MODEL G0513 SERIES
HEAVY-DUTY 17" BANDSAW
OWNER'S MANUAL
(MODELS G0513, G0513P, G0513ANV, & EXTREME MODELS G0513X2, G0513X2B, G0513X2BF, & G0513X2F)

For Model G0513X2B Only

C US
252923

Model G0513X2B

Model G0513ANV

#TS15097 PRINTED IN TAIWAN

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

INTRODUCTION 3
Manual Accuracy 3
Contact Info 3
G0513 Series Combination Manual 3
Basic Controls 4
Control Panel 4
Front Controls 4
Motor Brake 4
Rear Controls 5

SECTION 1: SAFETY 8
Safety Instructions for Machinery 8
Additional Safety for Bandsaws 10

SECTION 2: POWER SUPPLY 11
Availability 11
Full-Load Current Rating 11
Circuit Information 11
Circuit Requirements 12
Grounding Requirements 12
Extension Cords 14
Voltage Conversion 14

SECTION 3: SETUP 15
Introduction 15
Needed for Setup 15
Unpacking 15
Inventory 16
G0513, G0513P, & G0513ANV 16
G0513X2, G0513X2B, G0513X2BF, & G0513X2F 17
Cleanup 18
Site Considerations 18
Floor Load 18
Placement Location 18
Moving & Placing Bandsaw 19
Using Eye Bolt 19
Using Wood Blocks 19
Mounting 20
Bolting to Concrete Floors 20
Assembly 20
Installing Guide Post Handwheel, Positive Stop Bolt, & Table 20
Installing Fence (G0513, G0513P, G0513ANV, & G0513X2F) 22
Installing Fence (G0513X2B & G0513X2BF) 23
Installing Foot Brake Pedal (G0513X2BF & G0513X2F) 24
Installing Resaw Fence (G0513X2, G0513X2B, G0513X2BF, & G0513X2F) 24
Initial Blade Tracking 25
Adjusting Positive Stop 26
Dust Collection 27
Power Cord Connection (G0513X2BF & G0513X2F) 27
Test Run 28
Tensioning Blade 30
Flutter Method 30
Deflection Method 31
Adjusting Blade Support Bearings 32
Adjusting Blade Guides 33
Adjusting Blade Guides (G0513, G0513P, & G0513ANV) 34
Adjusting Blade Guide Bearings (G0513X2, G0513X2B, G0513X2BF, & G0513X2F) 35
Aligning Table 36
Aligning Fence 37
Aligning Fence (G0513, G0513P, G0513ANV, G0513X2, & G0513X2F) 37
Aligning Fence (G0513X2B & G0513X2BF) 38
Calibrating Miter Gauge 38

SECTION 4: OPERATIONS 39
Disabling & Locking Switch (G0513, G0513P, G0513ANV, G0513X2) 39
Disabling & Locking Switch (G0513X2B, G0513X2BF, G0513X2F) 40
General Overview 40
Straight Cuts 40
Irregular Cuts 40
Basic Cutting Tips 40
Operation Overview 41
Workpiece Inspection 41
Table Tilt 42
Models G0513, G0513P, & G0513ANV 42
Models G0513X2, G0513X2B, G0513X2BF, & G0513X2F 42
Guide Post 43
Fine Tune Tracking 43
Blade Selection 44
Blade Terminology 44
Blade Length 44
Blade Width 44
Blade Material 44
Tooth Set 45
Tooth Type 45
Blade Selection Chart 46
Blade Breakage 47
Blade Care & Break-In 47

Blade Changes 48
Removing Blade 48
Installing Blade 48
Blade Speed 49
Crosscutting 50
Resawing 50
Cutting Curves 51
Stacked Cuts 52

SECTION 5: ACCESSORIES 53

SECTION 6: MAINTENANCE 55
Schedule 55
Wheel Brush 55
Cleaning & Protecting 55
Lubrication 55
Blade Post Rack 55
Tension Adjustment Assembly 56
Trunnions 56

SECTION 7: SERVICE 57
Troubleshooting 57
V-Belt Service 60
Checking V-Belt 60
Replacing V-Belt 60
Blade Lead 61
Adjusting Wheel Brush 62
Adjusting Tension Lever 62
Adjusting Guide Post Travel 63
Checking/Adjusting Guide Post Parallel with Blade Side-to-Side 63
Checking/Adjusting Guide Post Parallel with Blade Front-to-Back 64
Aligning Wheels 65
Checking Coplanarity 65
Shimming Upper Wheel 66
Adjusting Lower Wheel 67
Magnetic Brake Adjustment (G0513X2B, G0513X2BF) 67

SECTION 8: WIRING 68
Wiring Safety Instructions 68
G0513, G0513P, G0513ANV, & G0513X2 Wiring Diagram 69
G0513X2B Wiring Diagram 70
G0513X2BF Wiring Diagram 71
G0513X2F 220V Wiring Diagram 72
G0513X2F 110V Wiring Diagram 73

SECTION 9: PARTS 74
G0513/G0513P/G0513ANV Main 74
G0513/G0513P/G0513ANV Table, Trunnion, & Lower Blade Guides 76
G0513/G0513P/G0513ANV Fence 77
G0513/G0513P/G0513ANV Upper Blade Guides & Miter Gauge 78
G0513 Labels 80
G0513P Labels 81
G0513ANV Labels 82
G0513X2 Main 83
G0513X2 Labels 85
G0513X2B Main 86
G0513X2B Labels 89
G0513X2BF Main 90
G0513X2BF Labels 93
G0513X2F Main 94
G0513X2F Labels 97
G0513X2, G0513X2B, G0513X2BF, & G0513X2F Guides & Trunnions 98
G0513X2 & G0513X2F Fence Assembly & Table 100
G0513X2B & G0513X2BF Fence Assembly & Table 101
G0513X2BF & G0513X2F Foot Brake 102

WARRANTY & RETURNS 105

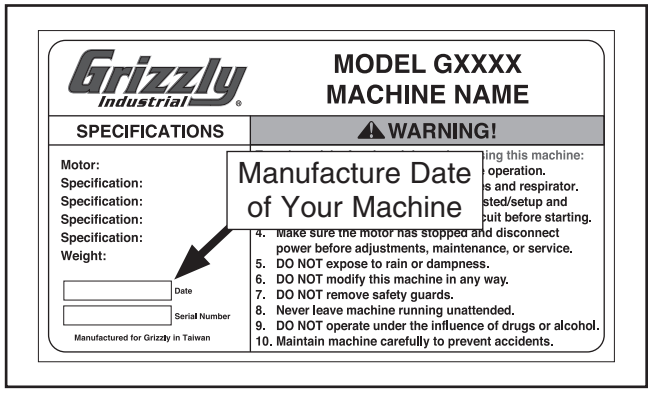
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

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

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

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

G0513 Series Combination Manual

The G0513 Series Bandsaws share many similarities. Thus, this combination manual includes information for all seven models of the G0513 Series Bandsaws.

Unless otherwise specified, information applies to all models. Headers are used to identify information that only applies to specific models.

Basic Controls

Refer to **Figures 1–4** and the following descriptions to become familiar with the basic controls and components of your bandsaw. Knowledge of these controls and terminology will help you better understand this manual.

Control Panel

The 2-button power switch on Models G0513, G0513P, and G0513X2 is located on the column for easy access (see **Figure 1**). The power button can be disabled with a padlock to prevent unauthorized startup of the bandsaw (refer to **Page 39** for additional details).

Figure 1. 2-Button power switch.

The Models G0513X2B, G0513X2BF, and G0513X2F feature a power switch that can be disabled with a key to prevent unauthorized starting of the machine (see **Figure 2**). To disable the switch, turn the key to "0" and remove it. To enable the switch, insert the key and turn it to "1."

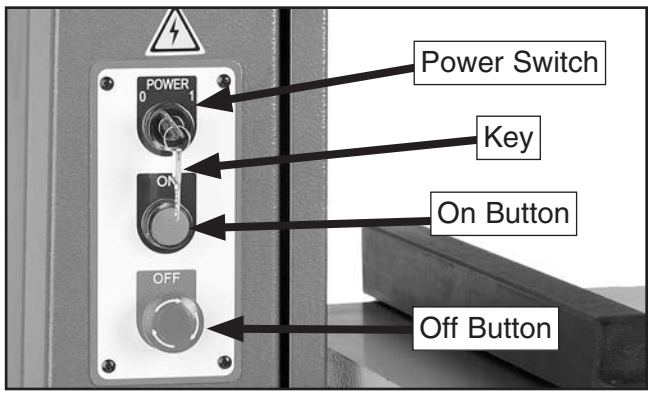


Figure 2. Control panel with a switch disabling lock.

Front Controls

A. Blade Tension Scale: Allows for easy monitoring of blade tension in arbitrary numbers 1–8.

B. Blade Tension Handwheel: Tensions blade in gradual increments.

C. Blade Tracking Window: Allows you to monitor blade tracking on the wheel without opening the wheel cover.

D. Fence and Miter Gauge: Supports workpiece for controlled straight or angled cuts.

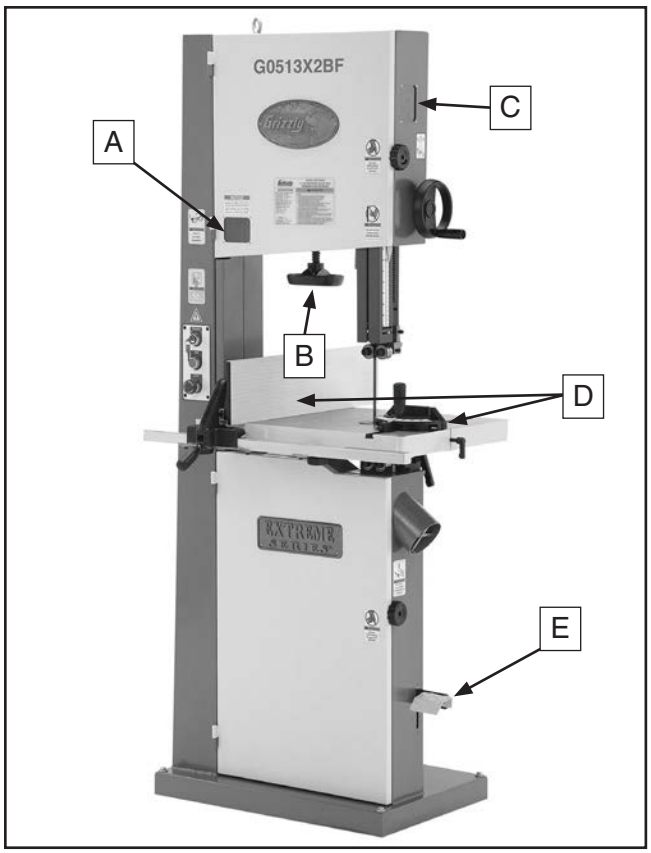


Figure 3. Front controls (G0513X2BF shown).

E. Foot Brake (Models G0513X2BF & G0513X2F): Quickly stops bandsaw blade and motor.

Motor Brake

The Models G0513X2B and G0513X2BF have a motor brake that activates and quickly stops the blade when the OFF button is used, or the foot pedal is pressed on the Model G0513X2BF.

Rear Controls

F. Wheel Cover Lock Knobs: Secure the wheel covers.

G. Quick-Release Blade Tension Lever: Adjusts blade tension for quick blade changes.

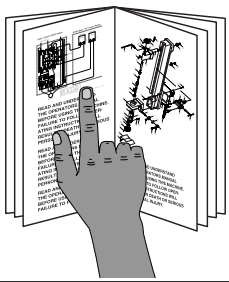
H. Blade Tracking Knob and Lock Lever: Moves and locks upper wheel tilt for blade tracking.

I. Table Tilt Controls: Adjusts table tilt and locks the table in place.

J. Magnetic Switch: Provides thermal overload protection for the motor.

K. Lower Wheel Adjustment Hub: Used when adjusting coplanarity of the wheels.

L. Guide Post Handwheel and Lock Knob: Quickly moves the upper guide post to the desired height; locks setting.



⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

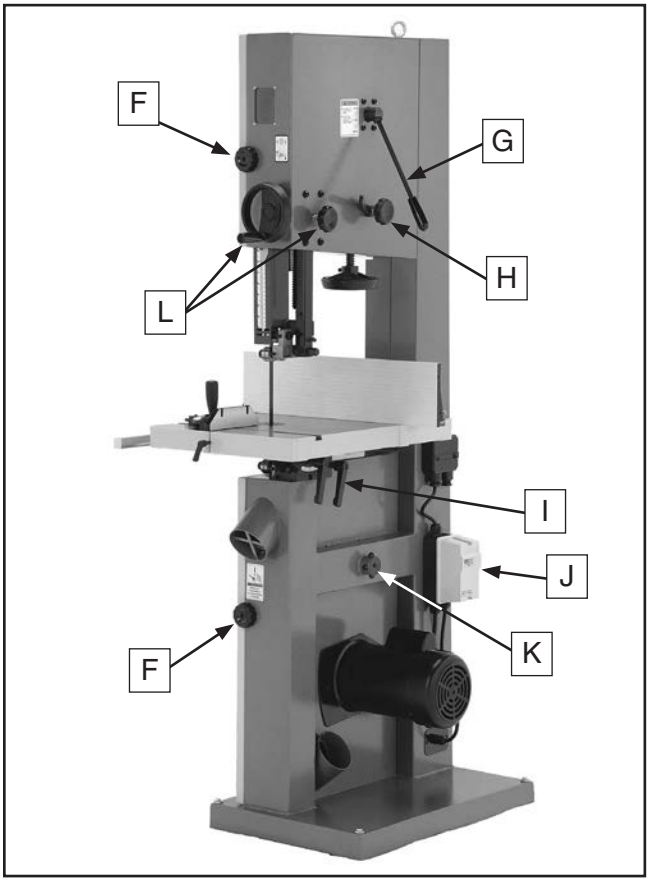


Figure 4. Rear controls (G0513X2B shown).

MACHINE DATA SHEET

MODEL G0513 SERIES 17" BANDSAWS

Model Number	G0513/G0513P/ G0513ANV	G0513X2	G0513X2B	G0513X2BF	G0513X2F
Product Dimensions					
Weight	266 lbs.	325 lbs.	352 lbs.	357 lbs.	335 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	32" x 32" x 73"				
Footprint (Length x Width)	27" x 17¾"				
Shipping Dimensions					
Type	Wood Slat Crate				
Weight	342 lbs.	418 lbs.	446 lbs.	460 lbs.	434 lbs.
Length x Width x Height	20" x 30" x 81"	31" x 21" x 81"	31" x 20" x 81"		31" x 21" x 81"
Electrical					
Power Requirement	110V/220V, Single-Phase, 60 Hz		220V, Single-Phase, 60 Hz		110V/220V, Single-Phase, 60 Hz
Full Load Current	20A at 110V, 10A at 220V	19A at 110V, 9.5A at 220V	8.7A	10A	20A at 110V, 10A at 220V
Minimum Circuit Size	30A at 110V, 15A at 220V		15A		30A at 110V, 15A at 220V
Prewired	220V				
Switch	2-Button Power Switch		Magnetic w/Thermal Overload Protection		
Switch Voltage	110V/220V		220V		110V/220V
Cord Included	Yes			No	
Plug Included	No		Yes, NEMA 6-15	No	
Motor					
Type	TEFC Capacitor Start Induction				
Horsepower	2 HP				
Voltage	110V/220V		220V		110V/220V
Phase	Single-Phase				
Amperage	20A at 110V, 10A at 220V	19A at 110V, 9.5A at 220V	8.7A	10A	20A at 110V, 10A at 220V
Speed	1725 RPM				
Cycle	60 Hz				
Power Transfer	Belt Drive				
Bearings	Shielded and Permanently Lubricated				
Operation					
Blade Speeds	1700, 3500 FPM				
Table Tilt	Left 10°, Right 45°	Left 5°, Right 45°			

Model Number	G0513/G0513P/ G0513ANV	G0513X2	G0513X2B	G0513X2BF	G0513X2F
Cutting Capacities					
Maximum Cutting Height	12⅛"	12"			
Maximum Capacity Left of Blade	16¼"				
Blade Information					
Standard Blade Length	131½"				
Blade Width Range	⅛"–1"				
Blade Guides	Roller Disc, Ball Bearings	Ball Bearings			
Guide Post Size	1.18" (30mm) Square				
Guide Post Type	Square Tubing, 0.075" in Wall Thickness				
Table Dimensions					
Length x Width x Thickness	17" x 17" x 1½"	23⅝" x 17¼" x 1½"			
Floor to Table Height	37½"				
Fence Information					
Locks in Front	Yes				
Locks in Rear	No				
Adjustable for Blade Lead	Yes				
Resaw Fence Included	No	Yes			
Construction					
Table	Precision-Ground Cast Iron				
Fence	Deluxe Extruded Aluminum	Cast Iron Fence w/ Extruded Aluminum Resaw Fence			
Body	Reinforced Steel				
Wheels	Computer-Balanced Cast Aluminum	Computer-Balanced Cast Iron			
Wheel Tire	Polyurethane				
Wheel Covers	Pre-Formed Steel				
Paint	Powder Coated				
Other Related Information					
Foot Brake	No			Yes	
Motor Brake	No		Yes		No
Wheel Diameter	16¾"				
Wheel Width	1¼"				
Dust Ports	2 at 4"				
Mobile Base Model	D2057A				
Other Specifications					
Country of Origin	Taiwan				
Warranty	1 Year				
ISO Factory	Yes				
Serial Number Location	ID Label on Upper Wheel Cover				
Assembly Time	1 Hour				

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.

⚠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.**

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

⚠WARNING
Additional Safety for Bandsaws

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to perform the cut and increase the risk of kickback. Inspect blades for cracks and missing teeth before each use.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure the blade teeth face down toward the table and the blade is properly tensioned and tracked before operating.

SMALL WORKPIECE HANDLING. If your hands slip during a cut while holding small workpieces with your fingers, serious personal injury could occur. Always support/feed the workpiece with push sticks, jig, vise, or some type of clamping fixture.

BLADE SPEED. Moving the workpiece against a blade that is not at full speed could cause the blade to grab the workpiece and draw the operator's hands into the blade. Always allow the blade to reach full speed before starting the cut.

WORKPIECE SUPPORT. If the workpiece should unexpectedly twist during cutting, it could kickback or draw the operator's hands into the blade. Always keep the workpiece flat and firm against the table when cutting. If necessary, use a jig or other work-holding device.

BLADE SUPPORT. The blade tension and guides/support bearings keep the blade straight when cutting. Always keep the blade tension, blade guides, and support bearings properly adjusted and positioned to avoid the blade bending or breaking with the forces of the cutting operation.

CUTTING TECHNIQUES. Plan your operation so the blade always cuts to the outside of the workpiece. DO NOT back the workpiece away from the blade while the saw is running, which could cause kickback and personal injuries. If you need to back the workpiece out, turn the bandsaw ***OFF*** and wait for the blade to come to a complete stop. DO NOT twist or put excessive stress on the blade that could damage it.

HAND PLACEMENT. Never position fingers or hands in line with the blade. If the workpiece or your hands slip, serious personal injury could occur.

FEED RATE. To avoid the risk of the workpiece slipping and causing operator injury, always feed stock evenly and smoothly. DO NOT force or twist the blade while cutting, especially when sawing small curves.

WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is NOT designed to cut metal, glass, stone, tile, etc.

BLADE CONTROL. To avoid serious personal injury, DO NOT attempt to stop or slow the blade with your hand or the workpiece. Allow the blade to stop on its own.

UPPER BLADE GUIDE SUPPORT. To reduce the exposure of the operator to the blade and provide maximum support for the blade, keep the upper blade guides and support bearing no more than 1" above the workpiece.

⚠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.

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 electrican or qualified service personnel in accordance with all applicable codes and standards.

⚠WARNING

Electrocution, fire, or equipment damage may occur if machine is not correctly grounded and connected to the power supply.

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.

G0513, G0513P, G0513ANV, & G0513X2F Full-Load Current Rating
At 110V.....20 Amps
At 220V .....10 Amps

G0513X2 Full-Load Current Rating
At 110V.....19 Amps
At 220V .....9.5 Amps

G0513X2B Full-Load Current Rating
At 220V 8.7A

G0513X2BF Full-Load Current Rating
At 220V 10A

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

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

Circuit Information

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

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

Circuit Requirements

These machines are prewired to operate on a 220V power supply circuit that has a verified ground and meet the 220V operation requirements listed below.

Models G0513, G0513P, G0513ANV, G0513X2, and G0513X2F can be converted to operate on a 110V power supply (refer to **Voltage Conversion** instructions beginning on **Page 69**) that has a verified ground and meet the 220V operation requirements listed below.

Model Number	G0513, G0513P, G0513ANV, G0513X2, G0513X2F	G0513X2B & G0513X2BF
Circuit Requirements For 220V Operation:		
Nominal Voltage	220V/240V	
Cycle	60 Hz	
Phase	Single-Phase	
Power Supply Circuit	15 Amps	
Plug/Receptacle	NEMA 6-15	
Power Cord	"S"-Type, 3-Wire, 14 AWG, 300 VAC	
Circuit Requirements For 110V Operation:		
Nominal Voltage	110V/120V	N/A
Cycle	60 Hz	
Phase	Single-Phase	
Power Supply Circuit	30 Amps	
Plug/Receptacle	NEMA L5-30	
Power Cord	"S"-Type, 3-Wire, 12 AWG, 300 VAC	

Grounding Requirements

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

Grounding Requirements for 220V: The plug specified under "Circuit Requirements for 220V Operation" on this page has a grounding prong that must be attached to the equipment-grounding wire inside the specified power cord. The plug must only be inserted into a matching receptacle (see **Figure 5**) that is properly installed and grounded in accordance with all local codes and ordinances.

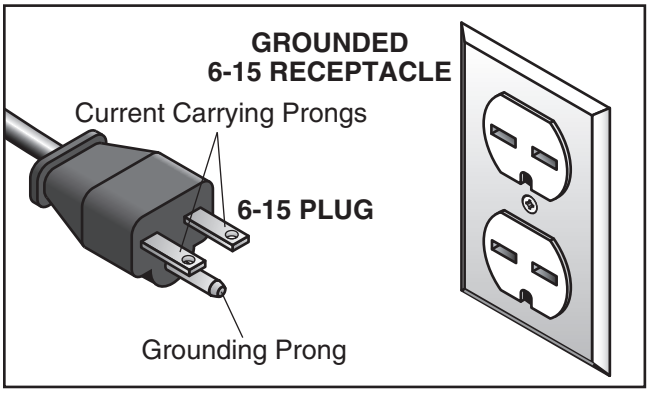
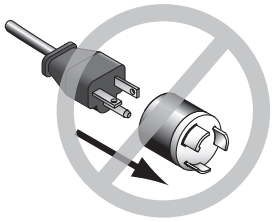


Figure 5. Typical 6-15 plug and receptacle.

⚠CAUTION



No adapter should be used with the required plug. If the plug does not fit the available receptacle, or the machine must be reconnected for use on a different type of circuit, the reconnection must be made by a qualified electrician and comply with all local codes and ordinances.

Grounding Requirements for 110V: The plug specified under "Circuit Requirements for 110V Operation" on the previous page has a grounding prong that must be attached to the equipment-grounding wire inside the specified power cord. The plug must only be inserted into a matching receptacle (see **Figure 6**) that is properly installed and grounded in accordance with all local codes and ordinances.

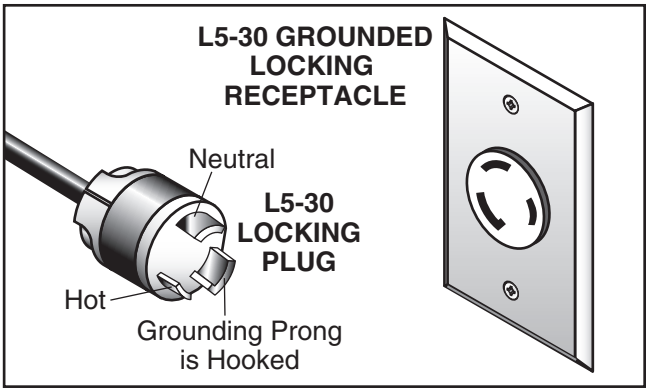


Figure 6. Typical L5-30 plug and receptacle.

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

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

⚠WARNING

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

⚠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.

Extension Cords

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

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

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

Minimum Gauge Size at 220V .....14 AWG
Minimum Gauge Size at 110V.....12 AWG
Maximum Length (Shorter is Better).....50 ft.

Voltage Conversion

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

Models G0513, G0513P, G0513ANV, & G0513X2

To perform the voltage conversion, install the correct plug and rewire the motor to the new voltage, according to the wiring diagram provided on **Page 69**.

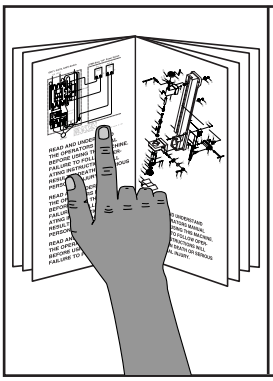
Model G0513X2F

To perform the voltage conversion, replace the magnetic switch with the 110V version (Part No. P0513X2F244), install the correct power cord and plug, and rewire the motor to the new voltage, according to the wiring diagram provided on **Page 72**.

NOTICE

If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor.

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!

Introduction

The bandsaw is an efficient and flexible woodworking machine. However, the bandsaw functions are inter-dependent and each one must be properly set up and adjusted so that the entire machine operates correctly.

For instance, in this **SETUP** section, you will do an initial blade tensioning before adjusting the blade tracking. This will also allow you to properly adjust the table angle, positive stop, blade guides, and support bearing.

To prepare the machine for safe cutting and good results, take extra care when performing these inter-dependent tasks and complete them in the correct order.

Needed for Setup

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

Description	Qty
• Additional People	1
• Safety Glasses	1 per Person
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags	As Needed
• Forklift/Strap or Chain w/Lifting Hook (Each component rated for at least 1000 lbs)	1 Each
• 1x4 & 2x4 Shims (Optional)	1 Each
• Feeler Gauges 0.004", 0.016"	1 Each
• Straightedge	1
• Fine Ruler	1
• Machinist's Square	1
• Phillips Screwdriver #2	1
• Hex Wrench 6mm	1
• Dust Collection System	1
• Dust Hose 4"	2
• Hose Clamps 4"	2

Unpacking

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

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

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

Inventory

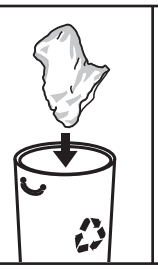
The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

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

G0513, G0513P, & G0513ANV

Shipping Inventory (Figures 7 & 8):	**Qty**
A. Bandsaw (not shown)	1
B. Table	1
C. Miter Gauge	1
D. Rear Rail	1
E. Front Rail	1
F. Fence Assembly	1
G. Guide Post Handwheel	1

Hardware & Tools (Not Shown)	**Qty**
• Eye Bolt M10-1.5 (May Be Installed)	1
• Flat Washers 8mm (Table)	4
• Lock Washers 8mm (Table)	4
• Hex Bolts M8-1.25 x 16 (Table)	4
• Hex Bolt M8-1.25 x 90 (Positive Stop)	1
• Hex Nuts M8-1.25 (Positive Stop, Fence)	2
• Cap Screws M6-1 x 16 (Fence)	2
• Hex Bolts M6-1 x 20 (Fence)	2
• Lock Washers 6mm (Fence)	2
• Flat Washers 6mm (Fence)	2
• Hex Nut M6-1 (Fence)	1
• Table Pin	1
• Table Insert	1
• Fence Handle M8-1.25 x 22 (Fence)	1
• Rail Pad M6-1 x 18 (Fence)	1
• Hex Wrench 5mm, 8mm	1 Each
• Open End Wrench 10 x 13mm	1



⚠WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

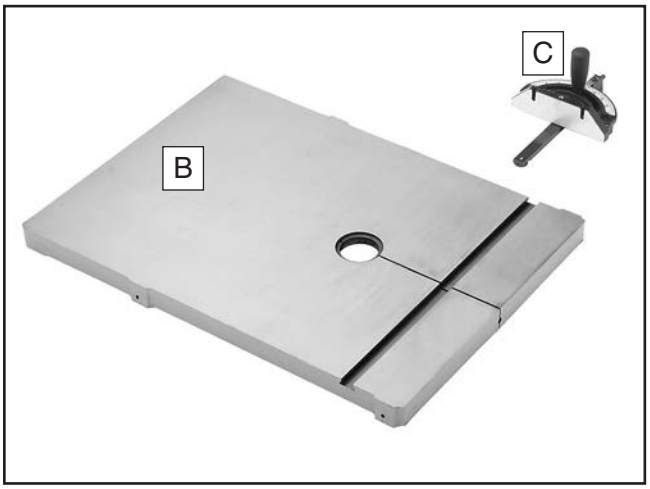


Figure 7. Table and miter gauge.

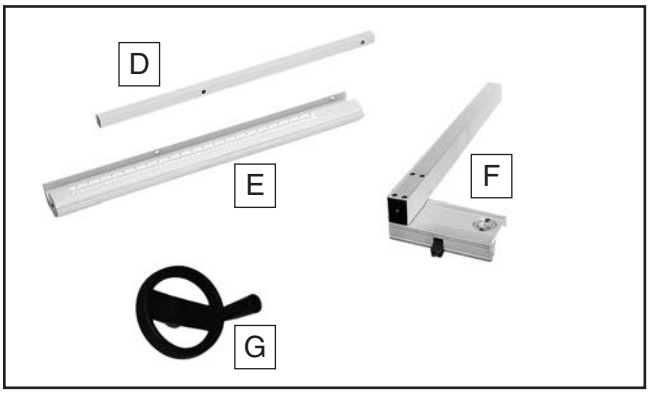


Figure 8. Other bandsaw components.

NOTICE

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

G0513X2, G0513X2B, G0513X2BF, & G0513X2F

Shipping Inventory (Figures 9 & 10): **Qty**

A. Bandsaw (not shown) 1
B. Table 1
C. Miter Gauge 1
D. Rear Rail 1
E. Resaw Fence 1
F. Front Rail 1
G. Fence Assembly 1
H. Foot Brake Pedal (G0513X2BF & G0513X2F) 1
I. Guide Post Handwheel 1

Hardware & Tools (Not Shown) **Qty**

- Eye Bolt M10-1.5 (May Be Installed) 1
- Flat Washers 8mm (Table, Fence, Rail) 8
- Lock Washers 8mm (Table, Rail) 5
- Hex Bolts M8-1.25 x 25 (Table) 4
- Hex Bolt M8-1.25 x 90 (Positive Stop) 1
- Hex Nuts M8-1.25 (Positive Stop, Fence) ... 2
- Cap Screws M6-1 x 20 (Rail) 3
- Cap Screw M8-1.25 x 20 (Rail) 1
- Lock Washers 6mm (Rail) 3
- Flat Washers 6mm (Rail) 3
- Hex Nut M6-1 (Fence) 1
- Cap Screws M6-1 x 16 (Foot Brake Pad) ... 2
- Lock Washers 6mm (Foot Brake Pad) 2
- Table Pin 1
- Table Insert 1
- Fence Handle M8-1.25 x 44 (Fence) 1
- Rail Pad M6-1 x 18 (Fence) 1
- Moving Plate (Fence) 1
- Rail Plates 3
- Hex Wrench 5mm, 8mm ..... 1 Each
- Open End Wrench 10 x 13mm 1

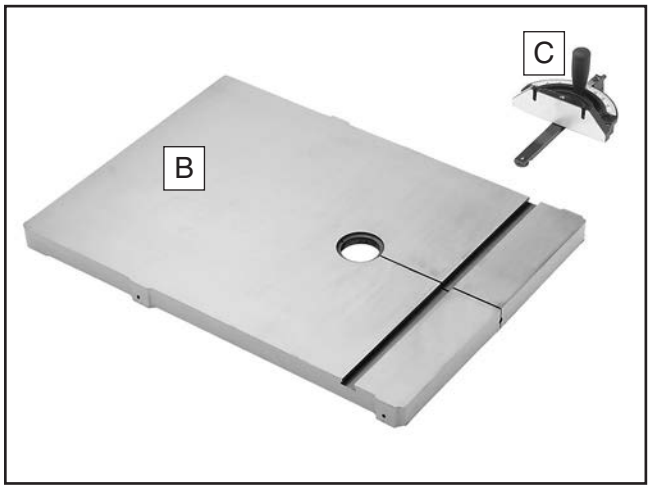


Figure 9. Table and miter gauge.

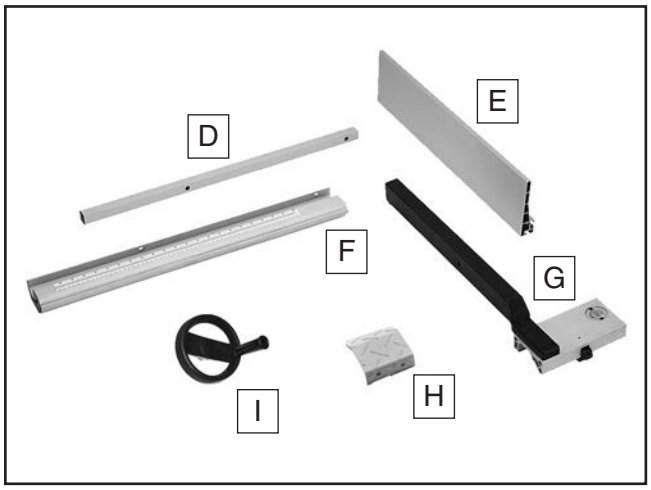


Figure 10. Other bandsaw components.

Cleanup

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

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

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

Before cleaning, gather the following:
- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

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

Site Considerations

Floor Load

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

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 11** for the minimum working clearances.

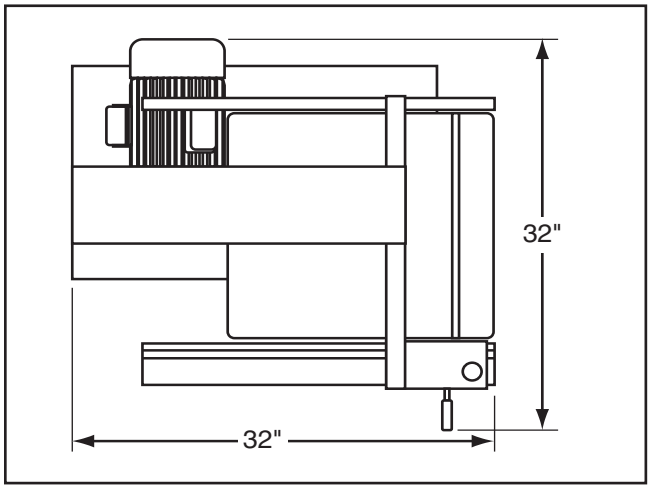
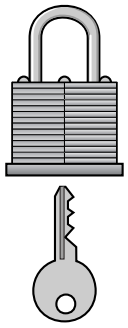


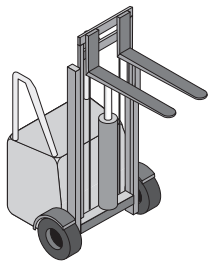
Figure 11. Minimum working clearances.



⚠CAUTION

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

Moving & Placing Bandsaw



⚠WARNING

This bandsaw is a heavy machine. Serious personal injury may occur if safe moving methods are not used. Get assistance and use power equipment to move the shipping crate and remove the machine from the shipping pallet.

Special care should be taken when moving this bandsaw. Only use one of the following methods to lift or move this bandsaw.

Using Eye Bolt

1. Move the crate to the prepared location, then remove the crate from the shipping pallet.

2. Unbolt the bandsaw from the pallet.

3. Install the eye bolt shown (see **Figure 12**), make sure it is threaded all the way in, then place the lifting hook through the eye bolt and lift the bandsaw slowly with a forklift.

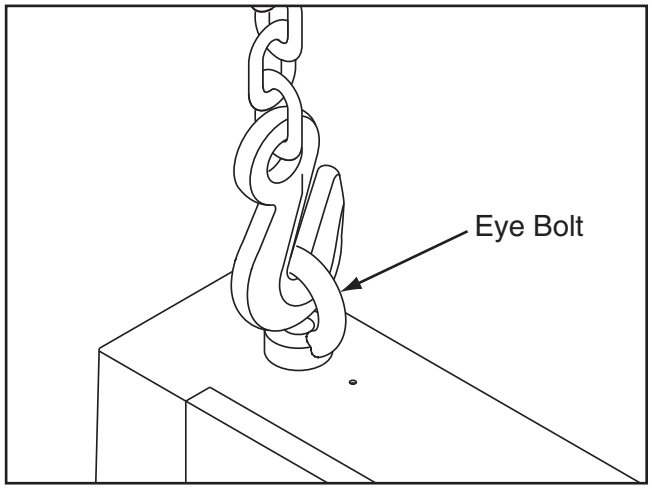


Figure 12. Lifting the bandsaw.

4. Remove the pallet and slowly set the bandsaw into position.

Using Wood Blocks

1. Move the crate to the prepared location, then remove the crate from the shipping pallet.

2. Unbolt the bandsaw from the pallet.

3. Carefully place the forklift forks under the head and insert a 1x4 block between the head and the left fork and a 2x4 block between the head and right fork so the bandsaw is level, as shown in **Figure 13**.

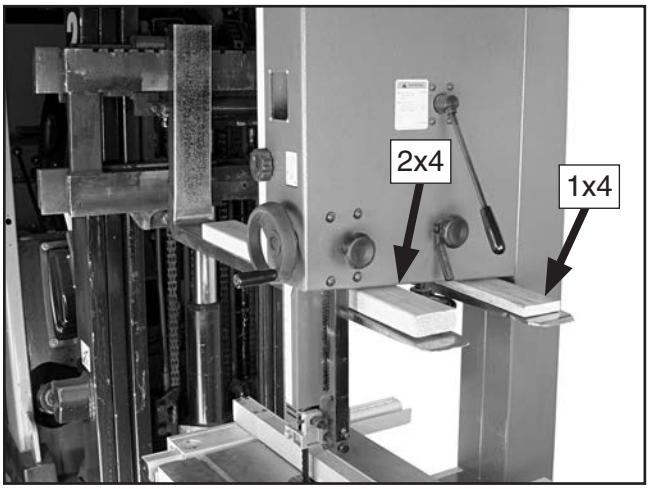


Figure 13. Example photo of lifting bandsaw with forklift using wood shims.

4. Lift the bandsaw off of the pallet, remove the pallet, then slowly set the bandsaw into position.

Note: *If you are concerned about your forklift forks hitting the tension handwheel, remove the handwheel before positioning the forks, then reinstall it after placing.*

⚠WARNING

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

Mounting

We recommend mounting your new machine to the floor. Because floor materials may vary, floor mounting hardware is not included. You may also mount your machine to a mobile base that has wheel locking or wheel retracting capabilities that keeps the mobile base from rolling when not in use.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (see **Figure 14**) and anchor studs (see **Figure 15**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

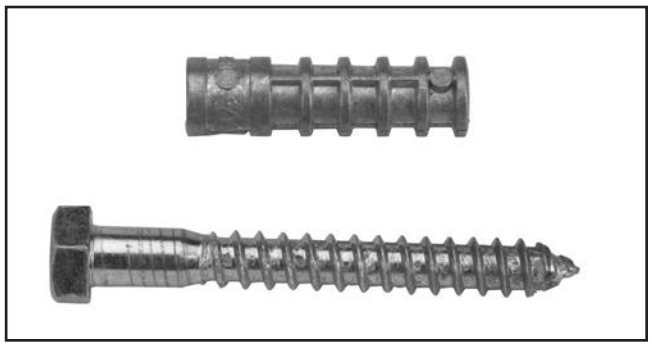


Figure 14. Typical lag shield anchor and bolt.

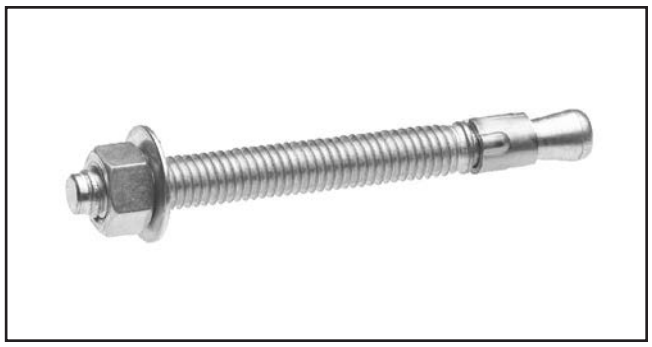


Figure 15. Typical anchor stud.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

Assembly

Installing Guide Post Handwheel, Positive Stop Bolt, & Table

1. Secure the guide post handwheel onto the handwheel shaft flat with the included set screw (see **Figure 16**).

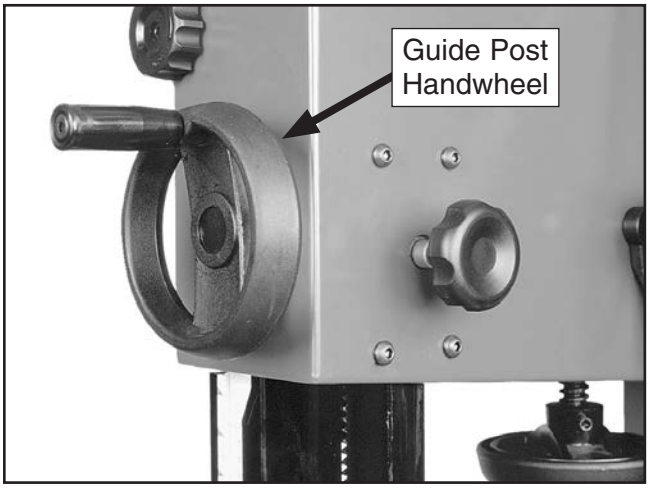


Figure 16. Guide post handwheel installed.

2. Thread the M8-1.25 hex nut halfway onto the M8-1.25 x 90 hex bolt (this is the positive stop bolt).

3. Thread the positive stop bolt into the threaded hole on bandsaw body (see **Figure 17**).

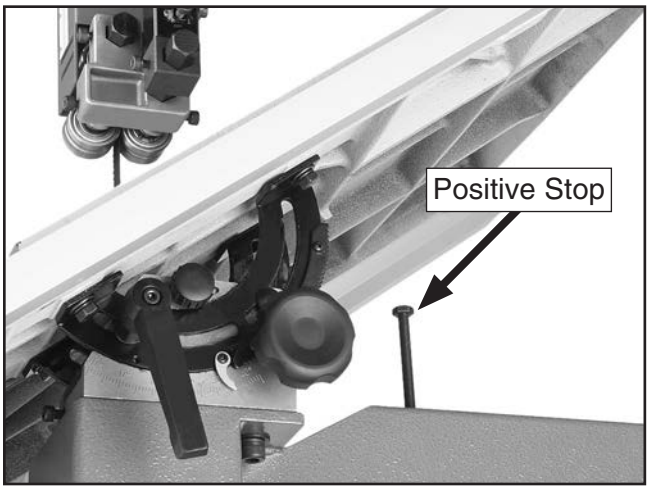


Figure 17. Positive stop bolt installed.

4. Loosen blade tension by rotating the quick-release tension lever clockwise, as shown in **Figure 18**.

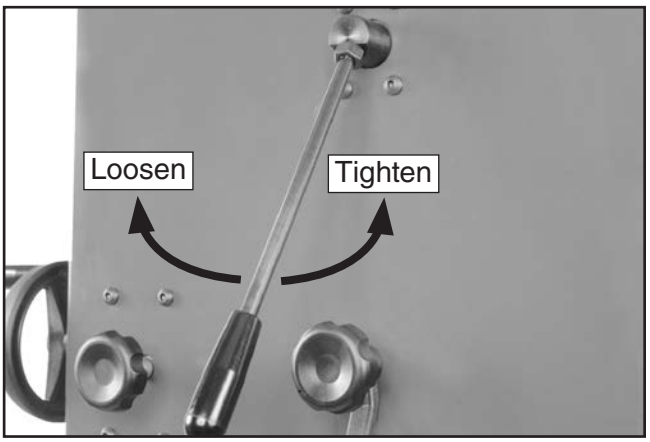


Figure 18. Quick-release tension lever.

5. Adjust the upper and lower blade guides away from the blade. Refer to **Adjusting Blade Guides** beginning on **Page 33** for more details.

CAUTION

All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling saw blades.

6. Remove the saw blade (refer to **Blade Changes** on **Page 48** for detailed instructions).

7. With the help of another person, lift the table onto the trunnions.

NOTICE

The table is heavy and requires two people to lift it onto the trunnions. Remove the saw blade to make table installation easier.

8. **Models G0513, G0513P and G0513ANV:** Secure the table to the trunnions, as shown in **Figure 19** with the (4) M8-1.25 x 16 hex bolts, 8mm lock washers, and 8mm flat washers.

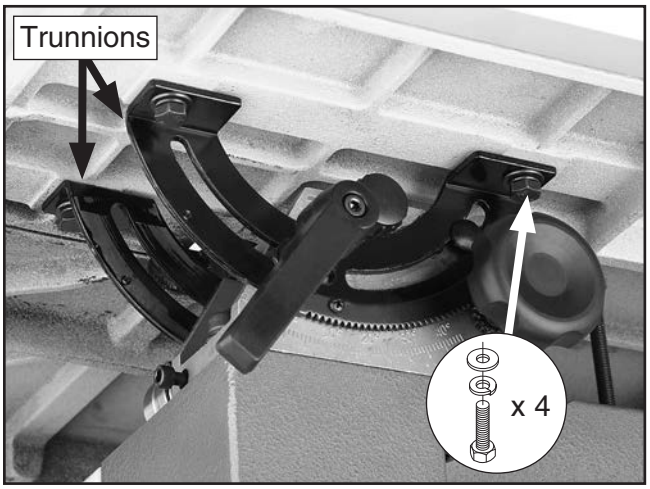


Figure 19. Mounting the table.

Models G0513X2, G0513X2B, G0513X2BF, and G0513X2F: Secure the table to the trunnions with the (4) M8-1.25 x 25 hex bolts, 8mm lock washers, and 8mm flat washers.

9. Replace the saw blade.

Installing Fence (G0513, G0513P, G0513ANV, G0513X2, & G0513X2F)

1. Attach the rear rail to the table with the (2) M6-1 x 16 cap screws, as shown in **Figure 20**.

2. Attach the front rail with the (2) M6-1 x 20 hex bolts, 6mm lock washers, and 6mm flat washers, as shown in **Figure 20**.

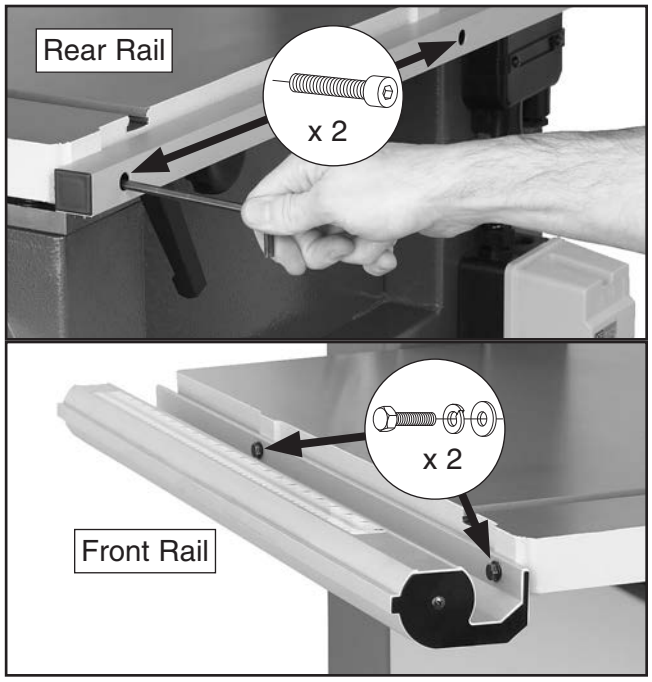


Figure 20. Rail installation.

3. Install an M8-1.25 hex nut on the fence handle, then thread the handle into the fence assembly, as shown in **Figure 21**. Tighten the hex nut against the fence pivot block to secure the handle.

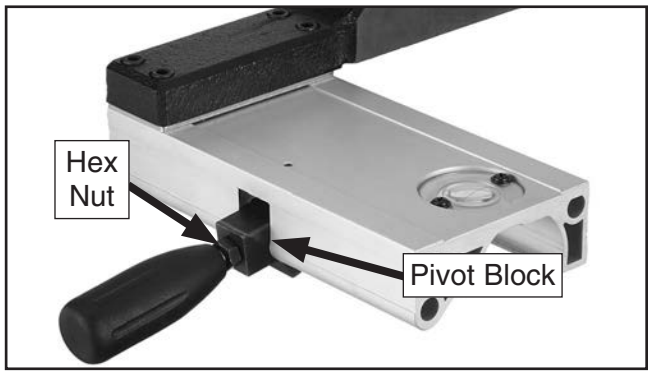


Figure 21. Handle installed on fence assembly.

4. Thread the M6-1 hex nut onto the rail pad, then thread the rail pad into the rear of the fence (see **Figure 22**).

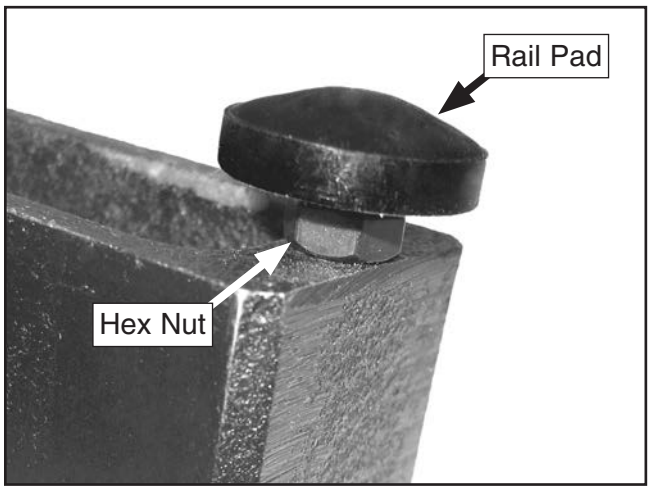


Figure 22. Installed rail pad.

5. Pull the fence handle up and place the fence assembly on the front rail (see **Figure 23** for an example photo).

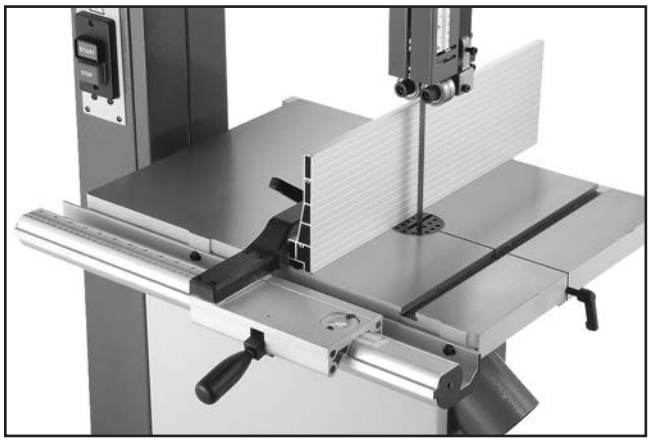


Figure 23. Example photo of correctly installed fence.

6. Push the fence handle down to lock the fence assembly in place.

7. Adjust the rear rail pad until there is an even gap between the bottom of the fence and the table, then tighten the rail pad hex nut against the fence.

Installing Fence (G0513X2B & G0513X2BF)

1. Attach the rail plates to the front rail with the (3) M6-1 x 20 cap screws, 6mm lock washers, and 6mm flat washers (see **Figure 24**).

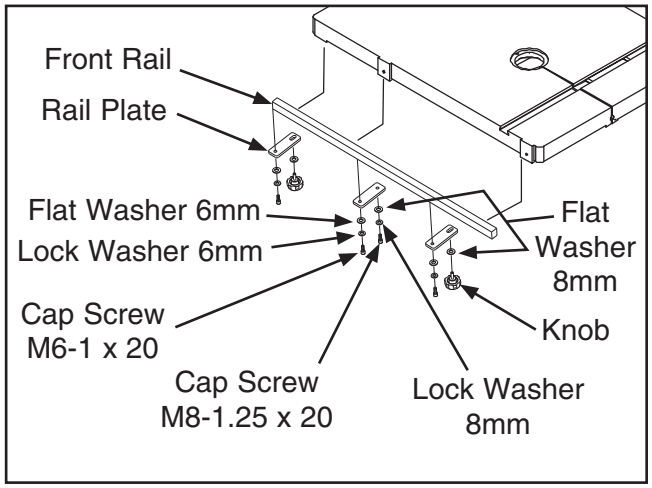


Figure 24. Installing front rail onto table.

2. Attach the outer two rail plates with the round and elongated mounting holes to the outer part of the table bottom with (2) M8-1.25 x 20 knobs and 8mm flat washers.

3. Attach the remaining rail plate with the round mounting holes using (1) M8-1.25 x 20 cap screw, 8mm lock washer, and 8mm flat washer (see **Figure 24**).

4. Thread the fence handle into the fence, then tighten the hex nut against the fence pivot block (see **Figure 25**).

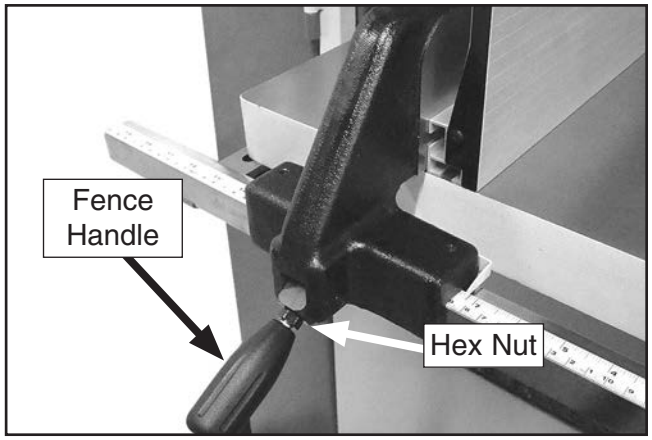


Figure 25. Fence handle components.

5. Install the fence on the left-hand side of the blade.

6. Place the fence flush against the bandsaw blade (see **Figure 26**).

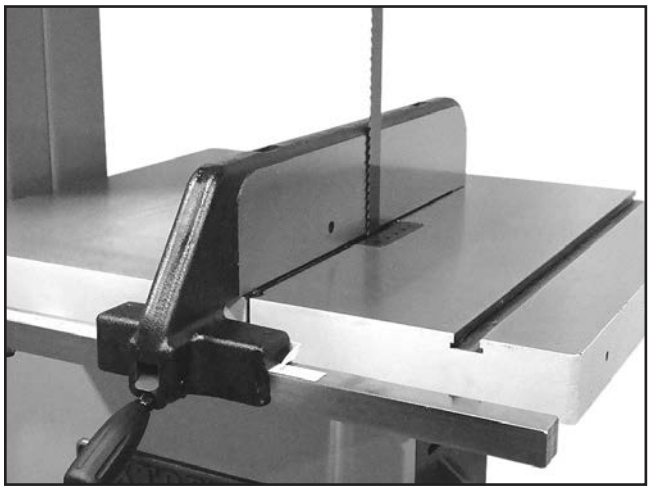


Figure 26. Fence flush with blade.

7. Loosen the pointer adjustment nut (see **Figure 27**) and set the pointer in line with "0" on the measurement scale on the rail.

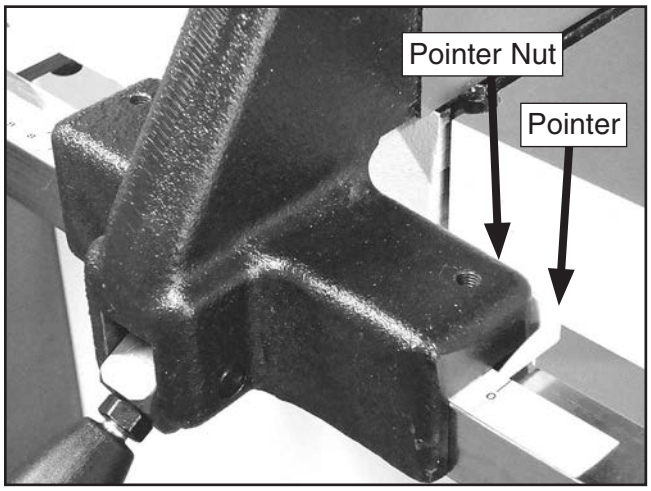


Figure 27. Calibrating fence pointer (adjustment nut out of view).

8. Re-tighten the pointer adjustment nut.

Installing Foot Brake Pedal (G0513X2BF & G0513X2F)

Secure the foot brake pedal to the brake lever using the (2) M6-1 x 16 cap screws and 6mm lock washers, as shown in **Figure 28**.

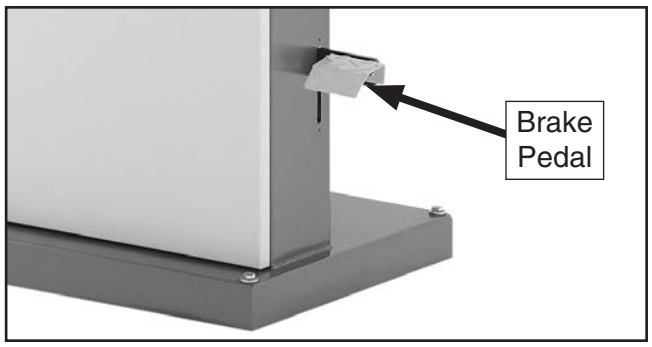


Figure 28. Foot brake installed.

Installing Resaw Fence (G0513X2, G0513X2B, G0513X2BF, & G0513X2F)

To Install the resaw fence:

1. Place the 8mm flat washer on the lock handle (see **Figure 29**), slide it through the hole in the fence, then thread the moving plate onto the end of the lock handle threads.

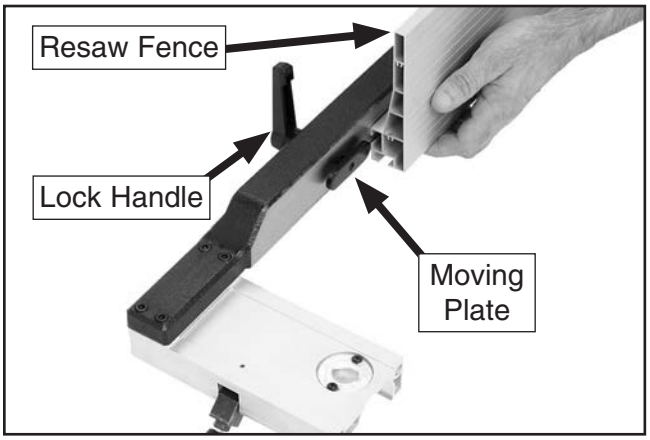
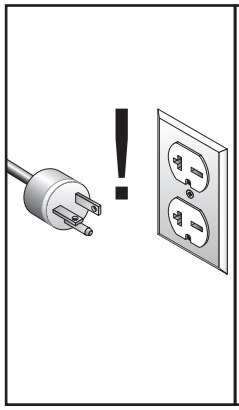


Figure 29. Attaching resaw fence.

2. Slide the resaw fence over the moving plate, as shown in **Figure 29**, so the moving plate fits inside the channel of the resaw fence, then tighten the lock handle.

Initial Blade Tracking



⚠WARNING

Serious personal injury can occur if the machine starts while your hand is touching the bandsaw wheel during tracking adjustments. Disconnect power from the bandsaw before performing blade tracking adjustments.

Blade tracking is primarily affected by the tilt of the upper wheel, known as "center tracking." However, the alignment of both wheels plays an important part as well (see the **Aligning Wheels** instructions on **Page 65** for more details).

The wheels on this bandsaw were aligned at the factory, so center tracking is the only adjustment that needs to be performed when the saw is new.

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the upper and lower blade guides are adjusted away from the blade.
3. Open the upper wheel cover.
4. Engage the quick tension lever, then turn the blade tension handwheel until the tension scale (see **Figure 30**) is between 4 and 6.

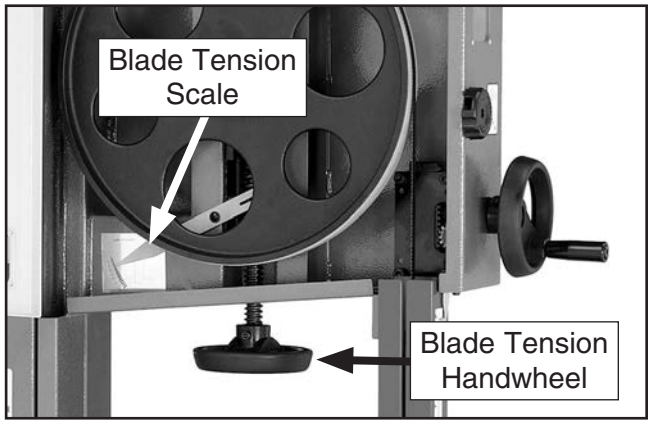


Figure 30. Blade tensioning controls.

⚠CAUTION

The wheels may have sharp edges and the blade teeth may extend beyond the edge, creating a laceration hazard. Be careful when turning the wheels by hand.

5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 31** for an illustration of this concept.

   —If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, then the bandsaw is already tracking properly and no further adjustments are needed at this time.

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

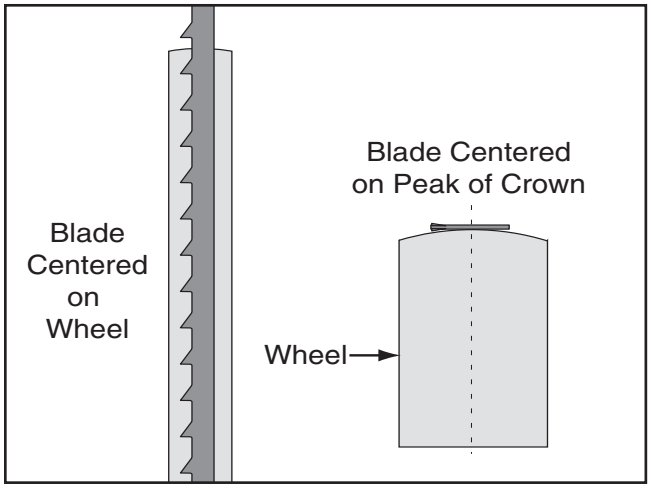


Figure 31. Center tracking profiles.

IMPORTANT

Changes made to the blade tension may change how the blade tracks.

6. Loosen the lock lever on the back of the bandsaw (see **Figure 32**) so that the blade tracking knob can rotate.

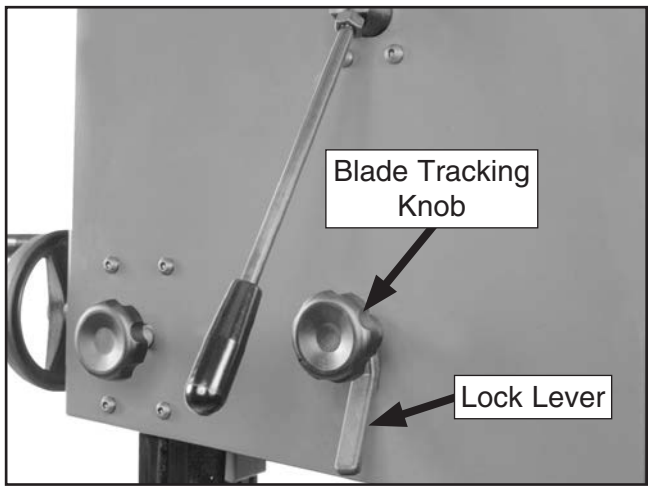


Figure 32. Blade tracking controls.

7. Spin the upper wheel with one hand and rotate the tracking control knob in small amounts with the other hand until the blade consistently rides in the center of the bandsaw wheel tire.

8. Tighten the tracking control lock knob and close the upper wheel cover.

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

*Fine tune tracking must be done with the bandsaw turned **ON**. This will be explained later in the **Operations** section.*

Adjusting Positive Stop

The positive stop allows the table to be quickly and accurately returned to the horizontal (0˚) position after being adjusted to a different angle.

To position the positive stop:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the blade tension until the mark on the blade tension scale is between 4 and 6.

3. Loosen the hex nut that locks the positive stop bolt in place.

4. Raise the guide post and place a machinist's square on the table next to the side of the blade, as illustrated in **Figure 33**. Adjust the table square with the blade, then secure it with the table tilt lock lever.

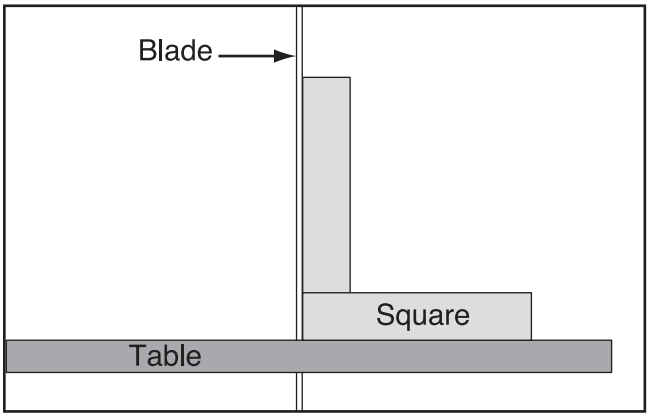


Figure 33. Squaring table to blade.

5. Adjust the positive stop bolt against the bottom of the table and secure it by tightening the hex nut against the trunnion bracket.

6. Check the adjustment for accuracy once you have tightened the hex nut.

7. Loosen the screw on the pointer, but do not remove it.

8. Align the tip of the pointer with the 0˚ mark on the table tilt scale, then re-tighten the screw to secure the setting.

Dust Collection

⚠CAUTION

DO NOT operate this bandsaw without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 4" dust hose over each dust port and secure them in place with a hose clamp (see **Figure 34**).

2. Tug the hoses to make sure they do not come off.

   Note: *A tight fit is necessary for proper performance.*

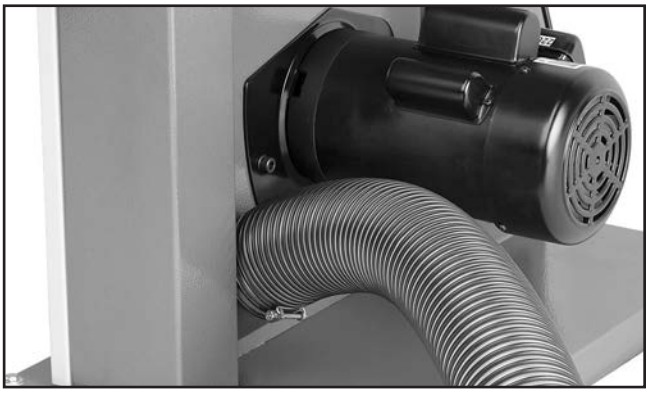


Figure 34. Dust hose attached to bottom dust port.

Power Cord Connection (G0513X2BF & G0513X2F)

⚠WARNING

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

The power cord connection MUST be performed by an electrician or qualified service personnel.

Items Needed	Qty
Cord "S"-Type, 3-Wire, 14 AWG, 300 VAC, at least 6 ft. long	1
Phillips Screwdriver #2	1
Wire Nuts for (2) 14 AWG Wires	3
Electrical Tape	As Needed

To connect the power cord to the machine:

1. Attach the required plug to the cord per the plug manufacturer's instructions (refer to **Power Supply** beginning on **Page 11** for specifications and the NEMA plug wiring on **Pages 71– 72**).

2. Remove the power supply junction box cover from the right rear of the bandsaw (see **Figure 35**). It is secured by two screws.

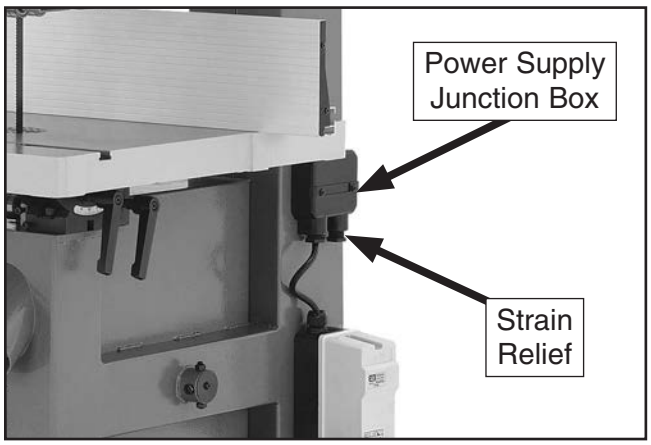


Figure 35. Power supply junction box on rear of bandsaw.

3. Loosen the right strain relief on the junction box, then feed the cord into the box with enough slack in the wires to make the connections.

4. Re-tighten the strain relief around the cord. Tug on it to make sure the wires inside the box will not move.

5. Connect the incoming ground wire to the ground post, as shown in **Figure 36**.

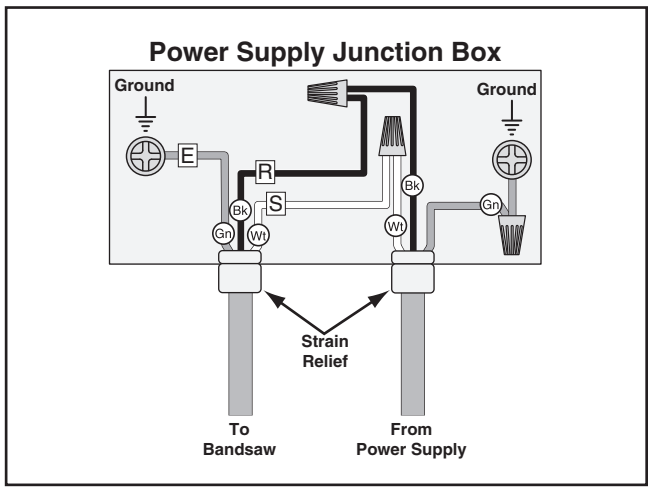


Figure 36. Incoming power cord connections.

6. Secure the two incoming hot wires to the black and white wires from the bandsaw with wire nuts, then wrap the nuts and wires with electrical tape to make sure they will not come loose.

7. Re-attach the junction box cover.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the safety disabling mechanism works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 57**.

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

To test run the machine:

1. Make sure that you have successfully completed the **Initial Blade Tracking** procedure on **Page 25** before continuing.

2. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.

3. Make sure all tools and objects used during setup are cleared away from the machine.

4. Connect the machine to the power source.

5. Test the operation of the machine to verify that it starts and operates correctly.

   G0513, G0513P, G0513ANV, & G0513X2 Only

   a. Verify that the machine is operating correctly by pressing the power button.

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

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

G0513X2B, G0513X2F, & G0513X2BF Only

a. Insert the key into the power switch (see **Figure 37**), then turn it to the "1".

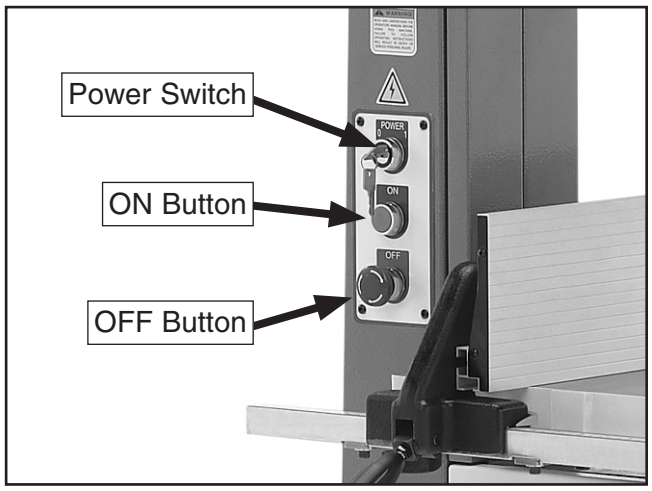


Figure 37. G0513X2B and G0513X2BF control panel.

b. Verify that the machine is operating correctly by pressing the ON button.

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

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

c. Press the OFF button to stop the bandsaw.

d. WITHOUT resetting the OFF button, press the ON button. The machine should not start.

— If the machine does start (with the OFF button pushed in), immediately disconnect the machine from power. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

e. Push the OFF button in, then twist it clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 38**).

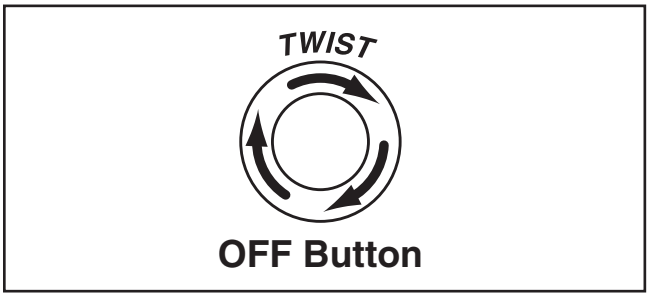


Figure 38. Resetting the OFF button.

f. Turn the key in the power switch to "0".

g. Try to turn the machine ***ON***. The bandsaw should not start.

— If the bandsaw starts, immediately disconnect the machine from power. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

6. Test the operation of the foot brake:

G0513X2BF & G0513X2F Only

a. Start the bandsaw, then press the foot brake. The motor should shut off and the blade should come to a rapid stop.

— If the motor does not stop or the blade does not come to a rapid stop, immediately disconnect the machine from power. The foot brake feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Congratulations! The test run is complete and you are ready to proceed with the following adjustments before putting the bandsaw into full operation.

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts, maximizing the life of the blade, and making other bandsaw adjustments. However, it will not compensate for cutting problems caused by too rapid of a feed rate, hardness variations between workpieces, and improper blade selection.

⚠CAUTION

Improper blade tension is unsafe, produces inaccurate and inconsistent results, and introduces unnecessary wear on bandsaw components. Over-tensioning the blade increases the chance of the blade breaking or wheel misalignment. Under-tensioned blades wander excessively while cutting and will not track properly during operation.

NOTICE

Tensioning the blade according to the blade tension scale before the Test Run section gave an approximate tension for completing the bandsaw setup. The following procedures tension the blade for operation.

Blade tensioning method is a matter of preference. The flutter method and the deflection method are described below. Either method safely tensions the blade. Experience and personal preference will help you decide which method your prefer. Optimal cutting results for any workpiece results from a combination of correct blade selection, proper blade tension, and a light and even feed rate.

Flutter Method

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the blade is properly center tracking as instructed in the **Initial Blade Tracking** on **Page 25**.

3. Raise the guide post all the way, and move the upper and lower blade guides away from the blade.

4. Engage the blade tension quick-release lever to apply tension to the blade (see **Figure 39**).

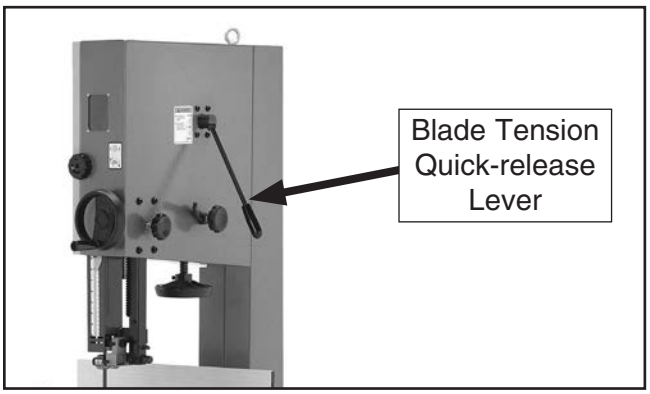


Figure 39. Blade tension quick-release lever (G0513X2 shown).

5. Connect the bandsaw to power, and turn the bandsaw ***ON***.

6. Using the blade tension handwheel (**Figure 40**), slowly decrease blade tension until the blade starts to flutter.

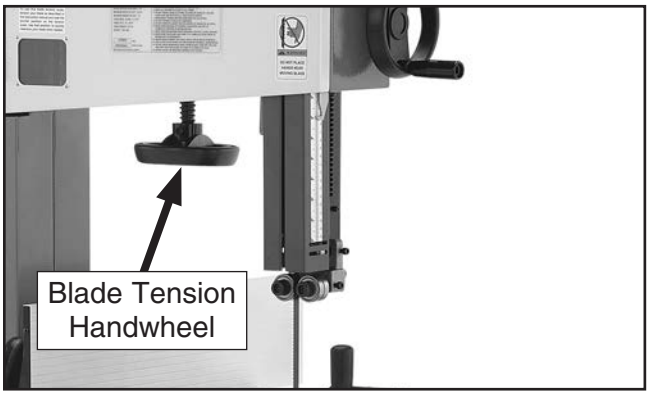


Figure 40. Blade tension handwheel.

7. Slowly increase the tension until the blade stops fluttering, then turn the blade tension adjustment knob an additional ⅛ to ¼ of a turn.

8. Turn the bandsaw ***OFF*** and disconnect it from power.

9. Note what the tension gauge reads. Use that as a guide for tensioning that specific blade in the future.

10. Re-adjust blade guides as described in **Adjusting Blade Guides** beginning on **Page 33** for your model bandsaw.

Deflection Method

The deflection method is more subjective than the flutter method. Each blade deflects differently and every user must determine what "moderate pressure" means. The following are general guidelines for tensioning the blade with the deflection method.

To tension the bandsaw blade:

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the blade is properly tracking as instructed in the **Initial Blade Tracking** section on **Page 25**.

3. Raise the guide post all the way, and move the upper and lower blade guides away from the blade.

4. Engage the blade tension quick-release lever to apply tension to the blade.

5. Using moderate pressure, push the center of the blade sideways.

   —If the blade deflects approximately ¼", it is properly tensioned. Proceed to **Step 6**.

   —If the blade deflects less than ¼" it is over-tensioned. Turn the blade tensioning handwheel counterclockwise two full turns and repeat this step.

   —If the blade deflects more than ¼", the blade is under-tensioned. Apply tension to the blade a small amount and repeat this step until the blade is properly tensioned.

6. Re-adjust the blade guides as described in **Adjusting Blade Guides** beginning on **Page 33** for your model bandsaw.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and blade guides must be properly adjusted before performing cutting operations.

Adjusting Blade Support Bearings

Support bearings stop excessive backward deflection of the blade from the advancing workpiece. The proper adjustment of the support bearings is an important part of making accurate cuts and prevents damage to the blade teeth from contact with the blade guides.

It is important that the distance of the support bearing behind the blade is the same as the distance of the blade guides behind the teeth gullets, which is typically about 0.016" (see **Figure 41**).

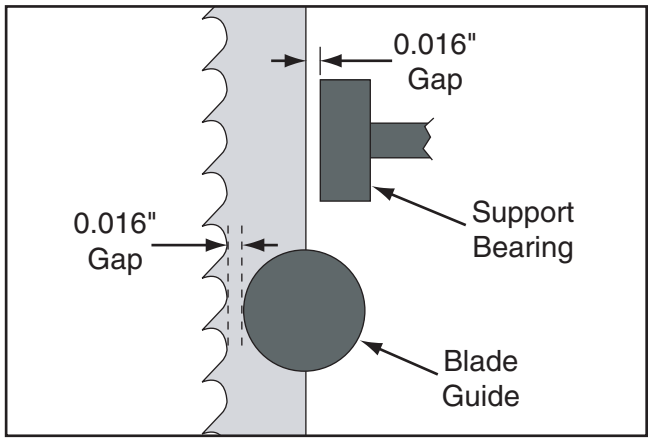


Figure 41. Distance settings of upper support bearings and blade guides.

NOTICE

Before adjusting the blade support bearings, make sure the blade is tracking properly (*Page 25*) and that it is correctly tensioned (*Page 30*).

Tools Needed **Qty**
Hex Wrench 5mm 1
Feeler Gauge 0.016" ..... 1 Each
Crisp Dollar Bill (Optional) 1

Tip: *You can use a crisp dollar bill in place of the feeler gauge for the following procedures. The thickness of the bill when folded in half twice is approximately 0.016".*

Refer to **Figures 42–43** and the following descriptions to become familiar with the controls to adjust the support bearings. Then, adjust the surface of the support bearings approximately 0.016" behind the blade.

Note: *The support bearing controls are similar for all models.*

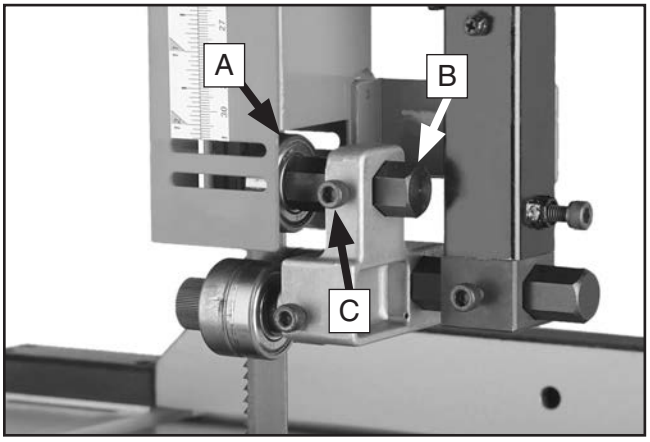


Figure 42. Upper support bearing controls.

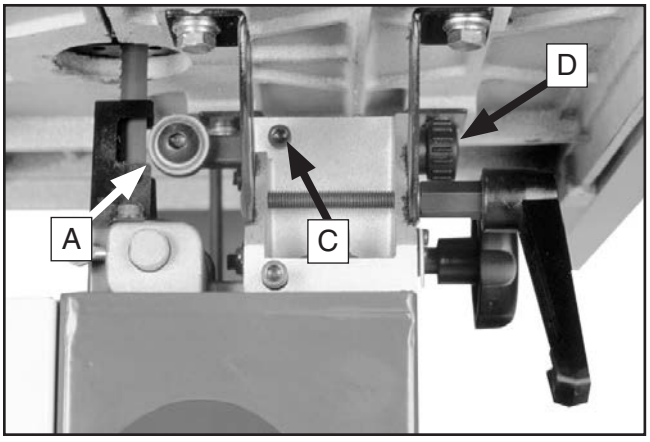


Figure 43. Lower support bearing controls.

A. Support Bearing. Stops excessive backward blade deflection from the pressure of the advancing workpiece.

Note: *The flat surface of the upper support bearing faces the blade. The round edge of the lower support bearing faces the blade.*

B. Upper Support Bearing Shaft. Mounts the support bearing behind the blade. When the support bearing shaft cap screw is loose, move this shaft by hand to adjust the upper support bearing approximately 0.016" behind the blade, then re-tighten the shaft cap screw to secure the setting.

C. Support Bearing Shaft Cap Screw. When loose, allows distance adjustment of the support bearing behind the blade.

D. Lower Support Bearing Adjustment Knob. When the support bearing shaft cap screw is loose, moves the support bearing toward or away from the blade. Use this knob to adjust the lower support bearing approximately 0.016" behind the blade, then re-tighten the shaft cap screw to secure the setting.

Adjusting Blade Guides

The blade guides provide side-to-side support to keep the blade straight while cutting. These guides are adjustable in two ways—forward-and-back and side-to-side.

To keep the blade straight while cutting, the blade guides must be as close to the sides of the blade without exerting any clamping pressure. This distance is typically about 0.004".

To prevent damage to the blade teeth as the blade deflects back while cutting, the guides must be behind the teeth gullets the same amount as the support bearing is behind the blade, which is typically about 0.016" (see **Figure 41** on the previous page for an illustration of this relationship).

Note: *Models G0513, G0513P, and G0513ANV use carbide discs as guides, while the remaining models use ball bearings.*

NOTICE

Before adjusting the blade guides, make sure the blade is tracking properly (*Page 25*) and that it is correctly tensioned (*Page 30*).

Important: *Although the function and the distance adjustment of the blade guides is the same for all the G0513 Series Models, the guide controls are not all the same. Use the set of instructions on the following pages that is correct for your model of bandsaw.*

Adjusting Blade Guides (G0513, G0513P, & G0513ANV)

Tools Needed	Qty
Hex Wrench 5mm	1
Feeler Gauge 0.004"	1 Each
Crisp Dollar Bill (Optional)	1
Fine Ruler	1

Tip: *You can use a crisp dollar bill in place of the feeler gauge. The thickness of the bill is approximately 0.004" .*

To adjust the upper blade guides:

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the thumb screws shown in **Figure 44**.

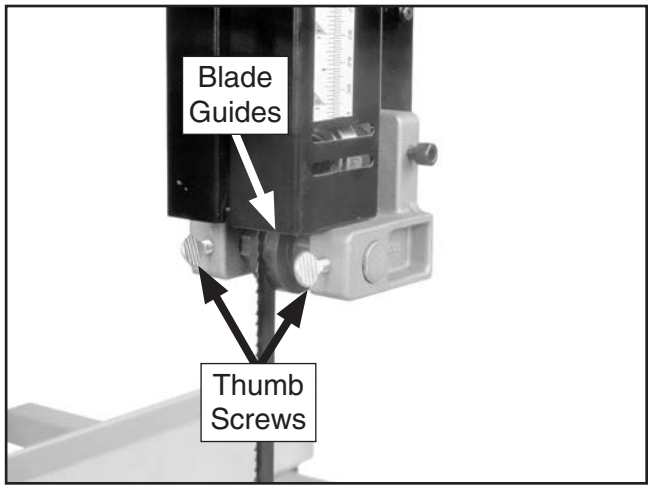


Figure 44. Upper blade guides side-to-side controls.

3. By hand, adjust the distance of the guides approximately 0.004" from the sides of the blades (see **Figure 45**), then re-tighten the thumb screws to secure the setting.

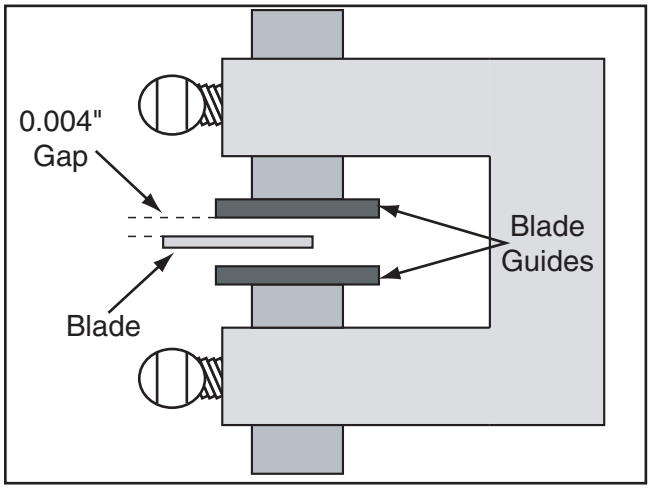


Figure 45. Correct gap between guide guides and blade.

4. Loosen the guide block cap screw shown in **Figure 46**.

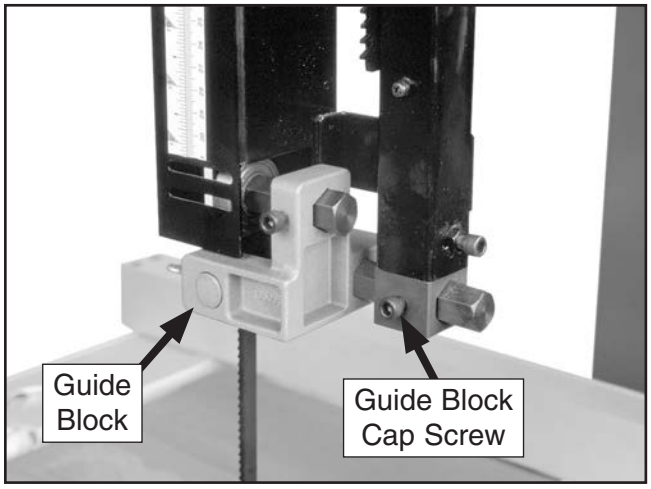


Figure 46. Back of upper blade guides.

5. By hand, slide the guide block to position the blade guides approximately 0.016" behind the teeth gullets (see **Figure 47**), then re-tighten the guide block cap screw to secure the setting.

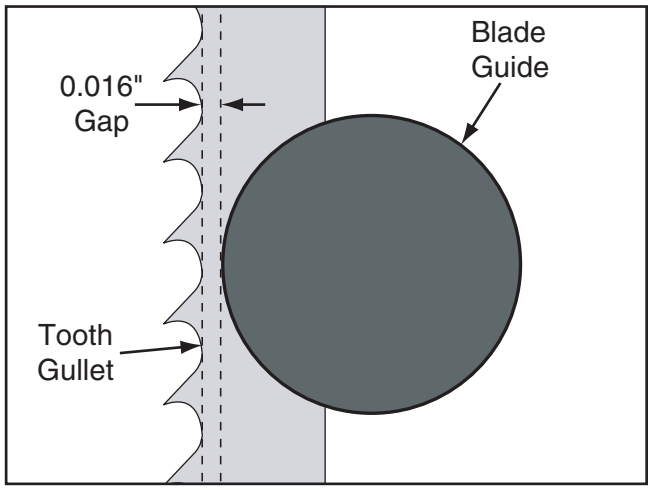


Figure 47. Correct guide alignment behind the teeth gullets.

NOTICE

Make sure that the blade teeth will not contact the guides when the blade is against the rear support bearing during the cut or the blade teeth will be damaged.

The lower blade guides are adjusted in the same manner as the upper blade guides. However, some controls are different. Refer to **Figure 48** to become familiar with these controls.

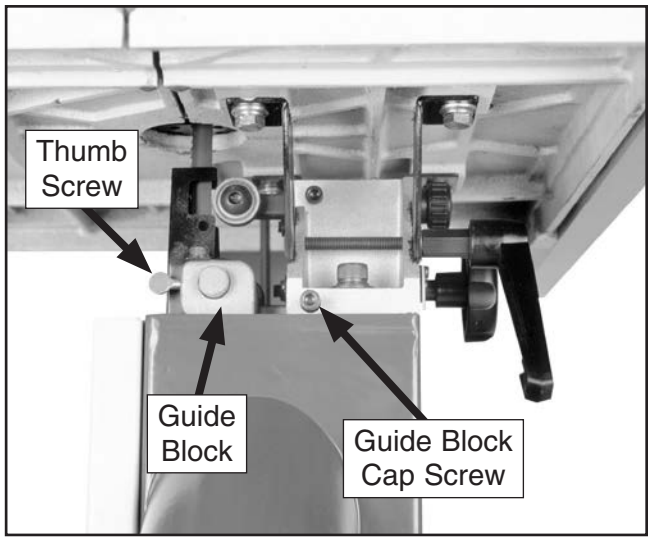


Figure 48. Lower blade guide controls.

Adjusting Blade Guide Bearings (G0513X2, G0513X2B, G0513X2BF, & G0513X2F)

Tools Needed	Qty
Hex Wrench 5mm	1
Feeler Gauge 0.004", 0.016"	1 Each
Crisp Dollar Bill (Optional)	1

Tip: *You can use a crisp dollar bill in place of the feeler gauge. The thickness of the bill is approximately 0.004", and when folded in half twice is approximately 0.016".*

Note: *The upper and lower guide bearings are adjusted in the same manner.*

To adjust the upper and lower blade guide bearings:

1. DISCONNECT BANDSAW FROM POWER!

2. Familiarize yourself with the blade guide controls shown in **Figure 49**.

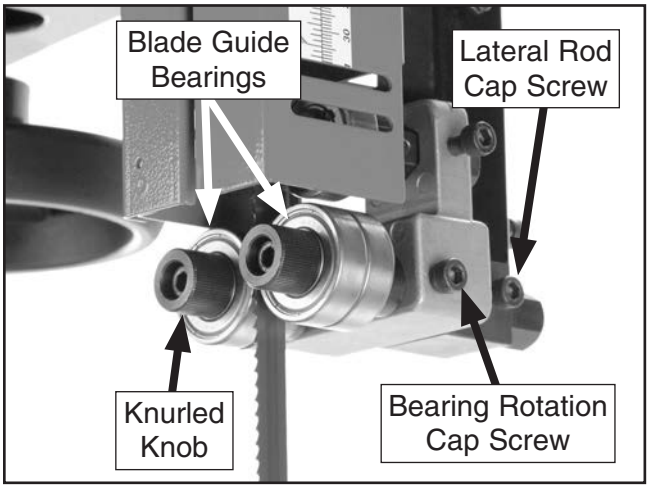


Figure 49. Blade guide controls.

NOTICE

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

3. Loosen the lateral rod cap screw and slide the guide block to position the blade guides approximately 0.016" behind the blade gullets, as illustrated in **Figure 50**.

Note: *The 0.016" spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the guide bearings as far forward as possible to the blade gullets, and still maintain the proper support bearing spacing adjustment.*

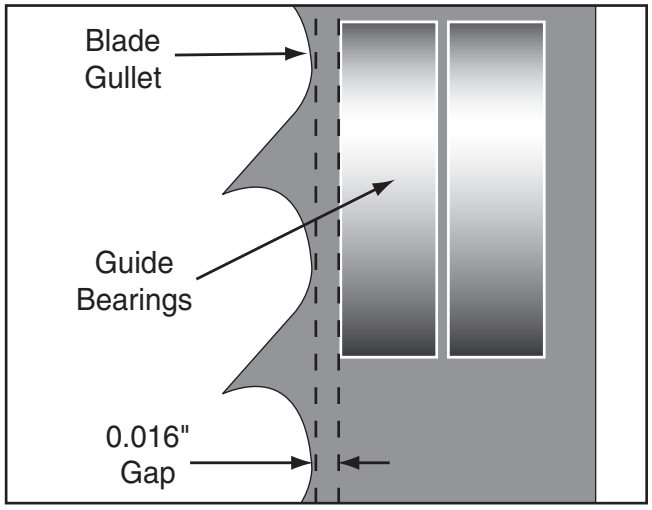


Figure 50. Lateral adjustment of blade guides.

4. Tighten the lateral rod cap screw to secure the setting.

5. Loosen both bearing rotation cap screws.

6. Rotate the knurled knob to position the bearings approximately 0.004" away from the blade.

7. Re-tighten the cap screws to lock the blade guide bearings in position.

Aligning Table

To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a wide (¾") blade installed.

Tools Needed	Qty
Straightedge	1
Fine Ruler	1
Square	1
Wrench or Socket 13mm	1

To align the table so the miter slot is parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the trunnion bolts that secure the table.

4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.

Note: *Make sure the straightedge does not go across a tooth.*

5. Use a fine ruler to gauge the distance between the straightedge and the miter slot. The distance you measure should be the same at the front and the back of the table (see **Figure 51**).

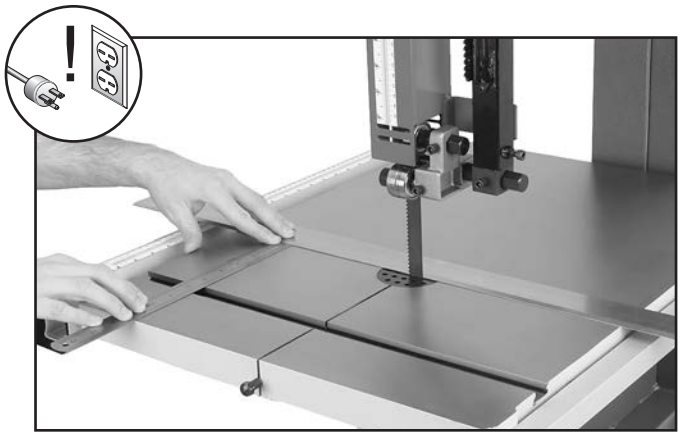


Figure 51. Measuring for miter slot to be parallel with blade.

—If the distance is not the same at the front and back of the table, adjust the table until it is.

6. Place a square on the table and against the back of the blade, as shown in **Figure 52**. The table should be perpendicular to the back of the blade.

—If the table is not perpendicular to the back of the blade, shim the table in the desired direction by placing washers between the table and the two trunnions.

7. Re-tighten the trunnion bolts to secure the settings.

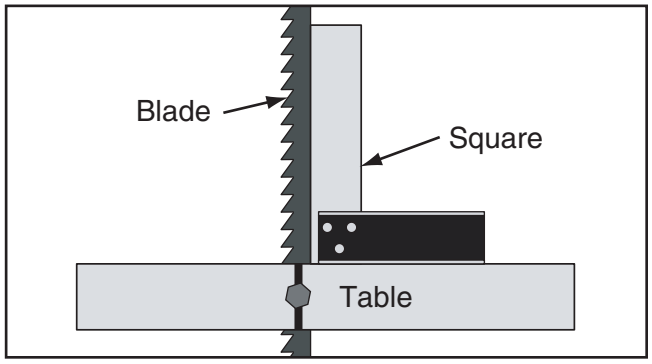


Figure 52. Squaring back of blade and table.

Aligning Fence

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

Tool Needed	Qty
Hex Wrench 5mm	1

Aligning Fence (G0513, G0513P, G0513ANV, G0513X2, & G0513X2F)

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the table is aligned with the blade (see **Aligning Table** on the previous page for detailed instructions).

3. Install the fence next to the miter slot.

4. Loosen the four cap screws located on the top face of the fence (see **Figures 53–54**).

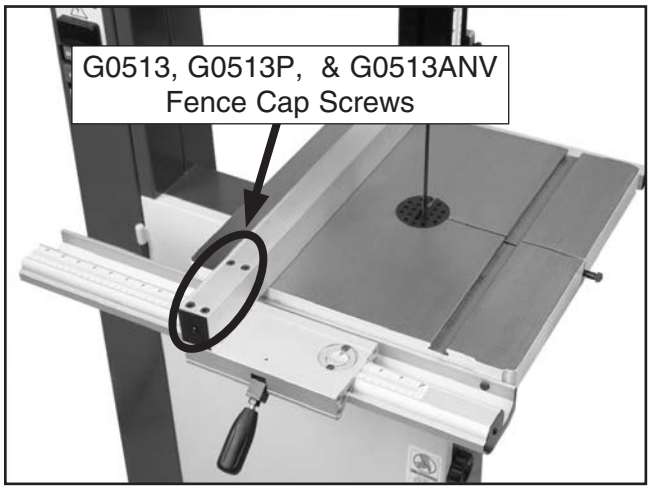


Figure 53. G0513, G0513P, & G0513ANV fence caps screws.

Figure 54. Four fence cap screws.

5. Adjust the fence face parallel with the edge of the miter slot.

6. Tighten the four cap screws, being careful not to move the fence.

Aligning Fence (G0513X2B & G0513X2BF)

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the table is aligned with the blade (see **Aligning Table** on **Page 36** for detailed instructions).

3. Install the fence and lock it in place next to the miter slot.

4. Loosen the end knobs and the center cap screw that secure the front rail to the table (see **Figure 55**).

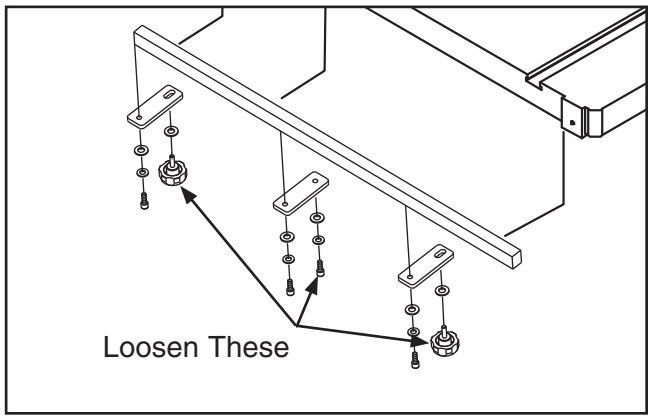


Figure 55. Loosen these knobs and cap screw.

5. Adjust the fence face parallel with the edge of the miter slot, as shown in **Figure 56**.

Figure 56. Example of fence parallel with miter slot.

6. Tighten the knobs and cap screw that secure the rail to the table, being careful not to move the fence.

Calibrating Miter Gauge

The miter gauge needs to be calibrated to the blade when it is first mounted in the miter slot.

Tool Needed	Qty
Phillips Screwdriver #2	1

To calibrate the miter gauge:

1. DISCONNECT BANDSAW FROM POWER!

2. Use a square with one edge against the face of the miter gauge and the other against the blade side, as shown in **Figure 57**.

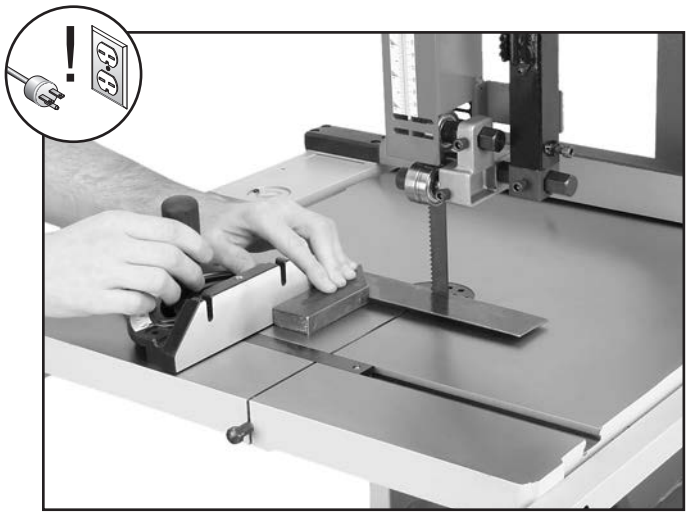


Figure 57. Squaring miter gauge to blade.

3. Loosen the lock knob on the miter gauge and adjust the face flush with the edge of the square.

4. Tighten the lock knob, and verify the setting.

   Note: *Sometimes the tightening procedure can affect the adjustment.*

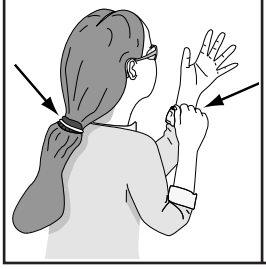
5. Loosen the screw that secures the angle pointer, and adjust the pointer to the 0˚ mark on the scale.

6. Re-tighten the screw to secure the setting.

SECTION 4: OPERATIONS

⚠WARNING

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



⚠WARNING

Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

⚠WARNING

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

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Disabling & Locking Switch (G0513, G0513P, G0513ANV, G0513X2)

The switch can be disabled and locked by inserting a padlock through the power button, as shown in **Figure 58**. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

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

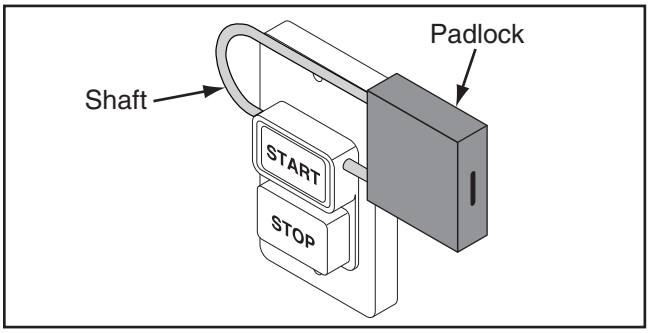


Figure 58. Switch disabled by a padlock.

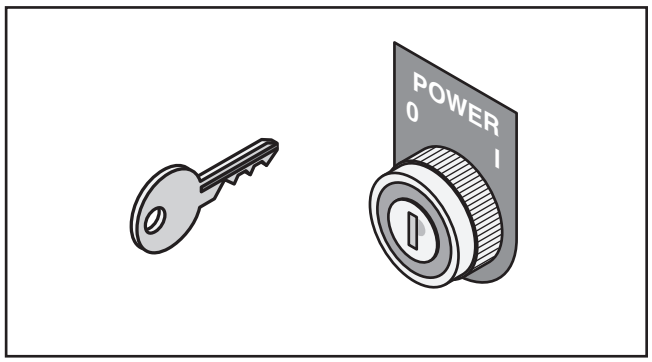
NOTICE

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

Disabling & Locking Switch (G0513X2B, G0513X2BF, G0513X2F)

The power switch can be disabled and locked by removing the key, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

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



⚠WARNING

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

General Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing many different cutting functions including:

Straight Cuts

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

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

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

Basic Cutting Tips

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

- Replace, sharpen, and clean blades as necessary and make adjustments periodically to keep the saw always running in top condition.

- Use a light and even feed rate while cutting. Light contact with the blade will permit easier line following and prevent undue friction.

- Avoid trying to turn tight corners because this will twist the blade. Remember, you must saw around corners.

- Misuse of the saw or using incorrect techniques is unsafe and results in frustration and poor cuts. Remember—the blade does the cutting with the operator's guidance.

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation.

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

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

1. Examines the workpiece to make sure it is suitable for cutting.

2. Adjusts the fence away from the blade the same width of the desired cut or out of the way for curve cutting and then locks it in place.

3. Adjusts the table tilt, if necessary, to the correct angle of the desired cut.

4. Adjusts the blade guide height to not more than 1" from the top of the workpiece.

5. Checks to make sure the workpiece can safely pass all the way through the blade without interference from other objects.

6. Puts on safety glasses.

7. Starts the dust collector and bandsaw.

8. Holds the workpiece firmly and flatly against both the table and fence, and then pushes the workpiece into the blade at a steady and controlled rate until the workpiece moves completely beyond the blade.

The operator is very careful to keep fingers away from the blade and uses a push stick to feed narrow workpieces.

9. Stops the bandsaw.

Workpiece Inspection

Some wood workpieces are not safe to cut or may require modification before they are safe to cut.

Before cutting wood, get in the habit of inspecting all workpieces for the following:

- **Material Type:** This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. Cutting drywall or cementitious backer board creates extremely fine dust, which may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, do NOT cut the workpiece.

- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can cause blade damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blade and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and can move unpredictably when being cut. DO NOT cut excessively warped wood.

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side faces the table or fence. On the contrary, a workpiece supported on the bowed side will rock during a cut, leading to loss of control.

Table Tilt

Model	Tilt Specifications
G0513, G0513P, G0513ANV	10° left, 45° right
G0513X2	5° left, 45° right
G0513X2B	5° left, 45° right
G0513X2BF	5° left, 45° right
G0513X2F	5° left, 45° right

Remove the positive stop bolt to tilt the table to the left (as viewed from the front).

Refer to **Figures 59–60** to familiarize yourself with the table tilt controls for your model bandsaw.

Models G0513, G0513P, & G0513ANV

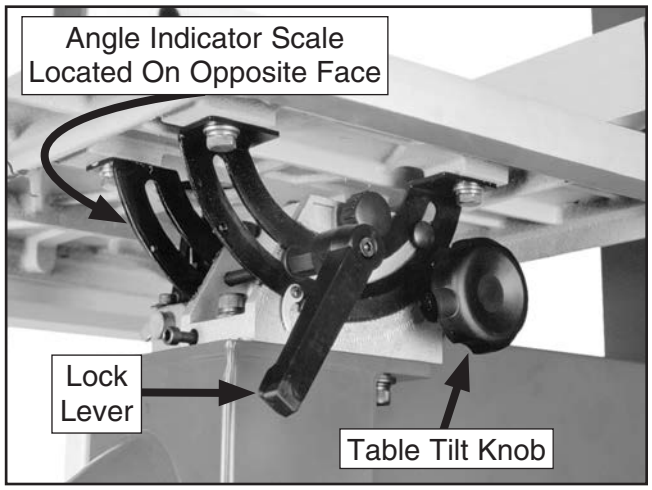


Figure 59. Table tilt controls
(G0513, G0513P, and G0513ANV rear view).

Models G0513X2, G0513X2B, G0513X2BF, & G0513X2F

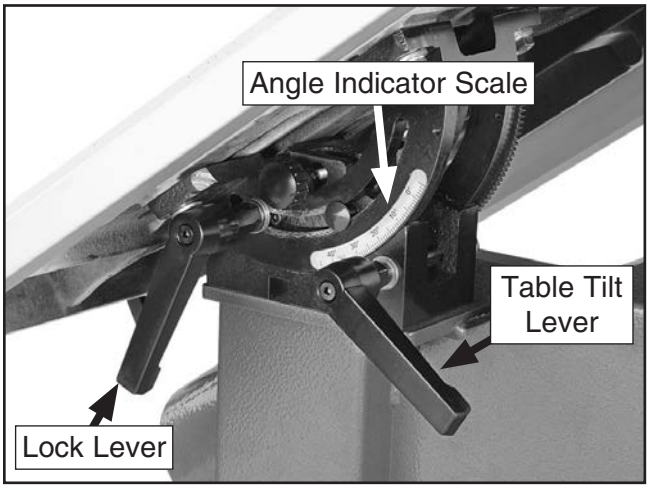


Figure 60. Table tilt controls
(G0513X2, G0513X2B, G0513X2BF, and G0513X2F, rear view).

To tilt the table:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the lock lever to enable table movement.
3. Use the table tilt knob/lever to adjust the angle of the table as displayed on the angle indicator scale.
4. Secure the table with the lock lever before continuing operation.

Guide Post

The guide post connects the upper blade guide assembly to the bandsaw. The guide post allows the blade guide assembly to move up or down so that it is as close to the workpiece as possible for safety and blade support.

In order to cut accurately and safely, the bottom of the blade guide assembly must be no more than 1" above the workpiece at all times—this positioning provides the greatest blade support and minimizes the amount of moving blade exposed to the operator.

To adjust the blade guide assembly on the guide post:

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure that the blade tension, blade tracking, support bearings, and blade guides are adjusted correctly, as previously described in the **SETUP** section.

3. Loosen the guide post lock knob shown in **Figure 61**.

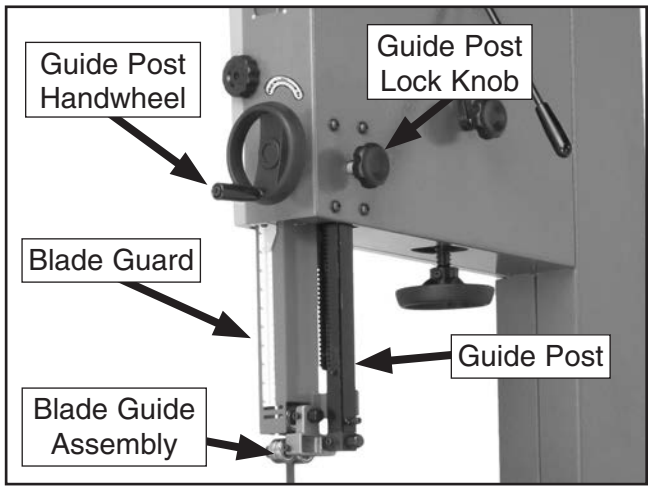


Figure 61. Guide post controls.

4. Turn the guide post handwheel to adjust the upper blade guide assembly to within 1" from the top of the workpiece.

5. Lock the guide post in place with the lock knob.

Fine Tune Tracking

During setup, the blade was tracked without the machine connected to power. In this procedure, the bandsaw is turned ***ON*** to perform fine tuning of the tracking. Make small changes with the blade tracking knob as you monitor the effect on the blade tracking.

To fine tune the tracking:

1. Close the wheel covers and turn the bandsaw ***ON***.

2. Observe the blade tracking path through the clear window on the right edge of the bandsaw, as shown in **Figure 62**.

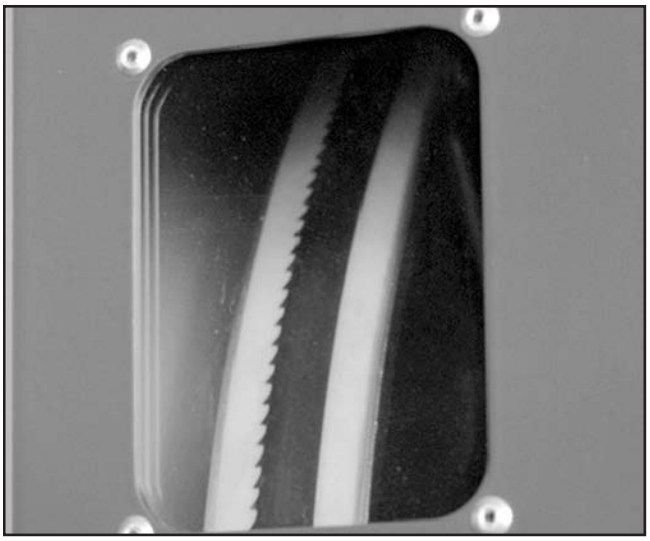


Figure 62. Blade tracking window.

3. Using the tracking controls, adjust the blade so it tracks on the center of the wheel.

4. Tighten the tracking lock to secure the setting.

Blade Selection

Selecting the right blade for the cutting task requires knowledge about blade characteristics and cutting priorities (i.e. speed, finish, etc.).

Blade Terminology

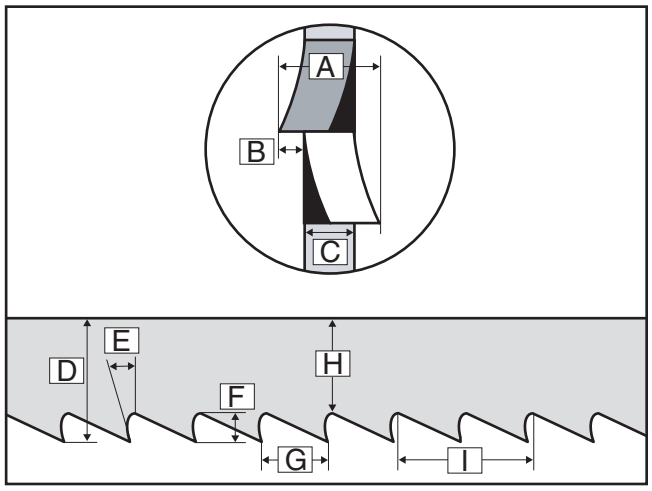


Figure 63. Bandsaw blade components.

A. Kerf: The amount of material removed by the blade during cutting.

B. Tooth Set: The amount each tooth is bent left or right along 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 face 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 Length

Measured by the blade circumference, blade lengths are specific to each bandsaw. They are determined by the wheel diameter and distance between the wheels.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width determines the largest and smallest curve that can be cut, and contributes to the accuracy of cutting straight—generally the wider the blade, the straighter it will cut.

Blade Material

Bandsaw blades must meet two requirements: flexibility and hardness. The flexibility of a blade allows it to travel on the wheel as a band, while hardness allows the teeth to cut and hold an edge. Modern materials technology has allowed bandsaw blades to meet these requirements in various ways.

Carbon Steel: These blades are differentially heat treated to provide hard teeth that will hold an edge, and yet be flexible in the back.

Carbide Tooth: Extremely hard carbide is either welded onto or impregnated into the carbon steel blades, providing superior edge-holding characteristics (see **Figure 64**).

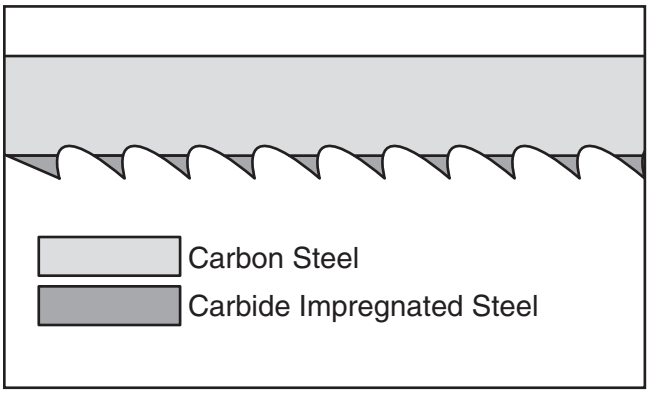


Figure 64. Carbide-tooth blade composition.

Bimetal Blade: A strip of high-speed tool steel is precision welded to a flexible carbon blade, then teeth are ground into the blade to provide good edge-holding qualities for blades taking a lot of abuse (see **Figure 65**).

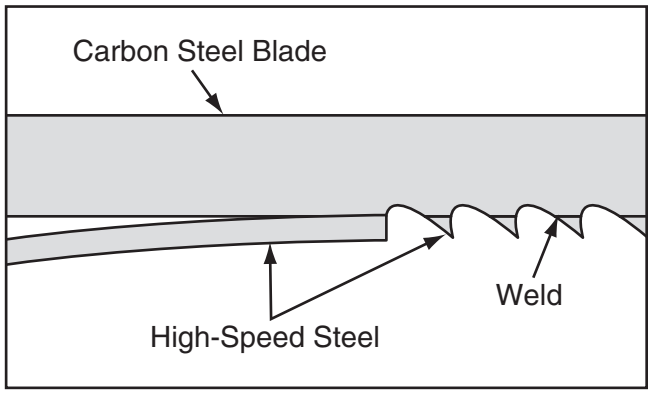


Figure 65. Bimetal blade composition.

Tooth Set

Two common tooth sets for wood bandsaw blades are alternate and raker. Each different type of tooth set removes material in a different manner, leaving cuts with different characteristics (see **Figure 66**).

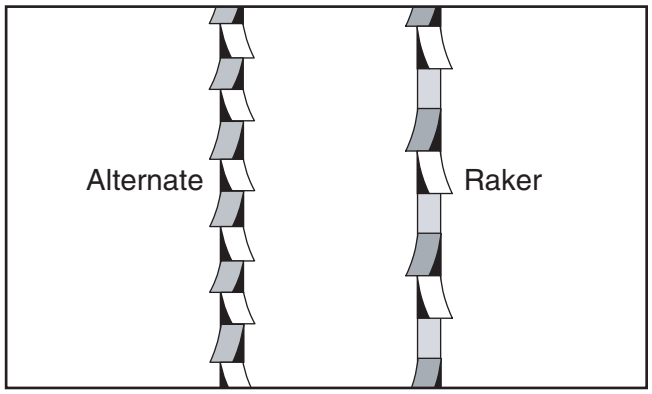


Figure 66. Common woodcutting bandsaw blade tooth sets.

Alternate: An all-purpose arrangement where the teeth are bent evenly left and right of the blade.

Raker: Three teeth in a recurring group—one bent left, one bent right, and then one that is not bent. The raker set is ideal for most contour cuts.

Tooth Type

The most common tooth types for wood blades are shown and described below (see **Figure 67**).

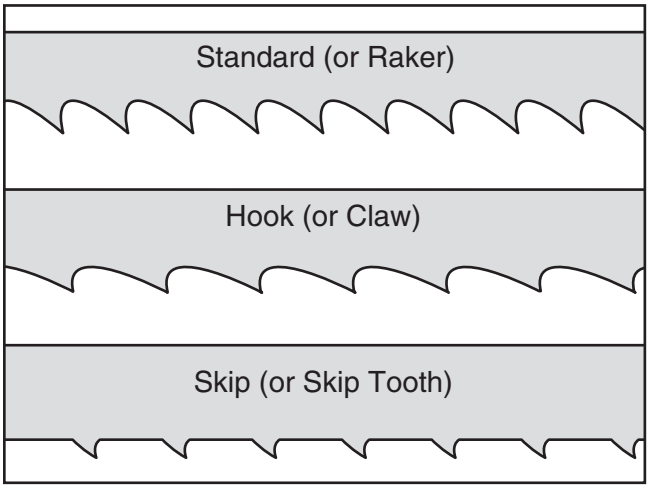


Figure 67. Typical tooth types.

Blade Selection Chart

Use the blade selection chart below as a general guide when selecting a blade for your operation.

Cutting Operation	Blade Width		
	Narrow (1/8"–1/4")	Medium (3/16"–1/2")	Wide (1/2"–3/4")
Resawing			H C
Ripping Thin Stock			H M
Ripping Thick Stock			H C
Ripping Round Stock		R M	R M
Crosscutting Thin Stock			R F
Crosscutting Thick Stock			R M
Crosscutting Round Stock		R F M	R F M
Mitre Cut			R F M
Tenons		R M	R M
Sharp Curves	R F		
Gradual Curves		S F M	

Key					
Tooth Type			Tooth Pitch (Teeth per Inch or TPI)		
H	R	S	F	M	C
Hook	Raker	Skip	Fine (14-32 TPI)	Medium (4-12 TPI)	Coarse (2-4 TPI)

Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable in some cases, since it is the natural result of the peculiar stresses that bandsaw blades must endure.

Blade breakage is also due to avoidable circumstances. Avoidable blade breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Faulty alignment or adjustment of the blade guides.
- Forcing or twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull or damaged teeth.
- Over-tensioned blade.
- Top blade guide assembly set too high above the workpiece. Adjust the top blade guide assembly so that there is approximately ⅛"–¼" between the bottom of the assembly and the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving the blade tensioned when not in use.
- Using the wrong pitch (TPI) for the workpiece thickness. The general rule of thumb is to have not less than two teeth in contact with the workpiece at all times during cutting.

Blade Care & Break-In

Blade Care

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

Be sure to select blades with the proper width, set, type, and pitch for each application. Using the wrong blade will produce unnecessary heat and shorten the life of the blade.

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

Blade Break-In

The sharp teeth tips and edges of a new blade are extremely sharp, and cutting at too fast of a feed rate fractures the beveled edges of the teeth and causes premature blade wear.

To properly break-in a new blade:

1. Choose the correct speed for the blade and material of the operation.
2. Reduce the feed pressure by half for the first 50–100 in^2 of material cut.
3. To avoid twisting the blade when cutting, adjust the feed pressure when the total width of the blade is in the cut.

Blade Changes

Blade changes entail removing the existing blade from the wheel and table, installing the new blade, then properly adjusting the blade tension and tracking.

Removing Blade

1. DISCONNECT BANDSAW FROM POWER!

2. Release the blade tension by turning the blade tension quick-release lever to the left (see **Figure 68**).

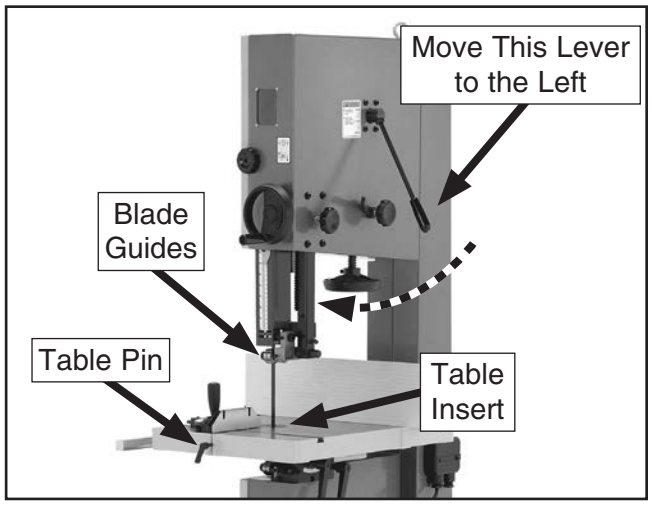


Figure 68. Blade changing controls (G0513X2 shown).

⚠CAUTION

All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear heavy leather gloves when handling saw blades.

3. Remove the table insert and the table pin. Adjust the upper and lower guide bearings as far away as possible from the blade.

4. Open the upper and lower wheel covers, and with gloved hands, slide the blade off of both wheels.

5. Rotate the blade 90˚ and slide it through the slot in the table to remove it.

Installing Blade

1. DISCONNECT BANDSAW FROM POWER!

2. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table.

   Note: *If the teeth will not point downward in any orientation, the blade is inside-out. Remove the blade, and twist it right side-out.*

3. Slip the blade through the blade guides, and mount it on the upper and lower wheels (see **Figure 69**).

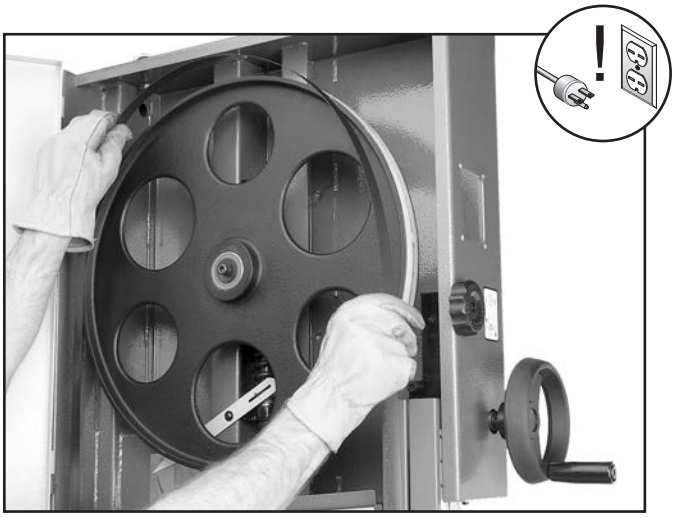


Figure 69. Placing blade on the wheels.

4. Tighten the blade tension lever.

5. Adjust the blade tension (refer to **Page 30**) and blade tracking (refer to **Page 43**).

6. Adjust the upper/lower guide bearings and the support bearings (refer to instructions beginning on **Page 32**).

7. Close the wheel covers.

8. Replace the table insert and table pin.

Blade Speed

The blade speed can be adjusted to 1700 or 3500 FPM. Speed adjustments are made by moving the V-belt position on the motor and wheel pulleys.

Most woodcutting can be performed successfully at the higher blade speeds. Slower blade speeds generally produce better results when cutting hardwoods, intricate curves, or when an exceptionally smooth cut is desired.

Use the chart below as a general guide to blade speed:

Type of Cutting Operation	Blade Speed (FPM)
Most Species of Wood	3500
Super Dense Hardwood	1700
Fast/Average Feed Rate	3500
Requires Slow Feed Rate	1700
Rough Edges Acceptable	3500
Requires Smooth Edges	1700
Quick, Production Cuts	3500
Detailed, Intricate Cuts	1700

To adjust the blade speed:

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the motor mount cap screws shown in **Figure 70**, and rotate the motor to loosen the V-belt.

Figure 70. Motor mount cap screws.

3. Refer to **Figure 71** to locate the correct V-belt position for the desired blade speed and move the V-belt to the indicated pulleys.

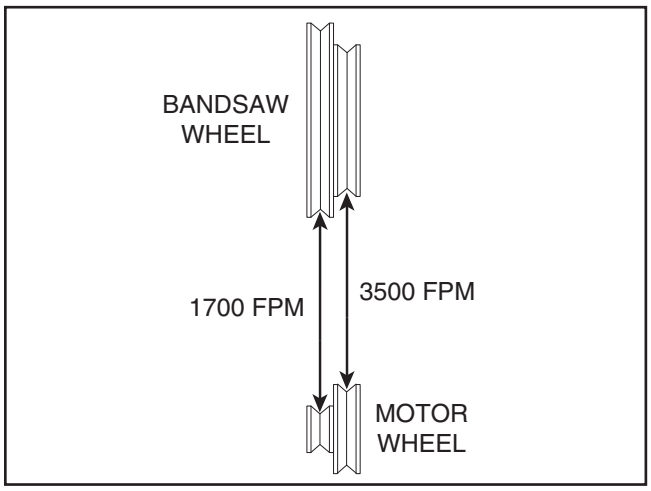


Figure 71. V-belt speeds.

4. Rotate the motor to tension the V-belt, then tighten the motor mount cap screws.

5. Check the V-belt tension by applying moderate pressure between the pulleys (see **Figure 72**). If deflection is not approximately ¾", re-tension the V-belt until it is.

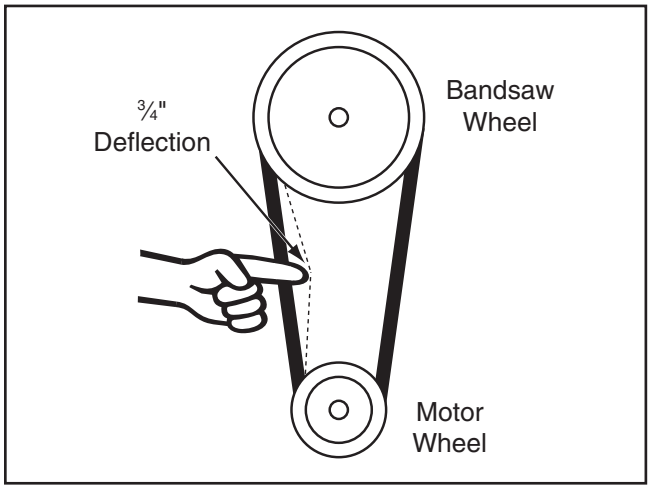


Figure 72. V-belt deflection.

Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To make a 90˚ crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.

2. Adjust the blade guide assembly to no more than 1" above the workpiece and the miter gauge to 90°.

3. Move the fence out of the way. Place the workpiece evenly against the miter gauge.

4. Hold the workpiece against the miter gauge and line up the mark with the blade.

5. After all safety precautions have been met, turn the bandsaw ***ON***. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 73** shows a typical crosscutting operation.

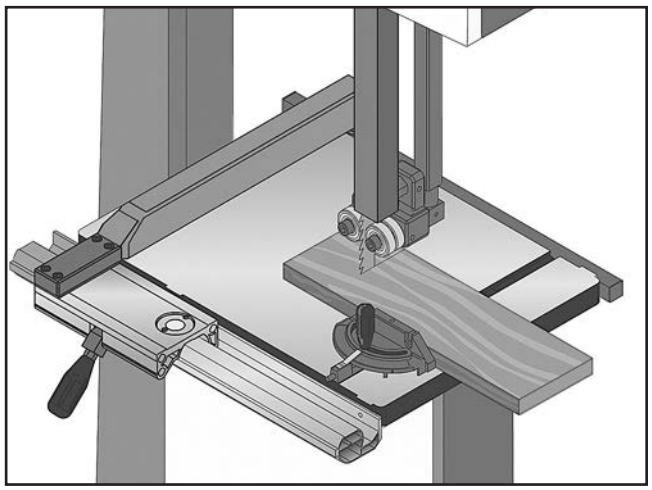


Figure 73. Example of crosscutting.

Resawing

Resawing (see **Figure 74** for an example) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

Blade selection is one of the most important considerations when resawing. Generally, the wider blade, the better. In most applications, a hook or a skip tooth style blade with fewer teeth-per-inch (from 2 to 4) is desirable because they offer larger gullet capacities for clearing sawdust, decrease blade heat, and reduce strain on the motor.

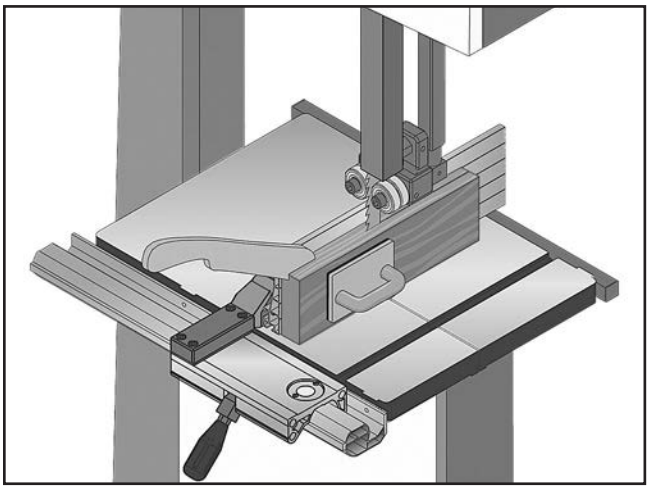


Figure 74. Example of resawing.

⚠WARNING

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

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the table is perpendicular to the blade.

2. Use the widest blade your bandsaw will accept.

   Note: *The blade must also be sharp and clean.*

3. Install the resaw fence, set it to the desired width of cut, and lock it in place.

   Note: *When resawing thin workpieces, set up the resaw fence in the alternate position, as shown in* ***Figure 75****, and make sure to use a push stick.*

Figure 75. Resaw fence installed in the alternate position.

NOTICE

The fence scale will NOT be accurate when using the resaw fence.

4. Support the ends of the board if necessary.

5. Turn the bandsaw ***ON***.

6. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece.

Cutting Curves

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

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

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

Stacked Cuts

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

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.

2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)

3. On the face of the top piece, lay out the shape you intend to cut.

4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line, as shown in **Figure 76**.

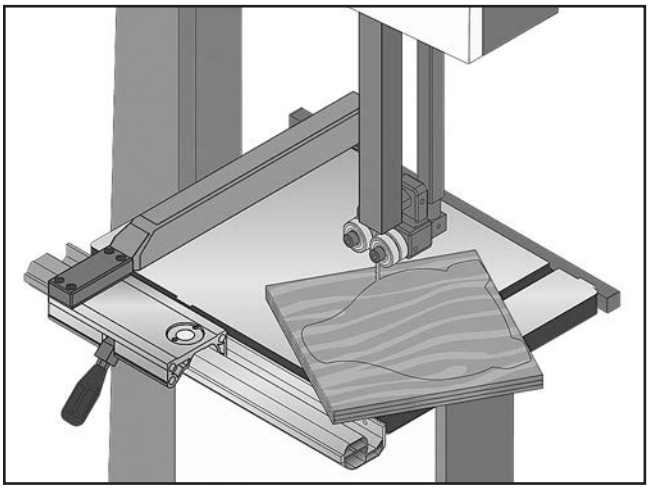


Figure 76. Example of stack cutting.

SECTION 5: ACCESSORIES

⚠WARNING

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

NOTICE

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

Call 1-800-523-4777 To Order

131-1/2" Carbon Steel Replacement Blades

Model	Width	TPI	Type	Gauge
H4803	1/8"	14	Raker	0.025
H4804	1/4"	6	Hook	0.025
H4805	1/4"	18	Raker	0.025
H4806	3/8"	10	Raker	0.025
H4807	1/2"	6	Hook	0.025
H4808	1/2"	10	Raker	0.025
H4809	3/4"	3	Hook	0.032
H4810	1"	6	Hook	0.035
H4811	1"	2	Hook	0.035

D2057A—Heavy-Duty SHOP FOX® Mobile Base

This patented base is the most stable on the market with outrigger type supports. Adjusts from 20" x 20½" to 29½" x 29½". 700 lb. capacity. Weighs 47 lbs.

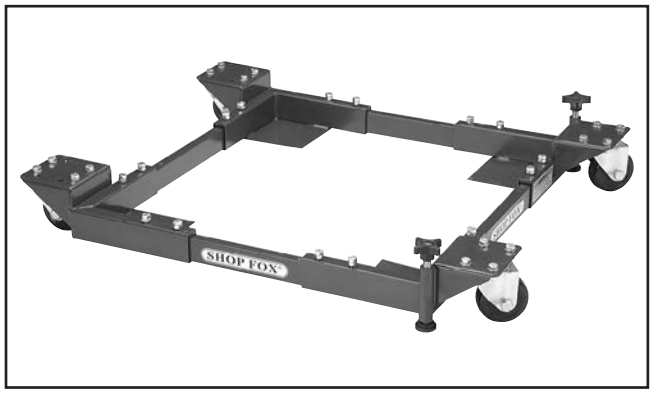


Figure 77. D2057A SHOP FOX® Mobile Base.

G1029Z2—2HP Dust Collector

The great combination of price and performance make this one of the most popular dust collectors we sell. Perfect for use as a central dust collector in a small shop or as a "dedicated" dust collector next to an industrial machine. Features 220V single-phase power, 1550 CFM, 2.5 micron filtration, and a 6" main inlet w/included 4" x 2" "Y" fitting.

Figure 78. G1029Z2 2HP dust collector.

T20388—Success with Bandsaws Book
Explore the many creative possibilities of floor-standing and portable bench-top bandsaws. With these practical instructions and color photographs, woodworkers can quickly master basic skills and then practice advanced procedures like making dovetail, mortise and tenon joints and cutting variable-curve edges— even make their own money-saving jigs and templates. 176 pages.

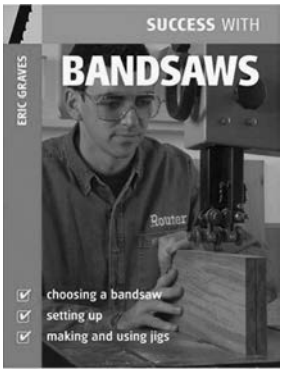


Figure 79. Success with Bandsaws book.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 80. Recommended products for protecting unpainted cast iron/steel part on machinery.

Basic Eye Protection

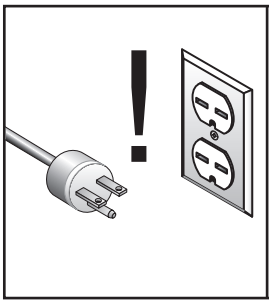
T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20452—"Kirova" Anti-Reflective S. Glasses
T20451—"Kirova" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5

Figure 81. Assortment of basic eye protection.

G8983—Tilting Roller Stand
Adjusts from 26" to 44", 0º-45º. 150 lb. capacity.
G8984—Single Roller Stand
Adjusts from 26 ⅝" to 45". 250 lb. capacity.
G8985—5 Roller Stand
Adjusts from 26" to 44⅝". 250 lb. capacity.
These super heavy-duty roller stands feature convenient hand knobs for fast height adjustment.

Figure 82. SHOP FOX® Roller Stands.

SECTION 6: MAINTENANCE



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

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.
- Worn or damaged saw blade.
- Worn or damaged wires.
- Check/clean wheel brush.
- Clean/protect table surface.
- Check lubrication points.
- Any other unsafe condition.

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

Wheel Brush

The bandsaw is equipped with a lower wheel brush to keep saw dust from building up on the tire. The brush should be checked daily and cleaned when it becomes dirty.

There is an adjustment bracket that allows the brush to be adjusted for bristle wear (refer to **Adjusting Wheel Brush** on **Page 62** for detailed instructions).

Cleaning & Protecting

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

Protect the unpainted cast iron surfaces on the table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 54** for more details).

Lubrication

An essential part of lubrication is cleaning the components before lubricating them. This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more grease to built-up grime will not result in smooth moving parts. Clean the components in this section with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

All bearings are sealed and permanently lubricated. Leave them alone until they need to be replaced.

Blade Post Rack

Lubrication Type ..... GL2 Grease or Equivalent
Amount .....Thin Coat
Frequency..... As Needed

To lubricate the blade post rack and pinion:

1. DISCONNECT BANDSAW FROM POWER!

2. Lower the blade guides until they reach the table.

3. Using a rag and mineral spirits, wipe off any existing grease and sawdust build-up on the rack (see **Figure 83**).

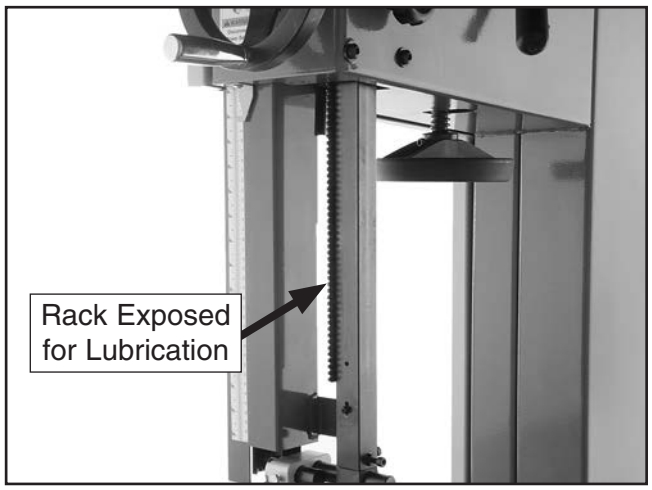


Figure 83. Example of rack lubrication location.

4. Apply a thin coat of lubricant to the rack.

5. Move the blade post up and down several times to distribute the lubricant, then remove any excess grease to help reduce potential sawdust build-up.

Tension Adjustment Assembly

Lubrication Type ..... GL2 Grease or Equivalent
Amount .....Thin Coat
Frequency..... As Needed

To lubricate the tension adjustment assembly:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the top wheel cover and look through the top of the wheel.

3. Using a rag and mineral spirits, wipe off any existing grease and sawdust build-up on the blade tension adjustment assembly and tension lever cam.

4. Apply a thin coat of lubricant to the tension adjustment assembly and tension lever cam (see **Figure 84**).

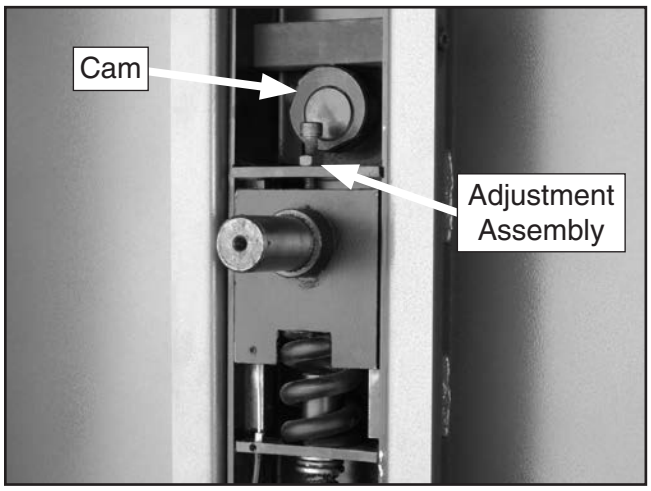


Figure 84. Example of tension adjustment assembly locations (top wheel removed for clarity).

Trunnions

Models G0513 and G0513P have steel trunnions that can be cleaned and lubricated with GL2 grease or equivalent along the sliding surfaces (see **Figure 85**) when necessary.

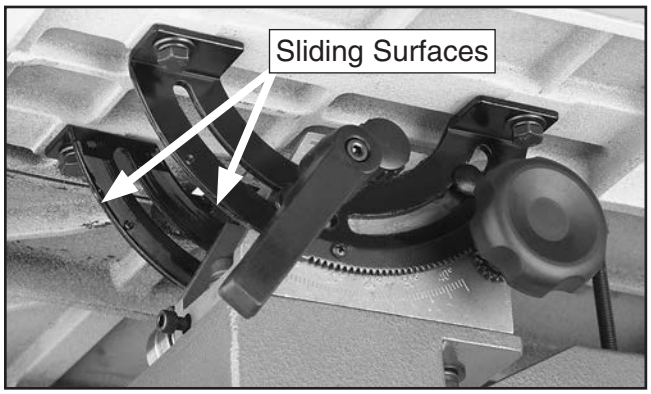


Figure 85. Trunnion lubrication location (G0513 & G0513P only).

Models G0513X2, G0513X2B, G0513X2BF, and G0513X2F have cast iron trunnions that produce a fine graphite powder over time that acts as a lubricant. We recommend not adding lubricant to the trunnions which could make a sticky substance that would prevent smooth movement.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.
Note: *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Stop button engaged/at fault. 2. Switch disabling key removed. 3. Overload relay in magnetic switch tripped. 4. Wiring break or short; loose connections. 5. Plug or receptacle is corroded or miswired. 6. Power supply off/incorrect voltage. 7. Motor connection wired incorrectly. 8. Contactor has poor contacts or is at fault. 9. Blown fuse/tripped circuit breaker. 10. Power switch at fault. 11. Start capacitor has blown. 12. Centrifugal switch at fault. 13. Motor at fault.	1. Reset/replace button. 2. Re-install switch disabling key. 3. Allow relay to cool. If necessary, reset. 4. Replace broken wires; fix shorts or loose connections. 5. Correct the wiring. 6. Switch power supply on/verify voltage. 7. Wire motor correctly. Refer to diagram inside junction box or the wiring diagrams beginning on **Page 69**. 8. Fix contacts or replace. 9. Replace fuse or reset circuit breaker. If problem is not due to circuit overload, find/repair short. 10. Replace switch. 11. Test/replace if at fault. 12. Adjust/replace centrifugal switch. 13. Repair or replace.
Machine has excessive vibration or noise.	1. V-belt tension incorrect. 2. Bent or dull blade. 3. Loose blade. 4. Blade weld contacting support bearing or blade guides. 5. Loose machine component. 6. Machine incorrectly mounted on floor. 7. Motor fan rubbing on fan cover. 8. V-belt worn or damaged. 9. Wheels not coplanar. 10. V-belt has a high spot. 11. Pulleys loose or not aligned; shaft bent. 12. Worn wheel bearing. 13. Wheel tires worn. 14. Wheels out of balance. 15. Motor at fault.	1. Re-tension V-belt (**Page 60**). 2. Replace blade (**Page 48**). 3. Re-tension blade (**Page 30**). 4. File/stone the blade weld smooth or round back of blade. 5. Tighten loose component. 6. Level/shim base; tighten/adjust mounting hardware. 7. Adjust/replace fan cover; replace fan if loose or damaged. 8. Replace V-belt (**Page 60**). 9. Adjust wheels coplanar (**Page 65**). 10. Replace/adjust the V-belt (**Page 60**). 11. Tighten or re-align pulleys; replace bent shaft. 12. Check/replace wheel bearing. 13. Replace tires. 14. Replace wheels. 15. Repair/replace motor.

Symptom	Possible Cause	Possible Solution
Machine stalls or slows when operating.	1. Too much pressure against workpiece. 2. Workpiece too moist or unsuitable. 3. Workpiece is warped. 4. Fence incorrectly adjusted. 5. V-belt slipping. 6. Run capacitor at fault. 7. Motor connection wired incorrectly. 8. Motor overheated. 9. Contactor has poor contacts or is at fault. 10. Centrifugal switch at fault. 11. Motor at fault.	1. Decrease the feed rate or workpiece pressure. 2. Only cut wood and ensure moisture is below 20%. 3. Straighten workpiece or use a different one. 4. Adjust/calibrate fence (**Page 37**). 5. Tension/replace V-belt (**Page 60**); ensure pulleys are aligned. 6. Test/repair/replace. 7. Wire motor correctly. Refer to diagram inside junction box or the wiring diagrams beginning on **Page 69**. 8. Let cool, clean motor, and reduce workload. 9. Test all legs for power, test field coil, and fix contacts or replace if at fault. 10. Adjust/replace centrifugal switch if available. 11. Test for shorted windings, bad bearings and repair or replace.
Miter bar binds in miter slot.	1. Miter slot dirty or gummed up.	1. Carefully clean miter slot.
Table does not tilt to 0 degrees.	1. Pointer or scale calibrated incorrectly. 2. Positive stop bolt not set correctly.	1. Calibrate pointer/scale at true 0 degrees. 2. Adjust positive stop bolt (**Page 26**).
Table does not tilt to 45 degrees.	1. Pointer or scale calibrated incorrectly. 2. Machine component blocking path.	1. Calibrate pointer/scale at true 45 degrees. 2. Remove component blocking table.
Table hard to tilt.	1. Sawdust or pitch trapped between trunnion and base. 2. Metal burrs on trunnion.	1. Clean/lubricate sliding surfaces of trunnions (**Page 56**). 2. Remove burrs.
Cuts are rough or show scoring.	1. Blade is overloaded and twists. 2. Blade TPI is too coarse or speed incorrect. 3. Blade is loose and slipping on wheels. 4. Blade tracking is incorrect. 5. Blade has missing or bent teeth. 6. Blade has a faulty weld.	1. Decrease the feed rate or workpiece pressure. 2. Use correct blade for application (**Page 44**). 3. Re-tension blade (**Page 30**). 4. Adjust blade tracking (**Page 25**) or adjust wheels coplaner (**Page 65**). 5. Replace the blade (**Page 48**). 6. Replace the blade (**Page 48**).
Blade or teeth break.	1. Blade tension too high. 2. Incorrect blade for application. 3. Feed rate or blade speed is too fast. 4. Operator is cutting corners too sharply. 5. Blade is dull. 6. Blade tracking is wrong. 7. Blade guides adjusted incorrectly. 8. Inadequate blade support near cutting area. 9. Blade weld at fault. 10. Wheel tires worn or damaged. 11. Fence or miter slot not aligned with blade.	1. Decrease blade tension (**Page 30**). 2. Use correct blade for application (**Page 44**). 3. Reduce feed rate or increase blade speed. 4. Use a wider arc on outside cuts, or use relief cuts to make tight inside cuts. 5. Replace blade (**Page 48**). 6. Adjust blade tracking (**Page 43**). 7. Re-adjust blade guides (**Page 33**). 8. Adjust upper blade guide closer to workpiece (**Page 33**). 9. Replace blade (**Page 48**). 10. Replace tires. 11. Align miter slot and fence with blade (**Page 36**).

Symptom	Possible Cause	Possible Solution
Blade wears on one side, slows, smokes or shows signs of overheating.	1. Blade contacting table insert.	1. Re-adjust blade guides (**Page 33)** to eliminate side pressure. Adjust table for correct blade clearance and miter slot alignment (**Page 36)**.
	2. Blade guides are mis-adjusted or worn.	2. Adjust/replace blade guides.
	3. Blade has insufficient support near cutting area.	3. Adjust upper blade guide closer to workpiece (**Page 33**).
	4. Blade installed backwards.	4. Properly install blade with teeth pointing down.
	5. Too much side pressure when feeding workpiece.	5. Feed workpiece straight into the blade.
	6. Wheels are out of alignment.	6. Adjust wheels so they are coplanar (**Page 65**).
	7. Dull or incorrect blade for workpiece.	7. Replace blade (**Page 48**).
	8. Blade is bell-mouthed.	8. Install new blade.
	9. Fence not parallel with blade (pressure at blade backside).	9. Adjust fence parallel with blade (**Page 37**).
	10. Table top is not square with blade.	10. Adjust/shim table/trunnion position until blade and table are parallel and square (**Page 36**).
Sawdust build-up inside cabinet.	1. Clogged dust port(s).	1. Clean out dust port(s).
	2. Low CFM (airflow) from dust collection system.	2. Repair ducting for leaks or clogs, move dust collector closer to machine, install a stronger dust collector.
Blade tracks incorrectly, or comes off wheels.	1. Tracking is not adjusted properly.	1. Adjust tracking (**Page 43**).
	2. Wheels are not coplanar.	2. Adjust wheel coplanarity (**Page 65**).
	3. Blade tension is too loose.	3. Increase blade tension (**Page 30**).
	4. Blade guides not adjusted correctly.	4. Adjust blade guides (**Page 33**).
	5. Feed rate too fast.	5. Decrease feed rate.
	6. Incorrect blade for bandsaw.	6. Install correct blade for machine.
	7. Blade is bell-mouthed, worn or dull.	7. Install new blade/de-tension blade when not in use.
	8. Rubber tire on wheel is damaged or worn.	8. Replace rubber tires.
Cut is crooked, or the blade wanders (blade lead).	1. Feed rate is too fast or blade speed is incorrect.	1. Adjust feed rate and cutting speed as required.
	2. Blade tension is low.	2. Increase the blade tension (**Page 30**).
	3. Blade is dull or damaged.	3. Replace blade (**Page 48**).
	4. Inadequate blade support.	4. Adjust upper blade guide closer to workpiece (**Page 33**).
	5. Incorrect blade for application.	5. Use wider blade.
	6. Blade is tracking incorrectly.	6. Adjust blade tracking (**Page 25**) (**Page 43**).
	7. Table is loose.	7. Tighten table mounting bolts or tilt lock lever.
	8. Fence/miter slot out of alignment.	8. Align table miter slot and fence with blade (**Page 36**).
	9. Blade guides mis-adjusted.	9. Adjust blade guides (**Page 33**).

V-Belt Service

Checking V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and properly tensioned. The belt should be free of cracks, fraying, and wear. Belt tension and condition should be checked at least every 3 months—more often if the bandsaw is used daily.

To check V-belt tension:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Check the condition of the V-belt. If the V-belt is cracked, frayed, or glazed, replace it.
4. Check the V-belt tension by applying moderate pressure between the pulleys (see **Figure 86**). If deflection is not approximately ¾", re-tension the V-belt following the same steps you normally use when changing blade speeds (refer to **Blade Speed** on **Page 49** if necessary).

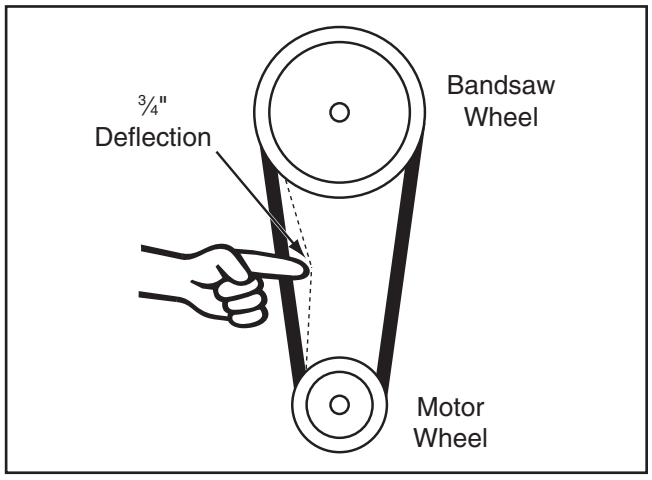


Figure 86. V-belt deflection.

Replacing V-Belt

To replace the V-belt, you must remove the blade and the lower wheel. After re-installation, you must properly re-tension the V-belt.

Tools Needed:	Qty
Hex Wrench 6mm	1
Hex Wrench 8mm	1

To replace the V-belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open both wheel covers, and remove the blade (refer to **Blade Changes** on **Page 48**).
3. Unthread the lower wheel mount bolt shown in **Figure 87**, and slide the lower wheel off the bearing shaft.

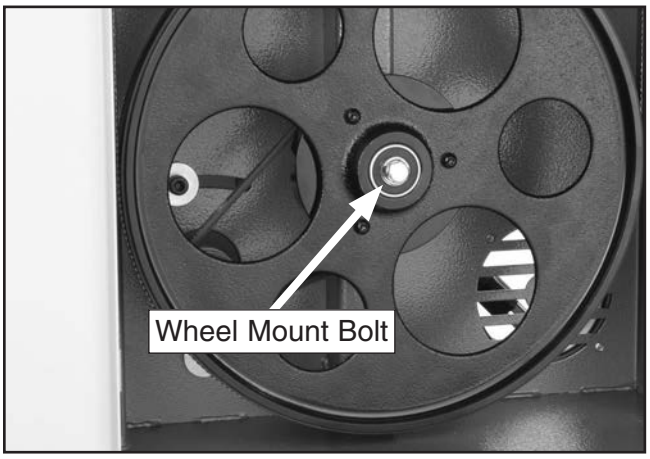


Figure 87. Example of wheel mount bolt.

4. Loosen the motor mount cap screws shown in **Figure 88**.

Figure 88. Motor mount cap screws.

5. Slip the old V-belt off of the wheel pulley and install the new V-belt in its place.
6. Properly tension the V-belt and re-tighten the motor mount cap screws.
7. Re-install the lower wheel back and secure it with the wheel mount bolt.
8. Re-install the blade and close the wheel covers.

Blade Lead

"Blade Lead" means that the blade does not cut straight when using the fence or miter gauge (see **Figure 89**). This is a common condition with all bandsaws. Worn or damaged blades may cause lead and replacing them will fix the problem. Still, if your bandsaw is setup correctly and lead occurs, compensate for it by skewing the fence.

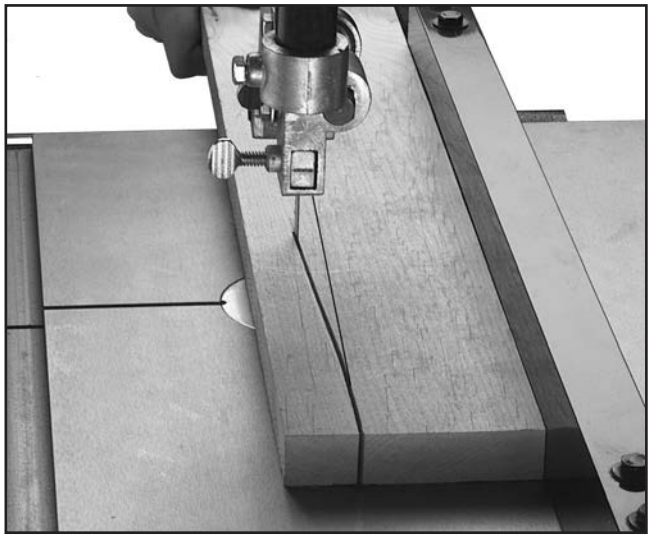


Figure 89. Example of blade leading away from line of cut.

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

1. Ensure that you have proper blade tension (refer to **Page 30**).

2. Ensure that the blade guides are adjusted correctly (refer to **Pages 33–36**).

3. Ensure that the fence (refer to **Page 37**) and miter gauge (refer to **Page 38**) is parallel to the blade.

To skew your fence:

1. Cut a piece of scrap wood approximately ¾" thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.

2. Slide the fence out of the way and cut freehand along the line. Stop at the halfway point. Turn the bandsaw ***OFF*** and wait for the blade to come to a complete stop.

3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.

4. Loosen the four cap screws on top of the fence.

5. Skew the fence as needed until it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.

6. While maintaining the skew, re-tighten the fence cap screws.

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

1. Set the miter gauge to 90°.

2. On a scrap piece of wood, mark a line that is perpendicular to the front edge. Starting where the line begins, cut the board by pushing it through the blade with the miter gauge.

3. Loosen the table mounting bolts, and shift the table to compensate for the blade lead.

4. Repeat **Steps 1–3** until the blade cuts straight when wood is pushed through with the miter gauge.

NOTICE

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

NOTICE

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

Adjusting Wheel Brush

The lower wheel has a brush, as shown in **Figure 90**, that is designed to sweep sawdust off the wheel tire as the wheel rotates. In order to work properly, the brush must make firm contact with the wheel.

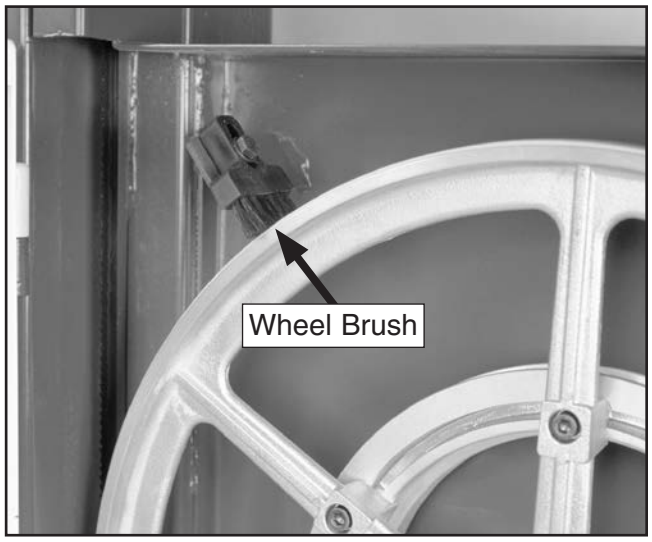


Figure 90. A wheel brush.

Tools Needed:	**Qty**
Wrench/Socket 10mm	2

To adjust the brush:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Loosen the bolt and nut that secures the brush in place.
4. Adjust the brush so it makes firm, even contact with the wheel—without bending the bristles.
5. Tighten the bolt and nut to secure the brush in place.

Adjusting Tension Lever

The quick-release tension lever was setup at the factory for use with the pre-installed 131½" blade. However, if you install a different length blade, you will need to adjust the quick-release adjustment screw so that the quick-release lever works correctly.

Keep in mind that actual blade lengths may vary slightly by manufacture.

Tools Needed:	**Qty**
Hex Wrench 5mm	1
Wrench 10mm	1

To adjust the quick-release lever:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers and install a new blade.
3. Loosen the jam nut on the tension adjustment screw 7-10 turns (see **Figure 91**).

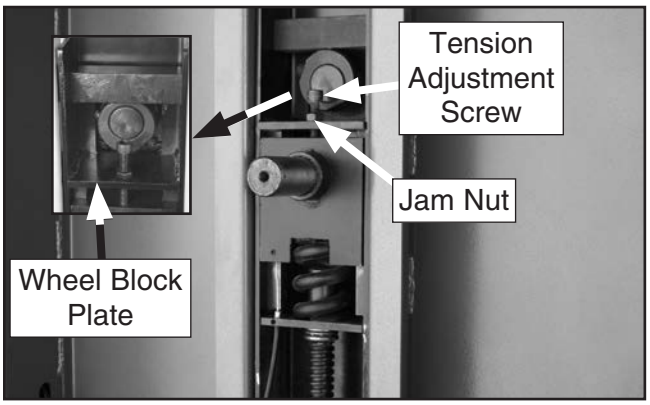


Figure 91. Example of quick-release tension lever adjustment screw.

4. Engage the quick-release lever, then turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade width.
5. Thread the tension adjustment screw (see **Figure 91**) down until it contacts the wheel block plate, then back it off 1-2 turns.
6. Re-tighten the jam nut.

Adjusting Guide Post Travel

The guide post assembly should remain parallel with the blade front-to-back and side-to-side along its length of travel. If it does not, follow these instructions to adjust it.

Important: Make sure the table is aligned with the blade from side-to-side and front-to-back before beginning these procedures (refer to **Aligning Table** on **Page 36** for detailed instructions).

Tools Needed:

Machinist's Square 1
Small Ruler 1
Hex Wrench 4mm 1
Hex Wrench 5mm 1
Metal Shims ..... (As Needed)

Checking/Adjusting Guide Post Parallel with Blade Side-to-Side

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the guide post lock knob, lower the guide post to within 1" of the table top, then tighten the knob.

3. Place a machinist's square on the table next to the right hand side of the guide post, as shown in **Figure 92**.

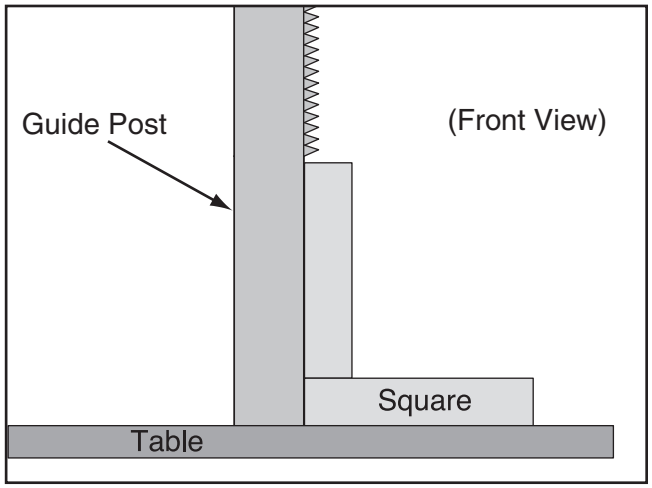


Figure 92. Example of checking guide post squareness.

—If there is no gap between the square and the guide post along its full length, no adjustments need to be made. Proceed to the next procedure.

—If there is a gap between the square and the guide post, the guide post is not parallel to the blade. Go to **Step 4**.

4. Loosen each of the four screws shown in **Figure 93** ¼ turn**.**

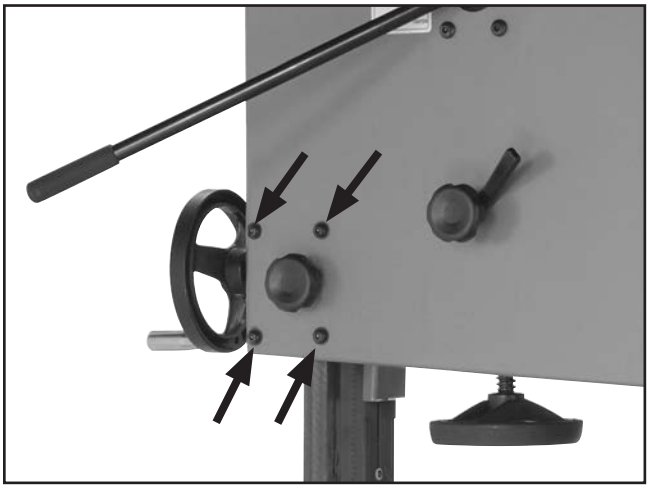


Figure 93. Guide post adjustment screws.

5. Gently tap the lower part of the guide post in the appropriate direction until there is no gap between the square and the guide post.

6. Tighten the screws shown in **Figure 93**.

Checking/Adjusting Guide Post Parallel with Blade Front-to-Back

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the guide post lock knob, lower the blade guide assembly to within 1" of the table top, then tighten the lock knob.

3. Remove the screws that secure the guide post guard and move it up and out of the way.

4. Measure the distance "A" between the upper front face of the guide post rack and the back of the blade (see **Figure 94**).

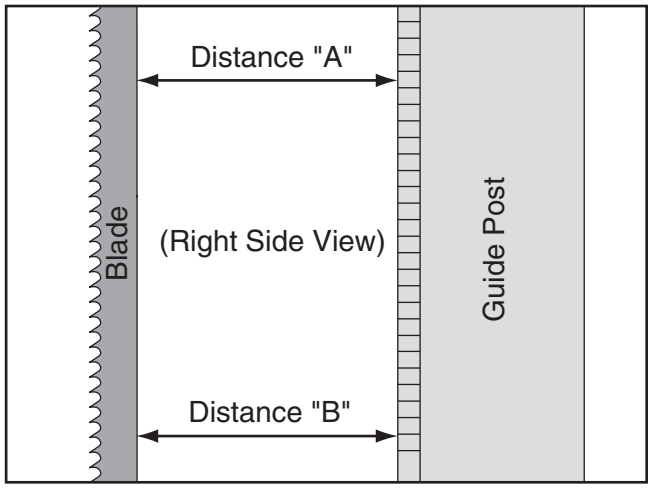


Figure 94. Example of measuring distance between rack and blade at top of guide post.

5. Measure the distance "B" between the bottom front face of the guide post rack and the back of the blade (see **Figure 94**).

—If the measurements taken in **Steps 4–5** are equal, no adjustments need to be made. Go to **Step 9**.

—If the measurements taken in **Steps 4–5** are not equal, go to **Step 6**.

6. Place the guide post guard on top of the guide post assembly so you can access the guide post bracket.

7. Loosen the four screws shown in **Figure 93** on the previous page enough to fit metal shims between the frame and the guide post bracket (see **Figure 95**).

—If the guide post to blade distance is greater at the bottom than at the top, place a shim between the bottom of the bracket and the frame (Shim "A"). This will tilt the bottom of the guide post toward the blade.

—If the guide post to blade distance is less at the bottom than at the top, place a shim between the top of the bracket and the frame (Shim "B"). This will tilt the bottom of the guide post away from the blade.

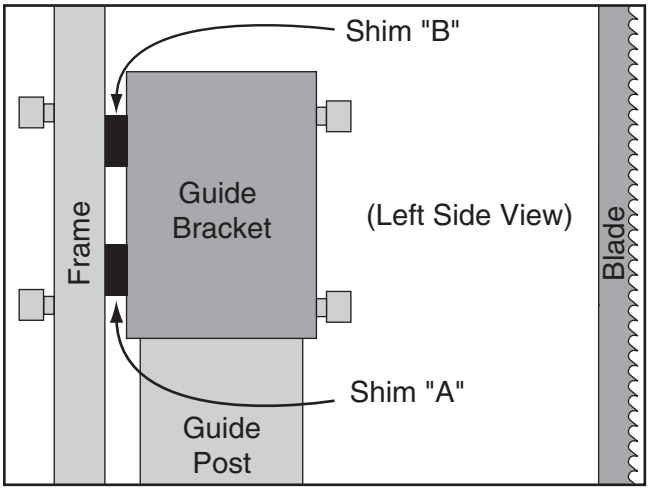


Figure 95. Location for placing shims.

8. Tighten the four screws shown in **Figure 93** on the previous page, then repeat **Steps 4–5**.

—If the measurements are equal, go to **Step 9**.

—If the measurements are not equal, continue adding shims as needed until guide post rack to blade distance is the same at the top and bottom.

9. Re-install the guide post guard with the screws removed in **Step 3**.

Aligning Wheels

Components and Hardware Needed: **Qty**
56" Long 2x4 1

Tools Needed:
Hex Wrenches 4 & 6 mm .....1 Ea
Wrench 13mm 1
Tape Measure..... 1
Coplanarity Gauge (see **Figure 96**) 1
Straightedge .....
Fine Ruler..... 1

Wheel alignment is one of the most critical factors for optimal performance from your bandsaw.

Heat, vibration, wandering, blade wear, tire wear and overall bandsaw wear are considerably decreased when the wheels are properly aligned or “coplanar.”

Coplanar wheels automatically track the blade by balancing it on the crown of the wheel. This is known as coplanar tracking.

Checking Coplanarity

1. Make the "Coplanarity Gauge" shown in **Figure 96**.

Note: *For best results, straighten the 2x4 with a jointer before cutting.*

2. DISCONNECT BANDSAW FROM POWER!

3. Remove the fence and open both wheel covers.

4. Adjust the blade guides away from the blade, loosen blade tension, remove the table insert and pin, then remove the blade.

5. Remove the table.

6. Reinstall the blade, making sure the guide bearings and support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.

7. Place your coplanarity gauge up against both wheels in the positions shown in **Figure 97**.

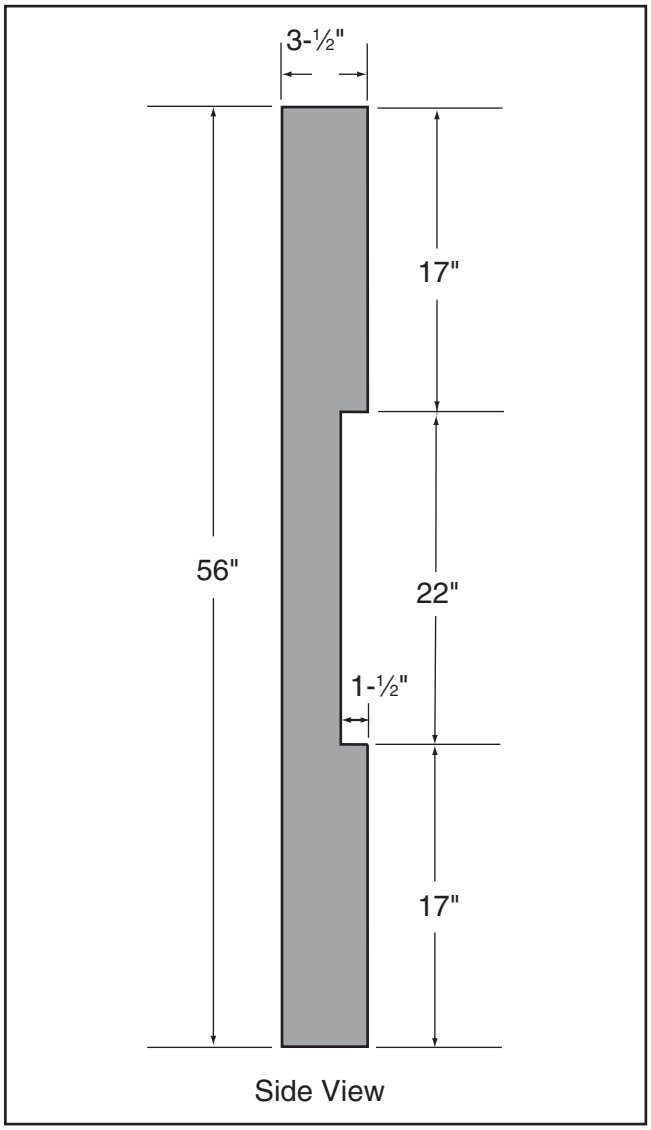


Figure 96. Dimensions of coplanarity gauge.

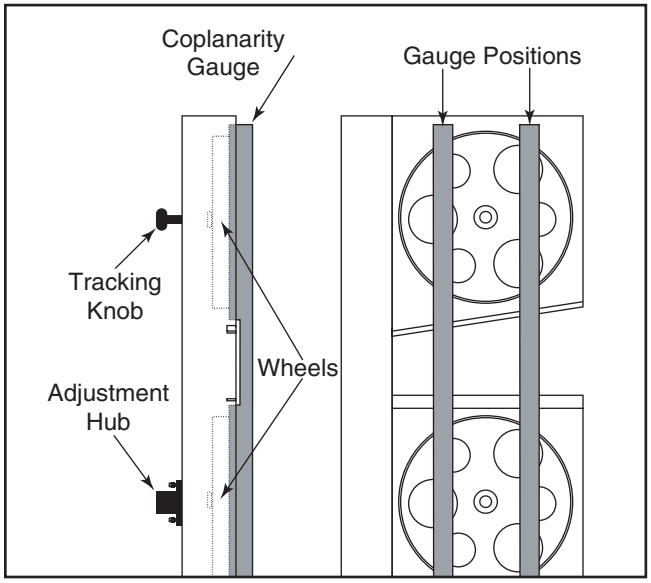


Figure 97. Checking for coplanarity.

—If the wheels are coplanar (**Figure 99**, **A**), the straightedge will evenly touch the top and bottom of both wheels.

—If the wheels are not coplanar (**Figure 99**, **B**), place the straightedge on the lower wheel first (ensuring that it touches both the top and bottom rim), then adjust the upper wheel tracking knob to make the upper wheel coplanar and parallel with the lower wheel.

—If the straightedge does not touch both wheels evenly, the upper wheel needs to be shimmed (**Figure 99, D**) or the lower wheel needs to be adjusted (**Figure 99, C**).

Shimming Upper Wheel

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the top wheel is adjusted parallel with the bottom wheel.

3. With a straightedge touching both points of the wheel that does not need to be adjusted, measure the distance away from the wheel that is out of adjustment (see **Figure 98**).

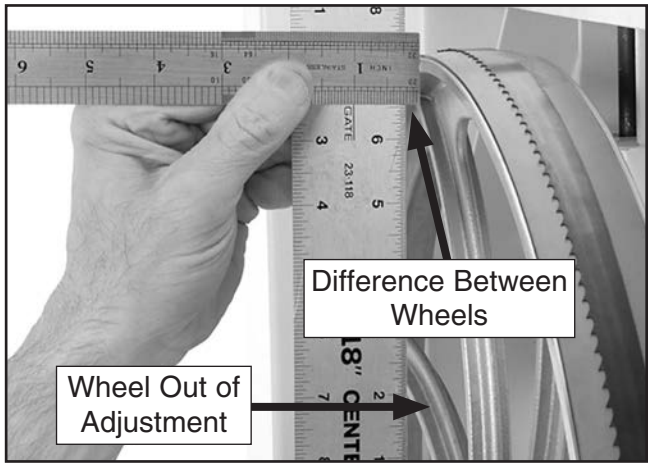


Figure 98 Determining distance needed to shim upper wheel.

4. Remove the blade from the saw, then remove the wheel that needs to be shimmed.

5. Determine how many shim washers you need to compensate for the distance measured in **Step 3** and place them on the wheel shaft.

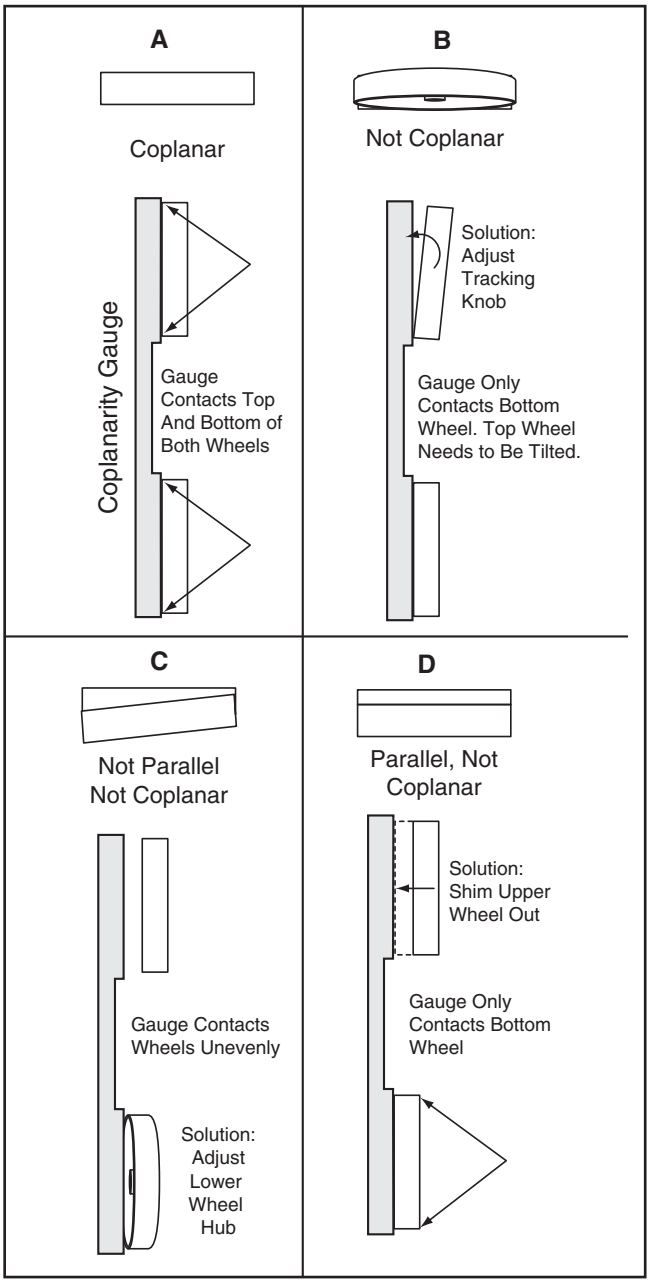


Figure 99. Coplanar diagram.

6. Replace the wheel, the original washers, the securing screw, and the blade.

7. Tighten the blade, then check the wheels with the coplanarity gauge. (Wheel coplanarity changes as the blade is tightened, so it is best to check the wheel alignment when the blade is tensioned as it would be for normal operations.)

8. When the wheels are coplanar, place a mark on each wheel where you held the straightedge. This assures repeated accuracy every time you adjust your wheels.

   Note: *When wheels are properly coplanar, the blade may not be centered on the crown of the wheel, but it will be balanced.*

Adjusting Lower Wheel

Only do this procedure if you cannot make the wheels coplanar with the tracking knob or by shimming the upper wheel. Make sure the upper wheel is adjusted as close as possible to being coplanar with the lower wheel before beginning. Do this procedure with the blade fully tensioned.

To adjust the lower wheel:

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the jam nuts on the lower wheel adjustment hub (see **Figure 100**).

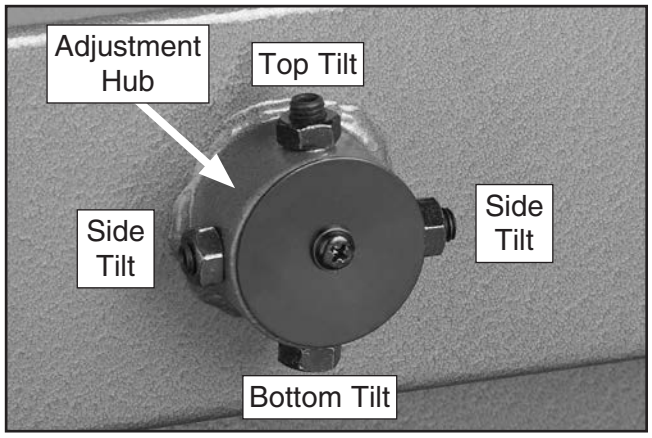


Figure 100. Lower wheel adjustment control.

3. Loosen one tilt adjustment set screw, then tighten the opposing set screw approximately an equal amount.

4. Check the wheels with the coplanarity gauge, then adjust the lower wheel at the hub as needed until it is parallel and coplanar with the top wheel.

5. Tighten the jam nuts to lock the tilt adjustment set screws in position.

Magnetic Brake Adjustment (G0513X2B, G0513X2BF)

The space between the magnetic motor brake and brake shoe is preset by the factory at 0.008" (0.2mm). To compensate for this wear, you should adjust this space every two to three years, or if the brake takes over five seconds for to stop the motor.

Tools Needed

Phillips Head Screwdriver..... 1
Feeler Gauge 0.008" 2
Dollar Bill, Folded Once (Optional)..... 1
Hex Wrench 3mm..... 1
Hex Wrench 4mm..... 1

To adjust the magnetic brake:

1. DISCONNECT BANDSAW FROM POWER!

2. Remove the motor fan cover, then loosen the cap screws securing the motor fan and brake shoe (see **Figure 101**).

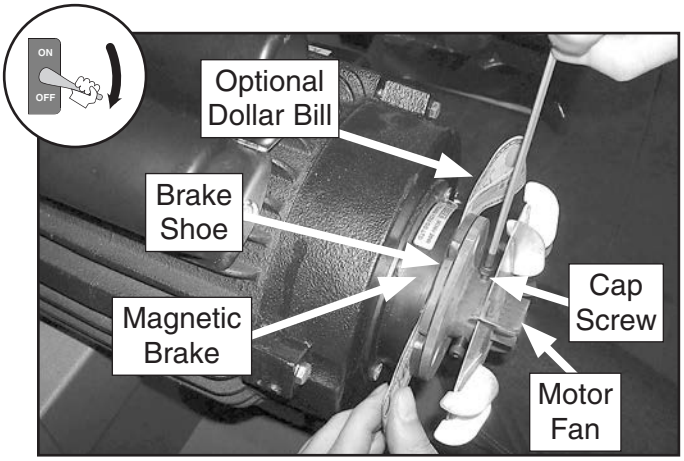


Figure 101. Adjusting distance between magnetic brake and brake shoe.

3. Place the feeler gauge (or dollar bill folded once) between the brake shoe and magnetic brake on either side.

4. Tighten the cap screws on the brake shoe and motor fan, remove the feeler gauge, then reinstall the motor fan cover.

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 aftermarket parts.

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

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

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

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

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

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

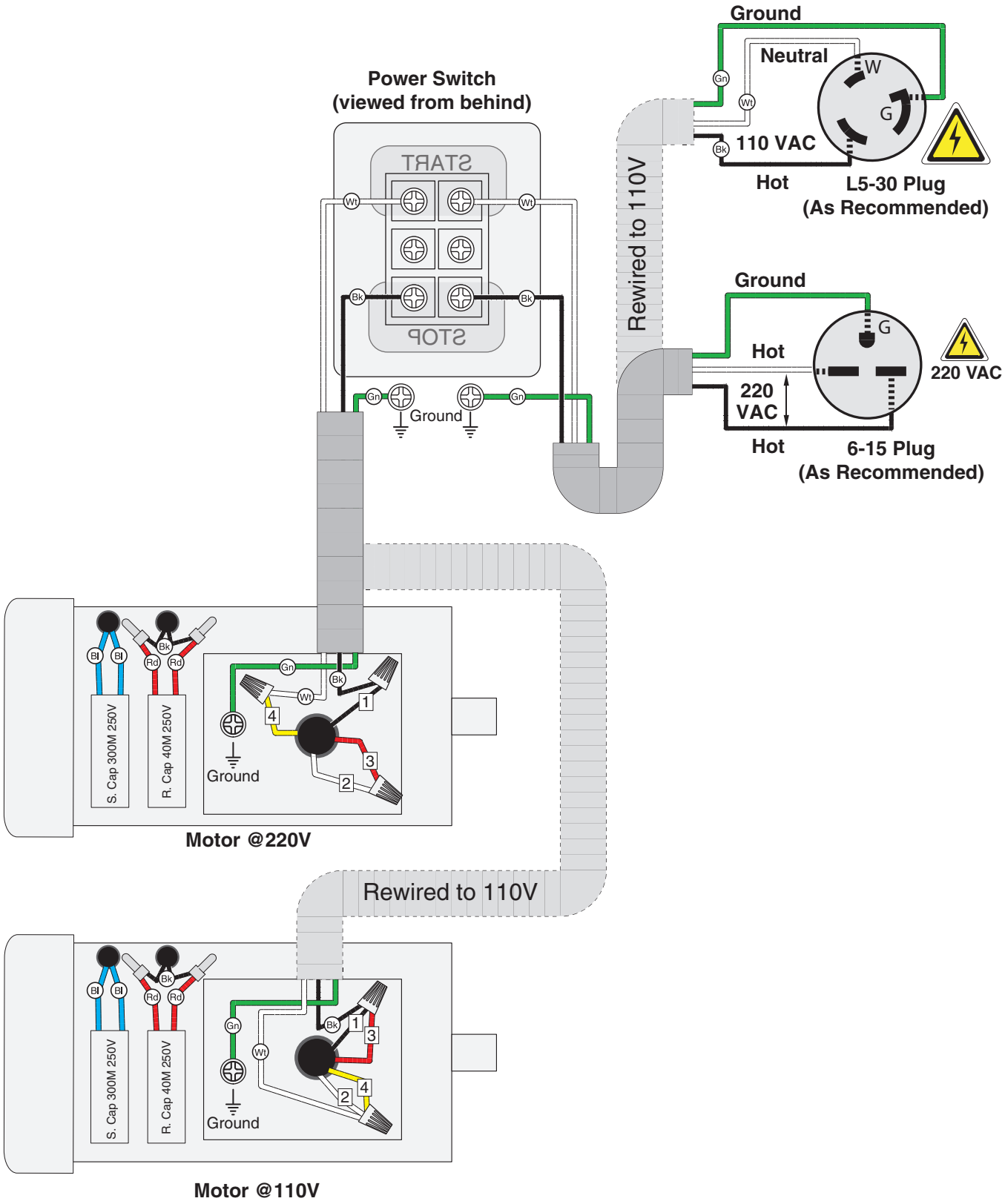
NOTICE

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

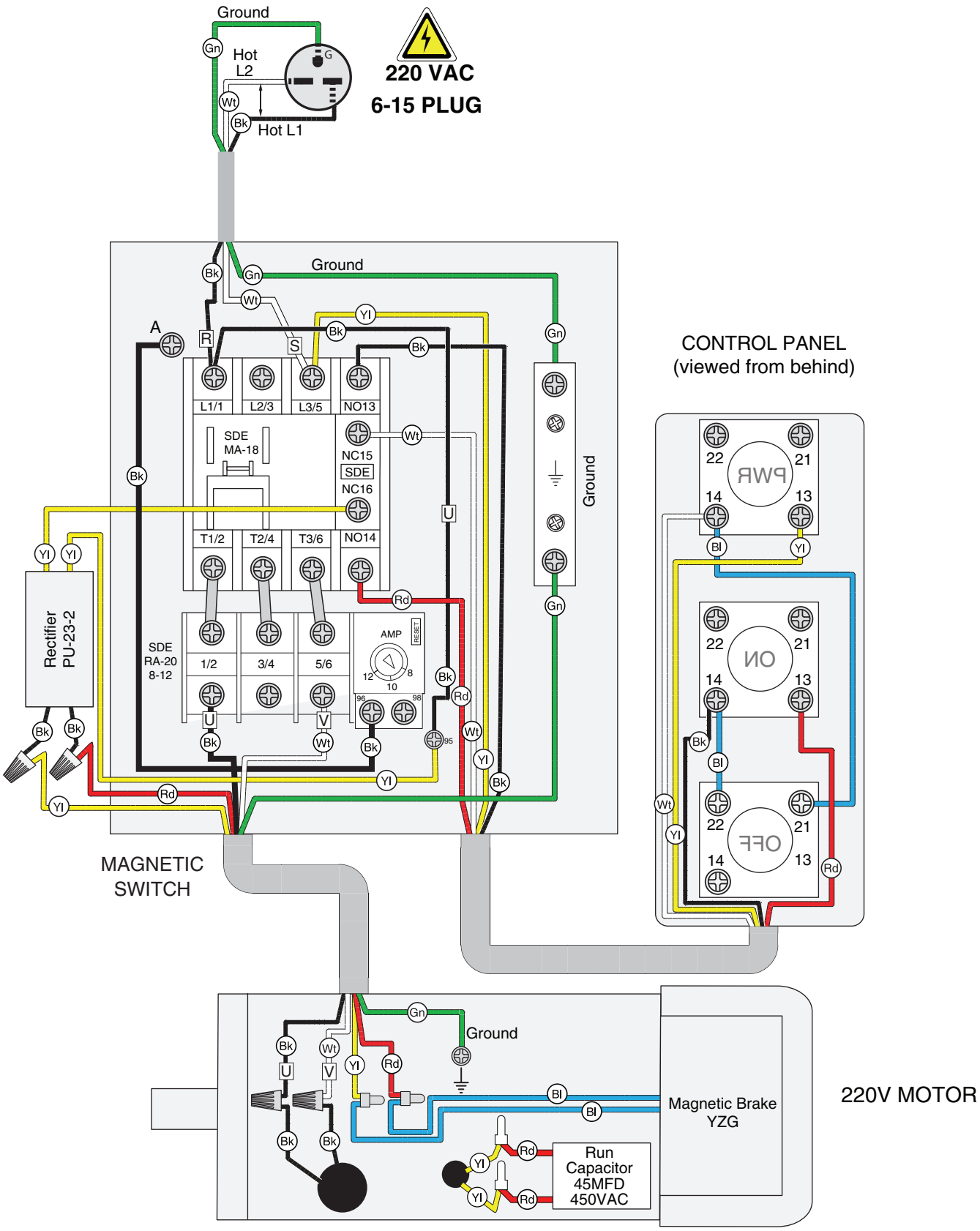
COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu		
RED	Rd	ORANGE	Or	PINK	Pk	TURQUOISE	Tu

G0513, G0513P, G0513ANV, & G0513X2 Wiring Diagram



G0513X2B Wiring Diagram



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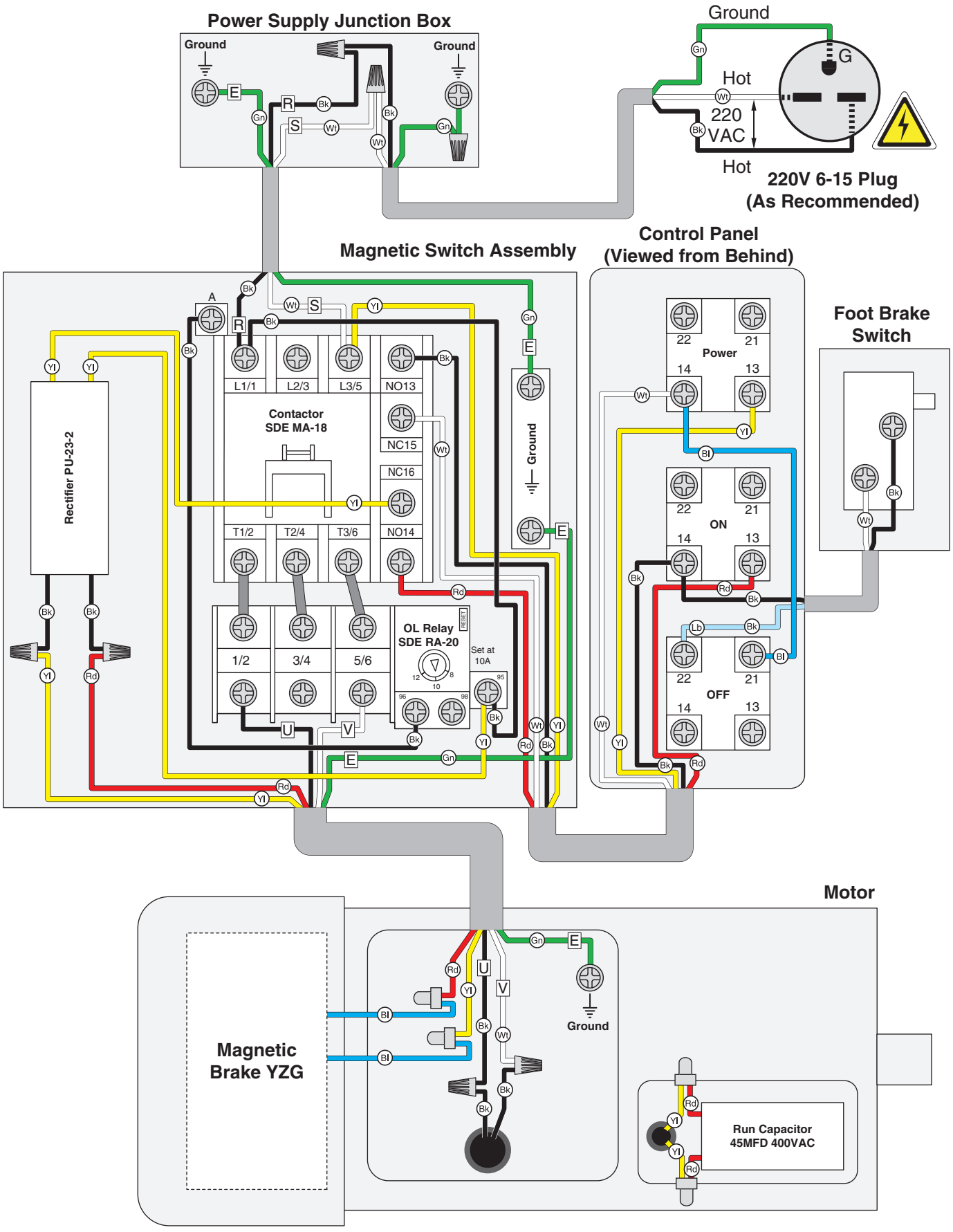
G0513X2BF Wiring Diagram



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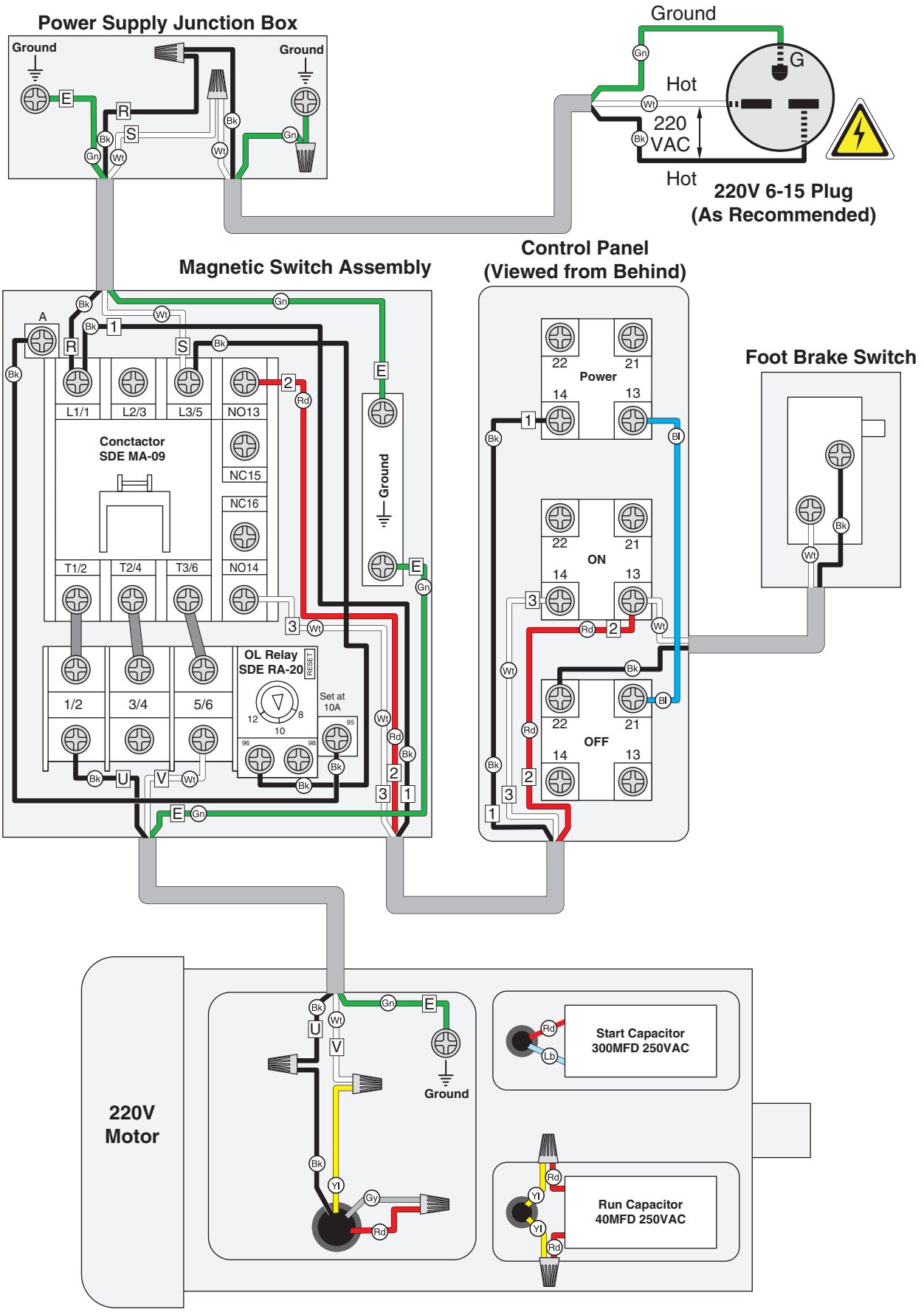
G0513X2F 220V Wiring Diagram



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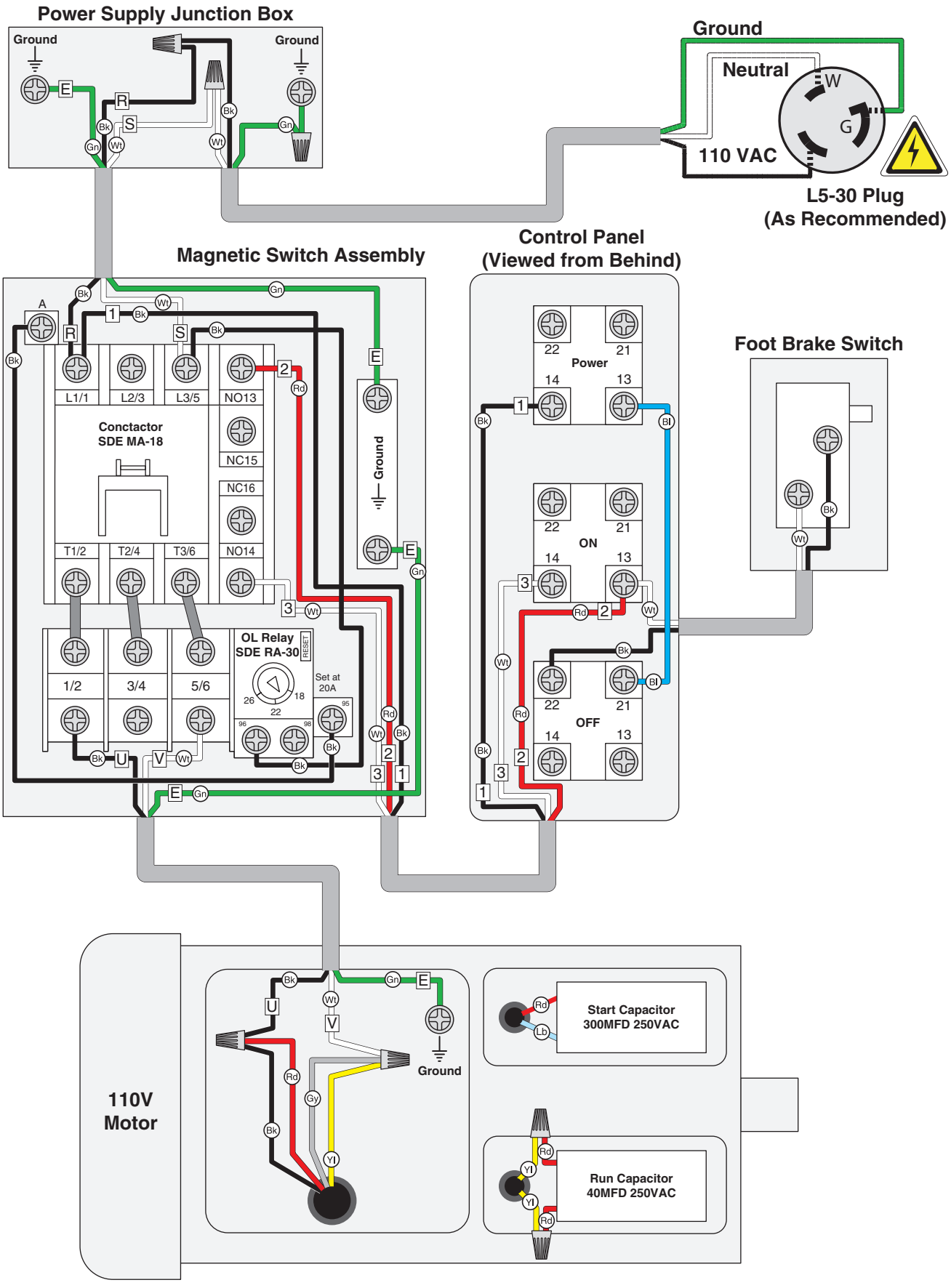
G0513X2F 110V Wiring Diagram



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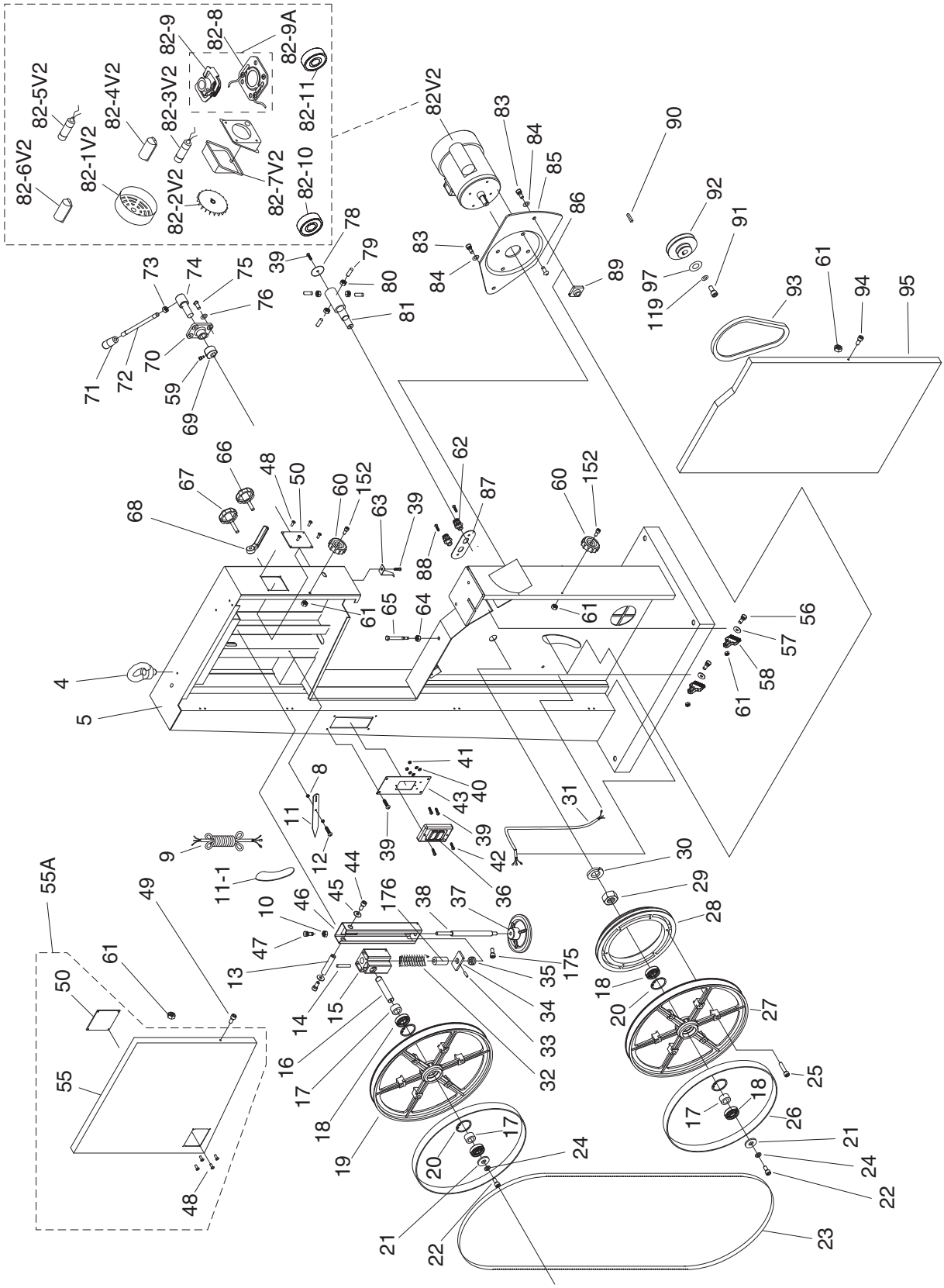
SECTION 9: PARTS

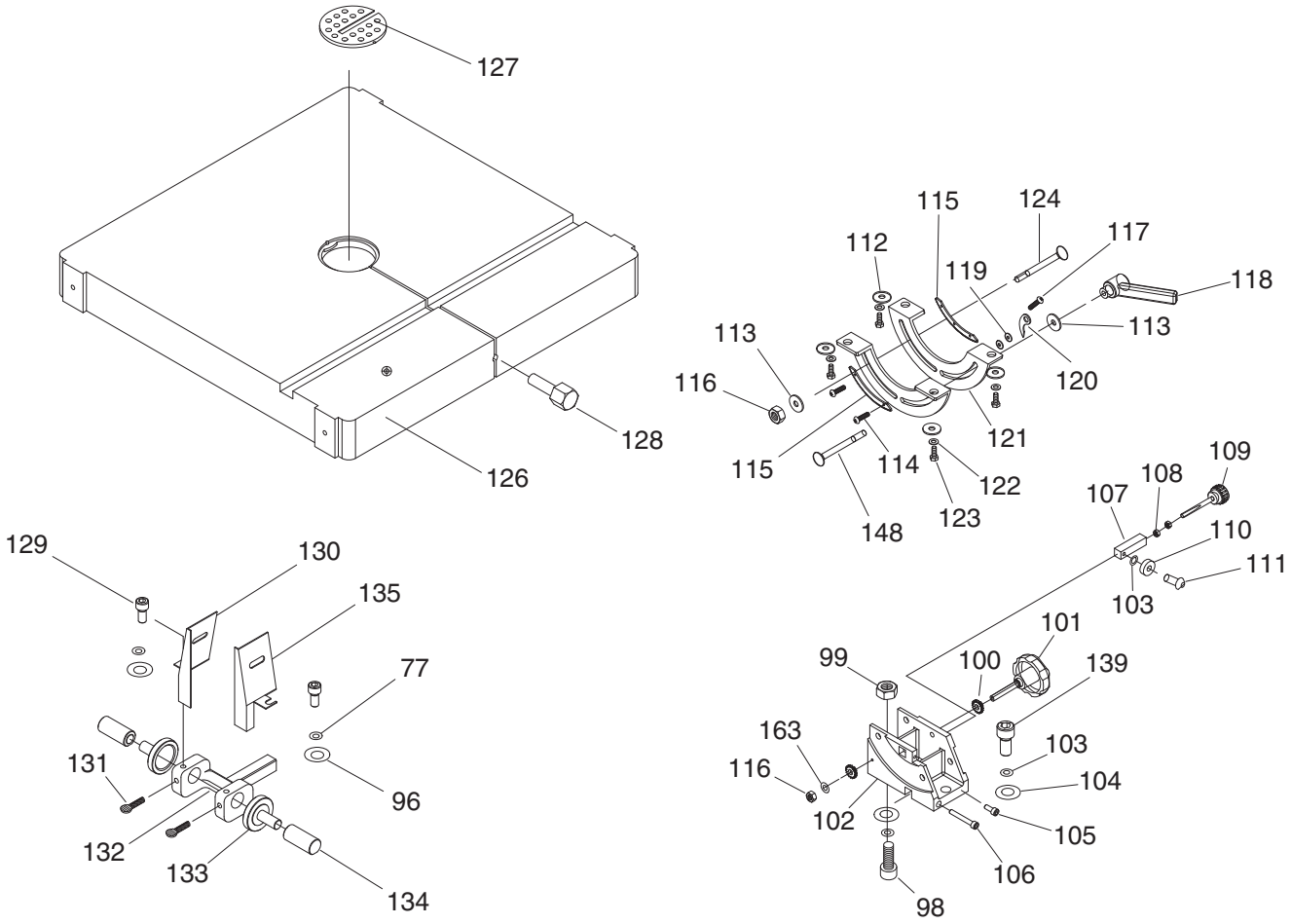
G0513/G0513P/G0513ANV Main



G0513/G0513P/G0513ANV Main Parts List

REF	PART #	DESCRIPTION
4	P0513004	LIFTING EYE BOLT M10-1.5
5	P0513005	MACHINE BODY (G0513)
5	P0513P005	MACHINE BODY (G0513P)
5	P0513ANV005	MACHINE BODY G0513ANV)
8	PW03M	FLAT WASHER 6MM
9	P0513009	POWER CORD 14G 3W 72"
10	PN01M	HEX NUT M6-1
11	P0513011	POINTER
12	P0513012	STEP SCREW M4-.7 X 5
13	P0513013	HINGE SHAFT
14	PRP10M	ROLL PIN 5 X 36
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513017	BUSHING
18	P6204-2RS	BALL BEARING 6204-2RS
19	P0513019	UPPER WHEEL 17"
20	PR25M	INT RETAINING RING 47MM
21	P0513X021	WHEEL FLAT WASHER 8MM
22	PB26M	HEX BOLT M8-1.25 X 30
23	P0513023	SAW BLADE 131.5" X 1/2" 6TPI HOOK
24	PLW04M	LOCK WASHER 8MM
25	PB29M	HEX BOLT M6-1 X 30
26	T23071	URETHANE TIRE 17" 1-PAIR
27	P0513027	LOWER WHEEL 17"
28	P0513028	LOWER WHEEL PULLEY
29	PN32	HEX NUT 1-14
30	PLW09	LOCK WASHER 1"
31	P0513031	MOTOR CORD 14G 3W
32	P0513032	COMPRESSION SPRING 7 X 8 X 90
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	ALIGNMENT PLATE
35	P51201	THRUST BEARING 51201
36	P0513036	2-BUTTON POWER SWITCH
37	P0513037	TENSION HANDWHEEL
38	P0513038	TENSION ADJUSTING ROD
39	PFS07M	FLANGE SCREW M5-.8 X 10
40	PTLW02M	EXT TOOTH WASHER 5MM
41	PN06M	HEX NUT M5-.8
42	PFS08M	FLANGE SCREW M5-.8 X 16
43	P0513043	SWITCH BACK PLATE
44	PB03M	HEX BOLT M8-1.25 X 16
45	PW01M	FLAT WASHER 8MM
46	P0513046	UPPER WHEEL SLIDING BRACKET
47	PB10M	HEX BOLT M6-1 X 25
48	PRIV005M	STEEL BLIND RIVET 3 X 13MM
49	PB04M	HEX BOLT M6-1 X 10
50	P0513050	CLEAR WINDOW
55	P0513055	UPPER WHEEL COVER (G0513)
55	P0513P055	UPPER WHEEL COVER (G0513P)
55	P0513ANV055	UPPER WHEEL COVER (G0513ANV)
55A	P0513X2055A	UPPER WHEEL COVER ASSY (G0513)
55A	P0513P055A	UPPER WHEEL COVER ASSY (G0513P)
55A	P0513ANV055A	UPPER WHEEL COVER ASSY (G0513ANV)
56	PB04M	HEX BOLT M6-1 X 10
57	PW03M	FLAT WASHER 6MM
58	P0513058	WHEEL BRUSH
59	PB10M	HEX BOLT M6-1 X 25
60	P0513060	STAR KNOB
61	PLN03M	LOCK NUT M6-1
62	P0513062	STRAIN RELIEF 16MM STRAIGHT LT
63	P0513063	HEIGHT POINTER
64	PN03M	HEX NUT M8-1.25
65	PB45M	HEX BOLT M8-1.25 X 100
66	P0513066	STAR KNOB BOLT M10-1.5 X 20
67	P0513067	STAR KNOB BOLT M10-1.5 X 55
68	P0513068	THREADED HANDLE M10-1.5
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	HANDLE M12-1.75
72	P0513072	LEVER
73	PN09M	HEX NUT M12-1.75
74	P0513074	LEVER HUB
75	PCAP14M	CAP SCREW M8-1.25 X 20
76	PLW04M	LOCK WASHER 8MM
78	P0513078	SHAFT COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513081	LOWER WHEEL SHAFT
82	P0513082	MOTOR 2HP 110V/220V 1-PH
82-1	P0513082-1	MOTOR FAN COVER
82-2	P0513082-2	MOTOR FAN
82-3V2	PC300T	S CAPACITOR 300M 250V 1-1/2 X 2-3/8 V2.01.10
82-4	P0513082-4	S CAPACITOR COVER
82-5V2	PC040H	R CAPACITOR 40M 250V 1-1/2 X 2-3/4 V2.01.10
82-6	P0513082-6	R CAPACITOR COVER
82-7	P0513082-7	MOTOR JUNCTION BOX
82-8	PCP001	CONTACT PLATE
82-9	PCS001	CENTRIFUGAL SWITCH 5/8-1725
82-9A	P0513082-9A	CENTRIFUGAL SWITCH W/CONT PLATE
82-10	P6203ZZ	BALL BEARING 6203ZZ
82-11	P6205ZZ	BALL BEARING 6205ZZ
83	PB95M	HEX BOLT M5-.8 X 16
84	PLW01M	LOCK WASHER 5MM
85	P0513085	MOTOR MOUNT BRACKET
86	PCAP14M	CAP SCREW M8-1.25 X 20
87	P0513087	STRAIN RELIEF PLATE 2-HOLE
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	PB81M	HEX BOLT M8-1.25 X 20 LH
92	P0513092	MOTOR PULLEY TYPE-A 3.5"
93	PVA42	V-BELT A42
94	PB04M	HEX BOLT M6-1 X 10
95	P0513095	LOWER WHEEL COVER (G0513)
95	P0513P095	LOWER WHEEL COVER (G0513P)
95	P0513ANV095	LOWER WHEEL COVER (G0513ANV)
97	PW01M	FLAT WASHER 8MM
119	PW01M	FLAT WASHER 8MM
152	PB08M	HEX BOLT M6-1 X 20
175	PB08M	HEX BOLT M6-1 X 20
176	P0513176	BUSHING

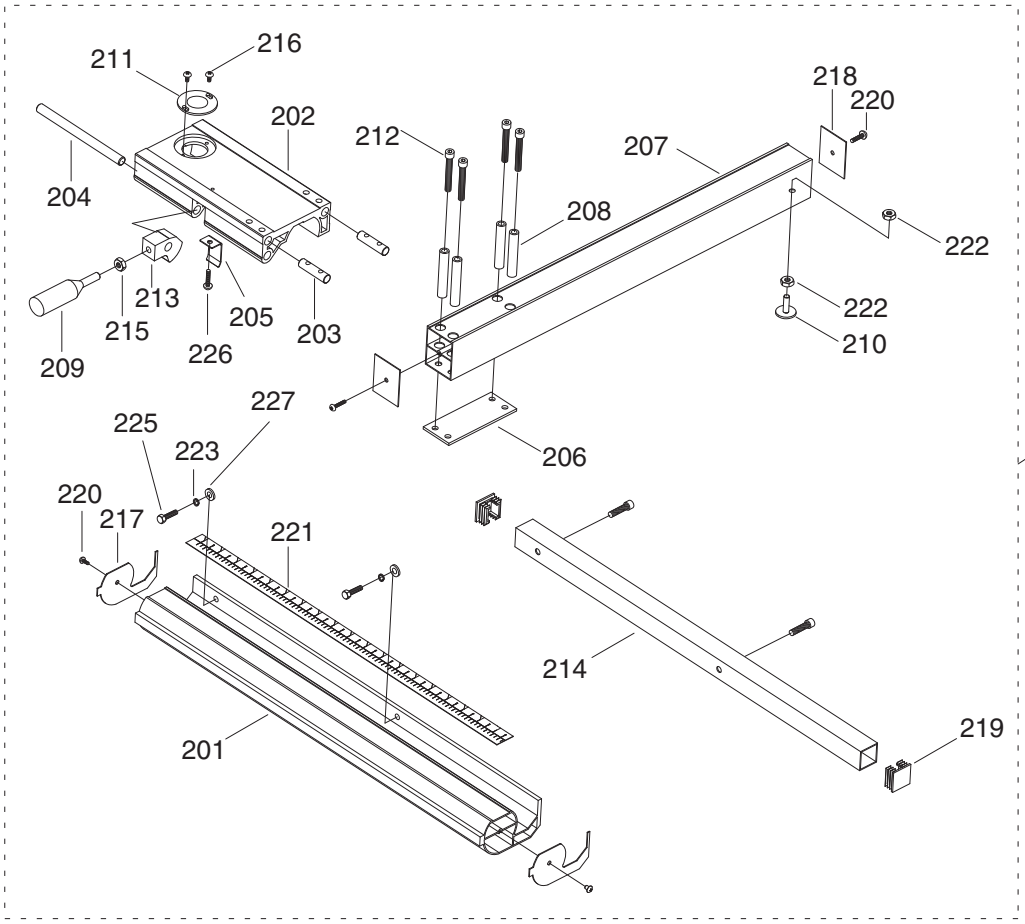
G0513/G0513P/G0513ANV Table, Trunnion, & Lower Blade Guides



REF	PART #	DESCRIPTION
77	PLW04M	LOCK WASHER 8MM
96	PW01M	FLAT WASHER 8MM
98	PCAP84M	CAP SCREW M10-1.5 X 35
99	PN02M	HEX NUT M10-1.5
100	P0513100	TRUNNION GEAR
101	P0513101	STAR KNOB BOLT
102	P0513102	TRUNNION SUPPORT BRACKET
103	PLW06M	LOCK WASHER 10MM
104	PW04M	FLAT WASHER 10MM
105	PCAP28M	CAP SCREW M6-1 X 15
106	PCAP37M	CAP SCREW M6-1 X 50
107	P0513107	ALIGNMENT ROD
108	PN01M	HEX NUT M6-1
109	P0513109	ADJUSTMENT KNOB BOLT M6-1
110	P6000ZZ	BALL BEARING 6000ZZ
111	PBHS25M	BUTTON HD CAP SCR M10-1.5 X 20
112	PW01M	FLAT WASHER 8MM
113	PW01M	FLAT WASHER 8MM
114	PS17M	PHLP HD SCR M4-.7 X 6
115	P0513115	GEAR PLATE
116	PLN04M	LOCK NUT M8-1.25
117	PS17M	PHLP HD SCR M4-.7 x 6

REF	PART #	DESCRIPTION
118	P0513118	LOCK HANDLE M8-1.25
119	PW01M	FLAT WASHER 8MM
120	P0513120	POINTER
121	P0513121	TRUNNION PLATE
122	PLW04M	LOCK WASHER 8MM
123	PCAP11M	CAP SCREW M8-1.25 X 16
124	PCB23M	CARRIAGE BOLT M8-1.25 X 80
126	P0513126	TABLE 17" X 17" (G0513/G0513P)
126	P0513ANV126	TABLE 17" X 17" (G0513ANV)
127	T24384	TABLE INSERT
128	P0555100	TABLE PIN
129	PB81M	HEX BOLT M8-1.25 X 20 LH
130	P0513130	LEFT GUARD
131	PTS001M	THUMB SCREW M6-1 X 16
132	P0513132	LOWER BLADE GUIDE SUPPORT
133	P0513133	BLADE GUIDE
134	P0513134	GUIDE ADJUSTMENT SHAFT
135	P0513135	RIGHT GUARD
139	PCAP72M	CAP SCREW M10-1.5 X 30
148	PCB10M	CARRIAGE BOLT M8-1.25 X 85
163	PLW04M	LOCK WASHER 8MM

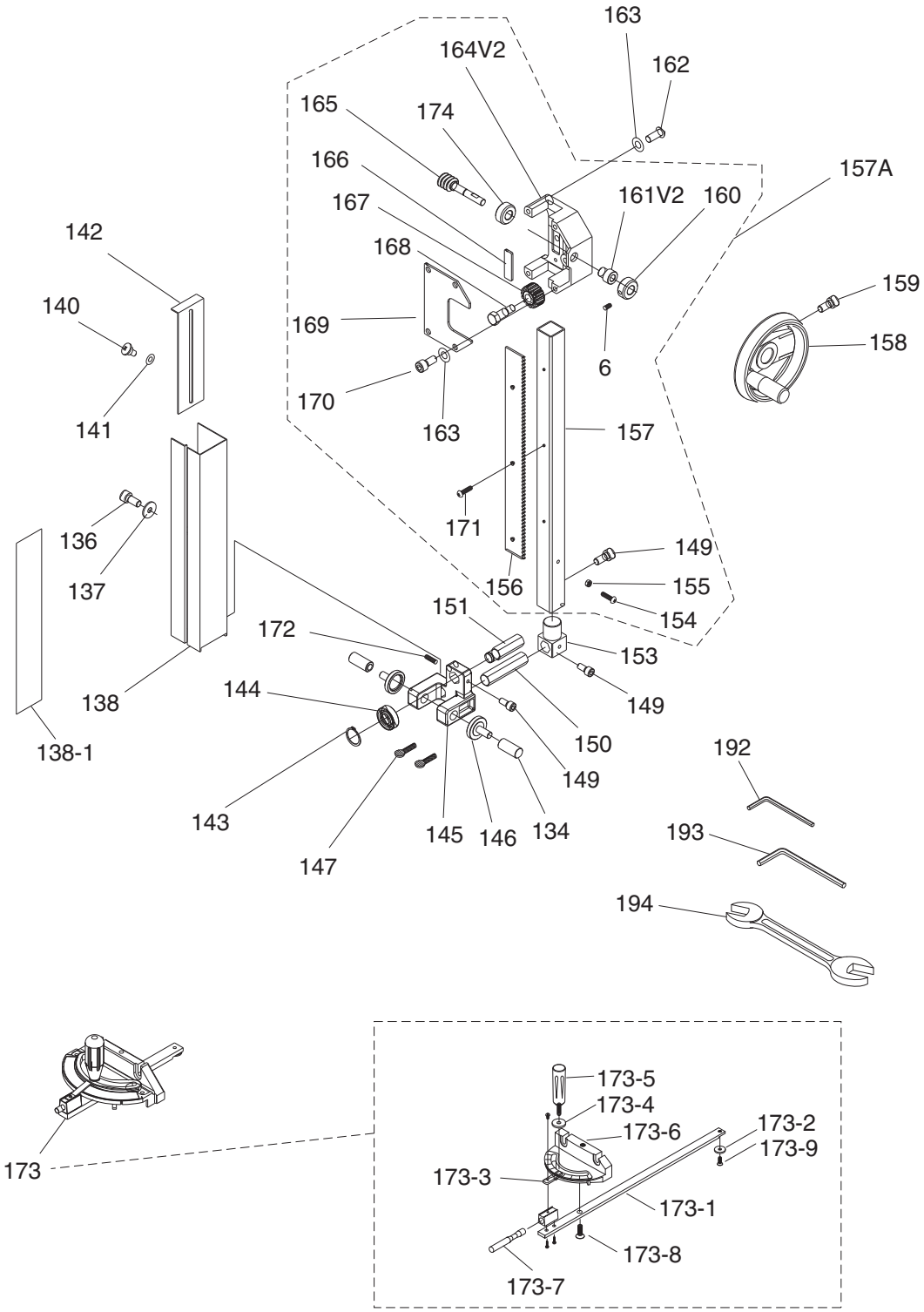
G0513/G0513P/G0513ANV Fence



REF	PART #	DESCRIPTION
125	P0513125	FENCE ASSEMBLY W/RAILS
201	P0513201	FRONT FENCE RAIL
202	P0513202	FENCE BASE
203	P0513203	ALIGNMENT SHAFT
204	P0513204	LOCK BLOCK SHAFT
205	P0555305	SPRING PLATE
206	P0555306	SPACER PLATE
207	P0513207	FENCE
208	P0513208	SLEEVE
209	P0513209	FENCE LOCK HANDLE
210	P0513210	RAIL PAD
211	P0513211	CONVEX WINDOW
212	PCAP83M	CAP SCREW M6-1 X 55
213	P0555313	LOCK CAM

REF	PART #	DESCRIPTION
214	P0513214	REAR FENCE RAIL
215	PN01M	HEX NUT M6-1
216	PFS04M	FLANGE SCREW M4-.7 X 6
217	P0555317	FRONT RAIL END CAP
218	P0513218	FENCE END CAP
219	P0555319	REAR RAIL END CAP
220	PHTEK3M	TAP SCREW M3.5 X 8
221	P0513221	FENCE SCALE
222	PN01M	HEX NUT M6-1
223	PLW03M	LOCK WASHER 6MM
225	PB08M	HEX BOLT M6-1 X 20
226	PFS05M	FLANGE SCREW M4-.7 X 10
227	PW03M	FLAT WASHER 6MM

G0513/G0513P/G0513ANV Upper Blade Guides & Miter Gauge

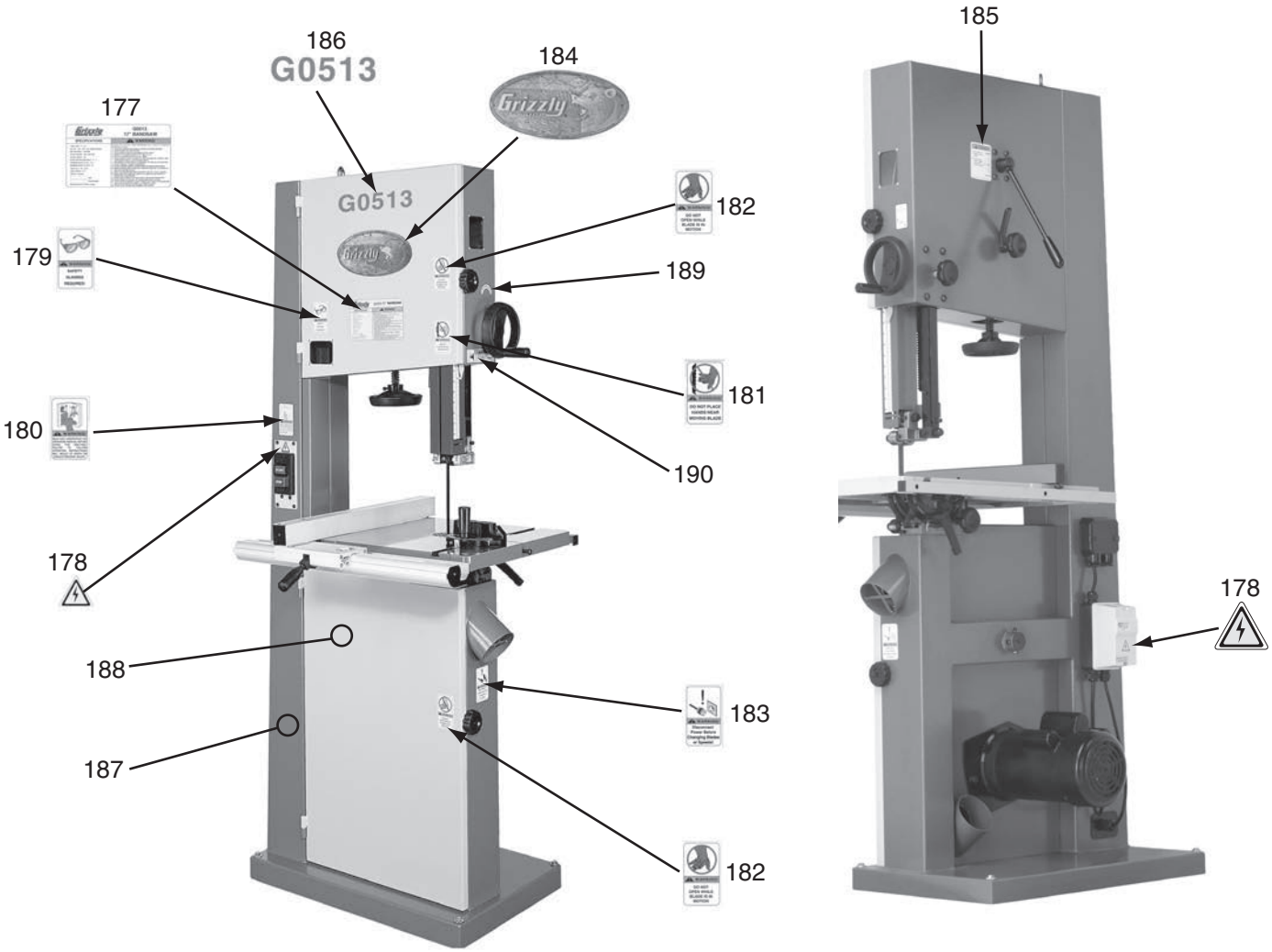


G0513/G0513P/G0513ANV Upper Blade Guides & Miter Gauge Parts List

REF	PART #	DESCRIPTION
6	PSS07M	SET SCREW M5-.8 X 5
134	P0513134	GUIDE ADJUSTMENT SHAFT
136	PCAP148M	CAP SCREW M8-1.25 X 80
137	PW01M	FLAT WASHER 8MM
138	P0513138	UPPER BLADE GUARD (G0513/G0513P)
138	P0513ANV138	UPPER BLADE GUARD (G0513ANV)
138-1	P0513138-1	BLADE GUARD SCALE
140	P0513012	STEP SCREW M4-.7 X 5
141	P0513141	FIBER WASHER 5MM
142	P0513142	SLIDING PLATE (G0513/G0513P)
142	P0513ANV142	SLIDING PLATE (G0513ANV)
143	PR05M	EXT RETAINING RING 15MM
144	P6202ZZ	BALL BEARING 6202ZZ
145	P0513145	UPPER BLADE GUIDE SUPPORT
146	P0513133	BLADE GUIDE
147	PTS001M	THUMB SCREW M6-1 X 16
149	PCAP28M	CAP SCREW M6-1 X 15
150	P0513150	ADJUSTMENT SHAFT
151	P0513151	UPPER SPACING SLEEVE
153	P0513153	UPPER GUIDE SUPPORT BLOCK
154	PS38M	PHLP HD SCR M4-.7 X 10
155	PN04M	HEX NUT M4-.7
156	P0513156	RACK
157A	P0513157A	GUIDE POST ASSEMBLY
157	P0513157	GUIDE POST
158	P0513158	ELEVATION HANDWHEEL
159	PB08M	HEX BOLT M6-1 X 20

REF	PART #	DESCRIPTION
160	P0513160	PINION GEAR STEP BOLT
161V2	P0513161V2	THREADED BUSHING V2.06.09
162	PCAP14M	CAP SCREW M8-1.25 X 20
163	PLW04M	LOCK WASHER 8MM
164V2	P0513164V2	THREADED GUIDE BRACKET 14MM V2.06.09
165	P0513165	WORM CYLINDER
166	P0513166	FIXED PLATE
167	P0513167	PINION GEAR 15T
168	P0513168	PINION GEAR STEP BOLT
169	P0513169	BRACKET COVER
170	PCAP11M	CAP SCREW M8-1.25 X 16
171	PS07M	PHLP HD SCR M4-.7 X 8
172	PSS11M	SET SCREW M6-1 X 16
173	P0513173	MITER GAUGE ASSY
173-1	P0513173-1	GUIDE BAR
173-2	P1022029-1	T-SLOT WASHER 5MM
173-3	P0506147	INDICATOR
173-4	P0513173-4	NYLON WASHER 1/4"
173-5	P0513173-5	MITER GAUGE HANDLE 1/4"-20
173-6	P0513173-6	MITER GAUGE BODY
173-7	P0513173-7	INDEXING PIN
173-8	PS37M	PHLP HD SCR M6-1 X 6
173-9	PFS01M	FLANGE SCREW M5-.8 X 8
174	P0513174	BUSHING
192	PAW05M	HEX WRENCH 5MM
193	PAW08M	HEX WRENCH 8MM
194	PWR1013	WRENCH 10 X 13MM OPEN-END

G0513 Labels



REF	PART #	DESCRIPTION
177	P0513177	MACHINE ID LABEL
178	PLABEL-14	ELECTRICITY LABEL
179	PLABEL-11	SAFETY GLASSES LABEL
180	PLABEL-12	READ MANUAL LABEL
181	PLABEL-19	HANDS/BS BLADE LABEL
182	PLABEL-20	DONT OPEN LABEL
183	PLABEL-18	UNPLUG BANDSAW LABEL

REF	PART #	DESCRIPTION
184	G8589	GRIZZLY NAMEPLATE- LARGE
185	P0513185	SAW TENSION LABEL
186	P0513186	MODEL NUMBER LABEL
187	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
188	PPAINT-10	LIGHT GRAY REF PAINT
189	P0513189	GUIDE POST ADJUST LABEL
190	P0513190	BS BLADE ENCLOSURE LABEL

⚠WARNING

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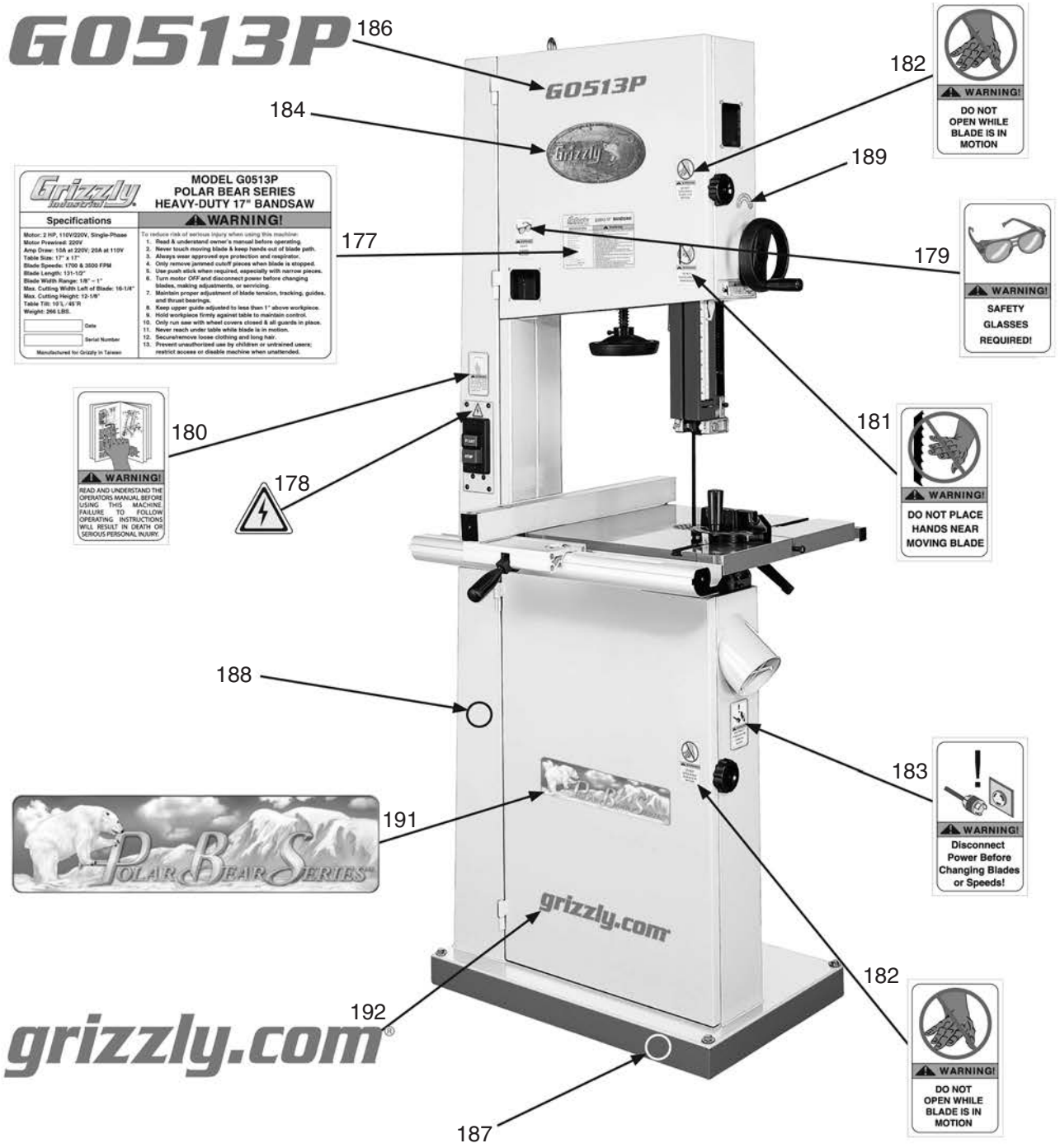
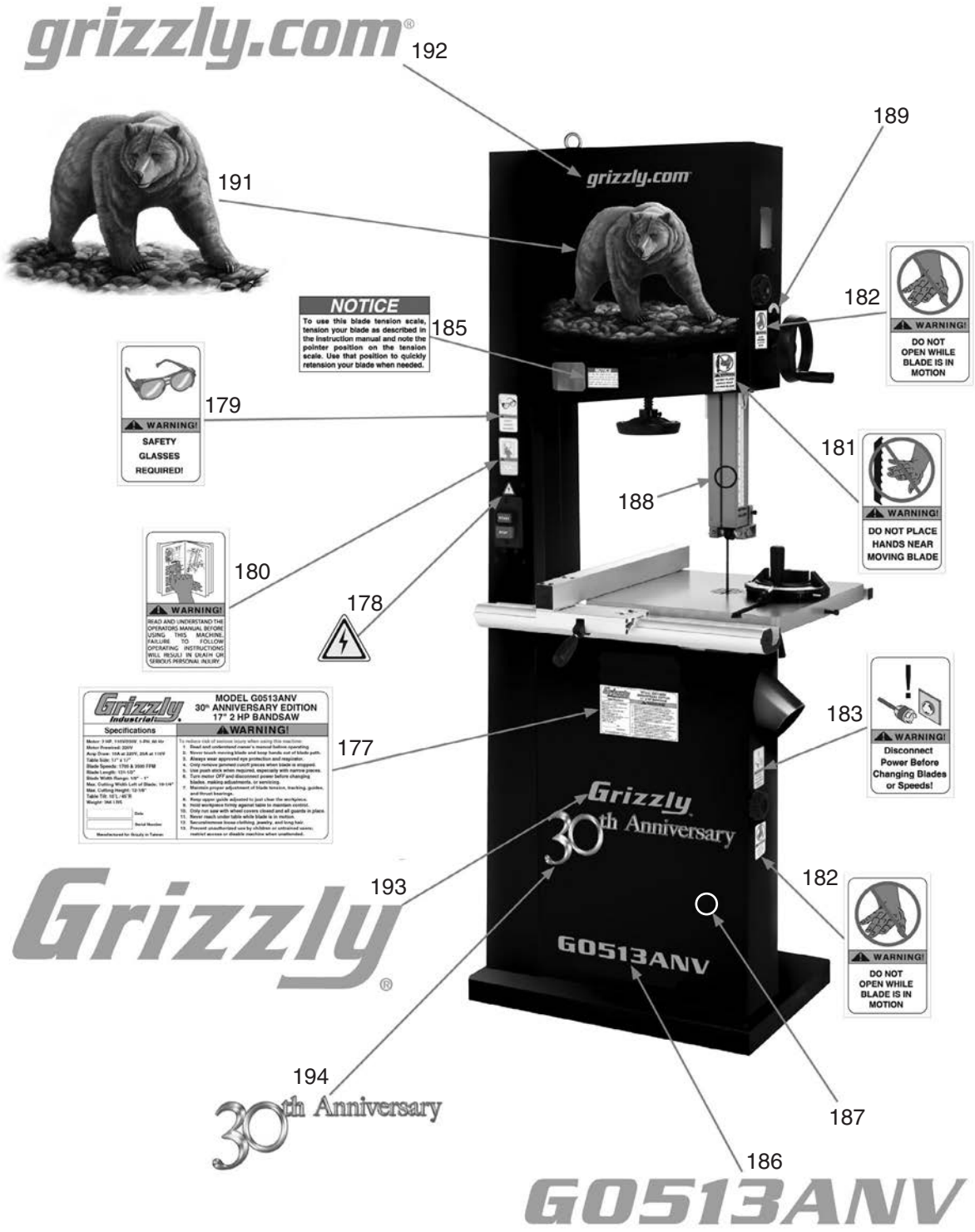
G0513P Labels



REF	PART #	DESCRIPTION
177	P0513P177	MACHINE ID LABEL
178	PLABEL-14	ELECTRICITY LABEL
179	PLABEL-11	SAFETY GLASSES LABEL
180	PLABEL-12	READ MANUAL LABEL
181	PLABEL-19	HANDS/BS BLADE LABEL
182	PLABEL-20	DONT OPEN LABEL
183	PLABEL-18	UNPLUG BANDSAW LABEL

REF	PART #	DESCRIPTION
184	G8589	GRIZZLY NAMEPLATE- LARGE
186	P0513P186	MODEL NUMBER LABEL
187	PPAINT-01	GRIZZLY GREEN TOUCH-UP PAINT
188	PPAINT-24	PB WHITE TOUCH-UP PAINT
189	P0513189	GUIDE POST ADJUST LABEL
191	PLABEL-75	POLAR BEAR LOGO
192	P0513P192	GRIZZLY.COM LABEL

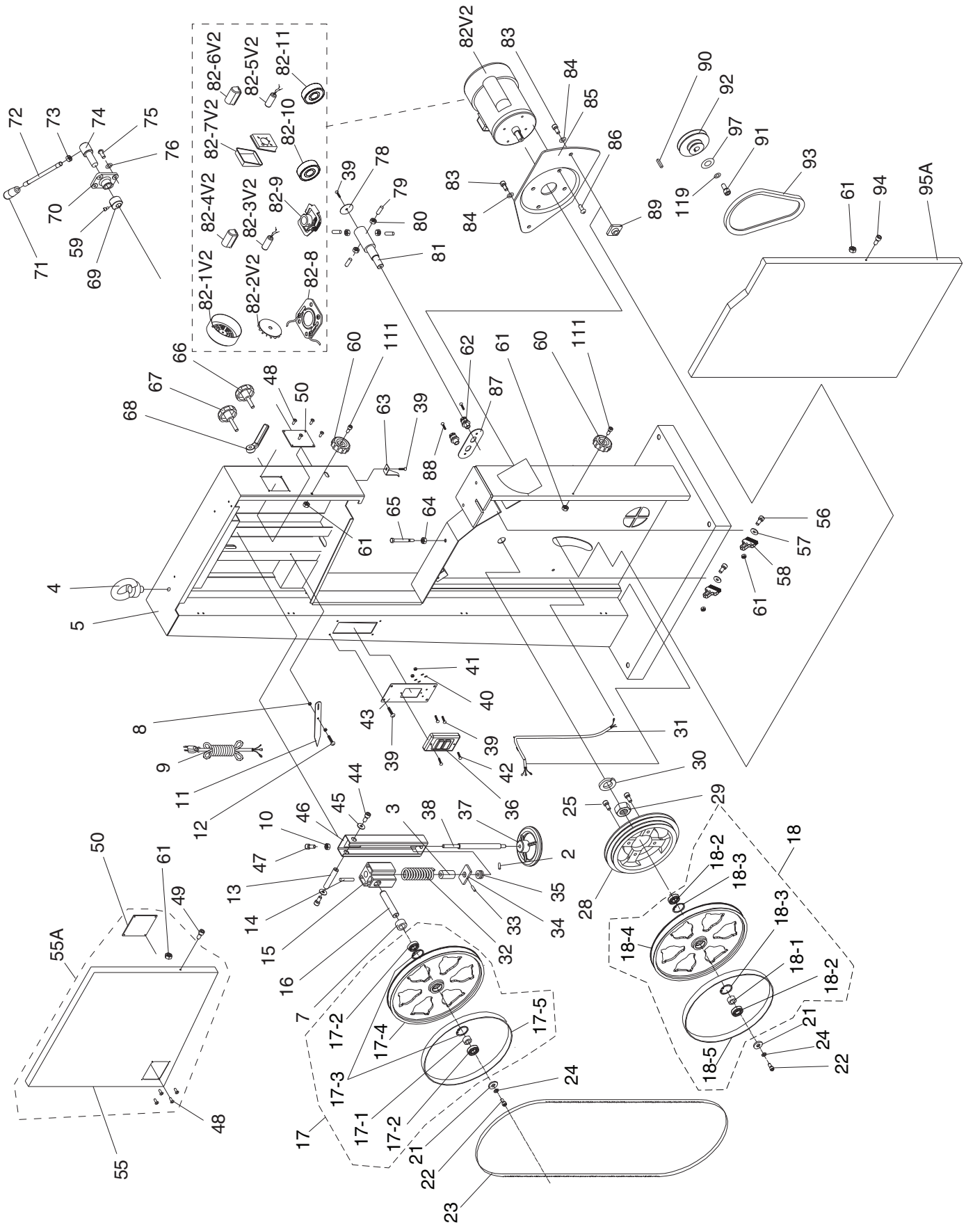
G0513ANV Labels



REF	PART #	DESCRIPTION
177	P0513ANV177	MACHINE ID LABEL
178	PLABEL-14	ELECTRICITY LABEL
179	PLABEL-11	SAFETY GLASSES LABEL
180	PLABEL-12	READ MANUAL LABEL
181	PLABEL-19	HANDS/BS BLADE LABEL
182	PLABEL-20	DONT OPEN LABEL
183	PLABEL-18	UNPLUG BANDSAW LABEL
185	P0513185	SAW TENSION LABEL

REF	PART #	DESCRIPTION
186	P0513ANV186	MODEL NUMBER LABEL
187	P0513ANV187	BLACK TOUCH-UP PAINT
188	P0513ANV188	ORANGE TOUCH-UP PAINT, PANTONE 151C
189	P0513189	GUIDE POST ADJUST LABEL
191	P0513ANV191	GRIZZLY BEAR LABEL
192	P0513ANV192	ORANGE GRIZZLY.COM LABEL
193	P0513ANV193	GRIZZLY LOGO LABEL
194	P0513ANV194	30TH ANNIVERSARY LABEL

G0513X2 Main

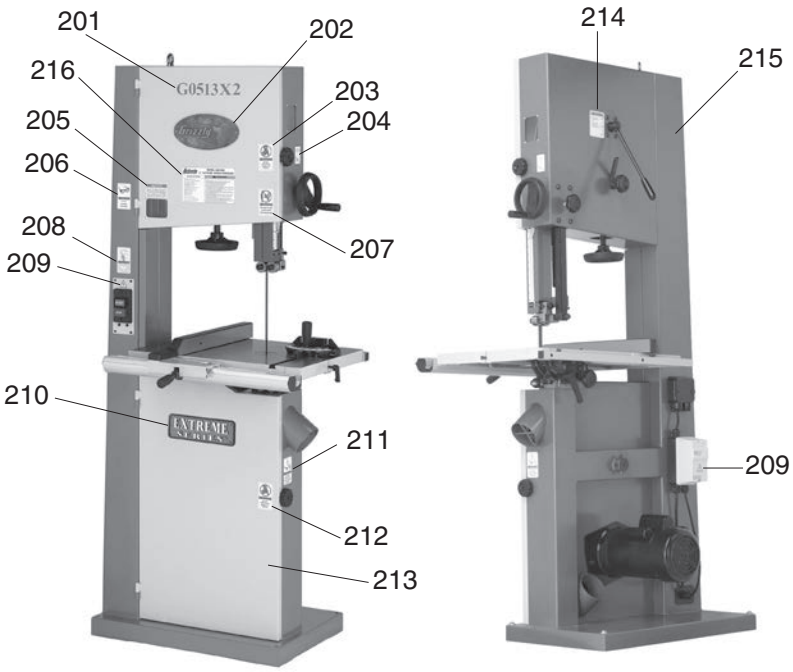


G0513X2 Main Parts List

REF	PART #	DESCRIPTION
2	PSS01M	SET SCREW M6-1 X 10
3	P0513X003	BUSHING
4	P0513004	LIFTING EYE BOLT M10-1.5
5	P0513005	MACHINE BODY
7	P0513X007	BUSHING
8	PW03M	FLAT WASHER 6MM
9	P0513009	POWER CORD 14G 3W 72"
10	PN01M	HEX NUT M6-1
11	P0513011	POINTER
12	P0513012	STEP SCREW M4-.7 X 5
13	P0513013	HINGE SHAFT
14	PRP10M	ROLL PIN 5 X 36
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513X2B017	UPPER WHEEL ASSEMBLY
17-1	P0513017	BUSHING
17-2	P6204-2RS	BALL BEARING 6204-2RS
17-3	PR25M	INT RETAINING RING 47MM
17-4	P0513X019	UPPER WHEEL 17"
17-5	T23071	URETHANE TIRE 17" 1-PAIR
18	P0513X2B018	LOWER WHEEL ASSEMBLY
18-1	P0513017	BUSHING
18-2	P6204-2RS	BALL BEARING 6204-2RS
18-3	PR25M	INT RETAINING RING 47MM
18-4	P0513X027	LOWER WHEEL 17"
18-5	T23071	URETHANE TIRE 17" 1-PAIR
21	P0513X021	WHEEL FLAT WASHER 8MM
22	PCAP11M	CAP SCREW M8-1.25 X 16
23	P0513023	SAW BLADE 131.5" X 1/2" 6TPI HOOK
24	PLW04M	LOCK WASHER 8MM
25	PCAP14M	CAP SCREW M8-1.25 X 20
28	P0513028	LOWER WHEEL PULLEY
29	PN32	HEX NUT 1-14
30	PLW09	LOCK WASHER 1"
31	P0513031	MOTOR CORD 14G 3W
32	P0513032	COMPRESSION SPRING 7 X 8 X 90
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	ALIGNMENT PLATE
35	P51201	THRUST BEARING 51201
36	P0513036	2-BUTTON POWER SWITCH
37	P0513037	TENSION HANDWHEEL
38	P0513038	TENSION ADJUSTING ROD
39	PFS07M	FLANGE SCREW M5-.8 X 10
40	PTLW02M	EXT TOOTH WASHER 5MM
41	PN06M	HEX NUT M5-.8
42	PFS08M	FLANGE SCREW M5-.8 X 16
43	P0513043	SWITCH BACK PLATE
44	PCAP11M	CAP SCREW M8-1.25 X 16
45	PWF08M	FENDER WASHER 8MM
46	P0513046	UPPER WHEEL SLIDING BRACKET
47	PCAP05M	CAP SCREW M8-1.25 X 50
48	PRIV005M	STEEL BLIND RIVET 3 X 13MM
49	PCAP04M	CAP SCREW M6-1 X 10
50	P0513050	CLEAR WINDOW
55A	P0513X2055A	UPPER WHEEL COVER ASSY

REF	PART #	DESCRIPTION
55	P0513055	UPPER WHEEL COVER
56	PB10M	HEX BOLT M6-1 X 25
57	PW03M	FLAT WASHER 6MM
58	P0513058	WHEEL BRUSH
59	PCAP06M	CAP SCREW M6-1 X 25
60	P0513060	STAR KNOB
61	PLN03M	LOCK NUT M6-1
62	P0513062	STRAIN RELIEF 16MM STRAIGHT LT
63	P0513063	HEIGHT POINTER
64	PN03M	HEX NUT M8-1.25
65	PB124M	HEX BOLT M8-1.25 X 90
66	P0513066	STAR KNOB BOLT M10-1.5 X 20
67	P0513067	STAR KNOB BOLT M10-1.5 X 55
68	P0513068	THREADED HANDLE M10-1.5
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	HANDLE M12-1.75
72	P0513072	LEVER
73	PN09M	HEX NUT M12-1.75
74	P0513074	LEVER HUB
75	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
76	PLW04M	LOCK WASHER 8MM
78	P0513078	SHAFT COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513081	LOWER WHEEL SHAFT
82V2	P0513X2082V2	MOTOR 2HP 110V/220V 1-PH V2.01.10
82-1V2	P0513X2082-1V2	MOTOR FAN COVER V2.01.10
82-2V2	P0513X2082-2V2	MOTOR FAN V2.01.10
82-3V2	PC300T	S CAPACITOR 300M 250V 1-1/2 X 2-3/8 V2.01.10
82-4V2	P0513X2082-4V2	S CAPACITOR COVER V2.01.10
82-5V2	PC040G	R CAPACITOR 40M 250V 1-3/8 X 2-5/8 V2.01.10
82-6V2	P0513X2082-6V2	R CAPACITOR COVER V2.01.10
82-7V2	P0513X2082-7V2	MOTOR JUNCTION BOX V2.01.10
82-8	PCP001	CONTACT PLATE 5/8
82-9	PCS001	CENTRIFUGAL SWITCH 5/8-1725
82-10	P6203ZZ	BALL BEARING 6203ZZ
82-11	P6205ZZ	BALL BEARING 6205ZZ
83	PB32M	HEX BOLT M10-1.5 X 25
84	PLW06M	LOCK WASHER 10MM
85	P0513085	MOTOR MOUNT BRACKET
86	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
87	P0513087	STRAIN RELIEF PLATE 2-HOLE
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	PB81M	HEX BOLT M8-1.25 X 20 LH
92	P0513092	MOTOR PULLEY TYPE-A 3.5"
93	PVA42	V-BELT A42
94	PCAP04M	CAP SCREW M6-1 X 10
95A	P0513095	LOWER WHEEL COVER
97	PWF08M	FENDER WASHER 8MM
111	PCAP02M	CAP SCREW M6-1 X 20
119	PLW02M	LOCK WASHER 4MM

G0513X2 Labels



REF	PART #	DESCRIPTION
201	P0513X2201	MODEL NUMBER LABEL
202	G8588	GRIZZLY LOGO PLATE
203	PLABEL-20	OPEN DOOR LABEL
204	P0513X204	GUARD ADJ LABEL
205	P0513X205	SCALE DIRECTIONS LABEL
206	PLABEL-11	SAFETY GLASSES LABEL
207	PLABEL-19	HANDS/BLADE LABEL
208	PLABEL-12	READ MANUAL LABEL

REF	PART #	DESCRIPTION
209	PLABEL-14	ELECTRICITY LABEL
210	P0513X210	EXTREME SERIES PLATE
211	PLABEL-18	DISCONNECT POWER LABEL
212	PLABEL-20	OPEN DOOR LABEL
213	PPAINT-11	PUTTY TOUCH-UP PAINT
214	P0513X214	TENSION ADJ LABEL
215	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
216	P0513X2216	MACHINE ID LABEL

⚠WARNING

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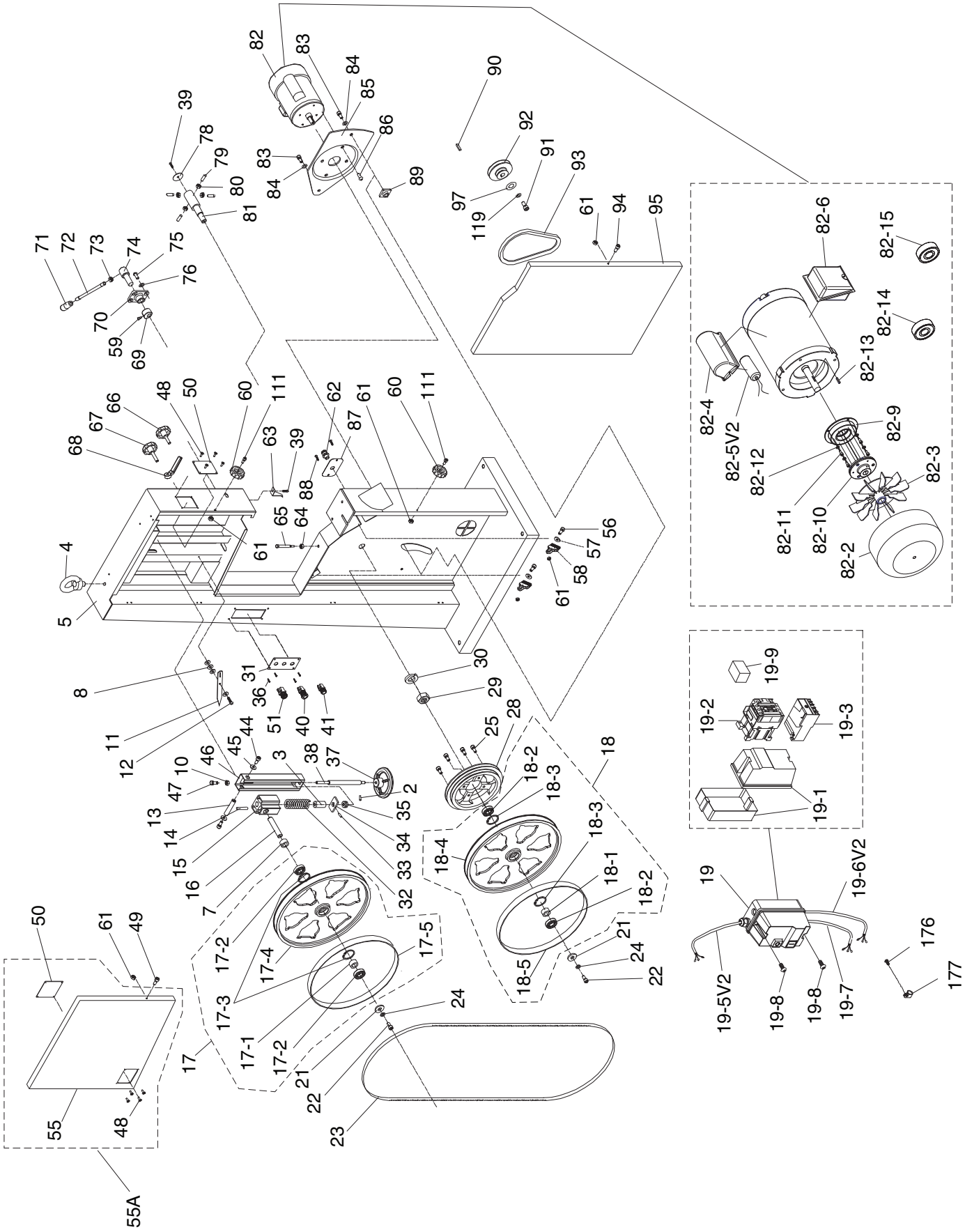
G0513X2B Main



G0513X2B Main Parts List

REF	PART #	DESCRIPTION
2	PSS01M	SET SCREW M6-1 X 10
3	P0513X003	BUSHING
4	P0513004	LIFTING EYE BOLT M10-1.5
5	P0513005	MACHINE BODY
7	P0513X007	BUSHING
8	PW03M	FLAT WASHER 6MM
10	PN01M	HEX NUT M6-1
11	P0513011	POINTER
12	P0513012	STEP SCREW M4-.7 X 5
13	P0513013	HINGE SHAFT
14	PRP91M	ROLL PIN 5 X 35
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513X2B017	UPPER WHEEL ASSEMBLY
17-1	P0513017	BUSHING
17-2	P6204-2RS	BALL BEARING 6204-2RS
17-3	PR25M	INT RETAINING RING 47MM
17-4	P0513X019	UPPER WHEEL 17"
17-5	T23071	URETHANE TIRE 17" 1-PAIR
18	P0513X2B018	LOWER WHEEL ASSEMBLY
18-1	P0513017	BUSHING
18-2	P6204-2RS	BALL BEARING 6204-2RS
18-3	PR25M	INT RETAINING RING 47MM
18-4	P0513X027	LOWER WHEEL 17"
18-5	T23071	URETHANE TIRE, 1-PAIR
19	P0513X2B019	MAG SWITCH ASSEMBLY MPE-18
19-1	P0513X2B019-1	MAG SWITCH COVER ASSEMBLY
19-2	P0513X2B019-2	CONTACTOR SDE MA-18 220V
19-3	P0513X2B019-3	OL RELAY SDE RA-20 8-12A
19-5V2	P0513X2B019-5V2	PWR CORD 14G 3W 6-15P V2.02.12
19-6V2	P0513X2B019-6V2	CONTROL CORD 16G 5W V2.05.11
19-7	P0513X2B019-7	MOTOR CORD 14G 5W
19-8	PS09M	PHLP HD SCR M5-.8 X 10
19-9	P0513X2B019-9	RECTIFIER PU-23-2
21	P0513X021	WHEEL FLAT WASHER 8MM
22	PCAP11M	CAP SCREW M8-1.25 X 16
23	P0513023	SAW BLADE 131.5" X 1/2" 6TPI HOOK
24	PLW04M	LOCK WASHER 8MM
25	PCAP14M	CAP SCREW M8-1.25 X 20
28	P0513028	LOWER WHEEL PULLEY
29	PN32	HEX NUT 1-14
30	PLW09	LOCK WASHER 1"
31	P0513X2B031	CONTROL PANEL PLATE
32	P0513032	COMPRESSION SPRING 7 X 8 X 90
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	ALIGNMENT PLATE
35	P51201	THRUST BEARING 51201
36	PHTEK15M	TAP SCREW M4 X 10
37	P0513037	TENSION HANDWHEEL
38	P0513038	TENSION ADJUSTING ROD
39	PFS07M	FLANGE SCREW M5-.8 X 10
40	P0513X2B040	STOP BUTTON

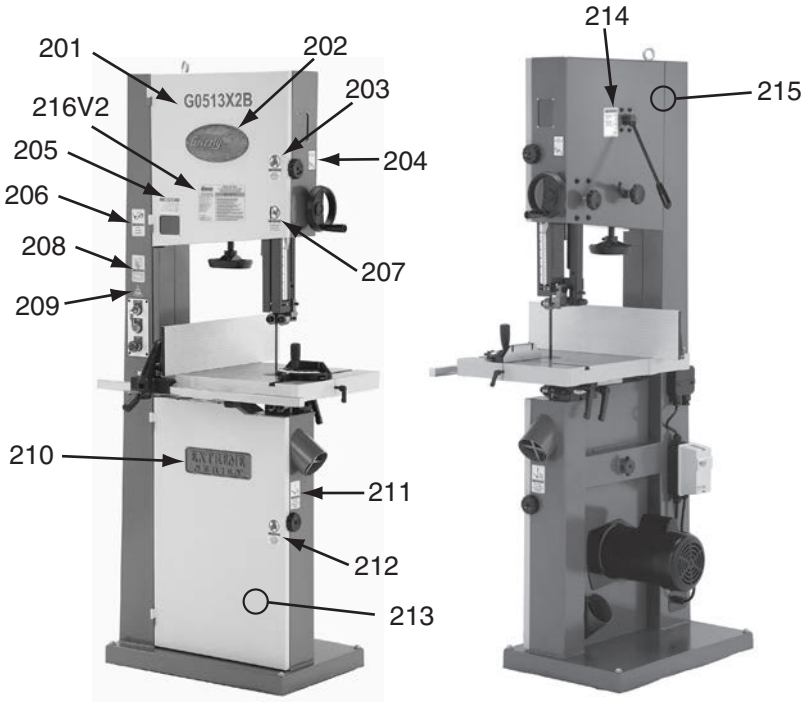
REF	PART #	DESCRIPTION
41	P0513X2B041	START BUTTON
44	PCAP11M	CAP SCREW M8-1.25 X 16
45	PWF08M	FENDER WASHER 8MM
46	P0513046	UPPER WHEEL SLIDING BRACKET
47	PCAP06M	CAP SCREW M6-1 X 25
48	PRIV005M	STEEL BLIND RIVET 3 X 13MM
49	PCAP04M	CAP SCREW M6-1 X 10
50	P0513050	CLEAR WINDOW
51	P0513X2B051	KEY SWITCH
55A	P0513X2055A	UPPER WHEEL COVER ASSY
55	P0513055	UPPER WHEEL COVER
56	PB10M	HEX BOLT M6-1 X 25
57	PW03M	FLAT WASHER 6MM
58	P0513058	WHEEL BRUSH
59	PCAP06M	CAP SCREW M6-1 X 25
60	P0513060	STAR KNOB
61	PLN03M	LOCK NUT M6-1
62	P0513062	STRAIN RELIEF 16MM STRT LT
63	P0513063	HEIGHT POINTER
64	PN03M	HEX NUT M8-1.25
65	PB124M	HEX BOLT M8-1.25 X 90
66	P0513066	STAR KNOB BOLT M10-1.5 X 20
67	P0513067	STAR KNOB BOLT M10-1.5 X 53
68	P0513068	THREADED HANDLE M10-1.5
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	HANDLE M12-1.75
72	P0513072	LEVER
73	PN09M	HEX NUT M12-1.75
74	P0513074	LEVER HUB
75	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
76	PLW04M	LOCK WASHER 8MM
78	P0513078	SHAFT COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513081	LOWER WHEEL SHAFT
82	P0513X2B082	MOTOR 2HP 220V 1-PH W/BRAKE
82-2	P0513X2B082-2	MOTOR FAN COVER
82-3	P0513X2B082-3	MOTOR FAN
82-4	P0513X2B082-4	CAPACITOR COVER
82-5V2	PC045B	R CAPACITOR 45M 450V 2 X 2-1/2
82-6	P0513X2B082-6	MOTOR JUNCTION BOX
82-9	P0513X2B082-9	MAGNETIC BRAKE YZG
82-10	P0513X2B082-10	BRAKE SHOE
82-11	PCAP26M	CAP SCREW M6-1 X 12
82-12	PLW03M	LOCK WASHER 6MM
82-13	PK23M	KEY 5 X 5 X 25
82-14	P6203ZZ	BALL BEARING 6203ZZ
82-15	P6205ZZ	BALL BEARING 6205ZZ
83	PB32M	HEX BOLT M10-1.5 X 25
84	PLW06M	LOCK WASHER 10MM
85	P0513085	MOTOR MOUNT BRACKET

G0513X2B Main Parts List

REF	PART #	DESCRIPTION
86	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
87	P0513X2B087	STRAIN RELIEF PLATE 1-HOLE
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	PK15M	KEY 5 X 5 X 35
92	P0513092	MOTOR PULLEY TYPE-A 3.5"
93	PVA42	V-BELT A-42

REF	PART #	DESCRIPTION
94	PCAP04M	CAP SCREW M6-1 X 10
95	P0513095	LOWER WHEEL COVER
97	PWF08M	FENDER WASHER 8MM
111	PCAP02M	CAP SCREW M6-1 X 20
119	PLW04M	LOCK WASHER 8MM
176	PFS07M	FLANGE SCREW M5-.8 X 10
177	P0513X2B177	STRAIN RELIEF 5/16" ELBOW LT

G0513X2B Labels



REF	PART #	DESCRIPTION
201	P0513X2B201	MODEL NUMBER LABEL
202	G8588	GRIZZLY LOGO PLATE
203	PLABEL-20	OPEN DOOR LABEL
204	P0513X204	GUARD ADJ LABEL
205	P0513X205	SCALE DIRECTIONS LABEL
206	PLABEL-11	SAFETY GLASSES LABEL
207	PLABEL-19	HANDS/BLADE LABEL
208	PLABEL-12	READ MANUAL LABEL

REF	PART #	DESCRIPTION
209	PLABEL-14	ELECTRICITY LABEL
210	P0513X210	EXTREME SERIES PLATE
211	PLABEL-18	DISCONNECT POWER LABEL
212	PLABEL-20	OPEN DOOR LABEL
213	PPAINT-11	PUTTY TOUCH-UP PAINT
214	P0513X214	TENSION ADJ LABEL
215	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
216V2	P0513X2B216V2	MACHINE ID LABEL CSA V2.05.11

⚠WARNING

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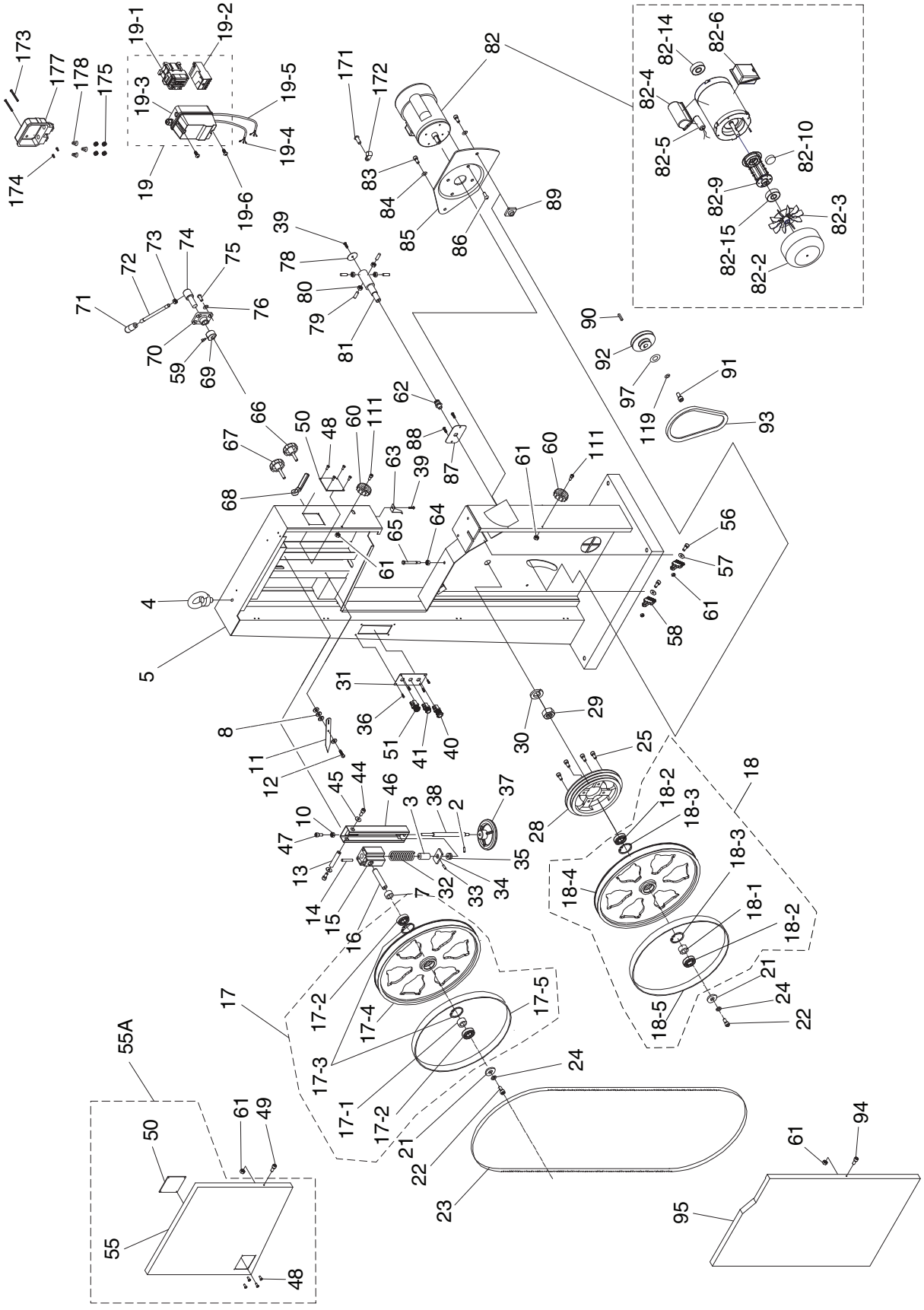
G0513X2BF Main



G0513X2BF Main Parts List

REF	PART #	DESCRIPTION
2	PSS01M	SET SCREW M6-1 X 10
3	P0513X003	BUSHING
4	P0513004	LIFTING EYE BOLT M10-1.5
5	P0513X2F005	MACHINE BODY
7	P0513X007	BUSHING
8	PW03M	FLAT WASHER 6MM
10	PN01M	HEX NUT M6-1
11	P0513011	POINTER
12	P0513012	STEP SCREW M4-.7 X 5
13	P0513013	HINGE SHAFT
14	PRP91M	ROLL PIN 5 X 35
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513X2B017	UPPER WHEEL ASSEMBLY
17-1	P0513017	BUSHING
17-2	P6204-2RS	BALL BEARING 6204-2RS
17-3	PR25M	INT RETAINING RING 47MM
17-4	P0513X019	UPPER WHEEL 17"
17-5	T23071	URETHANE TIRE 17" 1-PAIR
18	P0513X2B018	LOWER WHEEL ASSEMBLY
18-1	P0513017	BUSHING
18-2	P6204-2RS	BALL BEARING 6204-2RS
18-3	PR25M	INT RETAINING RING 47MM
18-4	P0513X027	LOWER WHEEL 17"
18-5	T23071	URETHANE TIRE 17" 1-PAIR
19	P0513X2BF019	MAG SWITCH ASSY SDE MPE-18 220V
19-1	P0513X2B019-2	CONTACTOR SDE MA-18 220V
19-2	P0513X2B019-3	OL RELAY SDE RA-20 8-12A
19-3	P0513X2BF019-3	MAG SWITCH COVER ASSEMBLY
19-4	P0513X2B019-6V2	CONTROL CORD 16G 5W V2.05.11
19-5	P0513X2B019-7	MOTOR CORD 14G 5W
19-6	PS09M	PHLP HD SCR M5-.8 X 10
21	P0513X021	WHEEL FLAT WASHER 8MM
22	PCAP11M	CAP SCREW M8-1.25 X 16
23	P0513023	SAW BLADE 131.5" X 1/2" 6TPI HOOK
24	PLW04M	LOCK WASHER 8MM
25	PCAP14M	CAP SCREW M8-1.25 X 20
28	P0513X2F028	WHEEL PULLEY/BRAKE DRUM
29	PN32	HEX NUT 1-14
30	PLW09	LOCK WASHER 1"
31	P0513X2B031	CONTROL PANEL PLATE
32	P0513032	COMPRESSION SPRING 7 X 8 X 90
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	ALIGNMENT PLATE
35	P51201	THRUST BEARING 51201
36	PHTEK15M	TAP SCREW M4 X 10
37	P0513037	TENSION HANDWHEEL
38	P0513038	TENSION ADJUSTING ROD
39	PFS07M	FLANGE SCREW M5-.8 X 10
40	P0513X2B040	STOP BUTTON
41	P0513X2B041	START BUTTON
44	PCAP11M	CAP SCREW M8-1.25 X 16
45	PWF08M	FENDER WASHER 8MM

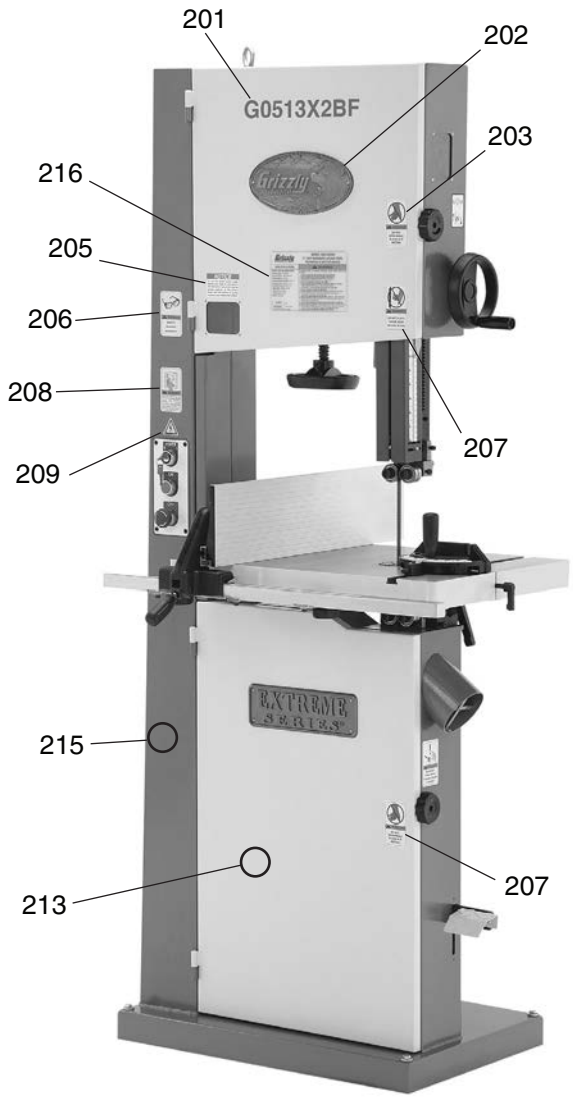
REF	PART #	DESCRIPTION
46	P0513046	UPPER WHEEL SLIDING BRACKET
47	PCAP06M	CAP SCREW M6-1 X 25
48	PRIV005M	STEEL BLIND RIVET 3 X 13MM
49	PCAP04M	CAP SCREW M6-1 X 10
50	P0513050	CLEAR WINDOW
51	P0513X2B051	KEY SWITCH
55A	P0513X2055A	UPPER WHEEL COVER ASSY
55	P0513055	UPPER WHEEL COVER
56	PB10M	HEX BOLT M6-1 X 25
57	PW03M	FLAT WASHER 6MM
58	P0513058	WHEEL BRUSH
59	PCAP06M	CAP SCREW M6-1 X 25
60	P0513060	STAR KNOB
61	PLN03M	LOCK NUT M6-1
62	P0513062	STRAIN RELIEF 16MM STRAIGHT LT
63	P0513063	HEIGHT POINTER
64	PN03M	HEX NUT M8-1.25
65	PB124M	HEX BOLT M8-1.25 X 90
66	P0513066	STAR KNOB BOLT M10-1.5 X 20
67	P0513067	STAR KNOB BOLT M10-1.5 X 53
68	P0513068	THREADED HANDLE M10-1.5
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	HANDLE M12-1.75
72	P0513072	LEVER
73	PN09M	HEX NUT M12-1.75
74	P0513074	LEVER HUB
75	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
76	PLW04M	LOCK WASHER 8MM
78	P0513078	SHAFT COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513X2F081	LOWER WHEEL SHAFT
82	P0513X2BF082	MOTOR 2HP 220V 1-PH W/BRAKE
82-2	P0513X2BF082-2	MOTOR FAN COVER
82-3	P0513X2BF082-3	MOTOR FAN
82-4	P0513X2BF082-4	CAPACITOR COVER
82-5	PC045C	R CAPACITOR 45M 400V 2 X 2-1/2
82-6	P0513X2BF082-6	MOTOR JUNCTION BOX
82-9	P0513X2BF082-9	MAGNETIC BRAKE YZG
82-10	P0513X2BF082-10	BRAKE SHOE
82-14	P6205ZZ	BALL BEARING 6205ZZ
82-15	P6203ZZ	BALL BEARING 6203ZZ
83	PB32M	HEX BOLT M10-1.5 X 25
84	PLW06M	LOCK WASHER 10MM
85	P0513085	MOTOR MOUNT BRACKET
86	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
87	P0513X2B087	STRAIN RELIEF PLATE 1-HOLE
88	PHTEK15M	TAP SCREW M4 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	PB81M	HEX BOLT M8-1.25 X 20 LH
92	P0513092	MOTOR PULLEY TYPE-A 3.5"

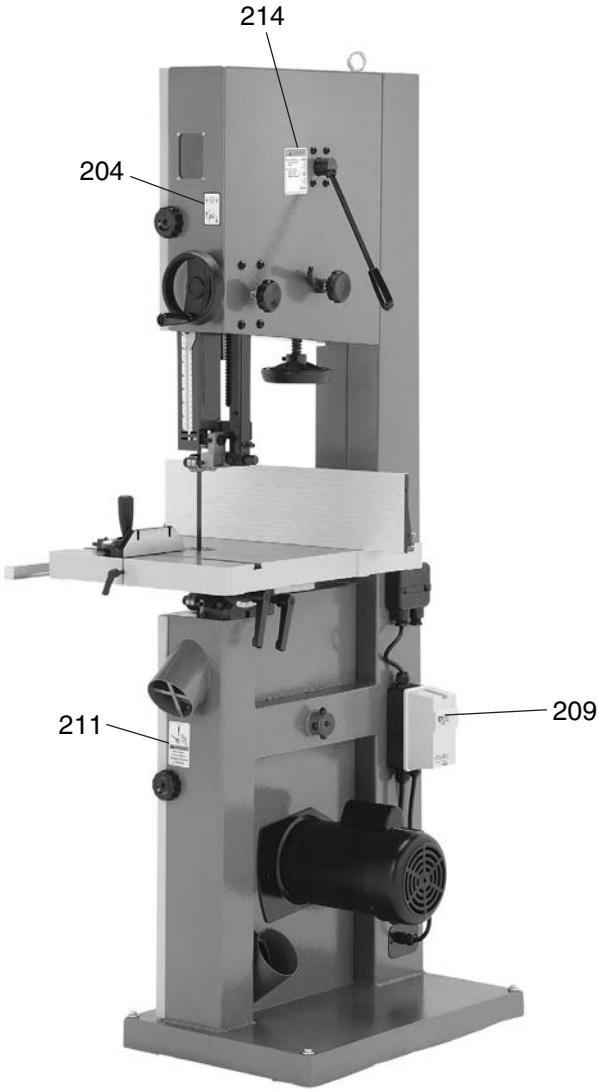
G0513X2BF Main Parts List

REF	PART #	DESCRIPTION
93	PVA42	V-BELT A42
94	PCAP04M	CAP SCREW M6-1 X 10
95	P0513095	LOWER WHEEL COVER
97	PWF08M	FENDER WASHER 8MM
111	PCAP02M	CAP SCREW M6-1 X 20
119	PLW04M	LOCK WASHER 8MM
171	PFS07M	FLANGE SCREW M5-.8 X 10

REF	PART #	DESCRIPTION
172	P0513X2F189	CORD CLIP 5/16"
173	PFS09M	FLANGE SCREW M5-.8 X 50
174	PS38M	PHLP HD SCR M4-.7 X 10
175	PTLW02M	EXT TOOTH WASHER 5MM
177	P0513X2F197	JUNCTION BOX
178	PWRN01	WIRE NUT 14-22G

G0513X2BF Labels





REF	PART #	DESCRIPTION
201	P0513X2BF201	MODEL NUMBER LABEL
202	G8589	NAMEPLATE-LARGE
203	PLABEL-20	DON'T OPEN DOOR LABEL
204	P0513X204	GUARD ADJUSTMENT LABEL
205	P0513X205	SCALE DIRECTIONS LABEL
206	PLABEL-11	SAFETY GLASSES LABEL
207	PLABEL-19	HANDS/BLADE HAZARD LABEL

REF	PART #	DESCRIPTION
208	PLABEL-12	READ MANUAL LABEL
209	PLABEL-14	ELECTRICITY LABEL
211	PLABEL-18	UNPLUG/DOOR HAZARD LABEL
213	PPAINT-11	PUTTY TOUCH-UP PAINT
214	P0513X214	TENSION ADJ LABEL
215	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
216	P0513X2BF216	MACHINE ID LABEL

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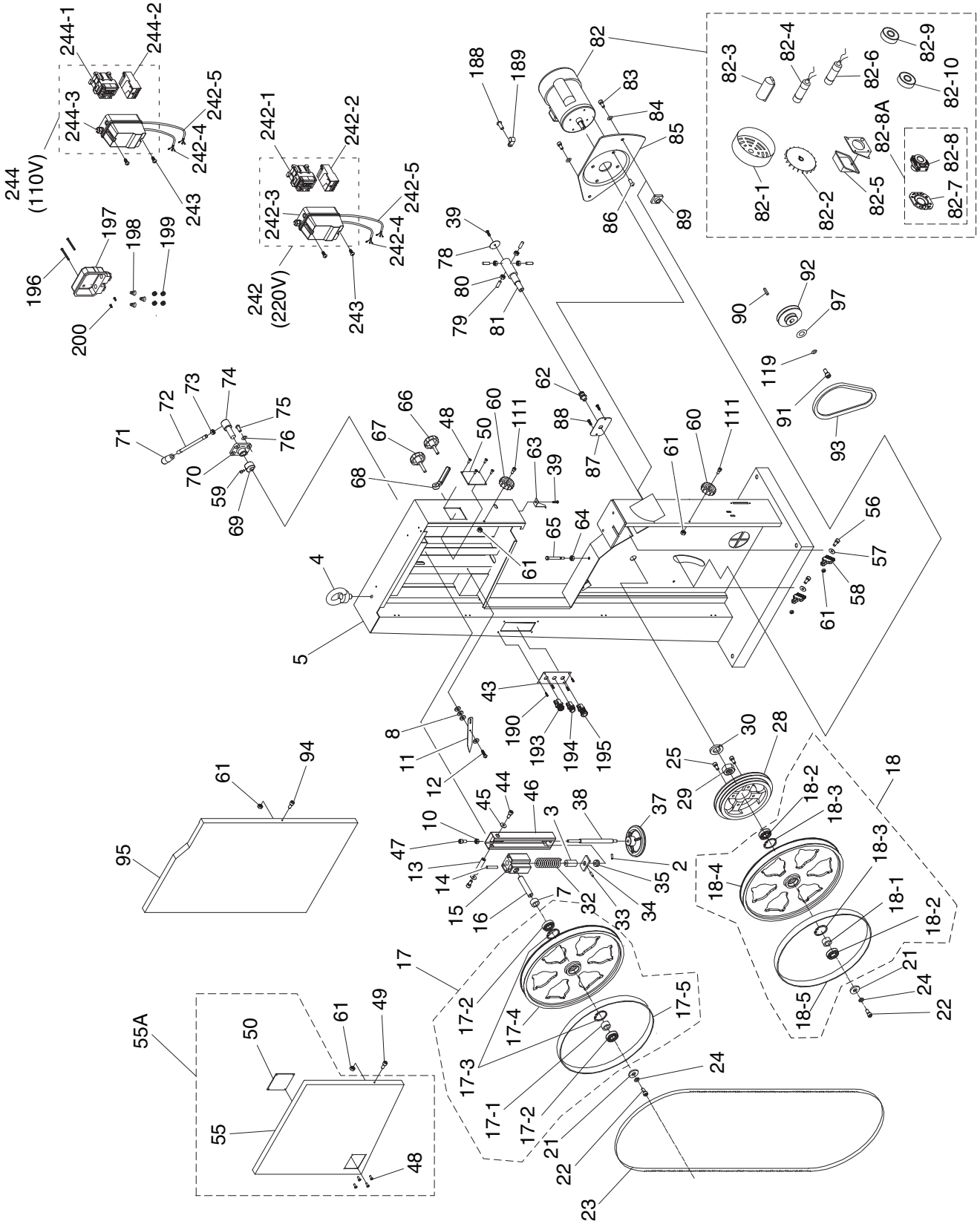
G0513X2F Main



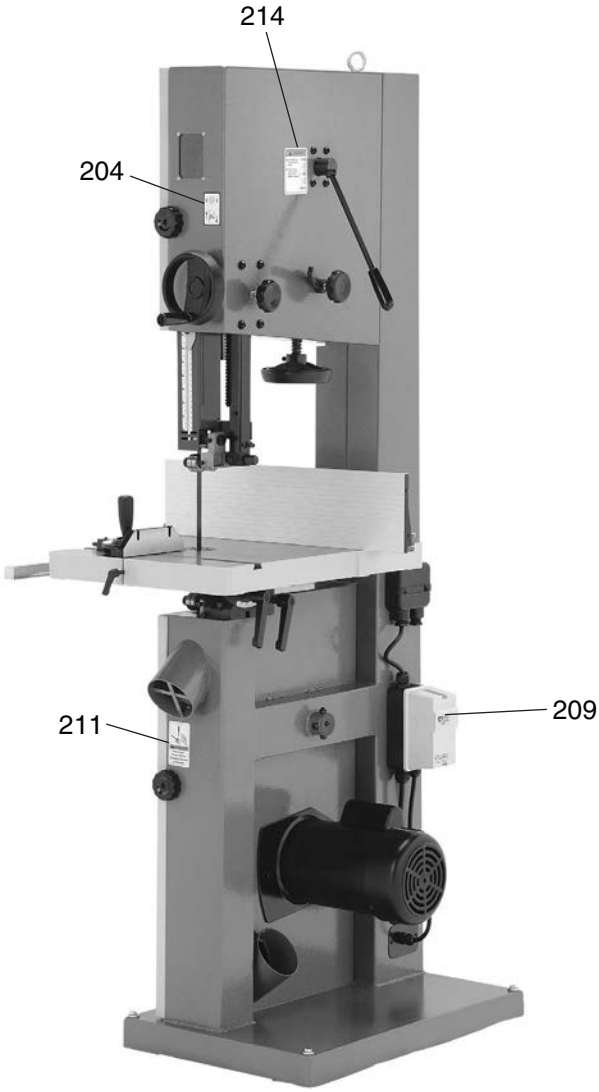
G0513X2F Main Parts List

REF	PART #	DESCRIPTION
2	PSS01M	SET SCREW M6-1 X 10
3	P0513X003	BUSHING
4	P0513004	LIFTING EYE BOLT M10-1.5
5	P0513X2F005	MACHINE BODY
7	P0513X007	BUSHING
8	PW03M	FLAT WASHER 6MM
10	PN01M	HEX NUT M6-1
11	P0513011	POINTER
12	P0513012	STEP SCREW M4-.7 X 5
13	P0513013	HINGE SHAFT
14	PRP10M	ROLL PIN 5 X 36
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513X2B017	UPPER WHEEL ASSEMBLY
17-1	P0513017	BUSHING
17-2	P6204-2RS	BALL BEARING 6204-2RS
17-3	PR25M	INT RETAINING RING 47MM
17-4	P0513X019	UPPER WHEEL 17"
17-5	T23071	URETHANE TIRE 17" 1-PAIR
18	P0513X2B018	LOWER WHEEL ASSEMBLY
18-1	P0513017	BUSHING
18-2	P6204-2RS	BALL BEARING 6204-2RS
18-3	PR25M	INT RETAINING RING 47MM
18-4	P0513X027	LOWER WHEEL 17"
18-5	T23071	URETHANE TIRE, 1-PAIR
21	P0513X021	WHEEL FLAT WASHER 8MM
22	PCAP11M	CAP SCREW M8-1.25 X 16
23	P0513023	SAW BLADE 131.5" X 1/2" 6TPI HOOK
24	PLW04M	LOCK WASHER 8MM
25	PCAP14M	CAP SCREW M8-1.25 X 20
28	P0513X2F028	WHEEL PULLEY/BRAKE DRUM
29	PN32	HEX NUT 1-14
30	PLW09	LOCK WASHER 1"
32	P0513032	COMPRESSION SPRING 7 X 8 X 90
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	ALIGNMENT PLATE
35	P51201	THRUST BEARING 51201
37	P0513037	TENSION HANDWHEEL
38	P0513038	TENSION ADJUSTING ROD
39	PFS07M	FLANGE SCREW M5-.8 X 10
43	P0513X2B031	CONTROL PANEL PLATE
44	PCAP11M	CAP SCREW M8-1.25 X 16
45	PWF08M	FENDER WASHER 8MM
46	P0513046	UPPER WHEEL SLIDING BRACKET
47	PCAP05M	CAP SCREW M8-1.25 X 50
48	PRIV005M	STEEL BLIND RIVET 3 X 13MM
49	PCAP04M	CAP SCREW M6-1 X 10
50	P0513050	CLEAR WINDOW
55A	P0513X2055A	UPPER WHEEL COVER ASSY
55	P0513055	UPPER WHEEL COVER
56	PB10M	HEX BOLT M6-1 X 25
57	PW03M	FLAT WASHER 6MM
58	P0513058	WHEEL BRUSH
59	PCAP06M	CAP SCREW M6-1 X 25
60	P0513060	STAR KNOB
61	PLN03M	LOCK NUT M6-1
62	P0513062	STRAIN RELIEF 16MM STRAIGHT LT
63	P0513063	HEIGHT POINTER
64	PN03M	HEX NUT M8-1.25
65	PB124M	HEX BOLT M8-1.25 X 90
66	P0513066	STAR KNOB BOLT M10-1.5 X 20
67	P0513067	STAR KNOB BOLT M10-1.5 X 55
68	P0513068	THREADED HANDLE M10-1.5
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	HANDLE M12-1.75
72	P0513072	LEVER
73	PN09M	HEX NUT M12-1.75
74	P0513074	LEVER HUB
75	PBHS01M	BUTTON HD CAP SCR M8-125 X 20
76	PLW04M	LOCK WASHER 8MM
78	P0513078	SHAFT COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513X2F081	LOWER WHEEL SHAFT
82	P0513082V2	MOTOR 2HP 110V/220V 1-PH
82-1	P0513082-1V2	MOTOR FAN COVER
82-2	P0513082-2V2	MOTOR FAN
82-3	P0513082-4V2	CAPACITOR COVER
82-4	PC040G	R CAPACITOR 40M 250V 1-3/8 X 2-5/8
82-5	P0513082-7V2	MOTOR JUNCTION BOX
82-6	PC300T	S CAPACITOR 300M 250V 1-1/2 X 2-3/8
82-7	PCP001	CONTACT PLATE 5/8
82-8A	P0513082-9A	CENTRIFUGAL SWITH W/CONT PLATE
82-8	PCS001	CENTRIFUGAL SWITCH 5/8-1725
82-9	P6205ZZ	BALL BEARING 6205ZZ
82-10	P6203ZZ	BALL BEARING 6203ZZ
83	PB32M	HEX BOLT M10-1.5 X 25
84	PLW06M	LOCK WASHER 10MM
85	P0513085	MOTOR MOUNT BRACKET
86	PBHS01M	BUTTON HD CAP SCR M8-125 X 20
87	P0513X2B087	STRAIN RELIEF PLATE 1-HOLE
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	PB81M	HEX BOLT M8-1.25 X 20 LH
92	P0513092	MOTOR PULLEY TYPE-A 3.5"
93	PVA42	V-BELT A42
94	PCAP04M	CAP SCREW M6-1 X 10
95	P0513095	LOWER WHEEL COVER
97	PWF08M	FENDER WASHER 8MM
111	PCAP02M	CAP SCREW M6-1 X 20
119	PW05M	FLAT WASHER 4MM
188	PFS07M	FLANGE SCREW M5-.8 X 10
189	P0513X2F189	CORD CLIP 5/16"
190	PHTEK15M	TAP SCREW M4 X 10

G0513X2F Main Parts List

REF	PART #	DESCRIPTION
193	P0513X2F193	KEY SWITCH
194	P0513X2B041	START BUTTON
195	P0513X2B040	STOP BUTTON
196	PFS09M	FLANGE SCREW M5-.8 X 50
197	P0513X2F197	JUNCTION BOX
198	PWRN01	WIRE NUT 14-22G
199	PTLW02M	EXT TOOTH WASHER 5MM
200	PS38M	PHLP HD SCR M4-.7 X 10
242	P0513X2F242	MAG SWITCH ASSY 220V MPE-09
242-1	P0513X2F242-1	CONTACTOR SDE MA-09 220-240V
242-2	P0513X2F242-2	OL RELAY SDE RA-20 8-12A
242-3	P0513X2F242-3	MAG SWITCH COVER ASSEMBLY
242-4	P0513X2F242-4	CONTROL CORD 16G 3W
242-5	P0513031	MOTOR CORD 14G 3W
243	PS09M	PHLP HD SCR M5-.8 X 10
244	P0513X2F244	MAG SWITCH ASSY 110V MPE-18
244-1	P0513X2F244-1	CONTACTOR SDE MA-18 110V
244-2	P0513X2F244-2	OL RELAY SDE RA-30 18-26A
244-3	P0513X2F244-3	MAG SWITCH COVER ASSEMBLY

G0513X2F Labels



REF	PART #	DESCRIPTION
201	P0513X2F201	MODEL NUMBER LABEL
202	G8589	GRIZZLY NAMEPLATE- LARGE
203	PLABEL-20	DON'T OPEN DOOR LABEL
204	P0513X204	GUARD ADJUSTMENT LABEL
205	P0513X205	SCALE DIRECTIONS LABEL
206	PLABEL-11	SAFETY GLASSES LABEL
207	PLABEL-19	HANDS/BLADE HAZARD LABEL

REF	PART #	DESCRIPTION
208	PLABEL-12	READ MANUAL LABEL
209	PLABEL-14	ELECTRICITY LABEL
211	PLABEL-18	UNPLUG/DOOR HAZARD LABEL
213	PPAINT-11	PUTTY TOUCH-UP PAINT
214	P0513X214	TENSION ADJUSTMENT LABEL
215	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
216	P0513X2F216	MACHINE ID LABEL

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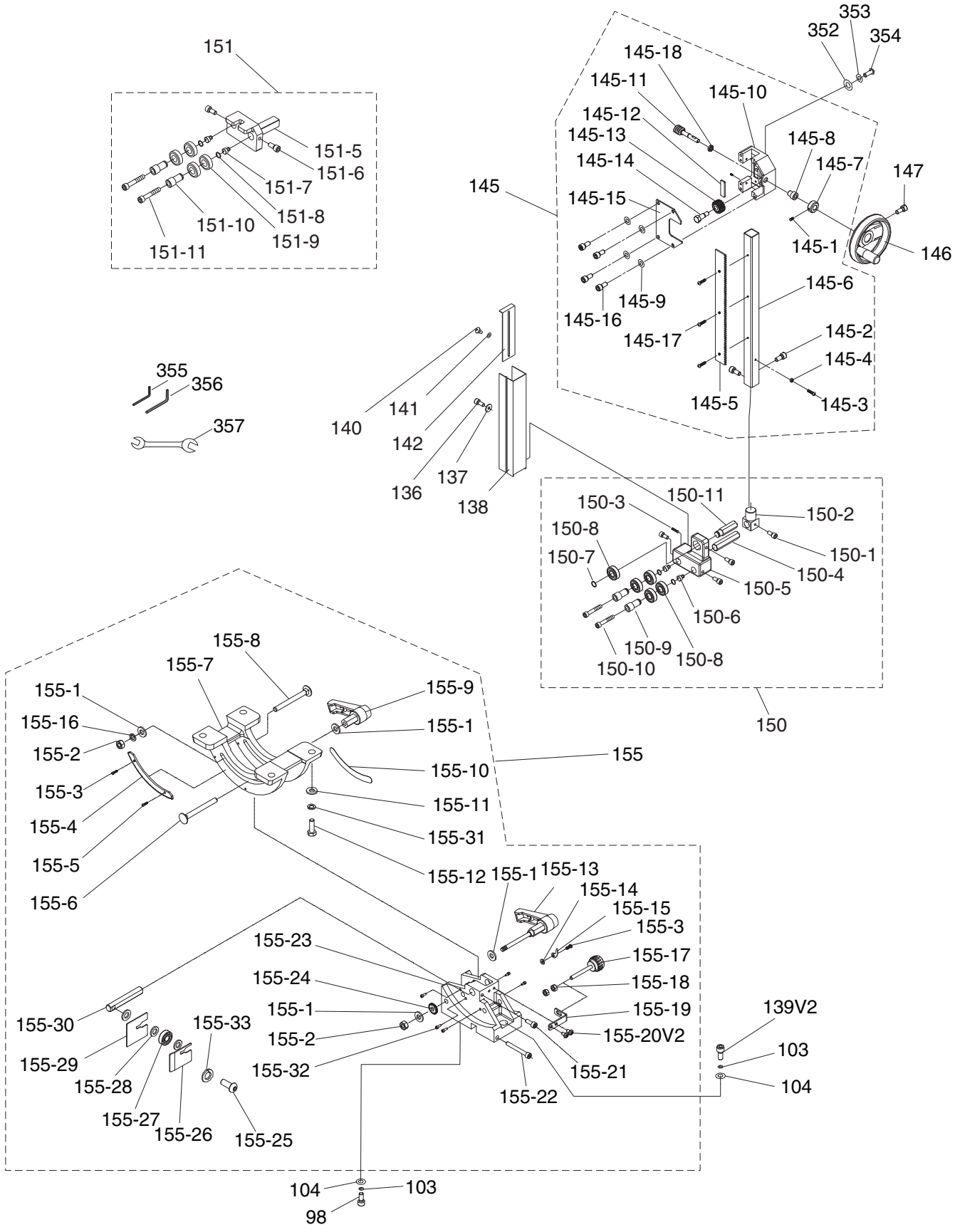
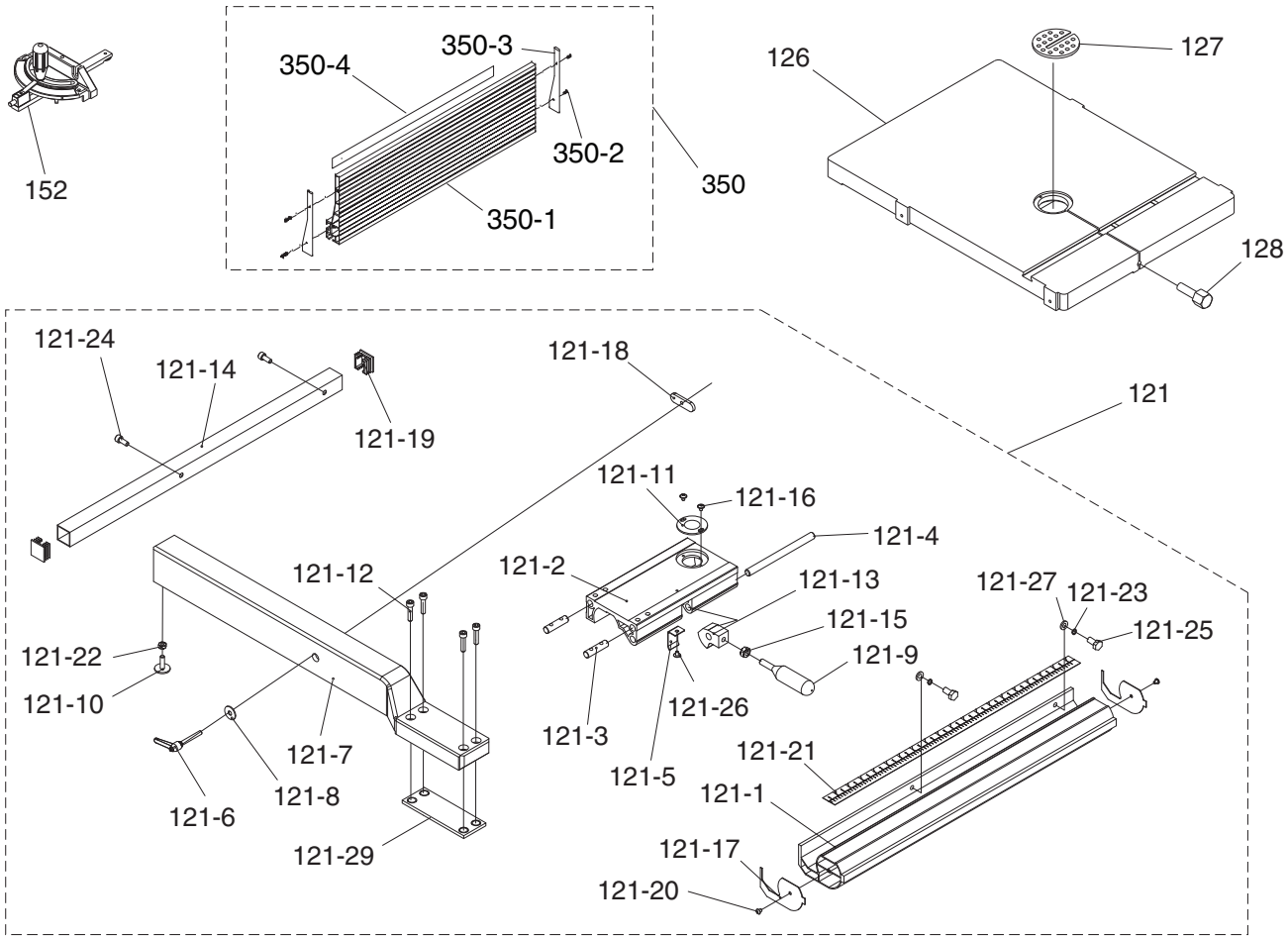
G0513X2, G0513X2B, G0513X2BF, & G0513X2F Guides & Trunnions



G0513X2, G0513X2B, G0513X2BF, & G0513X2F Guides & Trunnions Parts List

REF	PART #	DESCRIPTION
98	PCAP84M	CAP SCREW M10-1.5 X 35
103	PLW06M	LOCK WASHER 10MM
104	PW04M	FLAT WASHER 10MM
136	PCAP50M	CAP SCREW M5-.8 X 10
137	PW02M	FLAT WASHER 5MM
138	P0513138	UPPER BLADE GUARD
139V2	PCAP84M	CAP SCREW M10-1.5 X 35
140	P0513012	STEP SCREW M4-.7 X 5
141	P0513141	FIBER WASHER 5MM
142	P0513142	SLIDING PLATE
145	P0513157A	GUIDE POST ASSEMBLY
145-1	PSS07M	SET SCREW M5-.8 X 5
145-2	PCAP01M	CAP SCREW M6-1 X 16
145-3	PS38M	PHLP HD SCR M4-.7 X 10
145-4	PN04M	HEX NUT M4-.7
145-5	P0513156	RACK
145-6	P0513157	GUIDE POST
145-7	P0513160	LOCK COLLAR
145-8	P0513161V2	THREADED BUSHING V2.06.09
145-9	PLW04M	LOCK WASHER 8MM
145-10	P0513164V2	THREADED GUIDE BRACKET 14MM V2.06.09
145-11	P0513165	WORM CYLINDER
145-12	P0513166	FIXED PLATE
145-13	P0513167	PINION GEAR 15T
145-14	P0513168	PINION GEAR STEP BOLT
145-15	P0513169	BRACKET COVER
145-16	PCAP11M	CAP SCREW M8-1.25 X 16
145-17	PFH31M	FLAT HD SCR M4-.7 X 8
145-18	P0513174	BUSHING
146	P0513158	GUIDE POST HANDWHEEL
147	PCAP02M	CAP SCREW M6-1 X 20
150	P0513X150	UPPER BLADE GUIDE ASSEMBLY
150-1	PCAP01M	CAP SCREW M6-1 X 16
150-2	P0513X150-2	UPPER GUIDE SUPPORT BLOCK
150-3	PSS01M	SET SCREW M6-1 X 10
150-4	P0513X150-4	ADJUSTMENT BAR
150-5	P0513X150-5	UPPER BLADE GUIDE SUPPORT
150-6	P0513X150-6	ECCENTRIC SHAFT
150-7	PR05M	EXT RETAINING RING 15MM
150-8	P6202ZZ	BALL BEARING 6202ZZ
150-9	P0513X150-9	HANDLE BUSHING
150-10	PCAP48M	CAP SCREW M6-1 X 35
150-11	P0513X150-11	UPPER SPACING SHAFT
151	P0513X151	LOWER BLADE GUIDE ASSEMBLY
151-5	P0513X151-5	LOWER BLADE GUIDE SUPPORT
151-6	PCAP01M	CAP SCREW M6-1 X 16
151-7	P0513X151-7	ECCENTRIC SHAFT
151-8	PR05M	EXT RETAINING RING 15MM
151-9	P6202ZZ	BALL BEARING 6202ZZ
151-10	P0513X151-10	HANDLE BUSHING
151-11	PCAP48M	CAP SCREW M6-1 X 35
155	H8193	CAST IRON TRUNNION ASSEMBLY
155-1	PW01M	FLAT WASHER 8MM
155-2	PLN04M	LOCK NUT M8-1.25
155-3	PS17M	PHLP HD SCR M4-.7 x 6
155-4	P0513115	GEAR PLATE
155-5	PFH27M	FLAT HD SCR M4-.7 X 6
155-6	PCB10M	CARRIAGE BOLT M8-1.25 X 85
155-7	P0513X2162	CAST IRON TRUNNION
155-8	PCB23M	CARRIAGE BOLT M8-1.25 X 80
155-9	P0513118	LOCK HANDLE M8-1.25
155-10	P0513X2165	TABLE TILT SCALE
155-11	PW01M	FLAT WASHER 8MM
155-12	PB07M	HEX BOLT M8-1.25 X 25
155-13	P0513118	LOCK HANDLE M8-1.25
155-14	PW05M	FLAT WASHER 4MM
155-15	P0513120	POINTER
155-16	PLW04M	LOCK WASHER 8MM
155-17	P0513109	ADJUSTMENT KNOB BOLT M6-1
155-18	PN01M	HEX NUT M6-1
155-19	P0513X2174	L-BRACKET
155-20V2	PFH30M	FLAT HD SCR M5-.8 X 8
155-21	PCAP01M	CAP SCREW M6-1 X 16
155-22	PCAP37M	CAP SCREW M6-1 X 50
155-23	P0513X2178	TRUNNION SUPPORT BRACKET
155-24	P0513100	TRUNNION GEAR
155-25	PBHS19M	BUTTON HD CAP SCR M10-1.5 X 30
155-26	P0513X2181	RIGHT GUARD
155-27	P6000ZZ	BALL BEARING 6000ZZ
155-28	PW04M	FLAT WASHER 10MM
155-29	P0513X2184	LEFT GUARD
155-30	P0513X2185	ADJUSTMENT ROD
155-31	PLW04M	LOCK WASHER 8MM
155-32	PCAP97M	CAP SCREW M5-.8 X 6
155-33	PLW06M	LOCK WASHER 10MM
352	PW01M	FLAT WASHER 8MM
353	PLW04M	LOCK WASHER 8MM
354	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
355	PAW05M	HEX WRENCH 5MM
356	PAW08M	HEX WRENCH 8MM
357	PWR1013	WRENCH 10 X 13 OPEN-END

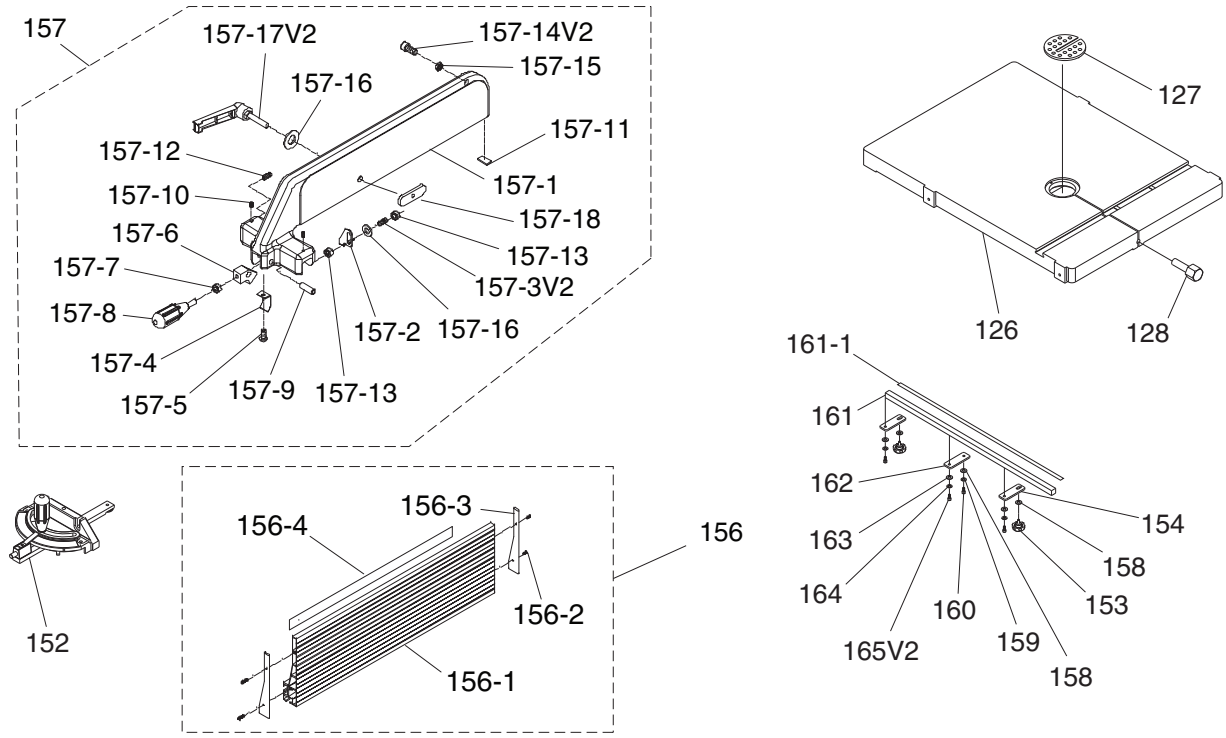
G0513X2 & G0513X2F Fence Assembly & Table



REF	PART #	DESCRIPTION
121	H7588	FENCE ASSEMBLY
121-1	PH7588001	FRONT RAIL 640MM
121-2	PH7587002	ADJUST BASE
121-3	PH7587003	FIXED SHAFT
121-4	PH7587004	SHAFT
121-5	PH7587005	SPRING PIECE
121-6	PH7528004	LOCK KNOB M8-1.25 X 44
121-7	PH7588007	CAST IRON FENCE 590MM
121-8	PW01M	FLAT WASHER 8MM
121-9	PH7587009	FENCE HANDLE M8-1.25 X 22
121-10	PH7587010	RAIL PAD
121-11	PH7587011	CONVEX WINDOW
121-12	PCAP69M	CAP SCREW M6-1 X 24
121-13	PH7587013	LOCK BLOCK
121-14	PH7588014	REAR RAIL 640MM
121-15	PN03M	HEX NUT M8-1.25
121-16	PFS04M	FLANGE SCREW M4-.7 X 6
121-17	PH7587017	GUARD PIECE
121-18	PH7528002	MOVING PLATE

REF	PART #	DESCRIPTION
121-19	PH7587019	PLUG
121-20	PHTEK3M	TAP SCREW M3.5 X 8
121-21	PH7587021	FENCE SCALE 18-1/2"
121-22	PN01M	HEX NUT M6-1
121-23	PLW03M	LOCK WASHER 6MM
121-24	PCAP01M	CAP SCREW M6-1 X 16
121-25	PB08M	HEX BOLT M6-1 X 20
121-26	PFB13M	FLANGE BOLT M4-.7 X 8
121-27	PW03M	FLAT WASHER 6MM
121-29	PH7587029	SPACER PLATE
126	P0513X126	TABLE 17" X 24"
127	T24384	TABLE INSERT
128	P0555100	TABLE PIN
152	P0513173	MITER GAUGE ASSY
350	P0513X2F350	RESAW FENCE ASSEMBLY
350-1	P0513X2F350-1	ALUMINUM RESAW FENCE 590MM
350-2	P0636X122	TAP SCREW 3.5 X 8
350-3	P0513X2B156-3	FENCE END PLATE 148 X 22 X 1
350-4	P0513X2F350-4	RESAW FENCE SCALE

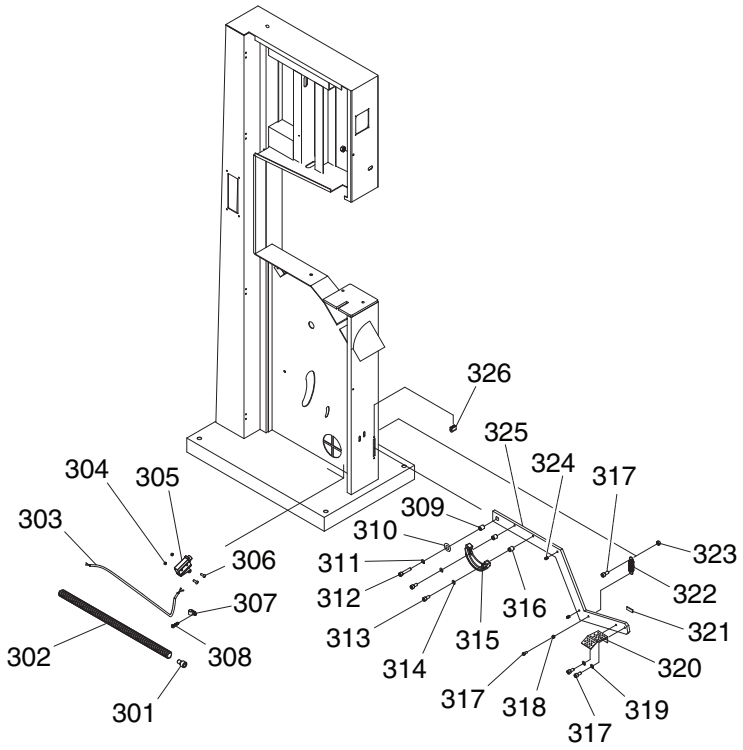
G0513X2B & G0513X2BF Fence Assembly & Table



REF	PART #	DESCRIPTION
126	P0513X2B126	TABLE 17" X 24"
127	T24384	TABLE INSERT
128	P0513X128	TABLE PIN
152	P0513173	MITER GAUGE ASSY
153	P0513X2B153	KNOB SCREW M8-1.25 X 20
154	P0513X2B154	OUTER RAIL PLATE
156	P0513X2B156	RESAW FENCE ASSEMBLY
156-1	P0513X2B156-1	ALUMINUM RESAW FENCE 590MM
156-2	P0636X122	TAP SCREW 3.5 X 8
156-3	P0513X2B156-3	FENCE END PLATE 148 X 22 X 1
156-4	P0513X2B156-4	RESAW FENCE SCALE
157	P0513X2B157	FENCE ASSEMBLY
157-1	P0513X2B157-1	FENCE
157-2	P0513X2B157-2	POINTER
157-3V2	PSS21M	SET SCREW M8-1.25 X 25
157-4	P0513X2B157-4	SPRING PIECE
157-5	PFS17M	FLANGE SCREW M4-.7 X 8
157-6	P0513X2B157-6	PIVOT BLOCK
157-7	PN03M	HEX NUT M8-1.25
157-8	P0513X2B157-8	FENCE LOCK HANDLE

REF	PART #	DESCRIPTION
157-9	P0513X2B157-9	SHAFT
157-10	P0513X2B157-10	PLASTIC SET SCREW M7-1 X 10
157-11	P0513X2B157-11	NYLON PAD
157-12	PSS14M	SET SCREW M8-1.25 X 12
157-13	PN03M	HEX NUT M8-1.25
157-14V2	PB09M	HEX BOLT M8-1.25 X 20
157-15	PN03M	HEX NUT M8-1.25
157-16	PW01M	FLAT WASHER 8MM
157-17V2	P0513X2B157-17V2	LOCK HANDLE M8-1.25 X 45 V2.05.11
157-18	P0513X2B157-18	MOVING PLATE
158	PW01M	FLAT WASHER 8MM
159	PLW04M	LOCK WASHER 8MM
160	PCAP14M	CAP SCREW M8-1.25 X 20
161	P0513X2B161	FRONT RAIL
161-1	P0513X2B161-1	FENCE SCALE
162	P0513X2B162	INNER RAIL PLATE
163	PW03M	FLAT WASHER 6MM
164	PLW03M	LOCK WASHER 6MM
165V2	PCAP02M	CAP SCREW M6-1 X 20

G0513X2BF & G0513X2F Foot Brake



REF	PART #	DESCRIPTION
301	P0513X2F222	CONDUIT GROMMET
302	P0513X2F221	FLEXIBLE CONDUIT 1/2" X 42"
303	P0513X2F220	SWITCH CORD 16G 2W
304	PN28	HEX NUT 4MM
305	P0513X2F218	BRAKE SWITCH SHINOZAKI AZ7141
306	PS51M	PHLP HD SCR M4-.7 X 30
307	P0513X2F224	CORD CLIP 5/8"
308	PHTEK4M	TAP SCREW M4 X 8
309	P0513X2F241	BUSHING
310	PW01M	FLAT WASHER 8MM
311	PLW04M	LOCK WASHER 8MM
312	PCAP31M	CAP SCREW M8-1.25 X 25
313	PCAP06M	CAP SCREW M6-1 X 25

REF	PART #	DESCRIPTION
314	PLW03M	LOCK WASHER 6MM
315	P0513X2F236	BRAKE SHOE
316	P0513X2F235	BUSHING
317	PCAP01M	CAP SCREW M6-1 X 16
318	PN01M	HEX NUT M6-1
319	PLW03M	LOCK WASHER 6MM
320	P0513X2F233	BRAKE PEDDLE
321	P0513X2F232	NYLON PAD
322	P0513X2F230	BRAKE EXTENSION SPRING
323	PN01M	HEX NUT M6-1
324	P0513X2F228	STEP BOLT M7-1 X 10 W/BUSHING
325	P0513X2F227	BRAKE LEVER
326	P0513X2F226	RUBBER CLIP

Grizzly Industrial, Inc. 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?

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

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 & 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.