 oz. AMGA#2 (ISO 68 Equivalent)



Figure 44. Recommended products for machine lubrication.

### G5618—Deburring Tool with two Blades

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



Figure 45. G5618 Deburring Tool.

### D2273—Single Roller Stand

### D2274—5 Roller Stand

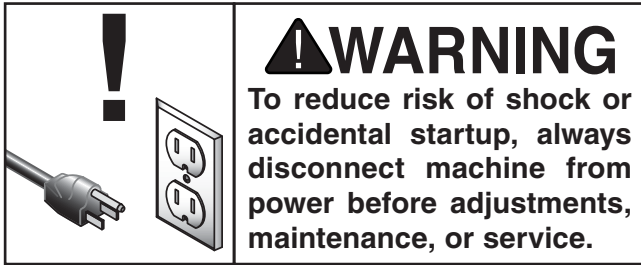
These roller stands are invaluable when working solo in any shop for outfeeding and support tasks. With 15<sup>7</sup>/<sub>8</sub>" wide rollers, adjustable 26"–44<sup>5</sup>/<sub>8</sub>" height, and all steel construction make them convenient and rugged.



Figure 46. D2273 and D2274 single and 5 roller stands.



# SECTION 6: MAINTENANCE



## Schedule

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

### Daily Check:

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

### Monthly Check:

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

### Annual Check:

- Lubricate gear box.

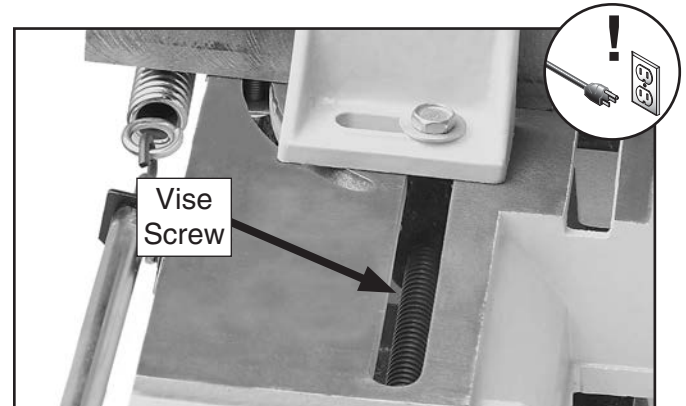
## Cleaning

Use a brush and a shop vacuum to remove chips and other debris from the machine. Keep the non-painted surfaces rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9.

Periodically, remove the blade and thoroughly clean all metal chips or built-up grease from the wheel surfaces and blade housing.

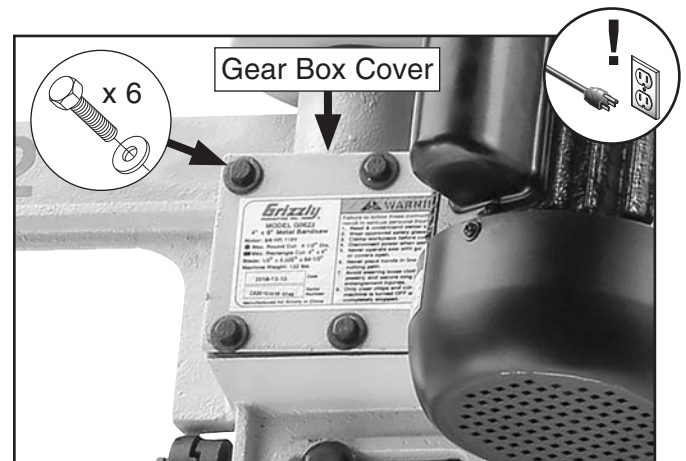
## Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise screw shown in **Figure 47** with multi-purpose gear grease.



**Figure 47.** Location to lubricate vise screw.

Once a year, replace the oil in the gear box. Lower the headstock all the way, then have an assistant help you tilt the bandsaw so the gear box is level and oil will not spill out when the cover is removed. Remove the six hex bolts and flat washers (see **Figure 48**) to remove the gear box cover.



**Figure 48.** Gear box cover and fasteners.

Use shop rags to absorb and remove the existing oil, then use mineral spirits to clean the gears and the inside of the box. Once the gears are dry, add as much new ISO 320 oil as the gear box will hold without overflowing, then install the cover.

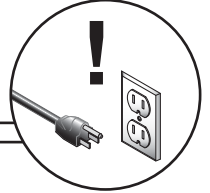




# SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

## Troubleshooting



### Motor & Electrical

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



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> <li>Excessive feed rate.</li> <li>The blade TPI is too great, or the material is too coarse.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Feed Rate</b> on <b>Page 24</b>, or <b>Blade Speed</b> on <b>Page 25</b> and adjust as required.</li> <li>Refer to <b>Blade Selection</b> on <b>Page 26</b> and adjust as required.</li> </ol>
Blades break often.	<ol style="list-style-type: none"> <li>The workpiece is loose in the vise.</li> <li>The feed or cut speed is wrong.</li> <li>The blade TPI is too great, or the material is too coarse.</li> <li>The blade is rubbing on the wheel flange.</li> <li>The bandsaw is being started with the blade resting on the workpiece.</li> <li>The guide bearings are misaligned, or the blade is rubbing on the wheel flange.</li> <li>The blade is too thick, or the blades are of low quality.</li> </ol>	<ol style="list-style-type: none"> <li>Clamp the workpiece tighter, or use a jig to hold the workpiece.</li> <li>Refer to <b>Feed Rate</b> on <b>Page 24</b>, or <b>Blade Speed</b> on <b>Page 25</b> and adjust as required.</li> <li>Refer to <b>Blade Selection</b> on <b>Page 26</b> and adjust as required.</li> <li>Refer to <b>Blade Tracking</b> on <b>Page 34</b>, and adjust as required.</li> <li>Start bandsaw and then slowly lower the headstock by setting the feed rate.</li> <li>Refer to <b>Blade Tracking</b> on <b>Page 34</b>, or <b>Blade Guides</b> on <b>Page 24</b>, and adjust as required.</li> <li>Use a higher quality blade.</li> </ol>
Blade dulls prematurely.	<ol style="list-style-type: none"> <li>The cutting speed is too fast.</li> <li>The blade TPI is too coarse.</li> <li>The blade feed pressure is too light.</li> <li>The workpiece has hard spots, welds, or scale is on the material.</li> <li>The blade is twisted.</li> <li>The blade is slipping on the wheels.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Blade Speed</b> on <b>Page 25</b> and adjust as required.</li> <li>Refer to <b>Blade Selection</b> on <b>Page 26</b> and adjust as required.</li> <li>Refer to <b>Feed Rate</b> on <b>Page 24</b>, and adjust as required.</li> <li>Increase the feed pressure, and reduce the cutting speed.</li> <li>Replace the blade.</li> <li>Refer to <b>Blade Tension</b> on <b>Page 35</b>, and adjust as required.</li> </ol>
Blade wears on one side.	<ol style="list-style-type: none"> <li>The blade guides are worn or mis-adjusted.</li> <li>The blade guide slide bracket is loose.</li> <li>The wheels are out of alignment.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Blade Guides</b> on <b>Page 24</b> and replace or adjust.</li> <li>Tighten the blade guide bracket.</li> <li>Refer to <b>Blade Tracking</b> on <b>Page 34</b>, and adjust as required.</li> </ol>
Teeth are ripping from the blade.	<ol style="list-style-type: none"> <li>The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece.</li> <li>The workpiece is vibrating in the vise.</li> <li>The blade gullets are loading up with chips.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Blade Selection</b> on <b>Page 26</b> and decrease the feed pressure. Refer to <b>Feed Rate</b> on <b>Page 24</b>, and adjust as required.</li> <li>Re-clamp the workpiece in the vise, and use a jig if required.</li> <li>Use a coarser-tooth blade.</li> </ol>
The cuts are crooked.	<ol style="list-style-type: none"> <li>The feed pressure is too high.</li> <li>The guide bearings are out of adjustment, or too far away from the workpiece.</li> <li>The blade tension is low.</li> <li>The blade is dull.</li> <li>The blade speed is wrong.</li> </ol>	<ol style="list-style-type: none"> <li>Refer to <b>Feed Rate</b> on <b>Page 24</b>, and adjust as required.</li> <li>Refer to <b>Blade Guides</b> on <b>Page 24</b> and replace or adjust.</li> <li>Refer to <b>Blade Tension</b> on <b>Page 35</b>, and adjust as required.</li> <li>Refer to <b>Blade Change</b> on <b>Page 33</b> and replace the blade.</li> <li>Refer to <b>Blade Speed</b> on <b>Page 25</b> and adjust as required.</li> </ol>

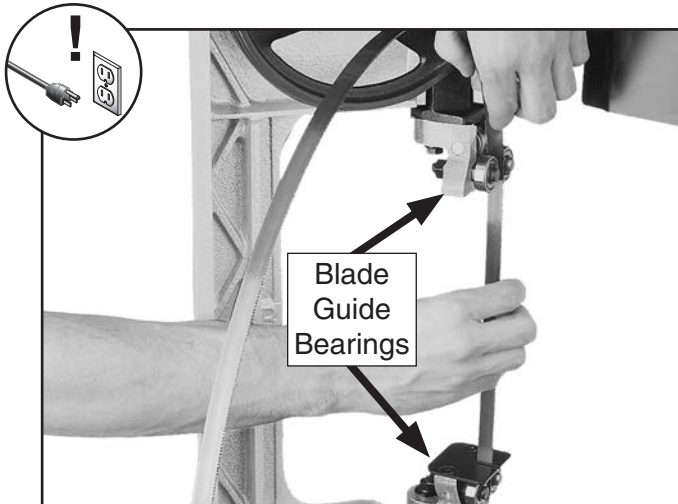


# Blade Change

Blades should be changed when they become dull, damaged, or when your operation requires a different blade.

## To change the blade on the bandsaw:

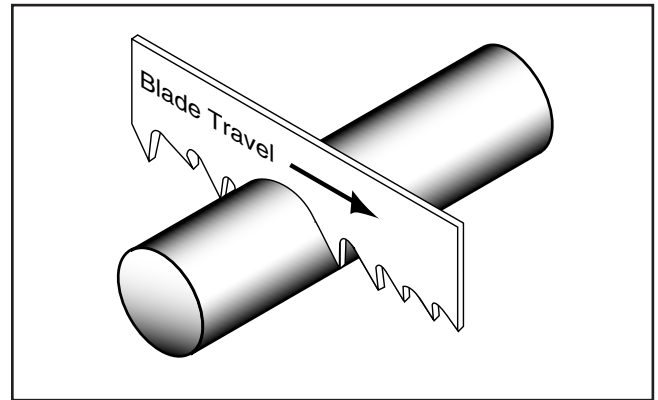
1. DISCONNECT BANDSAW FROM POWER!
2. Raise the head of the bandsaw to the vertical position, use the head locking pin to hold it in place, then remove the wheel access cover.
3. Loosen the tension knob and slip the blade off of the wheels.
4. Install the new blade through both blade guide bearings, as shown in **Figure 49**, and around the bottom wheel.



**Figure 49.** Installing blade.

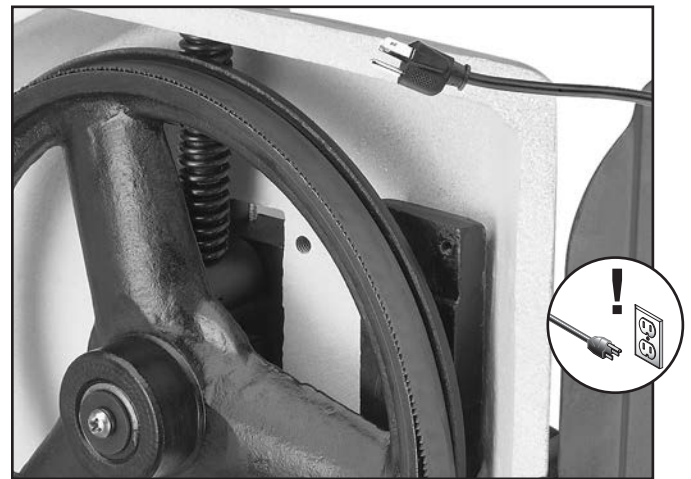
5. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

**Note:** *It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 50**, after mounting to the bandsaw. Some blades will have a directional arrow as a guide.*



**Figure 50.** Blade cutting direction.

6. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels (see **Figure 51**).



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

7. Tighten the tension knob so the blade will not slip on the wheels upon start up.
8. Connect the bandsaw to the power source.
9. Briefly turn the bandsaw **ON** then **OFF** to position the blade and resume the previous tracking.

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

—If the tracking is fine, proceed to **Blade Tension** on **Page 35**.



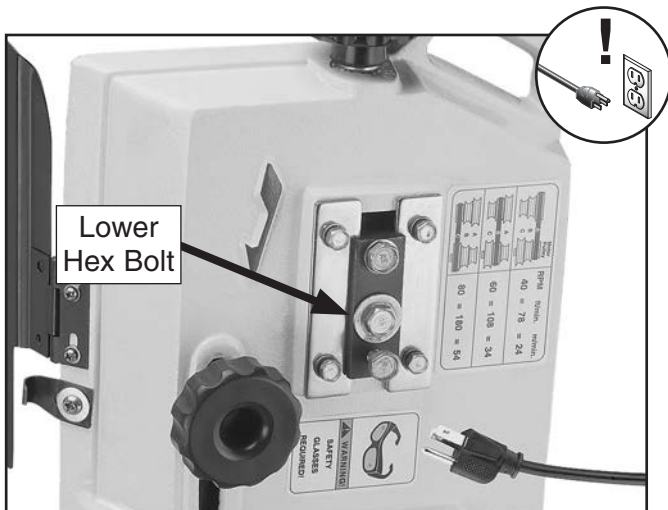
# Blade Tracking

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

**Tools Needed** Qty  
Wrench or Socket 14mm ..... 1

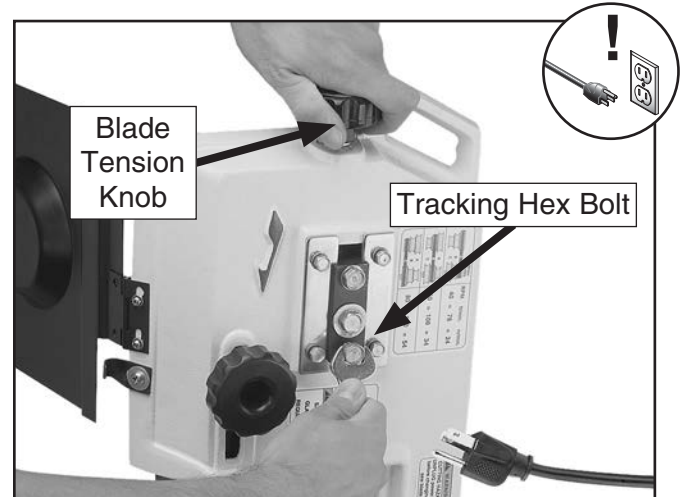
## To adjust the blade tracking on the bandsaw:

1. DISCONNECT BANDSAW FROM POWER!
2. Position the bandsaw in the vertical position.
3. Open the wheel access cover.
4. Loosen, but do not remove the lower hex bolt in the blade wheel tilting mechanism shown in **Figure 52**.



**Figure 52.** Blade tracking adjustments.

5. Use the blade tension knob to release the blade tension (see **Figure 53**).



**Figure 53.** Adjusting tracking hex bolt.

6. Adjust the tracking hex bolt, as shown in **Figure 53**, then tighten the lower hex bolt loosened in **Step 4**.

—Tightening the tracking hex bolt will move the blade closer to the shoulder of the wheel.

—Loosening the tracking hex bolt will move the blade away from the shoulder.

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

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

—If the blade walks away from the shoulder of the wheel or hits the shoulder, turn the bandsaw **OFF**, disconnect it from power, then repeat **Steps 4-8**.

9. Turn the bandsaw **OFF**, disconnect it from power, then replace the blade guard and wheel access cover.



# Blade Tension

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

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

## To tension the blade on the bandsaw:

1. Make sure the blade is tracking properly.
2. DISCONNECT BANDSAW FROM POWER!
3. Loosen and slide the blade guides as far apart as they will go then tighten them down again.
4. Turn the tension knob in **Figure 53** clockwise to tighten the blade as tight as you can.
5. Using moderate finger pressure, push against the side of the blade. The blade should not move more than 0.004".

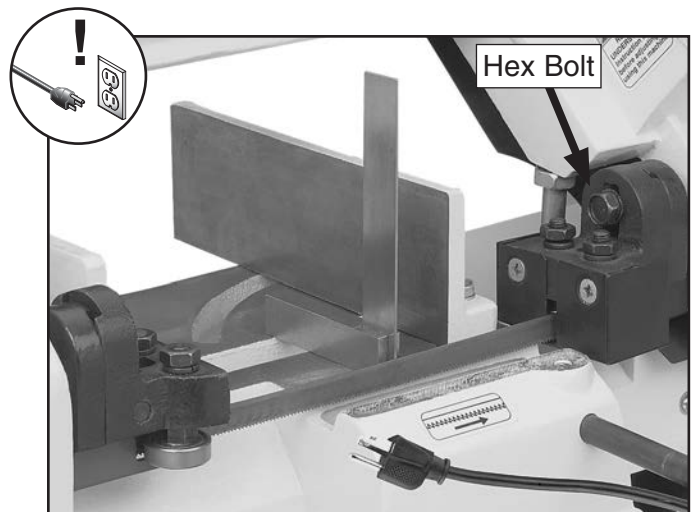
**Note:** We recommend using a blade tensioning gauge, like the one found in **ACCESSORIES** on **Page 29**. If you use this option please follow the instructions included with your gauge.

# Squaring the Blade

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

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

1. DISCONNECT BANDSAW FROM POWER!
2. Separate the blade guides as far as possible, the lower the head of the bandsaw all the way until it contacts the horizontal stop.
3. Place a square on the table bed and against the edge of the blade (**Figure 54**), and check different points along the length of the table between the blade guides.



**Figure 54.** Squaring the blade.

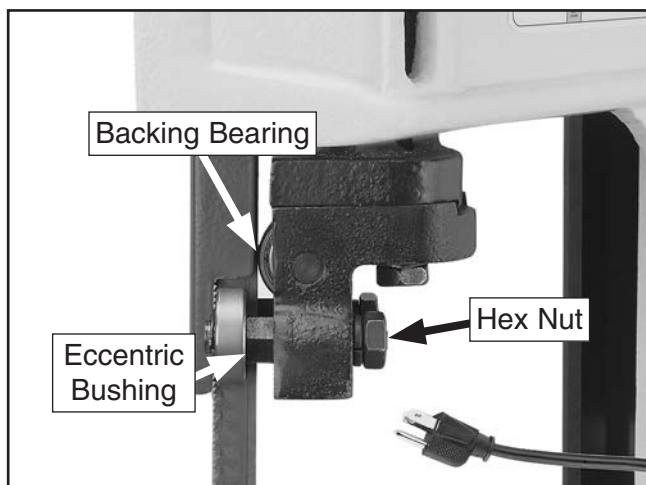
4. Loosen the hex bolt shown in **Figure 54**, and rotate the seat until the blade is vertical to the bed, then re-tighten the hex bolt.



# Blade Guide Bearings

The blade guide bearings must be properly adjusted to make square cuts. One bearing on each assembly has an eccentric bushing that allows it to be adjusted so the blade is square to the vise. The bearings are secured in place by a hex nut and lock washer, as shown in **Figure 55**.

Before adjusting the blade guide bearings, make sure that you have squared the blade to the table as discussed in the previous section.



**Figure 55.** Blade guide adjustments.

## To adjust the blade guide bearings:

1. DISCONNECT BANDSAW FROM POWER!
2. Position the vise to 90°, then lock it in place.
3. Put a machinist's square against the face of the vise and move it over to the blade.

—The square should evenly touch both the face of the vise and the blade. If it does, skip ahead to **Step 6**.

—If the square does not evenly touch the blade, but it does evenly touch the vise, continue with the next step.

4. Loosen the hex nuts that secure the eccentric bushings attached to the guide bearings.
5. Adjust the bearings as necessary to force the blade to be 90° to the vise, then re-tighten the hex nuts.
6. If any of the bearings are not touching the blade evenly, loosen the hex nuts and adjust them so the contact surface of the bearings touch the blade evenly.

**Note:** *Since the bearings twist the blade into position, it is acceptable if there is 0.001"-0.002" gap between the blade and the front or back of the bearing. Just make sure not to squeeze the blade too tightly with the bearings. After the guide bearings are set, you should be able to rotate the guide bearings (although they will be stiff) with your fingers.*

7. Adjust the backing bearing in the same manner, but leave a gap between 0.002-0.003" from the back of the blade.



# SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

## WARNING

### Wiring Safety Instructions

**SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

**MODIFICATIONS.** Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

**WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

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

**WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

**MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.





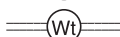





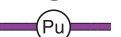




**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

#### NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

#### COLOR KEY

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



# Electrical Components

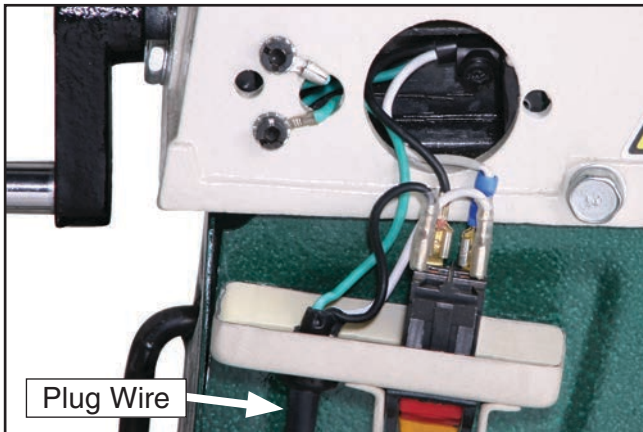
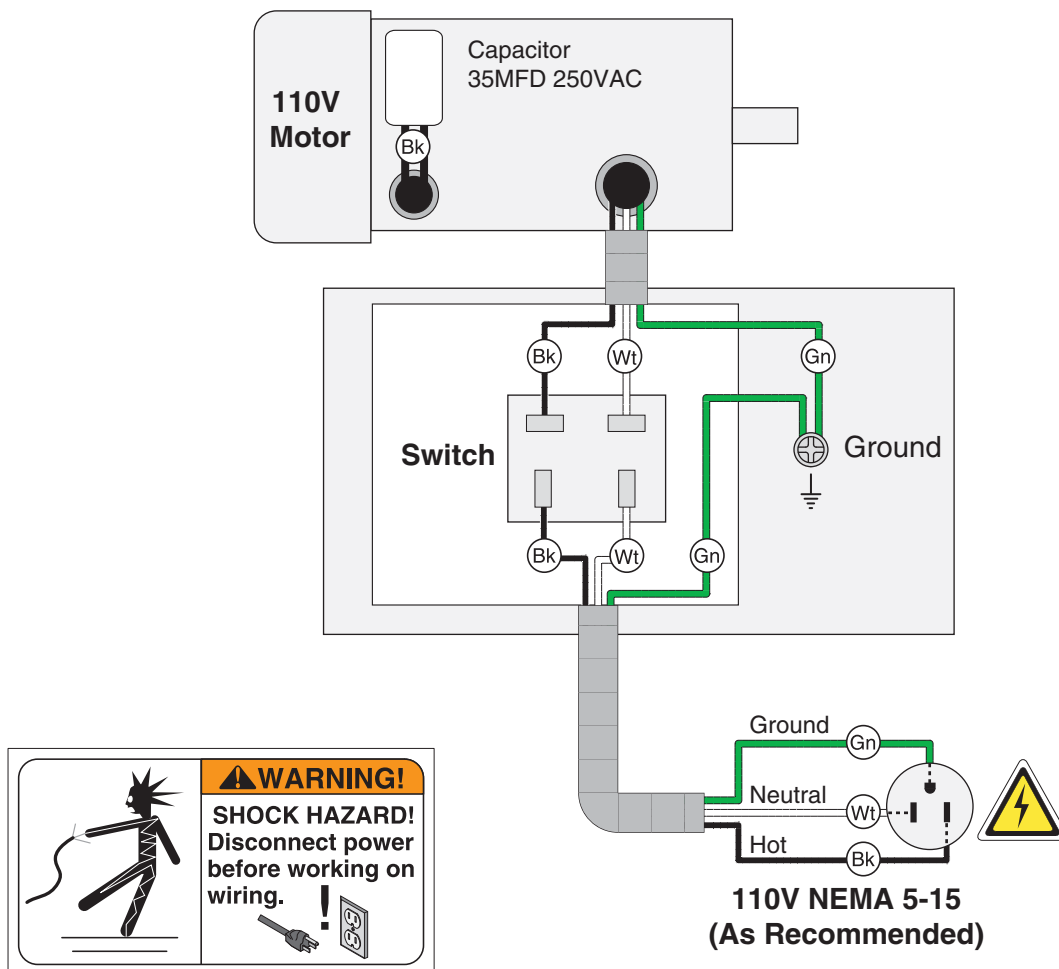


Figure 56. G0622 ON/OFF Switch.



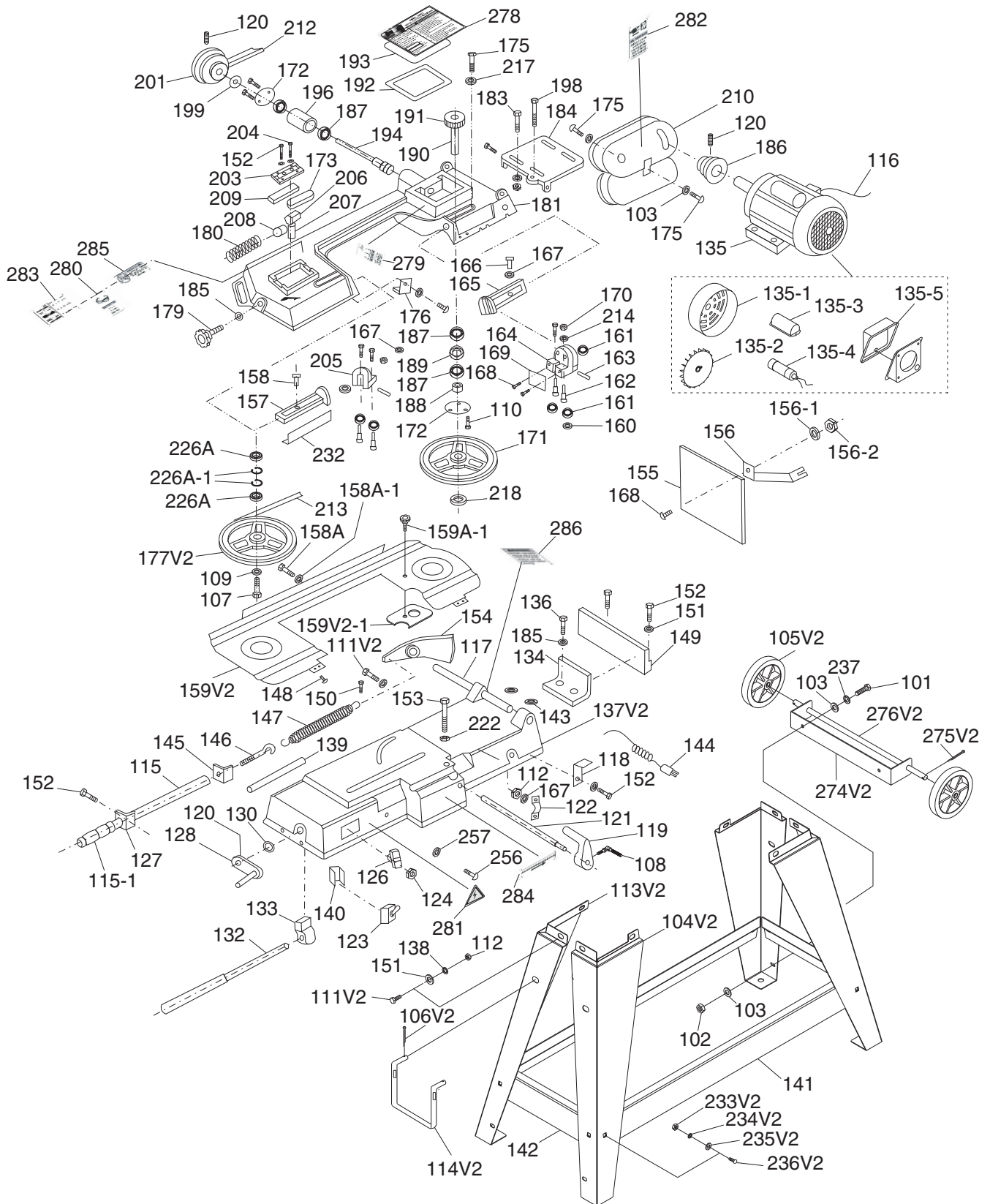
Figure 57. G0622 Capacitor.

## Wiring Diagram





# SECTION 9: Parts



# Parts List

REF	PART #	DESCRIPTION
101	P0622101	HEX BOLT M6-1 X 12
102	P0622102	HEX NUT M6-1
103	P0622103	FLAT WASHER 6MM
104V2	P0622104V2	STAND LEG (RIGHT) V2.09.17
105V2	P0622105V2	WHEEL ASSY V2.09.17
106V2	P0622106V2	COTTER PIN 4 X 30 V2.09.17
107	P0622107	PHLP HD SCR M6-1 X 12
108	P0622108	LOCK LEVER
109	P0622109	FLAT WASHER 6MM
110	P0622110	FLAT HD SCR M4-.7 X 10
111V2	P0622111V2	HEX BOLT M8-1.25 X 25
112	P0622112	HEX NUT M8-1.25
113V2	P0622113V2	STAND LEG (LEFT) V2.09.17
114V2	P0622114V2	TRANSPORT HANDLE V2.09.17
115	P0622115	ADJUSTING ROD
115-1	P0622115-1	RUBBER HANDLE GRIP
116	P0622116	MOTOR CORD
117	P0622117	PIVOTING ROD
118	P0622118	SUPPORT PLATE
119	P0622119	WORK STOP
120	P0622120	SET SCREW M8-1.25 X 10
121	P0622121	STOCK STOP ROD
122	P0622122	WIRE RELIEF RETAINER
123	P0622123	SWITCH
124	P0622124	HEX NUT M5-.8
126	P0622126	SWITCH PANEL
127	P0622127	ADJUSTING ROD SUPPORT
128	P0622128	HAND WHEEL
130	P0622130	EXT RETAINING RING 13MM
132	P0622132	LEADSCREW
133	P0622133	WISE NUT
134	P0622134	FRONT VISE JAW
135	P0622135	MOTOR 3/4HP 110V 1-PH
135-1	P0622135-1	MOTOR COVER
135-2	P0622135-2	FAN
135-3	P0622135-3	CAPACITOR COVER
135-4	P0622135-4	R CAPACITOR 35M 250V 1-5/8 X 2-13/16
135-5	P0622135-5	JUNCTION BOX
136	P0622136	HEX BOLT M10-1.5 X 30
137V2	P0622137V2	BED V2.09.17
138	P0622138	LOCK WASHER 8MM
139	P0622139	SCALE
140	P0622140	ELECTRIC CORD COVER
141	P0622141	LONG BRACE
142	P0622142	SHORT BRACE
143	P0622143	GASKET
144	P0622144	POWER CORD
145	P0622145	NUT PLATE
146	P0622146	SPRING ADJUSTING SCREW
147	P0622147	EXTENSION SPRING
148	P0622148	PHLP HD SCR M4-.7 X 10
149	P0622149	REAR VISE JAW
150	P0622150	SET SCREW M8-1.25 X 12

REF	PART #	DESCRIPTION
151	P0622151	FLAT WASHER 8MM
152	P0622152	HEX BOLT M8-1.25 X 25
153	P0622153	HEX BOLT M12-1.75 X 75
154	P0622154	PIVOT
155	P0622155	TABLE
156	P0622156	TABLE BRACKET
156-1	P0622156-1	FENDER WASHER 6MM
156-2	P0622156-2	HEX NUT M6-1
157	P0622157	ADJUSTABLE BRACKET (TOP)
158	P0622158	PHLP HD SCR M6-1 X 10
158A	P0622158A	PHLP HD SCR M5-.8 X 10
158A-1	P0622158A-1	FLAT WASHER 5MM
159V2	P0622159V2	BLADE BACK SAFETY COVER V2.02.08
159V2-1	P0622159V2-1	SAFETY COVER PLATE V2.02.08
159A-1	P0622159A-1	KNOB M6-1 X 8
160	P0622160	EXT RETAINING RING 8MM
161	P0622161	BALL BEARING 629ZZ
162	P0622162	GUIDE PIVOT
163	P0622163	BEARING SHAFT PIN 8 X 40MM
164	P0622164	BLADE ADJUSTABLE SEAT, LOWER
165	P0622165	ADJUSTABLE BRACKET
166	P0622166	GUIDE BEARING LOCK
167	P0622167	LOCK WASHER 8MM
168	P0622168	FLAT HD SCR M6-1 X 12
169	P0622169	BLADE GUARD
170	P0622170	HEX NUT M8-1.25
171	P0622171	FRONT BLADE WHEEL
172	P0622172	BLADE WHEEL BEARING COVER
173	P0622173	KEY 5 X 5 X 30
175	P0622175	PHLP HD SCR M6-1 X 12
176	P0622176	SWITCH CUT OFF TIP
177V2	P0622177V2	REAR BLADE WHEEL V2.02.08
179	P0622179	BLADE TENSION KNOB
180	P0622180	COMPRESSION SPRING
181	P0622181	BODY FRAME
183	P0622183	HEX BOLT M8-1.25 X 25
184	P0622184	MOTOR MOUNT PLATE
185	P0622185	FLAT WASHER 10MM
186	P0622186	MOTOR PULLEY
187	P0622187	BALL BEARING 620ZZ
188	P0622188	BEARING BUSHING
189	P0622189	OIL SEAL
190	P0622190	TRANSMISSION WHEEL SHAFT
191	P0622191	TRANSMISSION GEAR
192	P0622192	GEAR BOX GASKET
193	P0622193	GEAR BOX COVER
194	P0622194	WORM GEAR
196	P0622196	BEARING BUSHING
198	P0622198	HEX BOLT M8-1.25 X 50
199	P0622199	BUSHING
201	P0622201	WORM GEAR PULLEY
203	P0622203	BLADE TENSION PLATE



# Parts List (Cont.)

REF	PART #	DESCRIPTION
204	P0622204	HEX BOLT M8-1.25 X 35
205	P0622205	BLADE ADJUSTABLE SEAT, UPPER
206	P0622206	SLIDING PLATE DRAW BLOCK
207	P0622207	BLADE WHEEL SHAFT
208	P0622208	SHAFT BLOCK
209	P0622209	BLADE TENSION SLIDING GUIDES
210	P0622210	MOTOR PULLEY COVER
212	P0622212	V-BELT M22 3L220
213	P0622213	BLADE 1/2 X .028 X 64 1/2
214	P0622214	FLAT WASHER 8MM
217	P0622217	FLAT WASHER 6MM
218	P0622218	EXT RETAINING RING 15MM
222	P0622222	HEX NUT M12-1.75
226A	P0622226A	BALL BEARING 6202ZZ
226A-1	P0622226A-1	INT RETAINING RING 35MM
232	P0622232	BLADE SAFE GUARD
233V2	P0622233V2	HEX NUT M8-1.25 V2.09.17
234V2	P0622234V2	LOCK WASHER 8MM V2.09.17

REF	PART #	DESCRIPTION
235V2	P0622235V2	FLAT WASHER 8MM V2.09.17
236V2	P0622236V2	CARRIAGE BOLT M8-1.25 X 16 V2.09.17
237	P0622237	LOCK WASHER 6MM
256	P0622256	PHLP HD SCR M5-.8 X 25
257	P0622257	LOCK WASHER 5MM
274V2	P0622274V2	WHEEL STAND V2.09.17
275V2	P0622275V2	COTTER PIN 4 X 30 V2.09.17
276V2	P0622276V2	AXLE V2.09.17
277	P0622277	CORNER BRACKET
278	P0622278	MACHINE ID LABEL
279	P0622279	READ MANUAL LABEL
280	P0622280	SAFETY GLASSES LABEL
281	P0622281	ELECTRICITY LABEL
282	P0622282	UNPLUG MACHINE LABEL
283	P0622283	RPM LABEL
284	P0622284	BLADE TRAVEL LABEL
285	P0622285	BLADE SAFETY LABEL
286	P0622286	TIPPING HAZARD LABEL

## WARNING

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







# WARRANTY CARD

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

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

1. How did you learn about us?

Advertisement       Friend       Catalog  
 Card Deck       Website       Other:

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

0-2       3-5       6-9       10+

7. Do you think your machine represents a good value?       Yes       No

8. Would you recommend Grizzly Industrial to a friend?       Yes       No

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

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

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

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

\_\_\_\_\_
\_\_\_\_\_
\_\_\_\_\_



Place Stamp Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

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

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

# WARRANTY AND RETURNS

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

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

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

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

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

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

# *grizzly.com*<sup>®</sup>

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