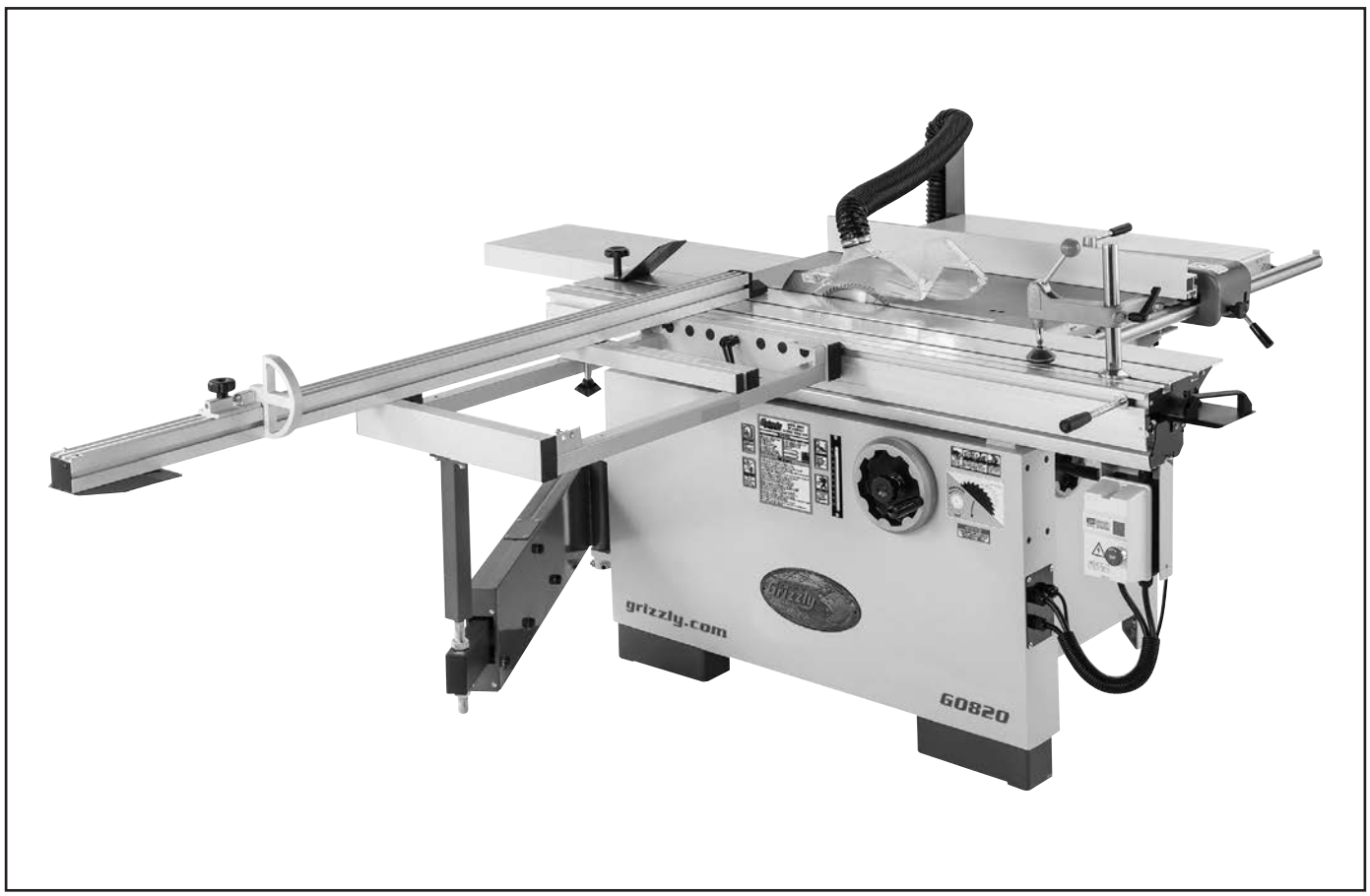
MODEL G0820

12" COMPACT SLIDING TABLE SAW

OWNER'S MANUAL

(For models manufactured since 10/17)



#BL18666 PRINTED IN TAIWAN V2.06.18

⚠ 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

Contact Info

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

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

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

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

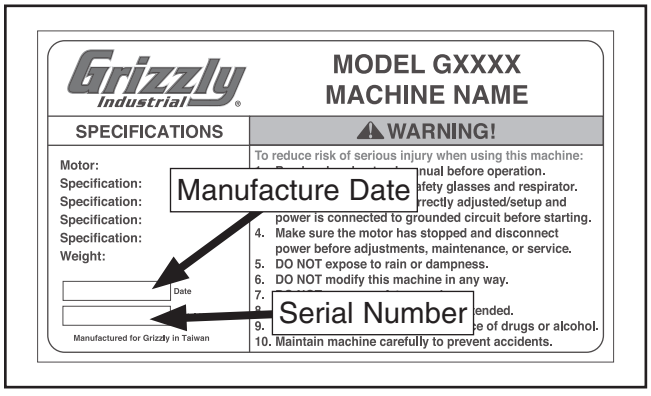
Manual Accuracy

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

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

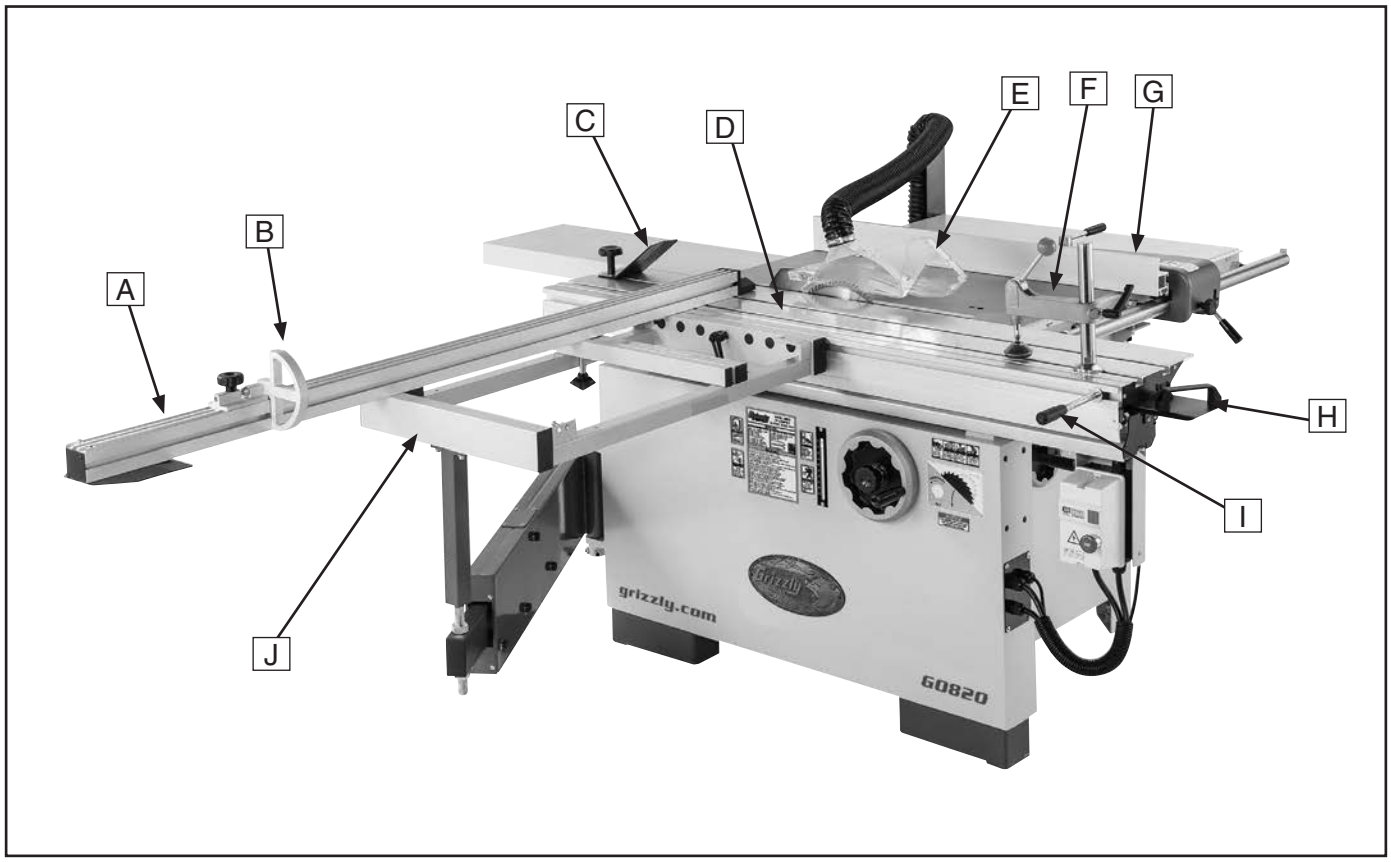
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



A. Crosscut Fence. Used during crosscutting operations to keep panels at 90˚ angle to blade. Features a scale and flip stop.

B. Flip Stop. Used for quick, precise measurements for repeatable cuts when using crosscutting fence.

C. Edge Shoe. Used with hold-down, keeps the other end of workpiece secured to sliding table.

D. Sliding Table. Ball-bearing rollers make it quick and easy to guide large, heavy panels through cut.

E. Blade Guard. Fully enclosed, adjustable blade guard maintains maximum protection around saw blade with a 2½" dust port that effectively extracts dust from cutting operation.

F. Hold-Down. Quickly clamps one end of workpiece to sliding table.

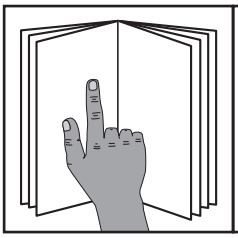
G. Rip Fence. Fully adjustable with micro-adjust knob for precision cuts. Fence face can be positioned for standard cutting operations, or placed in lower position for blade guard clearance during narrow ripping operations.

H. End Plate with Handle. Used to move sliding table during cutting operation.

I. Push Handle. Used to move sliding table during cutting operation.

J. Crosscut Table. Provides a wide, stable platform for supporting full-size panels during crosscutting operations.

Controls & Components



⚠WARNING

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

Refer to **Figures 1–5** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this saw.

Rip Fence

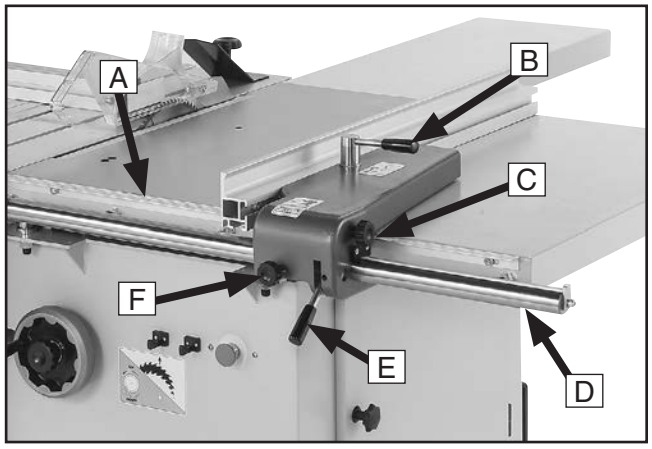


Figure 1. Rip fence controls.

A. Rip Fence Scale. Use scale to measure cut during ripping operations.

B. Slide Lock Handle. Secures aluminum fence face on its forward/backward slide track.

C. Micro-Adjust Knob. Provides precise adjustment of fence. Tighten micro-adjust lock knob to use this feature.

D. Rip Fence Rail. Provides a stable side-to-side path for sliding rip fence assembly toward or away from blade.

E. Rip Fence Lock Handle. Secures rip fence assembly in position along fence rail so workpiece is stable when cutting.

F. Micro-Adjust Lock Knob. Enables use of micro-adjust knob for precise positioning of rip fence.

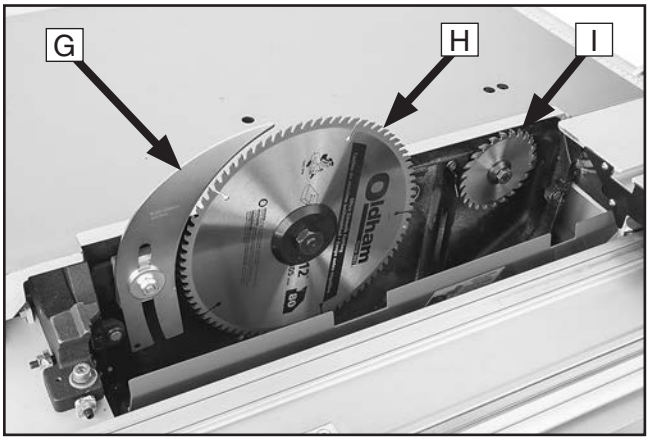


Figure 2. Saw blades and riving knife.

G. Riving Knife. Maintains kerf opening during cutting operations. This function is crucial to preventing kickback caused by the kerf closing behind the blade.

H. Main Blade. Performs the cutting operation.

I. Scoring Blade. Rotates in the opposite direction of the main blade and pre-cuts the surface of the workpiece before the actual cutting operation is performed to reduce tearout or chipping. The scoring blade is adjustable for kerf thickness and alignment with the main blade.

Front Controls

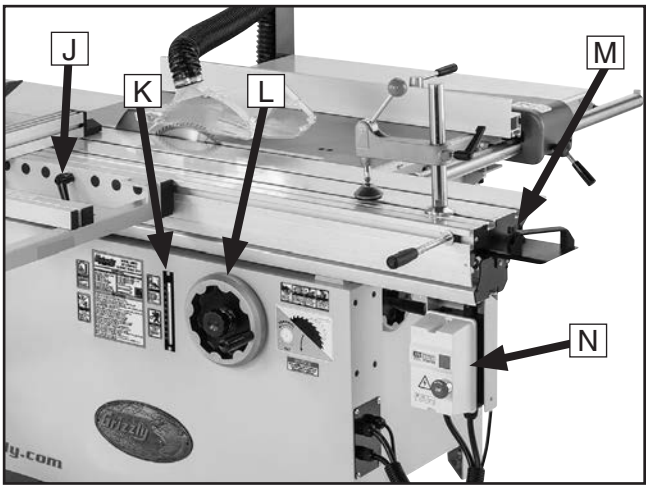


Figure 3. Front controls.

J. Crosscut Table Lock Lever. Secures crosscut table when locked; allows crosscut table to be repositioned along sliding table when unlocked.

K. Tilt Scale. Displays the tilt angle of blades in degrees.

L. Blade Tilt Handwheel. Adjusts the tilt angle of both blades. The lock knob in the center secures the handwheel to prevent blade from moving during operation.

M. Sliding Table Lock Lever. Allows sliding table to be locked in stationary position when turned clockwise; allows sliding table to move horizontally when turned counterclockwise.

N. Magnetic ON/OFF Switch: Green start button turns motor ***ON*** when pressed. Red Emergency Stop button turns motor ***OFF*** when pressed; for safety purposes, this button will remain depressed and prevent restarting until reset. Reset by rotating clockwise until it pops out.

Rear Controls

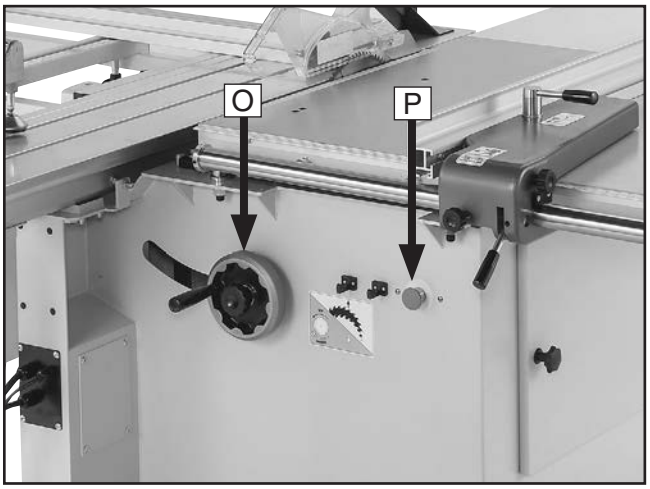


Figure 4. Rear controls.

O. Main Blade Elevation Handwheel. Raises and lowers the main blade. The lock knob in the center secures the handwheel to prevent blade from moving during operation.

P. Rear Emergency Stop Button. Turns motor ***OFF***. Twist clockwise until it pops out to reset.

Scoring Blade Controls

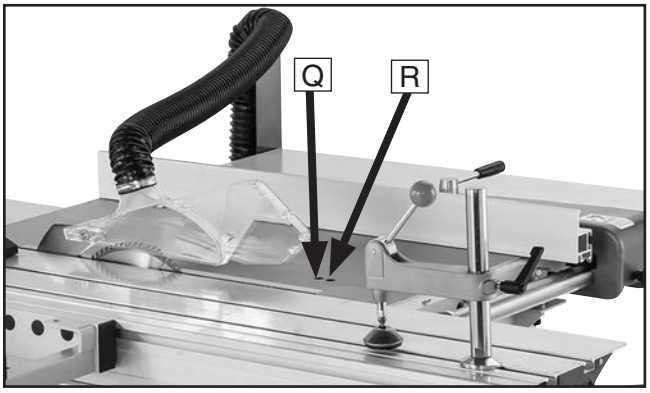


Figure 5. Riving knife controls.

Q. Scoring Blade Elevation Bolt. Raises and lowers the scoring blade to match kerf thickness of main blade using the T-handle wrench.

R. Scoring Blade Alignment Bolt. Adjusts the alignment of scoring blade to the main blade using the T-handle wrench.

Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this sliding table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is VERY important to us at Grizzly!

Arbor: Metal shaft extending from the drive mechanism, to which saw blade is mounted.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

Blade Guard: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

Crosscut: Cutting operation in which the crosscut fence is used to cut across the grain, or across the shortest width of the workpiece.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that cuts a flat bottomed groove into the face of the workpiece.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface.

Kerf: The resulting cut or gap in the workpiece from the saw blade passing through it while cutting.

Kickback: A dangerous event that happens if the blade catches on the workpieces while cutting. The force of the blade then throws the workpiece back toward the operator with what sounds like a horrible explosion. The danger comes from flying stock striking the operator or bystanders. The operator's hands may also be pulled into the blade during the kickback. Refer to **Preventing Kickback** on **Page 13** for additional information.

Non-Through Cut: A sawing operation in which the workpiece is not completely sawn through. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock.

Parallel: When two objects are spaced an equal distance apart at every point along two given lines or planes (i.e. the rip fence face is parallel to the face of the saw blade).

Perpendicular: Lines or planes that intersect and form right angles, i.e. the blade is perpendicular to the table surface.

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece.

Rip Cut: Cutting operation in which the rip fence is used to cut with the grain, or cut across the widest width of the workpiece.

Riving Knife: Metal plate located behind the blade maintains the kerf opening in the wood when cutting, and helps reduce the risk of injury from a kickback that otherwise would result in amputation.

Straightedge: A tool with a perfectly straightedge used to check the flatness, parallelism, or consistency of a surface(s).

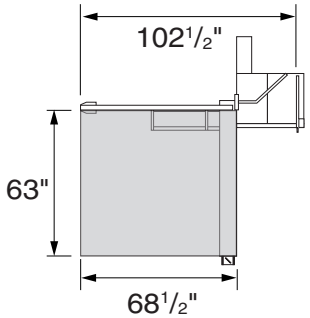
Through Cut: A sawing operation in which the workpiece is completely sawn through.

SLIDING TABLE SAW CAPACITIES

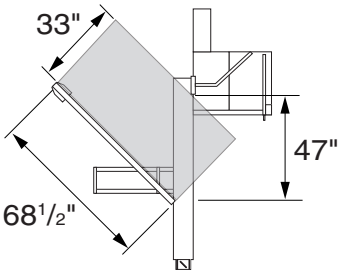
Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0820 12" COMPACT SLIDING TABLE SAW

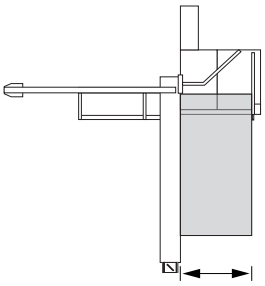
Max Workpiece Length



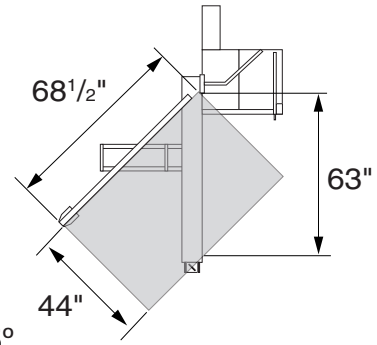
Crosscut



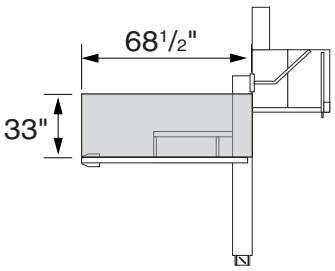
Miter Cut 45°
(push cut)



Ripping Width



Miter Cut 45°



Miter Cut 90°
(push cut)

MACHINE DATA SHEET

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

MODEL G0820 12" COMPACT SLIDING TABLE SAW

Product Dimensions:

Weight	828 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	118 x 90 x 45 in.
Footprint (Length x Width)	35 x 45 in.
Space Required for Full Range of Movement (Width x Depth)	134 x 118 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine & Sliding Table
Weight	996 lbs.
Length x Width x Height	67 x 46 x 45 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	220V or 440V, 3-Phase, 60 Hz
Prewired Voltage	220V
Full-Load Current Rating	20A at 220V, 10A at 440V
Minimum Circuit Size	30A at 220V, 15A at 440V
Connection Type	Cord at 220V, Permanent (Hardwire) at 440V
Power Cord Included	No
Recommended Power Cord	"S"-Type, 4-Wire, 12 AWG, 300 VAC for 220V
Recommended Plug Type	L15-30 for 220V
Switch Type	Magnetic Switch w/Overload Protection

Motors:

Main

Horsepower	7.5 HP
Phase	3-Phase
Amps	20A/10A
Speed	3450 RPM
Type	TEFC Induction
Power Transfer	Belt Drive
Bearings	Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type	N/A

Main Specifications:

Operation Information

Main Blade Size	12 in.
Riving Knife/Spreader Thickness	0.0984 in.
Required Blade Body Thickness	0.087 in.
Required Blade Kerf Thickness	0.118 in.
Main Blade Arbor Size	1 in.
Scoring Blade Size	4-3/4 in.
Scoring Blade Arbor Size	20 mm
Main Blade Tilt	0 – 45 deg.
Main Blade Speed	4000 RPM
Scoring Blade Tilt	0 – 45 deg.
Scoring Blade Speed	8000 RPM

Cutting Capacities

Max Depth of Cut At 90 Deg	3-5/16 in.
Max Depth of Cut At 45 Deg	2-3/8 in.
Rip Fence Max Cut Width	33 in.
Sliding Table w/Crosscut Fence Max Cut Width	68-1/2 in.
Sliding Table w/Crosscut Fence Max Cut Length	63 in.

Table Information

Floor To Table Height	34-1/4 in.
Table Size Length	35-1/4 in.
Table Size Width	21-1/2 in.
Table Size Thickness	2-1/4 in.
Table Size With Ext Wings Length	68 in.
Table Size With Ext Wings Width	40 in.
Table Size With Ext Wings Thickness	2-3/8 in.
Sliding Table Length	63 in.
Sliding Table Width	12-1/4 in.
Sliding Table Thickness	6 in.
Sliding Table T-Slot Top Width	5/8 in.
Sliding Table T-Slot Height	5/8 in.
Sliding Table T-Slot Bottom Width	1-1/4 in.

Fence Information

Crosscut Fence Type	Extruded Aluminum
Crosscut Fence Size Length	73-1/4 in.
Crosscut Fence Size Width	2-3/8 in.
Crosscut Fence Size Height	2-3/8 in.
Rip Fence Size Length	39-3/8 in.
Rip Fence Size Width	2 in.
Rip Fence Size Height	3-1/2 in.

Construction Materials

Table	Cast Iron
Sliding Table	Aluminum
Extension Table	Steel
Cabinet	Steel
Rip Fence	Aluminum
Miter Fence	Aluminum
Rip Fence Rails	Steel
Guard	Plastic
Spindle Bearing Type	Sealed and Permanently Lubricated
Cabinet Paint Type/Finish	Powder Coated

Other Related Information

No of Dust Ports	2
Dust Port Size	2-1/2, 5 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	3 Hours
Serial Number Location	Machine ID Label
Sound Rating	82 dB
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

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 your workshop kid proof!

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Sliding Table Saws

⚠WARNING

Serious injury or death can occur from getting cut or having body parts, such as fingers, amputated by rotating saw blade. Workpieces thrown by kickback can strike operators or bystanders with deadly force. Flying particles from cutting operations or broken blades can cause eye injuries or blindness. To minimize risk of getting hurt or killed, anyone operating machine MUST completely heed hazards and warnings below.

HAND & BODY POSITIONING. Keep hands away from saw blade and out of blade path during operation, so they cannot slip accidentally into blade. Stand to side of blade path. Never reach around, behind, or over blade. Only operate at front of machine.

BLADE GUARD. Use blade guard for all cuts that allow it to be used safely. Make sure blade guard is installed and adjusted correctly. Promptly repair or replace if damaged. Re-install blade guard immediately after operations that require its removal.

RIVING KNIFE. Use riving knife for all cuts. Make sure riving knife is aligned and positioned correctly. Promptly repair or replace it if damaged.

KICKBACK. Kickback occurs when saw blade ejects workpiece back toward operator. Know how to reduce risk of kickback. Learn how to protect yourself if it does occur.

WORKPIECE CONTROL. Feeding workpiece incorrectly increases risk of kickback. Make sure workpiece is in stable position on tables and supported by rip fence or crosscut fence during cutting operation. Never start saw with workpiece touching blade. Allow blade to reach full speed before cutting. Only feed workpiece against direction of main blade rotation. Always use some type of guide to feed workpiece in a straight line. Never back workpiece out of cut or move it backwards or sideways after starting a cut. Feed cuts all the way through to completion. Never perform any operation "freehand". Turn OFF saw and wait until blade is completely stopped before removing workpiece.

FENCE ADJUSTMENTS. Make sure rip fence remains properly adjusted and parallel with blade. Always lock fence before using.

PUSH STICKS/BLOCKS. Use push sticks or push blocks whenever possible to keep your hands farther away from blade while cutting. In event of an accident these devices will often take damage that would have happened to hands/fingers.

BLADE ADJUSTMENTS. Adjusting blade height or tilt during operation increases risk of crashing blade and sending metal fragments flying with deadly force at operator or bystanders. Only adjust blade height and tilt when blade is completely stopped and saw is ***OFF***.

CHANGING BLADES. Always disconnect power before changing blades. Changing blades while saw is connected to power greatly increases injury risk if saw is accidentally powered up.

DAMAGED SAW BLADES. Never use blades that have been dropped or otherwise damaged.

CUTTING CORRECT MATERIAL. Never cut materials not intended for this saw. Only cut natural and man-made wood products, laminate covered wood products, and some plastics. Cutting metal, glass, stone, tile, etc. increases risk of operator injury due to kickback or flying particles.

Preventing Kickback

Do the following to prevent kickback:

- When rip cutting, only cut workpieces that have at least one smooth and straightedge. DO NOT cut excessively warped, cupped or twisted wood. If workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.
- Ensure sliding table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table before cutting.
- Always use the riving knife whenever possible. It reduces risk of kickback and reduces your risk of injury if it does occur.
- Always keep blade guard installed and in good working order.
- Feed cuts through to completion. Any time you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.
- Ensure rip fence is adjusted parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the rip fence before cutting.

⚠WARNING

Statistics show that the most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward the operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some precautions to help protect yourself if kickback DOES occur:

- Stand to the side of the blade path when cutting. If a kickback does occur, the thrown workpiece usually travels directly towards the front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable parts of your body.
- Never, for any reason, place your hand behind the blade path. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick or push block to keep your hands farther away from the moving blade. If a kickback occurs, these safety devices will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to prevent or slow down kickback.

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to 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.

Full-Load Current Rating at 220V ..... 20 Amps
Full-Load Current Rating at 440V ..... 10 Amps

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

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

Circuit Requirements for 220V

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

Nominal Voltage 220V, 230V, 240V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 30 Amps
Plug/Receptacle ..... NEMA L15-30
Cord ..... "S"-Type, 4-Wire, 12 AWG, 300 VAC

Circuit Requirements for 440V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 440V, 480V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 15 Amps
Connection ..... Hardwire with Locking Switch

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

⚠CAUTION

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

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

Grounding Instructions

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.

For 220V operation: The power cord and plug specified under "Circuit Requirements for 220V" on the previous page have an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

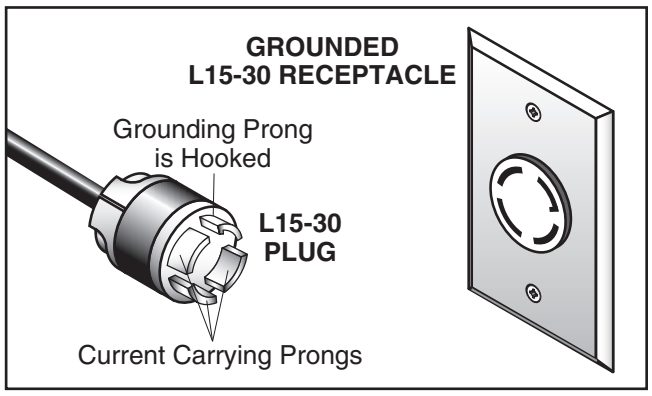


Figure 6. Typical L15-30 plug and receptacle.

For 440V operation: As specified in "Circuit Requirements for 440V" on the previous page, the machine must be hardwired to the power source, using a locking switch as a disconnecting means (see below). The machine must also be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. Due to the complexity and high voltage involved, this type of installation MUST be done by a qualified electrician.

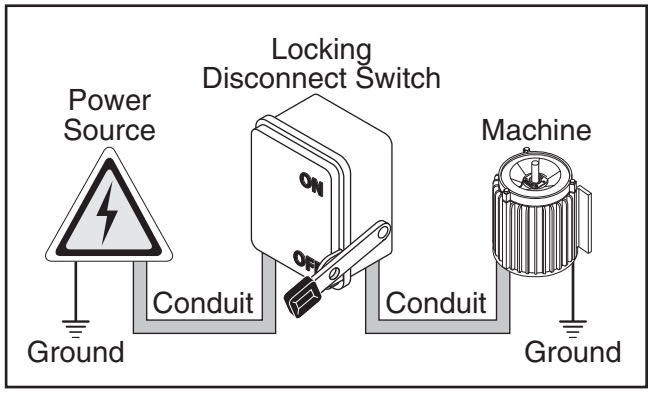


Figure 7. Typical hardwire setup with a locking disconnect switch.

WARNING

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

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

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

Extension Cords (220V Only)

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

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

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

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

NOTICE

Avoid using static phase converter to supply 3-Phase power, as it could damage or decrease life of sensitive electrical components. If you must use a phase converter, only use a rotary phase converter that is sized at least 50% larger than largest HP rating of this machine.

440V Conversion

The Model G0820 can be converted from 220V to 440V operation using the optional part #P08200084. This can be purchased from the Grizzly Order desk at (800) 523-4777. This conversion consists of: 1) Disconnecting the saw from the power source, 2) moving the fuse to the 440V holder, 3) replacing the magnetic switch overload relay, and 4) rewiring the motor junction box for 440V operation. Refer to **Page 83** for the detailed 440V wiring diagram.

All wiring changes must be done by an electrician or qualified service personnel before the saw is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

Before performing the conversion procedure, we recommend setting the blade to 0° and raising it all the way up to create clearance under the motor junction box for rewiring.

To convert G0820 for 440V operation:

1. DISCONNECT MACHINE FROM POWER!

2. Remove magnetic switch cover (see **Figure 8**).

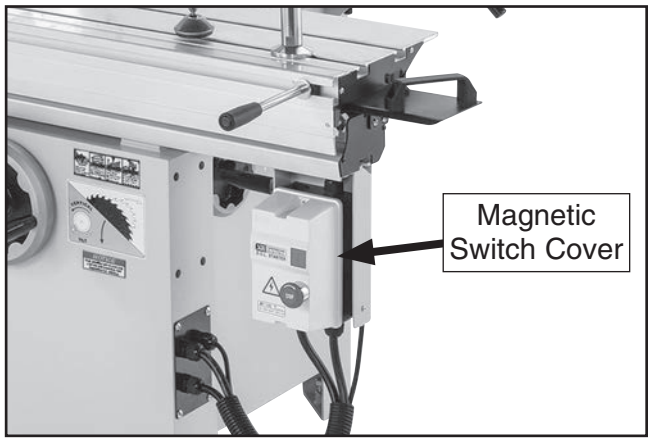


Figure 8. Location of magnetic switch cover.

3. Remove fuse from "220V" holder and insert it into "440V" holder (see illustration in **Figure 9**).

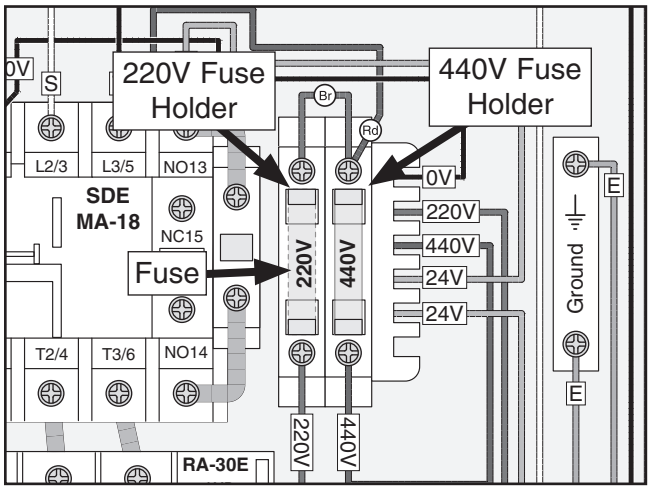


Figure 9. Moving fuse to "440V" fuse holder.

4. Remove overload relay for 220V and replace with overload relay from 440V Conversion Kit. Set amperage dial to 10A (see **Figure 10**).

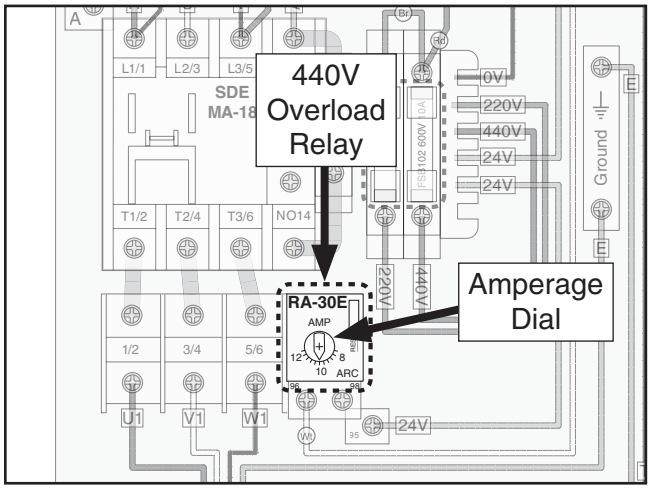


Figure 10. Overload relay for 440V Conversion Kit installed and set for specified trip current.

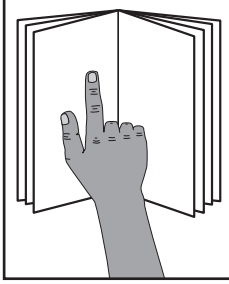
5. Open cabinet door on back of saw and remove motor junction box cover.

6. Rewire motor according to wiring diagram on **Page 83**.

7. Re-install motor junction box cover and close cabinet door.

8. After **Setup** and **Assembly** procedures are completed, connect machine to power, as instructed on **Page 34**.

SECTION 3: SETUP

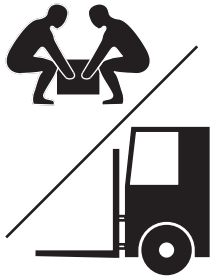


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

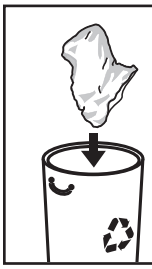
The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Additional People	2
• Safety Glasses (for each person)	1
• Cleaner/Degreaser (**Page 21**)	As Needed
• Disposable Shop Rags	As Needed
• Prybar	1
• Forklift (Rated for at least 1200 lbs.)	1
• Straightedge 4'	1
• Level	1
• Open-End Wrench 10mm	1
• Open-End Wrench 17mm	1
• Open-End Wrench 24mm	1
• Hex Wrench 3, 4, 5, 6, 8mm	1 Ea
• Dust Collection System w/5" Branch Line	1
• Dust Hose & Hose Clamp 5"	1 Ea
• Y-Fitting 2½" x 5" x 5"	1

Unpacking

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

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



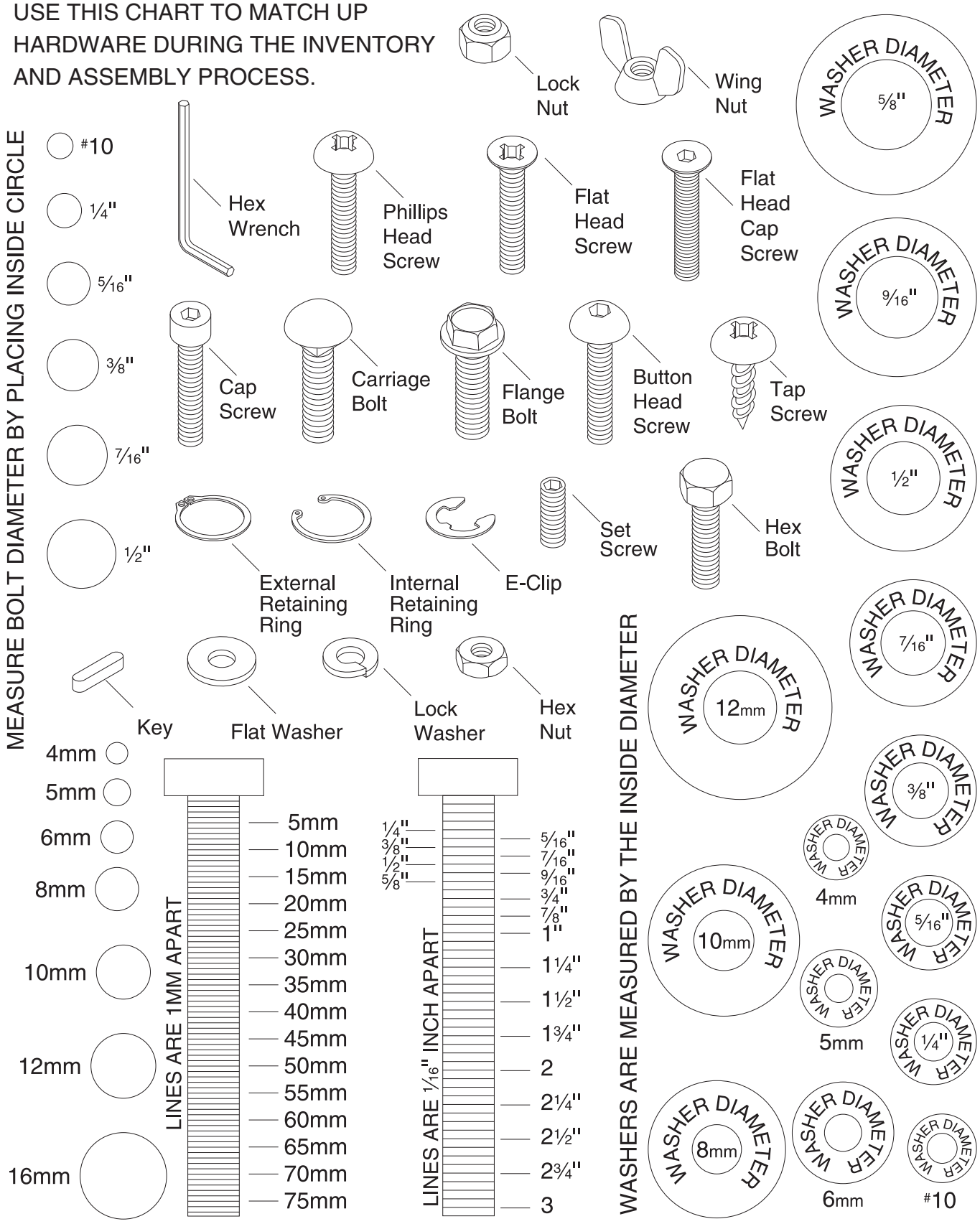
⚠WARNING

SUFFOCATION HAZARD!

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

Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE INVENTORY AND ASSEMBLY PROCESS.



Inventory

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

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

NOTICE

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

Inventory (Figure 11)		Qty
A.	Small Extension Table	1
B.	Large Extension Table	1
C.	Crosscut Table	1
D.	Rip Fence Rail w/Fasteners	1
E.	Crosscut Fence Assembly	1
F.	Rip Fence	1
G.	Rip Fence Scale	1

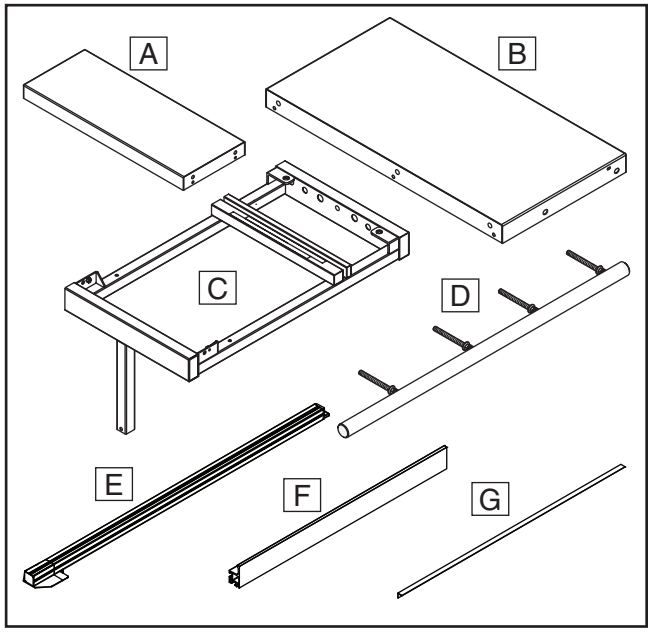


Figure 11. G0820 Inventory 1.

Inventory (Figure 12)		Qty
H.	Rip Fence Base	1
I.	Push Handle	1
J.	Flip Stop	1
K.	Push Stick	1
L.	Edge Shoe Assembly	1
M.	Hold-Down Assembly	1
N.	Splitter/Riving Knife	1
O.	Blade Guard	1
P.	Riving Knife (Toolbox)	1
Q.	End Plate	1
R.	End Cover	1
S.	End Cap	1
T.	Arbor Wrench (Toolbox)	1
U.	Combo Wrench 17/19mm (Toolbox)	2
V.	Combo Wrench 30mm (Toolbox)	2
W.	T-Handle Wrench 8mm (Toolbox)	1
X.	Toolbox	1

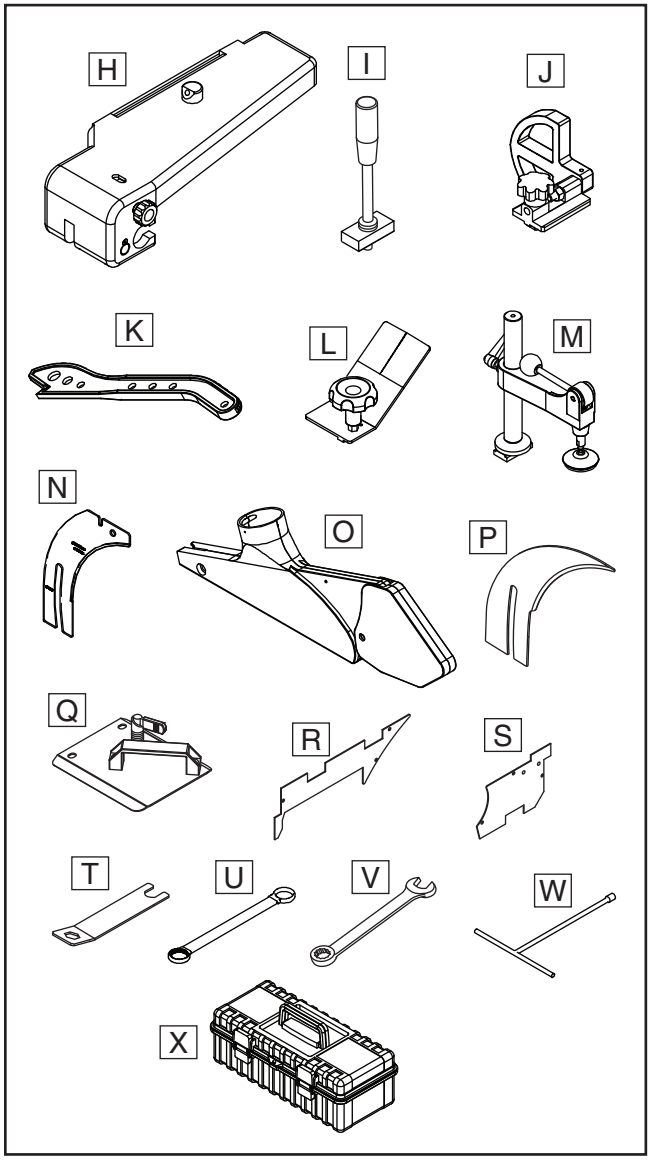


Figure 12. G0820 Inventory 2.

Inventory (Figure 13) **Qty**

Y. Lock Handles M10-1.5 x 12 2
Z. Lock Knob Bolt M10-1.5 x 55 1
AA. Rip Fence Stop Ring w/Set Screw 1
AB. Rip Fence End Stop 1
AC. Adjustable Lock Handle M12-1.75 x 55 1
AD. T-Nut Plate M12-1.75 1
AE. T-Nuts M8-1.25 2
AF. 0° Stop Block 1
AG. T-Bolt M8-1.25 x 60 1
AH. Pivot Bolt M8-1.25 1
AI. Long Knob M8-1.25 1
AJ. Knob Bolt M8-1.25 x 50 1
AK. Hose Clamps 2½" 2
AL. Dust Hose Support 1

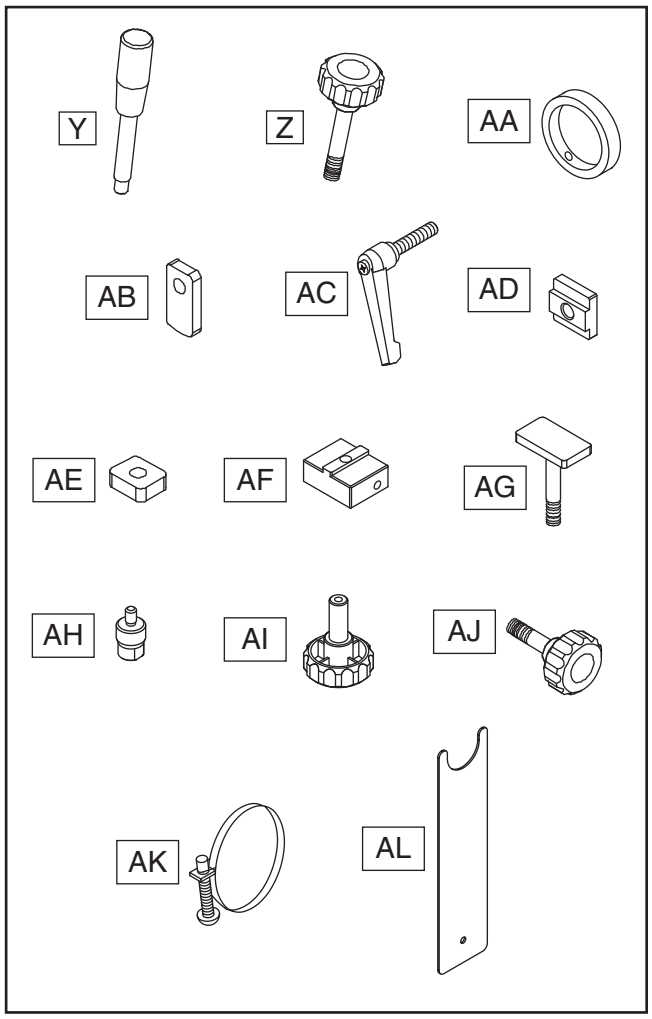


Figure 13. G0820 Inventory 3.

Fasteners (see Hardware Recognition Chart)

Hex Bolt M16-2 x 40 (Stand) 4
Hex Nut M16-2 (Stand) 4

B.H. Cap Screws M6-1 x 20 (End Plate) 2
Flat Washers 6mm (End Plate) 4
Lock Washers 6mm (End Plate) 2
Hex Nut M6-1 (End Plate) 2

Cap Screws M10-1.5 x 25 (Large Ext. Table) 3
Lock Washers 10mm (Large Ext. Table) 3
Flat Washers 10mm (Large Ext. Table) 3
Set Screws M10-1.5 x 20 (Large Ext. Table) 3
Hex Nuts M10-1.5 (Large Ext. Table) 3

Cap Screws M10-1.5 x 25 (Small Ext. Table) 2
Lock Washers 10mm (Small Ext. Table) 2
Flat Washers 10mm (Small Ext. Table) 2
Set Screws M10-1.5 x 20 (Small Ext. Table) 2
Hex Nuts M10-1.5 (Small Ext. Table) 2

B.H. Cap Screws M6-1 x 12 (Rip Fence Scale) 3
Flat Washers 6mm (Rip Fence Scale) 4
Hex Nut M6-1 (Rip Fence Scale) 1
Cap Screw M8-1.25 x 15 (Rip Fence Rail) 1
Lock Washer 8mm (Rip Fence Rail) 1

Cap Screw M8-1.25 x 35 (Crosscut Fence) 1
Lock Washer 8mm (Crosscut Fence) 1
Flat Washer 8mm Fiber (Crosscut Fence) 1

Flat Washer 12mm (Crosscut Table) 1
Fender Washer 8mm (Crosscut Table) 1
Hex Nuts M8-1.25 (Crosscut Table) 2
Flat Washer 8mm (Crosscut Table) 1

Cap Screw M10-1.5 x 25 (Blade Guard) 1
Lock Nut M10-1.5 (Blade Guard) 1

Cap Screw M10-1.5 x 20 (Dust Hose) 1
Flat Washer 10mm (Dust Hose) 1
Lock Nut M10-1.5 (Dust Hose) 1

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.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

NOTICE

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

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Figure 14. T23692 Orange Power Degreaser.

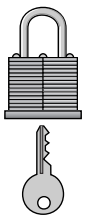
Site Considerations

Weight Load

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

Space Allocation

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



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

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

Electrical Installation

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

Lighting

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

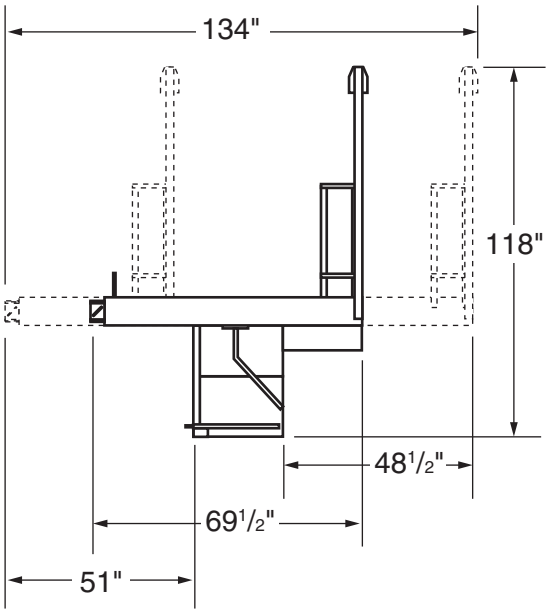
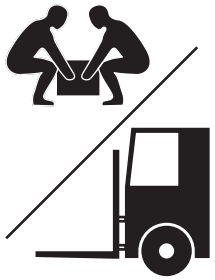


Figure 15. Minimum working clearances.

Lifting & Placing



⚠WARNING

HEAVY LIFT!

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

To lift and place saw:

1. Position crate as close to installation location as possible.

2. Remove top of crate. Position forklift forks as wide as possible while still fitting under center opening (see **Figure 16**).

Figure 16. How to insert forks for lifting table saw off pallet.

3. Remove small items packed around saw and unbolt saw from pallet.

⚠WARNING

DO NOT lift saw any higher than necessary to clear pallet. Serious personal injury and machine damage may occur if safe moving methods are not followed.

4. With an assistant holding each end to help stabilize load, lift saw with forklift just high enough to clear pallet, and move it to your predetermined location.

5. Lower saw onto ground and back forklift away.

6. Place level on cast-iron table.

7. If not already installed, thread (1) M16-2 hex nut onto each M16-2 x 40 hex bolt, then thread each bolt into stand corners (see **Figure 17**).

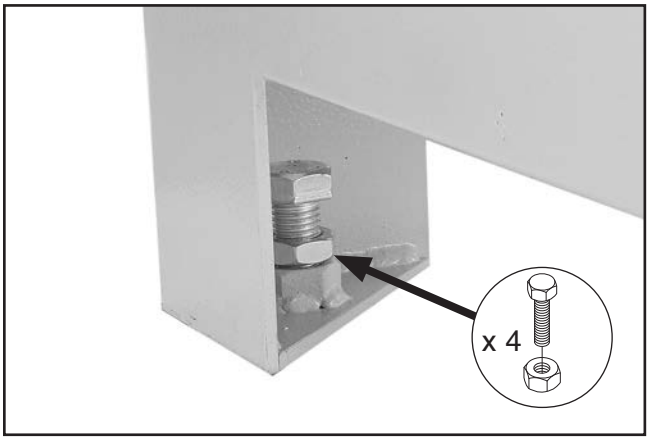


Figure 17. Hex bolt (1 of 4) in stand corner for leveling.

8. Use hex bolts to level saw table from left-to-right and from front-to-back. Leveling saw allows sliding table to move smoothly.

9. Tighten hex nuts against frame to prevent hex bolts from moving after leveling.

NOTICE

Harwired machines must be secured to the floor.

Assembly

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

To assemble sliding table saw:

1. Remove shipping brace shown in **Figure 18** from end of sliding table.

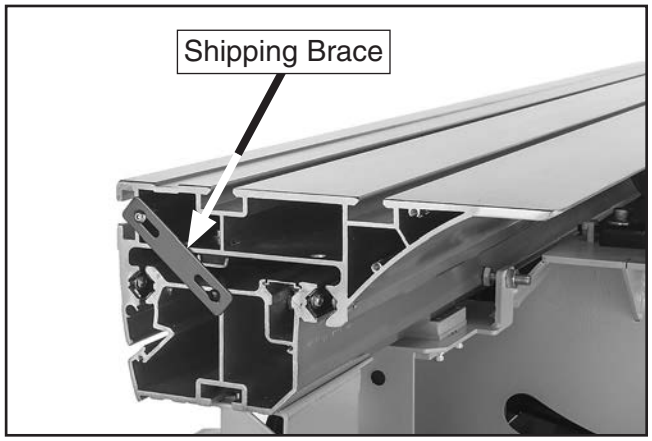


Figure 18. Shipping brace location.

2. Attach end cap with (2) pre-installed M4 x 8 tap screws (see **Figure 19**).

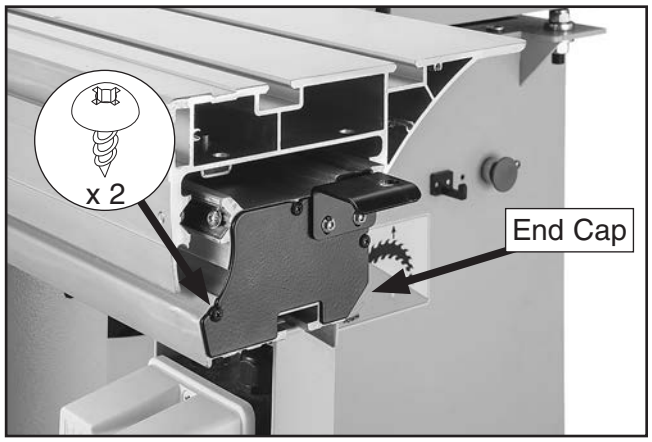


Figure 19. End cap attached to sliding table.

3. Pull sliding table forward a few inches and attach end plate with handle, as shown in **Figure 20**, using (2) M6-1 x 20 button head cap screws, (4) 6mm flat washers, (2) 6mm lock washers, and (2) M6-1 hex nuts.

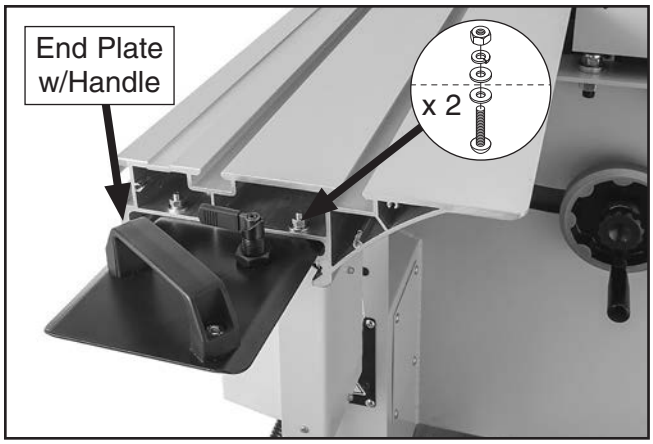


Figure 20. End plate with handle installed onto sliding table.

4. Attach end cover to sliding table with (3) pre-installed M5-.8 x 10 button head cap screws (see **Figure 21**).

5. Slide M12-1.75 T-nut on push handle assembly into T-slot at front end of sliding table, as shown in **Figure 21**, then tighten handle. It may be necessary to loosen T-nut first.

   Note: *Make sure pre-installed 12mm flat washer and 12mm copper washer are positioned in front of T-slot, as shown in* ***Figure 21***.

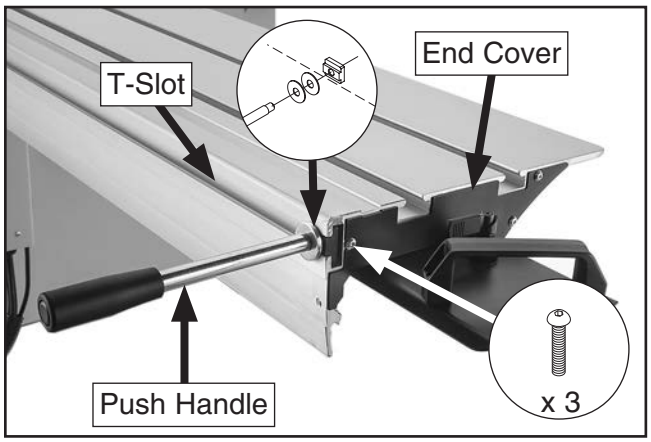


Figure 21. End cover and push handle installed.

6. Attach the cabinet door by sliding hinge sleeves over pins of already attached hinge (see **Figure 22**).

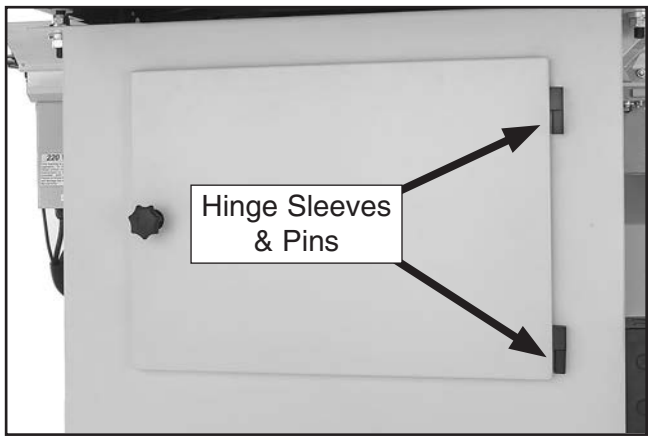


Figure 22. Cabinet door attached on hinges.

7. With help of another person to hold large extension table, attach it to cast-iron table with (3) M10-1.5 x 25 cap screws, (3) 10mm lock washers, and (3) 10mm flat washers, as shown in **Figure 23**. Finger-tighten only, for now.

8. Thread (3) M10-1.5 x 20 set screws with (3) M10-1.5 hex nuts where shown in **Figure 23**.

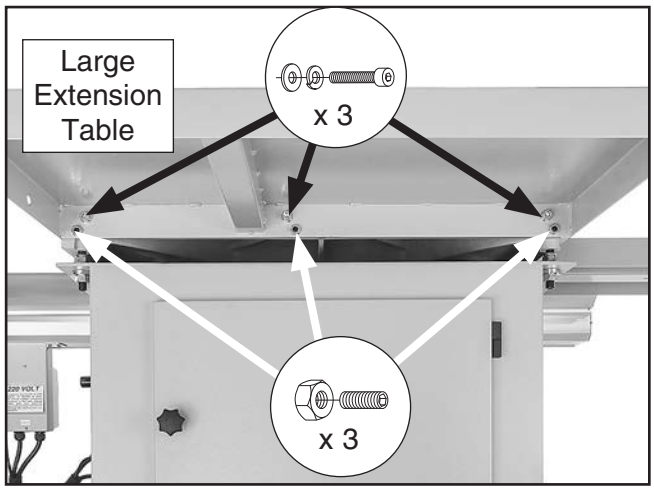


Figure 23. Large extension table attached to cabinet.

9. Place a straightedge across cast-iron table and large extension table to see if tables are parallel.

— If entire length of straightedge *is* parallel with both tables, move on to **Step 10**.

— If both tables are *not* parallel with straightedge, loosen hex nuts on set screws shown in **Figure 23**. Adjust set screws to align top of extension table with top of cast-iron table, then retighten hex nuts to secure setting.

10. Fully tighten cap screws from **Step 7**.

11. Attach small extension table to cast-iron table with (2) M10-1.5 x 25 cap screws, (2) 10mm flat washers and (2) 10mm lock washers (see **Figure 24**). Finger-tighten for now.

12. Thread (2) M10-1.5 x 20 set screws with (2) M10-1.5 hex nuts where shown in **Figure 24**.

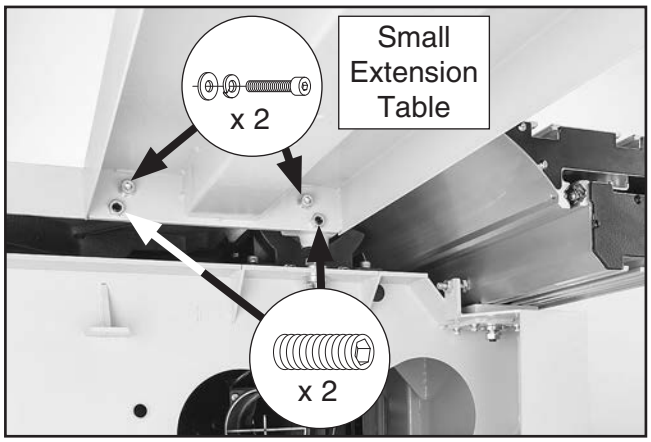


Figure 24. Small extension table attached to cabinet.

13. Place a straightedge across cast-iron table and small extension table to see if tables are parallel.

— If entire length of straightedge *is* parallel with both tables, move on to **Step 14**.

— If both tables are *not* parallel with straightedge, loosen hex nuts on set screws shown in **Figure 24.** Adjust set screws to align top of small extension table with top of cast-iron table, then retighten hex nuts to secure setting.

14. Fully tighten cap screws from **Step 11**.

15. Attach rip fence scale flush along top edge of cast-iron table and large extension table (see **Figure 25**) with (3) M6-1 x 12 button head cap screws, (4) 6mm flat washers, and (1) M6-1 hex nut.

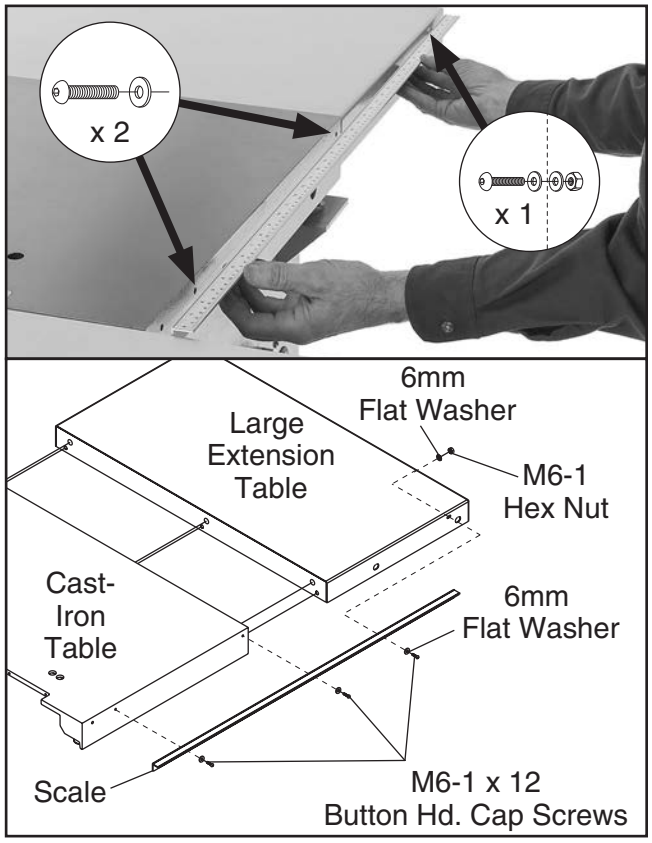


Figure 25. Mounting rip fence scale.

16. The rip fence rail is pre-assembled with four rail studs and accompanying hardware. Remove (1) hex nut, (1) lock washer, and (1) flat washer from end of each stud, as shown in **Figure 26**.

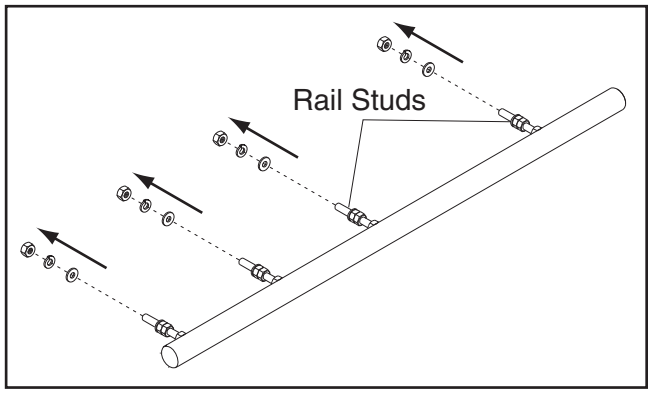


Figure 26. Removing rip fence rail hardware to prepare for installation.

17. Insert studs into tables as shown in **Figure 27**, and attach with hardware removed in **Step 16**.

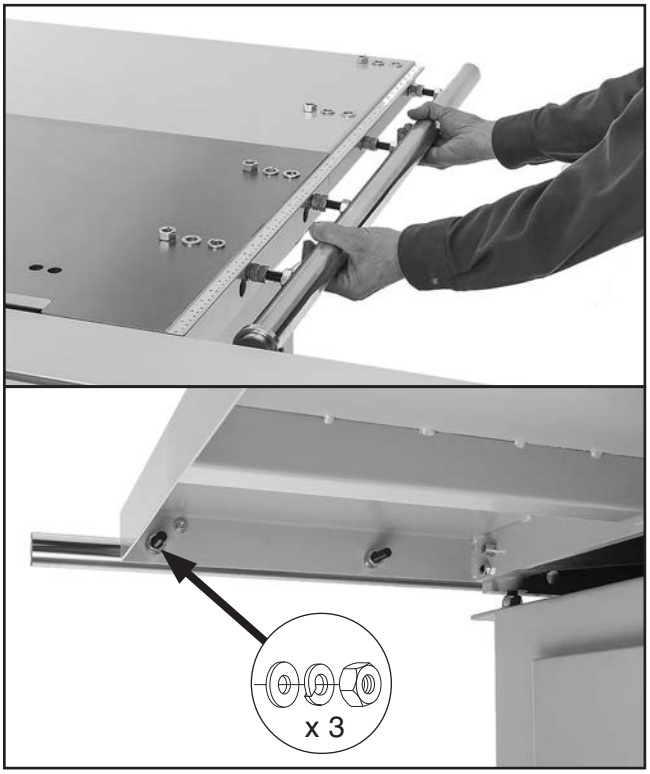


Figure 27. Installing the rip fence rail.

18. Slide rip fence base onto fence rail, as shown in **Figure 28**.

19. Thread (2) M10-1.5 x 12 lock handles and M10-1.5 x 55 lock knob bolt into rip fence base, as shown in **Figure 28**.

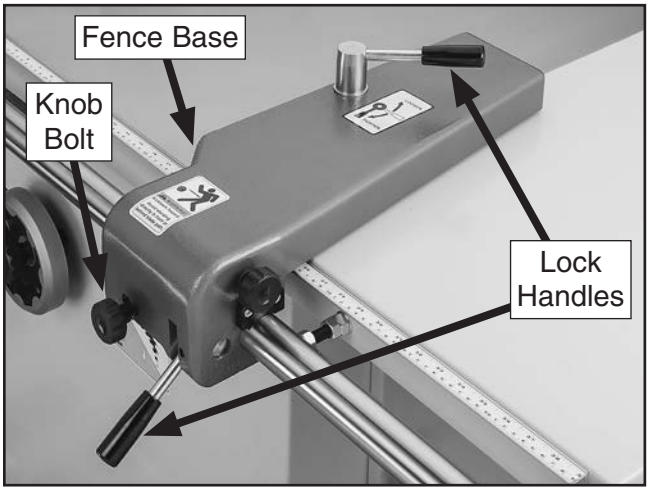


Figure 28. Rip fence attached with lock handles and lock knob installed.

20. Slide rip fence onto clamping plate, as shown in **Figure 29**, and lock it with slide-lock handle.

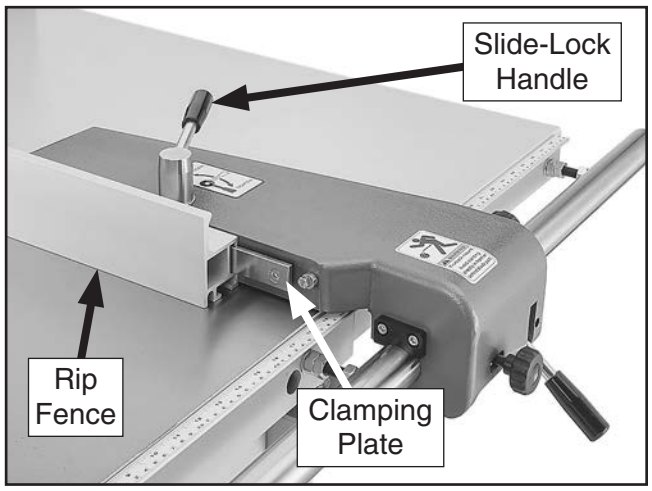


Figure 29. Rip fence attached to rip fence base.

21. Move sliding table all the way forward to expose blade cover. Pull blade cover toward front of machine to disengage magnetic catches (see **Figure 30**).

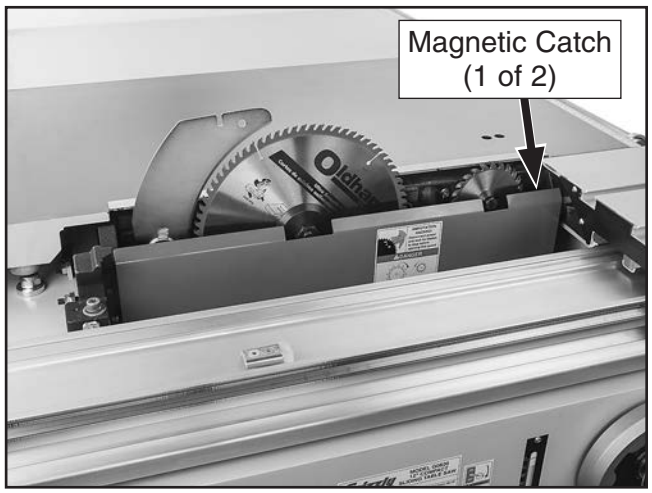


Figure 30. Location of magnetic catches that secure blade cover.

NOTICE

The Model G0820 does not ship with a 12" main blade. Refer to *Blade Requirements* and *Blade Selection* beginning on *Page 44* when purchasing the main blade.

22. Insert T-handle wrench into access hole shown in **Figure 31**.

Note: *Main blade is shown here only for illustrative purposes.*

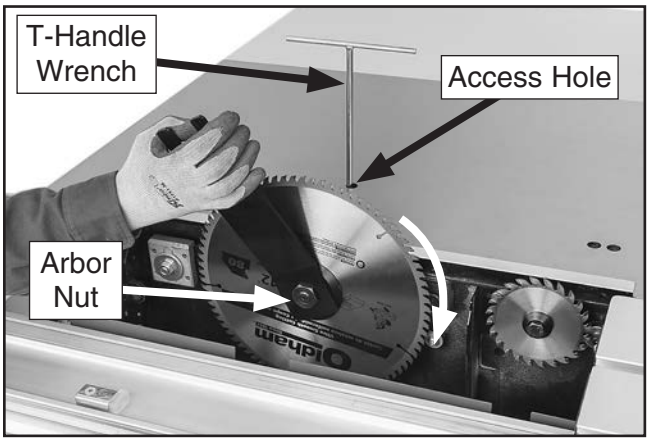


Figure 31. Loosening main blade arbor bolt.

23. Push down on T-handle wrench with one hand as you rotate arbor nut clockwise (it has left-hand threads). This will force end of T-handle wrench into arbor indent and prevent arbor from rotating in next steps.

24. Continue unthreading arbor nut clockwise until you can remove blade flange (see **Figure 32**).

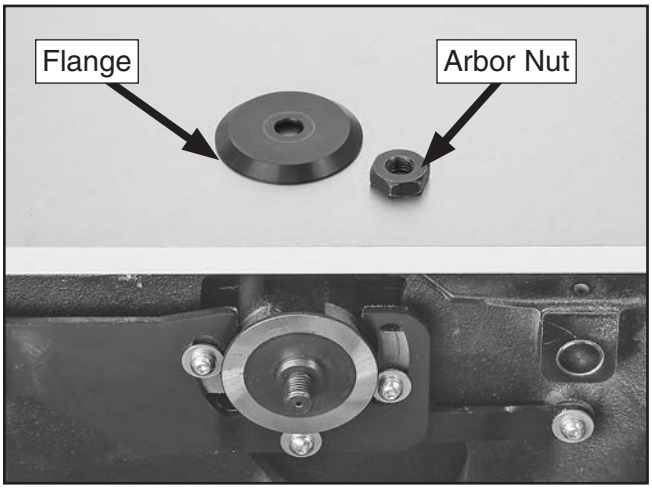


Figure 32. Flange and arbor nut removed from arbor.

⚠CAUTION

Before proceeding with the next steps, wear gloves to protect your hands when handling and installing blade.

25. Slide main blade (not included) over arbor with teeth facing to the right, then install flange (see **Figure 33**).

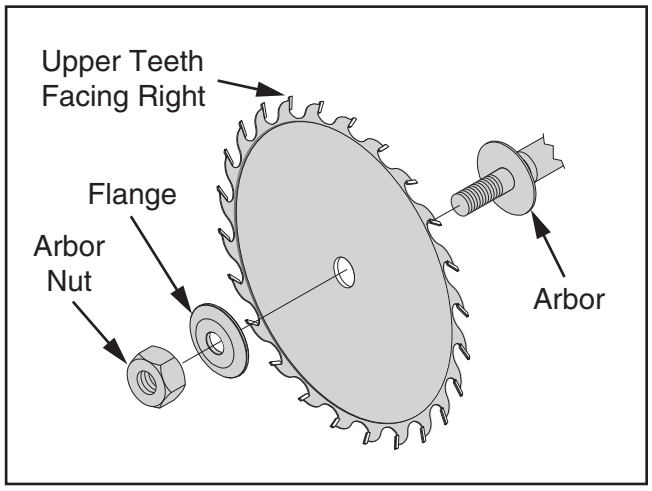


Figure 33. Main blade component assembly.

26. While still holding T-handle wrench, thread arbor nut on counterclockwise and fully tighten it to secure blade (see **Figure 34**).

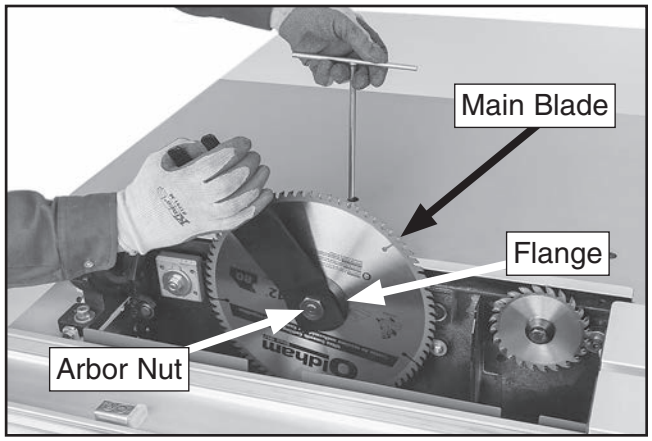


Figure 34. Main blade installed on arbor.

27. Close blade cover, then move sliding table all the way back and remove T-handle wrench.

28. Install riving knife or splitter/riving knife, as shown in **Figure 40**, but do not tighten mounting bolt yet (refer to **Riving Knife Alignment** beginning on **Page 43** for detailed information).

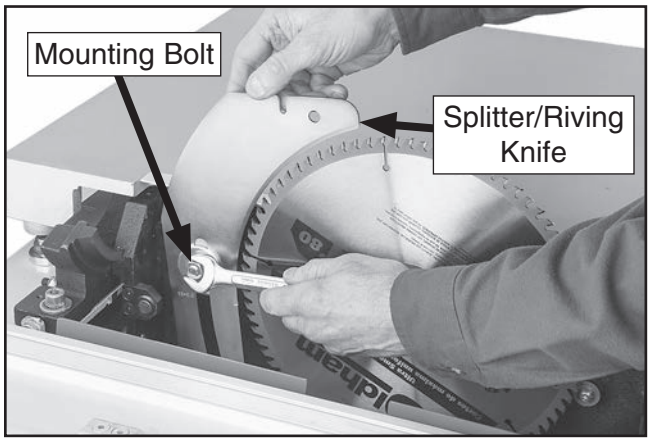


Figure 35. Installing splitter/riving knife.

29. Adjust riving knife or splitter/riving knife approximately ⅛" away from main blade, using a ⅛" or 3mm hex wrench as a guide (see **Figure 36**).

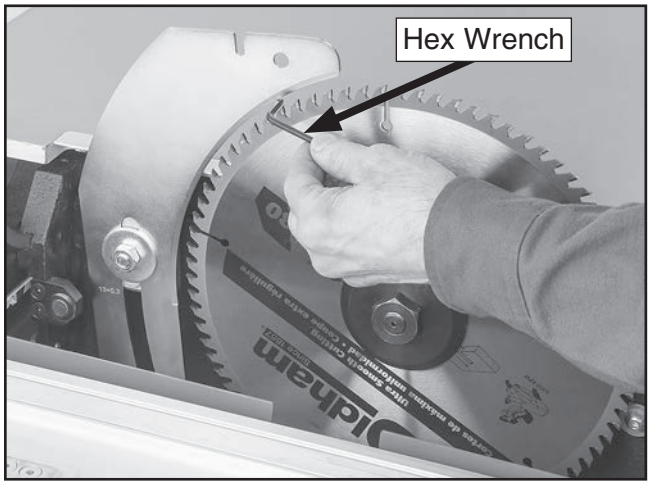


Figure 36. Adjusting splitter/riving knife-to-blade spacing.

30. Use straightedge to make sure riving knife or splitter/riving knife and scoring blade are aligned with main blade, as shown in **Figure 37**. The alignment should be with blade bodies, not carbide teeth (see inset).

— The riving knife or splitter/riving knife position can be changed by adjusting set screws at splitter/riving knife mounting block. Refer to **Riving Knife Mounting Block** on **Page 78** for more details.

— The scoring blade alignment can be changed by adjusting bolt accessible through table top (see **Figure 37**). Refer to **Aligning to Scoring Blade** on **Page 48** for more details.

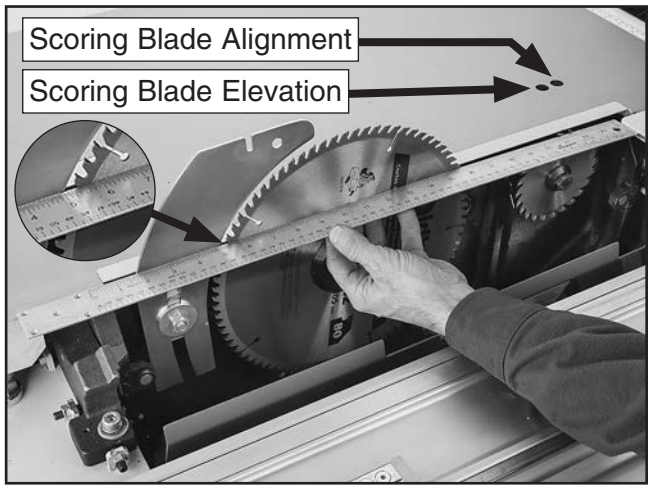


Figure 37. Access holes for scoring blade adjustment controls.

31. Close blade cover. Center sliding table over cabinet body and lock in place with sliding table lock lever (see **Figure 38**).

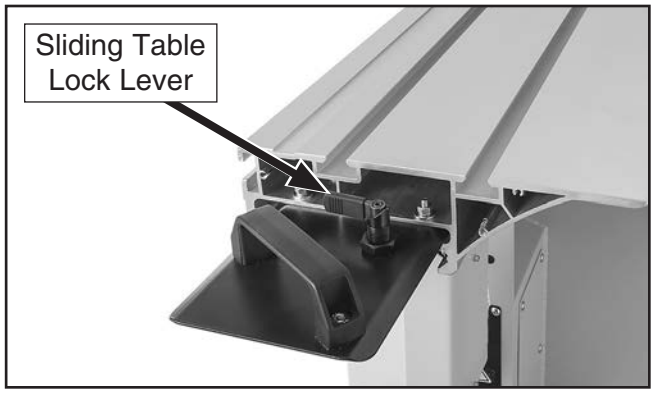


Figure 38. Location of sliding table lock lever.

32. Position rip fence 1/8" away from main blade.

33. Slide rip fence stop ring onto left end of rail and tighten pre-installed set screw to secure it in place (see **Figure 39**). When installed correctly, this ring will prevent rip fence from contacting blade.

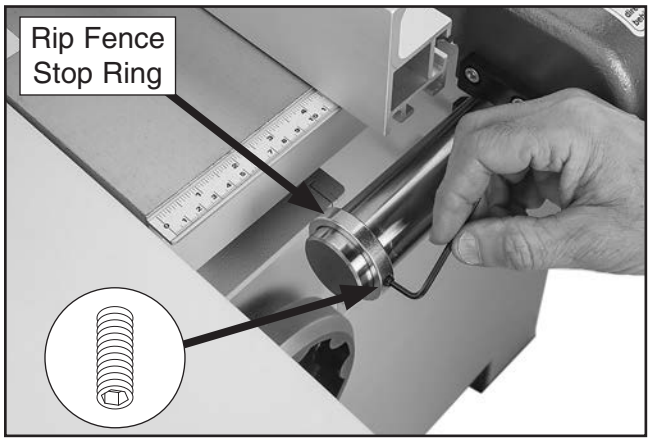


Figure 39. Rip fence stop ring attached to rail.

34. Attach rip fence end stop on opposite end of rip fence rail with (1) M8-1.25 x 15 cap screw and (1) 8mm lock washer (see **Figure 40**).

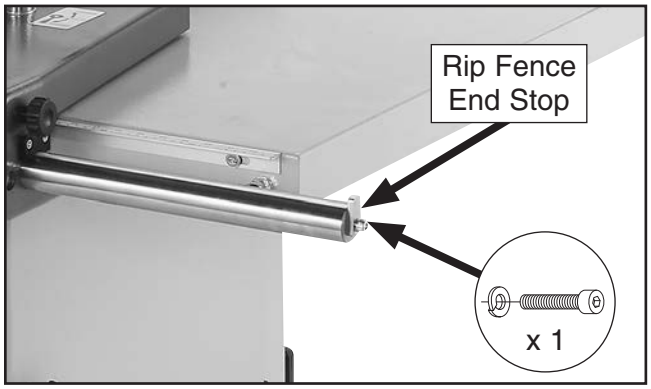


Figure 40. Rip fence end stop attached to rail.

35. Adjust rip fence to main blade and tables, as instructed in **Calibrating Rip Fence** on **Page 79**.

36. Thread M12-1.75 x 55 adjustable lock handle with a 12mm flat washer through hole in short side of crosscut table and into a M12-1.75 T-nut plate, as shown in **Figure 41**.

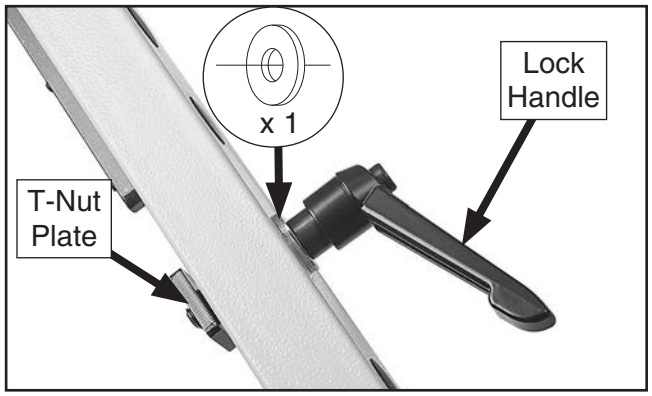


Figure 41. Crosscut lock handle installed on crosscut table.

37. With assistance from other people, place crosscut table on swing arm pivot pin and slide T-slot alignment plates and T-nut plate into sliding table T-slot, as shown in **Figure 42**.

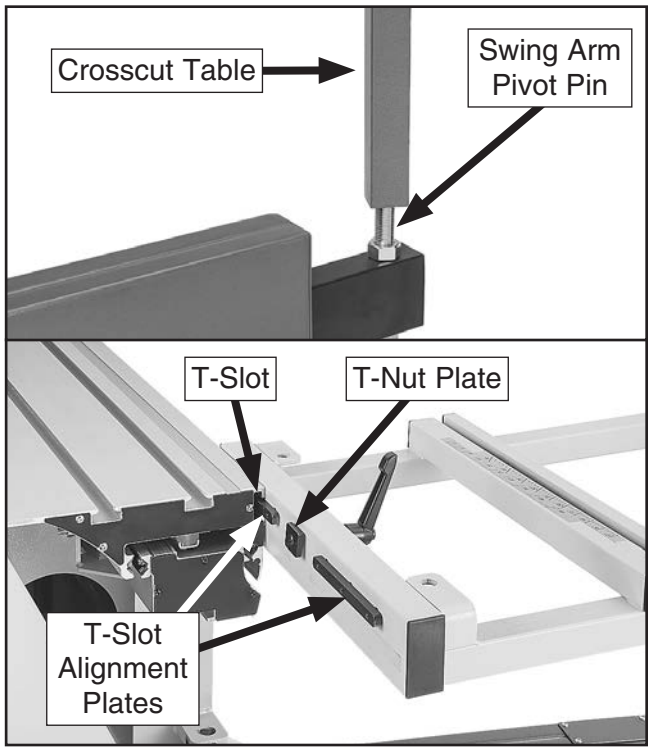


Figure 42. Attaching crosscut table to machine frame.

38. Remove tap screws and end cap from crosscut fence (see **Figure 43**).

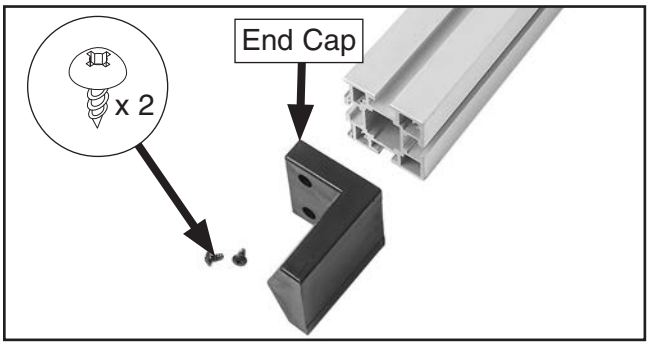


Figure 43. End cap removed from crosscut fence.

39. Slide M8-1.25 T-nut into T-slot in bottom of crosscut fence (see **Figure 44**) and position in front of stop bolt.

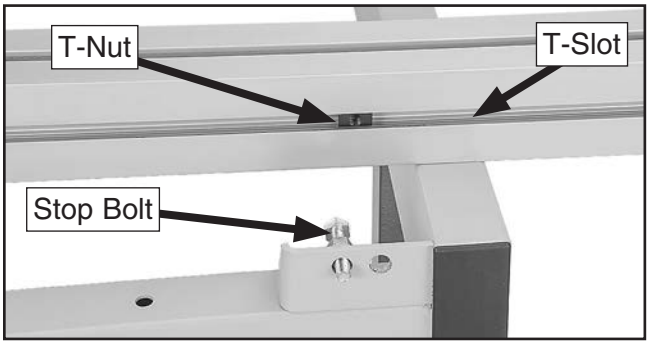


Figure 44. T-nut installed in bottom T-slot of crosscut fence for stop block.

40. Attach 0° stop block to T-nut with (1) M8-1.25 x 35 cap screw and (1) 8mm lock washer (see **Figure 45**).

Note: *Make sure threaded hole in stop block is positioned right of cap screw and aligned with hole to right of stop bolt.*

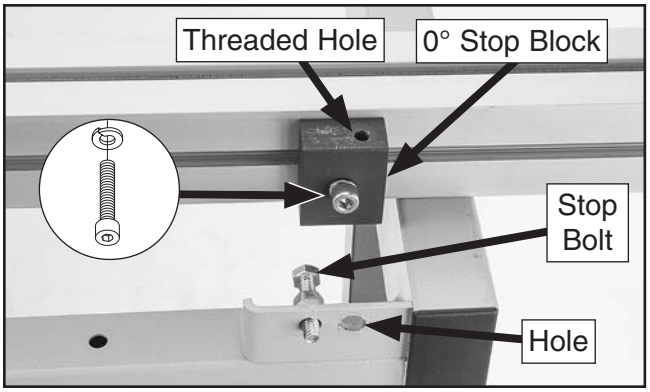


Figure 45. 90° stop block installed.

41. Slide M8-1.25 x 60 T-bolt into bottom T-slot of crosscut fence (see **Figure 46**).

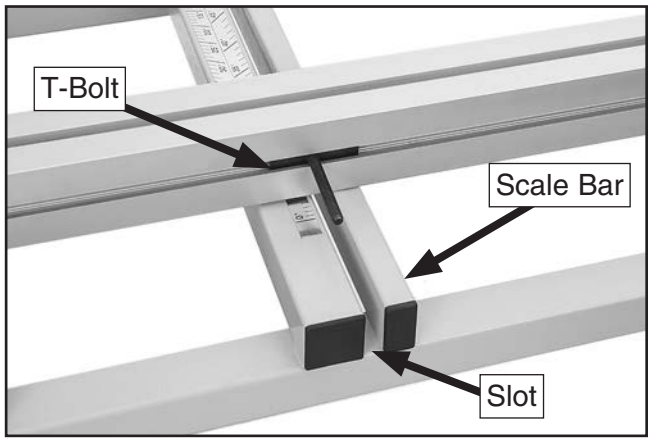


Figure 46. T-bolt installed in middle of crosscut table T-slot.

42. Slide (1) M8-1.25 T-nut into bottom T-slot of crosscut fence, then loosely thread M8-1.25 pivot bolt with (1) 8mm fiber flat washer into T-nut (see **Figure 47**).

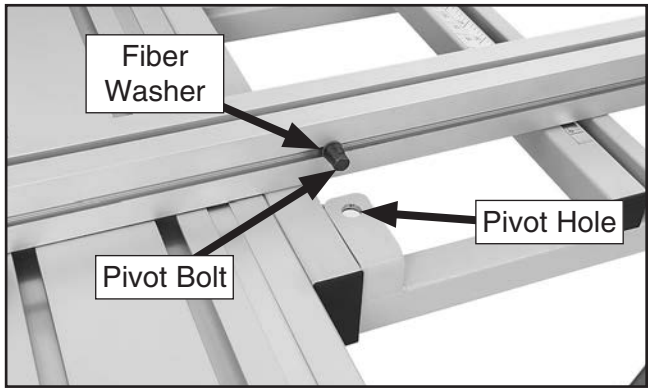


Figure 47. Pivot bolt installed in left end of crosscut table T-slot.

43. Slide (1) M8-1.25 T-nut into top T-slot of crosscut fence (see **Figure 48**). This will be used to attach flip stop in **Step 51**.

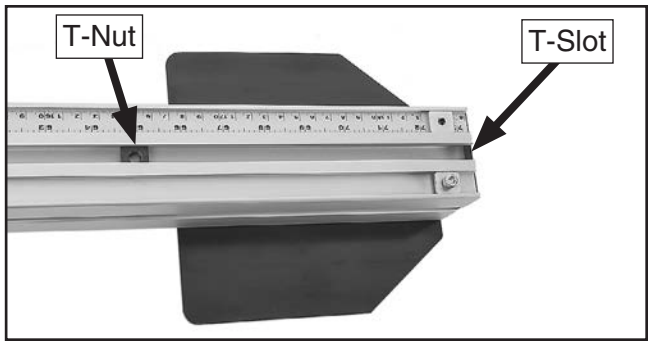


Figure 48. T-nut installed on right end of crosscut table T-slot.

44. Re-install end cap, then position crosscut fence so end cap is close to, but not touching main blade (see **Figure 49**).

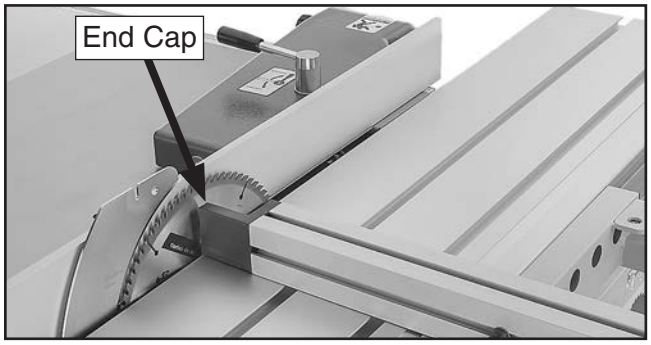


Figure 49. End cap positioned near blade.

45. Align pivot bolt with pivot hole (see **Figure 49**), then fully tighten pivot bolt.

46. Align T-slot bolt with slot in pre-installed scale bar (see **Figure 46**).

Note: *Long knob and fender washer will help secure crosscut fence in later step.*

47. Align 0° stop block with stop bolt, and align threaded hole in block with hole to right of stop bolt (see **Figure 45**).

48. Without moving previously installed hardware, flip crosscut fence over and insert pivot bolt and T-slot bolt into appropriate hole/slot.

49. From underneath middle of crosscut fence, thread M8-1.25 long knob with (1) 8mm fender washer onto previously installed T-bolt (see **Figure 50**).

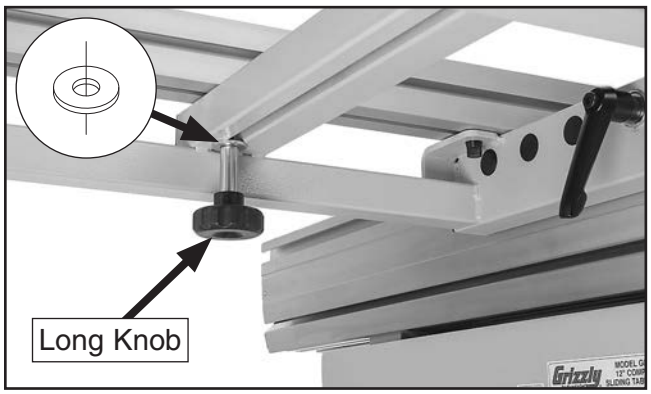


Figure 50. Long knob installed under middle of crosscut fence.

50. On right side of crosscut fence, make sure 0° stop block is against stop bolt, then secure fence by threading M8-1.25 x 50 knob bolt with (1) 8mm flat washer, and (2) M8-1.25 hex nuts into threaded hole on stop block, as shown in **Figure 51**.

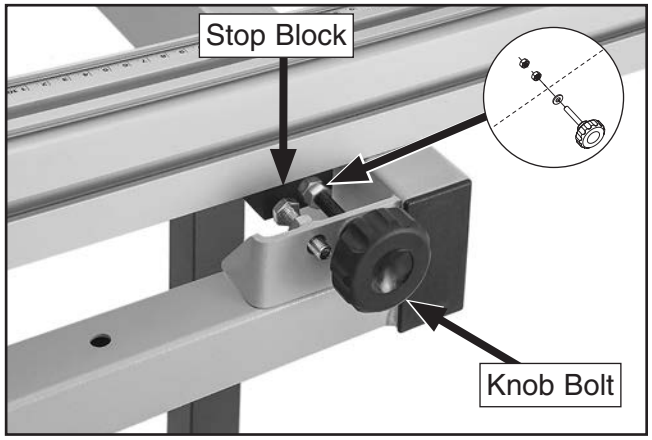


Figure 51. Knob bolt threaded into 90° stop block.

51. Attach flip stop (see **Figure 52**) by threading knob bolt into T-nut previously installed in top T-slot of fence.

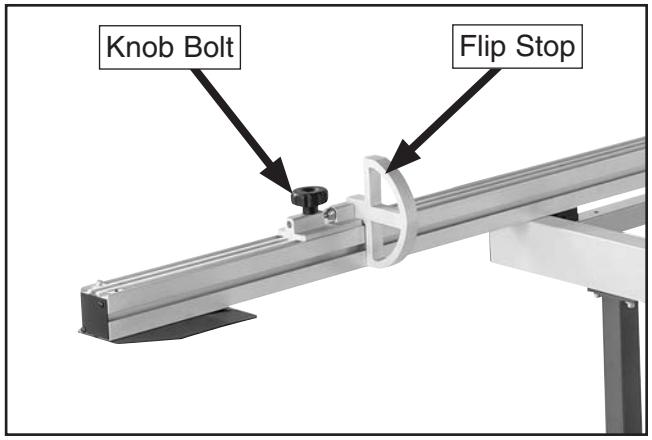


Figure 52. Flip stop installed onto crosscut fence.

52. If you installed splitter/riving knife earlier—instead of riving knife—raise main blade all the way up, and attach blade guard with (1) M10-1.5 x 25 cap screw and (1) M10-1.5 lock nut, as shown in **Figure 53**.

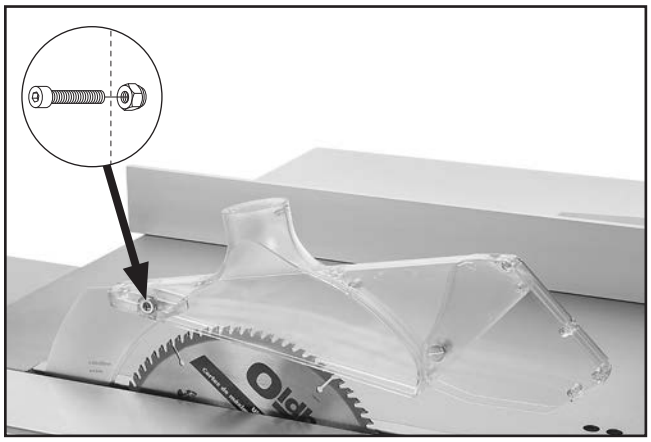


Figure 53. Blade guard installed onto splitter.

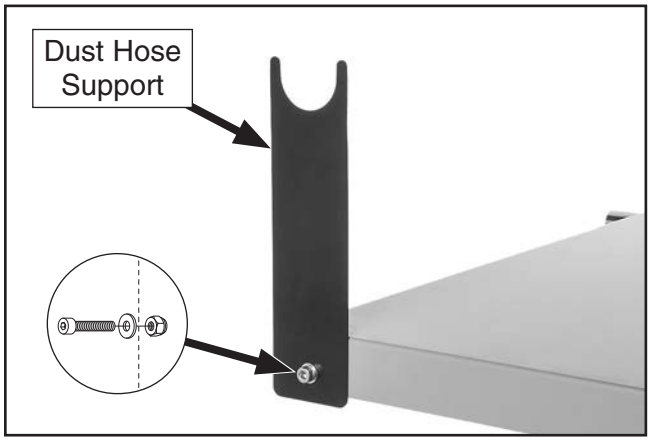


Figure 54. Dust hose support attached to rear of large extension table.

53. Attach dust hose support to large extension table with (1) M10-1.5 x 20 cap screw, (1) 10mm flat washer, and (1) M10-1.5 lock nut (see **Figure 54**).

Note: *The support can be placed on either the rear or side of the extension table using the two available holes.*

Dust Collection

⚠CAUTION

DO NOT operate the Model G0820 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.

Required CFM at 5" Dust Port: 615 CFM
Required CFM at 2½" Dust Port: 150 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 saw to dust collection system:

1. Secure 5" dust hose to port located under table with hose clamp, as shown in **Figure 55**.

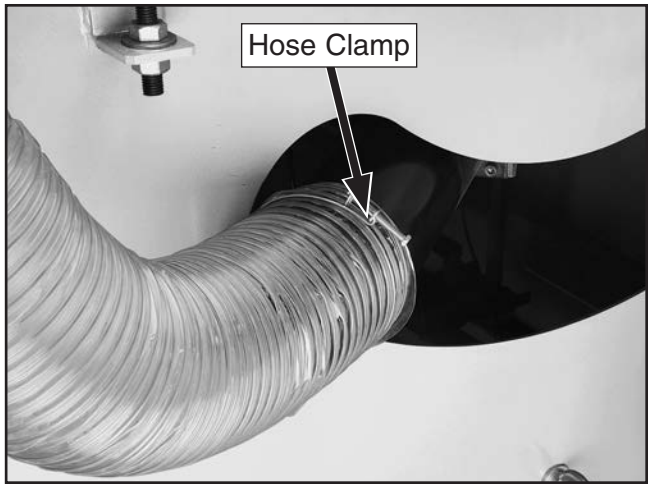


Figure 55. 5" Dust hose connected.

2. Connect 2½" dust hose to blade guard with hose clamp, as shown in **Figure 56**.

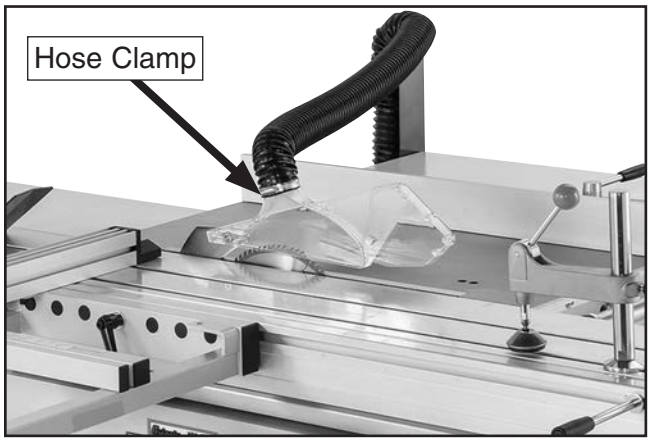


Figure 56. Blade guard and 2½" dust hose attached.

3. Run 2½" dust hose over dust hose support, as shown in **Figure 57**.

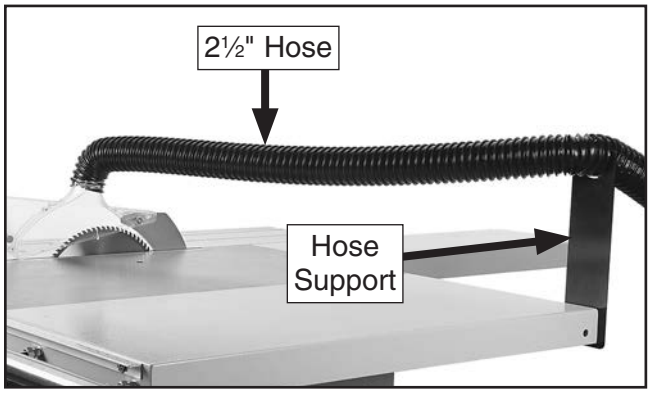


Figure 57. 2½" Dust hose held by hose support.

4. Connect 5" and 2½" dust hoses to Y-fitting, as shown in example in **Figure 58**, then attach it to single dust collection branch line.

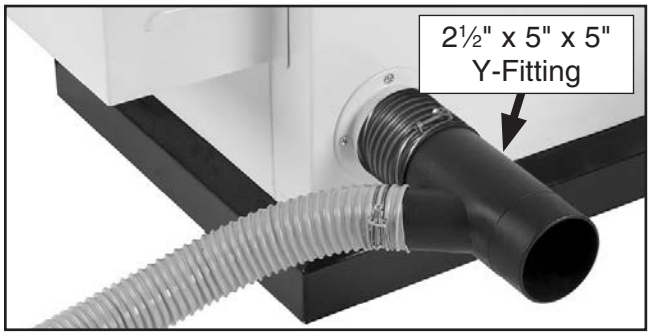
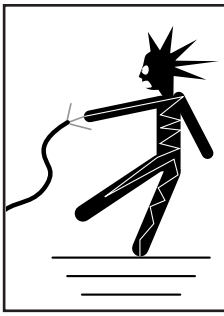


Figure 58. Example of dust hoses connected with Y-fitting.

5. Tug on all hose connections to make sure that they are tight and secure.

Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.



⚠WARNING

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

Note About Phase Converters: Avoid using a static phase converter to supply 3-Phase power for this machine, as it could damage or decrease the life of sensitive electrical components. If you must use a phase converter, only use a rotary phase converter that is sized at least 50% larger than the largest HP rating of this machine. If using a phase converter to supply power, only connect the manufactured leg or "wild wire" to the "S" terminal (see location **on this page**). The S terminal can handle power fluctuations because it is wired directly to the motor.

NOTICE

The Model G0820 is prewired for 220V. If you plan to operate the machine at 440V, refer to *440V Conversion* on *Page 16* for detailed instructions).

To connect incoming power wires:

1. Remove power junction box cover shown in **Figure 59**.

2. Insert incoming power cord through strain relief at bottom of junction box (see **Figure 59**).

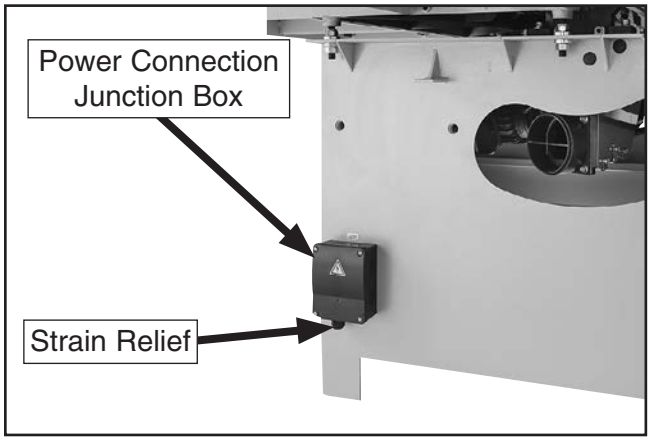


Figure 59. Power connection junction box location.

3. Connect ground wire to ground wire terminal, then connect incoming power wires to terminals shown in **Figure 60**. Refer to **Pages 82–83** for detailed wiring diagrams.

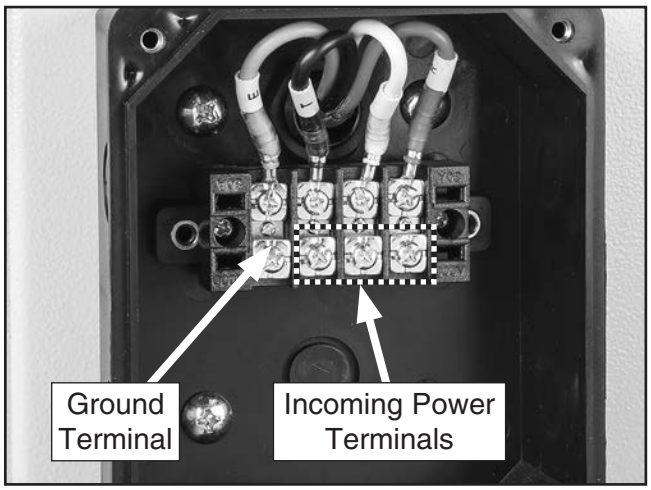


Figure 60. Terminal locations to connect incoming power wires and ground wire.

4. Make sure wires have enough slack so they are not pulled tight or stretched.

5. Re-install junction box cover, and perform **Test Run** in following section to verify correct phase polarity.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, 2) the main blade turns forward (clockwise when viewed from front of saw) and the scoring blade turns opposite the main blade, and 3) the safety features of the Emergency Stop button, blade cover switch, and cabinet door work correctly.

⚠WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

⚠WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.

2. Make sure saw blades are installed tightly and blade guard cover is closed.

3. Connect machine to power supply.

4. Twist Emergency Stop button clockwise until it pops out (see **Figure 61**). This resets switch so the machine can start.

5. Press ON button (see **Figure 61**) to turn machine ***ON***. Verify motor starts up and runs smoothly without any unusual problems or noises.

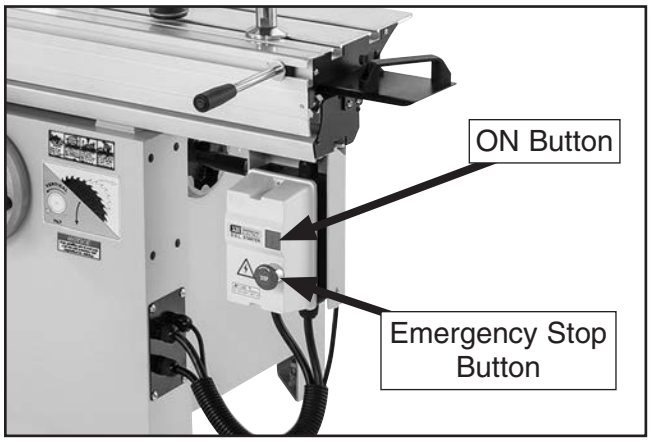


Figure 61. Emergency Stop switch button.

6. Verify main blade is rotating clockwise (when standing in front of machine) and scoring blade is rotating counterclockwise (opposite direction of main blade).

   Note: *You may need to stop the blade rotation and watch them come to a stop to determine which direction they are rotating.*

   — If blades are rotating in wrong direction, stop machine and DISCONNECT FROM POWER! Phase of incoming power supply is reversed. Remove power connection junction box cover and swap wires at “R” and “T" terminals (see **Figure 62**), then re-install junction box cover and reconnect machine to power.

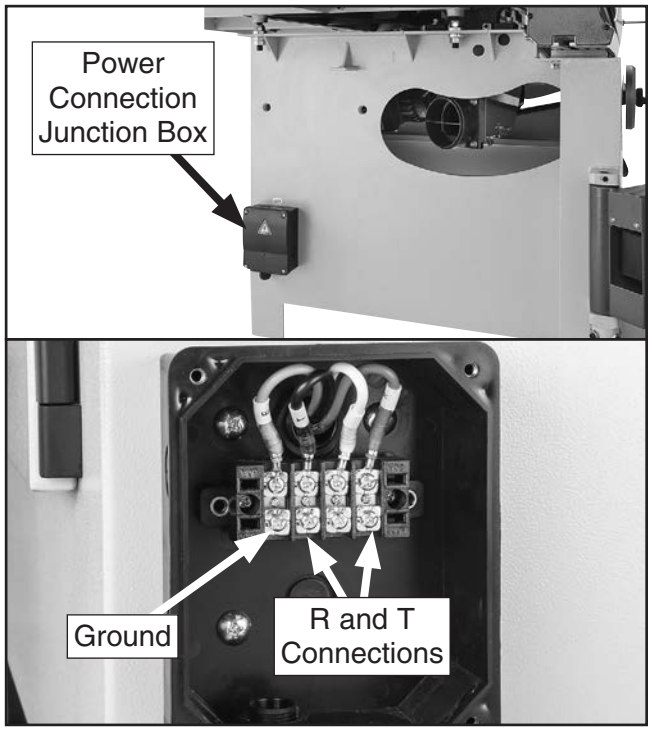


Figure 62. Up-close view of power supply terminal inside junction box.

⚠WARNING

Do not swap "R" or "T" wires with ground wire inside power connection junction box. Doing so will electrify machine frame, which could cause electrocution. Make sure incoming ground wire is only connected to left-most terminal post in the power connection junction box so machine is properly grounded.

7. Press Emergency Stop button on front of machine to turn machine ***OFF***.

8. WITHOUT resetting Emergency Stop button, press ON button. Machine should *not* start.

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

9. Reset Emergency Stop button on front of machine.

10. Repeat **Steps 7–9** with Emergency Stop button on rear of cabinet (see **Figure 63**).

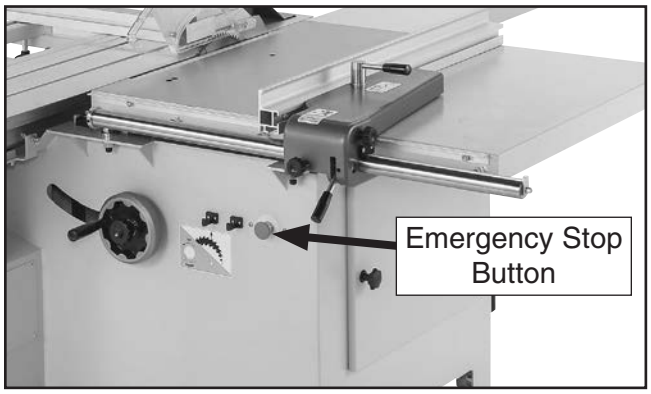


Figure 63. Emergency Stop on cabinet.

11. Move sliding table all the way right, then open blade cover, as shown in **Figure 64**. This activates blade cover safety switch to prevent saw from starting while cover is open.

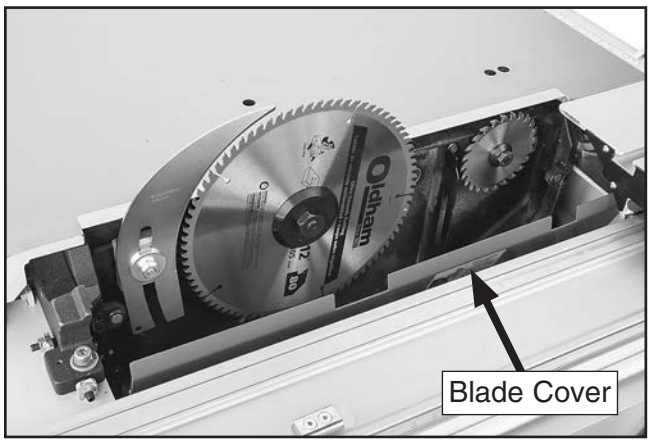


Figure 64. Blade cover open.

12. While staying safely away from blade, reset Emergency Stop button, then try to start main blade and scoring blade.

— If blades *do not* start, blade cover safety switch safety feature is working correctly.

— If blades *do* start (with blade cover open), immediately turn machine ***OFF*** and disconnect power. The blade cover safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

13. Carefully close blade cover, then move sliding table back to center of machine.

14. Open cabinet door shown in **Figure 65**. This activates cabinet door safety switch to prevent saw from starting while door is open.

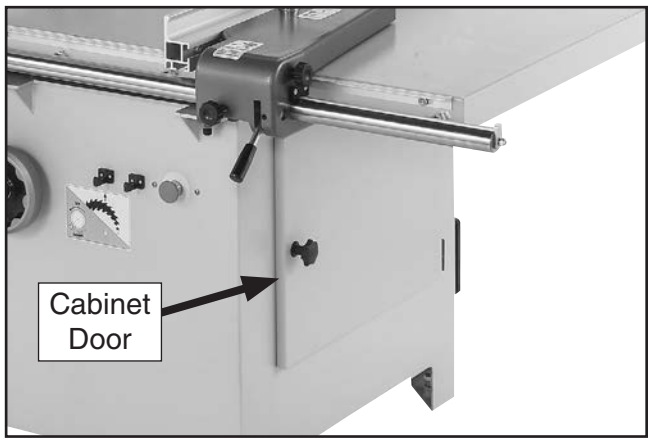


Figure 65. Cabinet door location.

15. While staying safely away from blade, try to start main blade and scoring blade.

— If blades *do not* start, cabinet door safety switch safety feature is working correctly.

— If blades *do* start (with cabinet door open), immediately turn machine ***OFF*** and disconnect power. The cabinet door safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

16. Close cabinet door, then push Emergency Stop button.

Congratulations. **Test Run** is complete!

Recommended Adjustments

The following list of adjustments were performed at the factory before the machine was shipped:

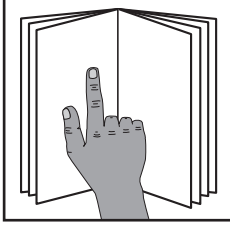
Be aware that machine components can shift during the shipping process. Pay careful attention to these adjustments during operation of the machine. If you find that the adjustments are not set according to the procedures in this manual or your personal preferences, re-adjust them.

SECTION 4: OPERATIONS

Operation Overview

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

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



⚠WARNING

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

⚠WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.

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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts blade tilt, if necessary, to correct angle of desired cut.
3. Adjusts blade height approximately ¼" higher than thickness of workpiece.
4. Adjusts fence to desired width of cut, then locks it in place.
5. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through the blade without interference.
6. Puts on safety glasses, respirator, and hearing protection. Locates push sticks, if needed.
7. Turns on dust collection system.
8. Feeds workpiece all the way through blade while maintaining firm pressure on workpiece against table and fence.
9. Turns machine ***OFF*** immediately after cut is complete and waits for blades to completely stop before removing workpiece.

NOTICE

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

Workpiece Inspection

Some workpieces are not safe to cut on this machine or may need to be modified before they can be safely cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate-covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the motor bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw greatly increases the risk of injury and damage to the saw or blade.

- ***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, cause kickback, 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 kickback and machine 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 blades, increases the risk of kickback, and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and may move unpredictably when being cut.

- ***Minor Warping:*** Slightly cupped workpieces can be safely supported with cupped side facing the table or fence; however, workpieces supported on the bowed side will rock during the cut, which could cause kickback.

Through & Non-Through Cuts

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through, as shown in the **Figure** below. Examples of through cuts are rip cuts, cross cuts, miter cuts, and beveled cuts. The blade guard assembly MUST be used when performing through cuts.

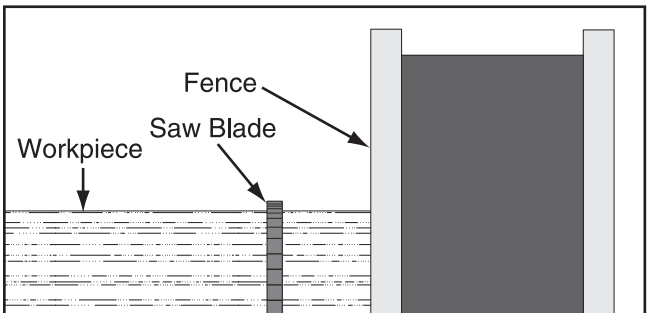


Figure 66. Example of a through cut (blade guard not shown for illustrative clarity).

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in the **Figure** below. The blade guard assembly MUST be used when performing all non-through cuts, except when the guard will not safely accommodate the workpiece.

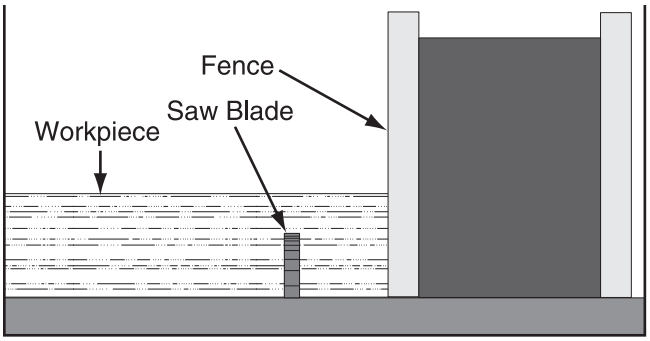


Figure 67. Example of a non-through cut.

Blade Guard & Splitter/Riving Knife

The term "blade guard" refers to the assembly that consists of the guard and splitter/riving knife assembly (see **Figure 68**). Each of these components have important safety functions.

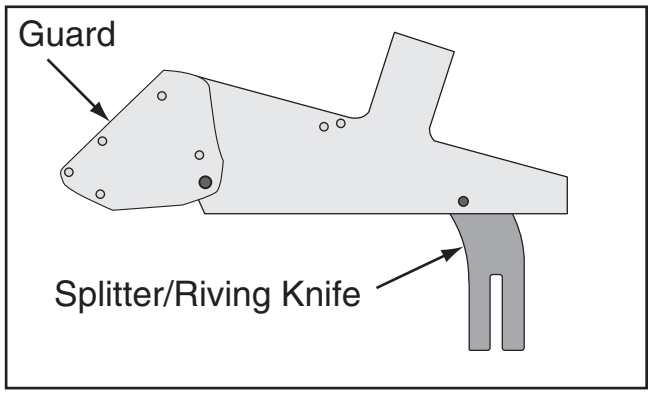


Figure 68. Blade guard assembly components.

Understanding the Blade Guard

The guard encloses the top of the blade to reduce the risk of accidental blade contact and contain flying chips or dust.

The guard is designed to lift as the workpiece is pushed into the blade, remain in contact with the workpiece during the cut, then return to a resting position against the table when the cut is complete. When installed and properly maintained, the guard is an excellent tool for reducing the risk of injury when operating the table saw.

To ensure that the guard does its job effectively, it MUST be installed and adjusted so that it moves up and down properly to accommodate workpieces and maintain coverage over the blade.

Understanding Splitter/Riving Knife

The splitter/riving knife is a metal plate that prevents the freshly cut pieces of the workpiece from pinching the backside of the blade and causing a kickback. It also acts as a barrier behind the blade to shield hands from being pulled into the blade if a kickback occurs and the operator is reaching behind the blade. (Reaching behind the blade is a major safety risk and should not be done).

⚠WARNING

To ensure that the splitter/riving knife works safely, it MUST be aligned with and correctly adjusted to the blade.

When to Use Blade Guard

The blade guard assembly MUST always be installed on the saw for all normal through cuts (those where the blade cuts all the way through the thickness of the workpiece). Operating the saw without the guard increases the risk of kickback or blade contact. If the blade guard is removed for specific operations, immediately replace it after those operations are complete.

When Not to Use Blade Guard

The blade guard cannot be used for any non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

IMPORTANT: *Whenever the blade guard cannot be used, the riving knife MUST be installed.*

Sometimes the blade guard or its components can get in the way when cutting very narrow workpieces or other specialized cuts. Because the blade guard is provided to decrease your risk of injury, it should not be used if it gets in the way of making a safe cut. Use good judgment!

Blade Guard Installation & Removal

The blade guard fits over the splitter/riving knife and is secured in place with an M10-1.5 x 25 cap screw and an M10-1.5 lock nut (see "Mounting Screw" in **Figure 69**). These are the only fasteners that need to be installed/removed when installing or removing the blade guard.

Figure 69. Blade guard mounted to splitter/riving knife.

When installing the blade guard, the mounting screw and lock nut must be left loose enough that the guard can freely pivot up and down, but not so loose that there is side-to-side play when pivoting.

Testing Guard for Correct Operation

After installing the blade guard, you must verify that it functions correctly before making a cut. To test the blade guard operation, lift up the front end about 4" then release it.

- If the blade guard freely drops down against the table surface, then it is functioning correctly and is ready for operation.
- If the blade guard remains in the position where you released it, or it does not drop down against the surface of the table, then the mounting screw and lock nut are too tight. Loosen it slightly and repeat this test until the guard functions correctly.
- If the blade guard feels loose and easily moves back and forth as you raise it, then the mounting screw and lock nut are too loose. Tighten it slightly and repeat this test until the guard functions correctly.

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating Saw

a) Wear eye protection.
b) Use saw-blade guard and splitter/riving knife for every operation for which it can be used, including all through sawing.
c) Keep hands out of the line of saw blade.
d) Use a push-stick when required.
e) Pay particular attention to instructions on reducing risk of kickback.
f) Do not perform any operation freehand.
g) Never reach around or over saw blade.

Splitter/Riving Knife Installation & Removal

The splitter/riving knife must be correctly installed, adjusted, and aligned in order to provide the maximum safety benefit.

The splitter/riving knife attaches to the mounting block, as shown in **Figure 70**. Always firmly tighten the hex nut when securing the splitter/riving knife in place.

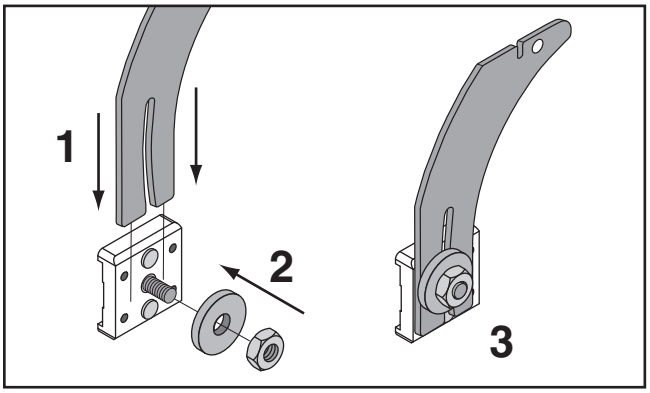


Figure 70. Installing splitter/riving knife on mounting block.

The splitter/riving knife also prevents the freshly cut sides of the workpiece from pinching the blade and causing kickback. For maximum effectiveness of this safety design, the splitter/riving knife must be positioned 3–8mm from the blade, as shown in **Figure 71**.

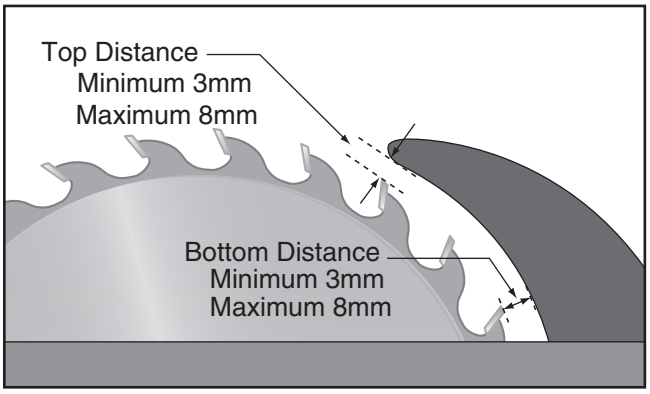


Figure 71. Allowable top and bottom distances between splitter/riving knife and blade.

Once the splitter/riving knife is properly positioned at the correct distance from the blade, verify that it is aligned with the blade by checking the alignment with a straightedge in the top and bottom locations shown in **Figure 72**.

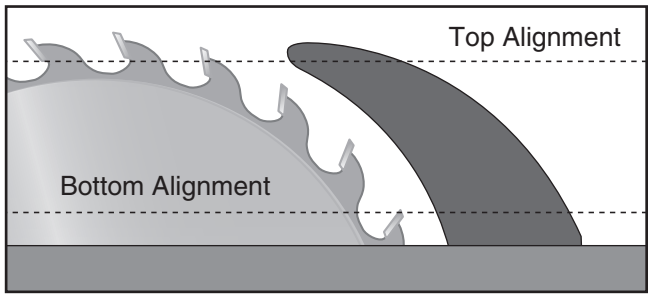


Figure 72. Checking top and bottom splitter/riving knife alignment with blade.

The splitter/riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in **Figure 73**.

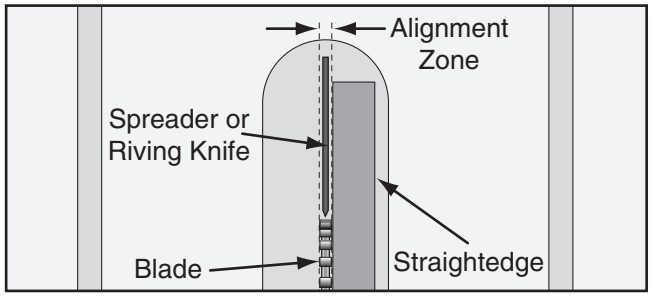


Figure 73. Verifying that splitter/riving knife is in the alignment zone behind the blade.

If the splitter/riving knife is not aligned or parallel with the blade, refer to **Riving Knife Mounting Block** on **Page 78**.

Riving Knife

The riving knife works in the same manner as the splitter/riving knife on the blade guard assembly. It is a metal plate that prevents the newly cut workpiece from pinching the backside of the blade and causing kickback.

The key difference between the splitter/riving knife and the riving knife is that the riving knife mounts below the blade's highest point of rotation, as shown in **Figure 74**, so that it can remain installed for non-through cuts.

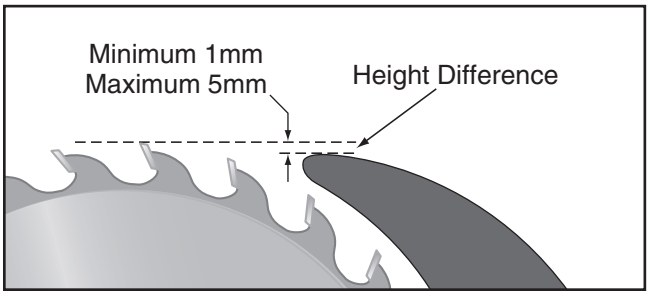


Figure 74. Height difference between riving knife and blade.

Similar to the splitter/riving knife, the riving knife acts as a barrier behind the blade to reduce the risk of hands being pulled into the blade if kickback occurs.

The riving knife must be kept within the range shown in **Figure 75**. For that reason, a 12" blade is required for operations that use a riving knife.

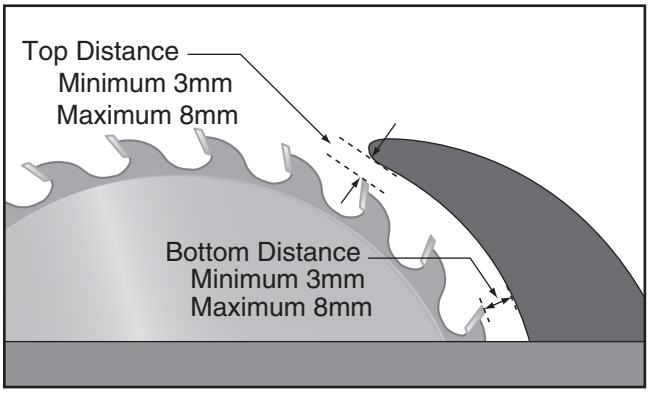


Figure 75. Allowable top and bottom distances between riving knife and blade.

Once the riving knife is properly positioned at the correct distance from the blade, verify that it is aligned with the blade by checking the alignment with a straightedge in the top and bottom locations shown in **Figure 76**.

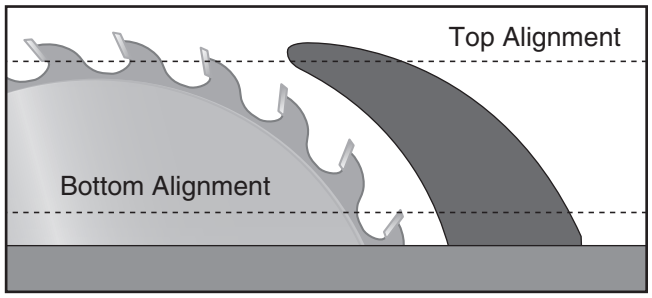


Figure 76. Checking top and bottom riving knife alignment with blade.

The riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in **Figure 77**.

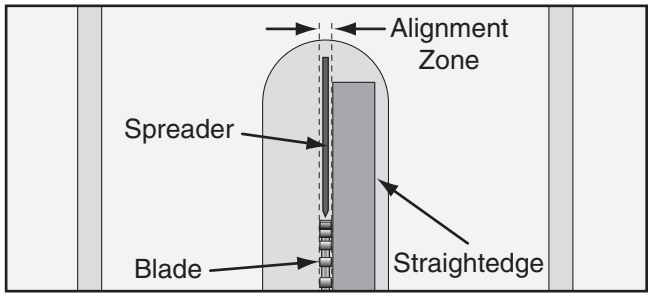


Figure 77. Verifying that riving knife is in the alignment zone behind the blade.

If the riving knife is not aligned or parallel with the blade, refer to **Riving Knife Mounting Block** on **Page 78**.

Riving Knife Installation & Removal

The riving knife must be correctly installed and adjusted in order to provide the maximum safety benefit.

The riving knife attaches to the mounting block as shown in **Figure 78**. Always firmly tighten the hex bolt when securing the riving knife in place.

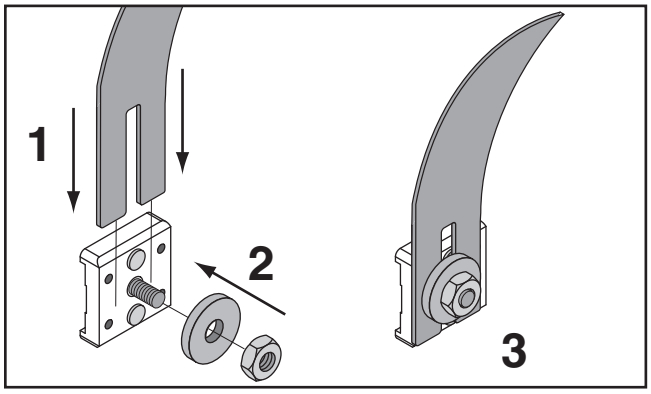


Figure 78. Installing riving knife on mounting block.

When to Use Riving Knife

Use the riving knife for all non-through cuts (defined on **Page 6**) or for those special operations where the blade guard or its components get in the way of safe operation, such as with very narrow cuts.

When Not to Use Riving Knife

Although it is possible to use the riving knife for through-cutting operations, the blade guard assembly offers far more injury protection and risk reduction than the riving knife. Therefore, **we strongly recommend** that you use the blade guard assembly and splitter/riving knife instead of the riving knife for through-cuts.

Blade Requirements

The riving knife included with this machine is 0.098" (2.5mm) thick and is only designed for 12" blades.

When choosing a main blade, make sure the blade size meets the requirements listed below. The thickness of the blade body and teeth can be measured with calipers or any precision measuring device.

Blade Size Requirements:
- Body Thickness: 0.087" (2.2mm)
- Kerf (Tooth) Thickness: 0.118" (2.99mm)

Blade Selection

This section on blade selection is by no means comprehensive. Always follow the saw blade manufacturer's recommendations to ensure safe and efficient operation of your table saw.

Ripping Blade Features:
- Best for cutting with the grain
- 30-40 teeth
- Flat-top ground tooth profile
- Large gullets for large chip removal

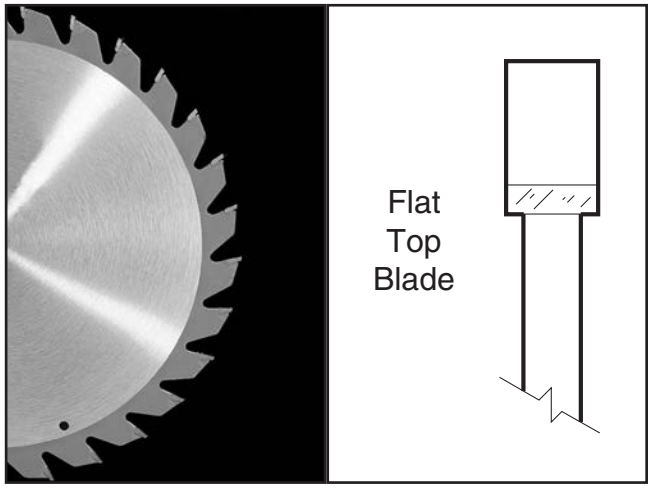


Figure 79. Ripping blade.

Crosscut Blade Features:
- Best for cutting across the grain
- 80–100 teeth
- Alternate top bevel tooth profile
- Small hook angle and a shallow gullet

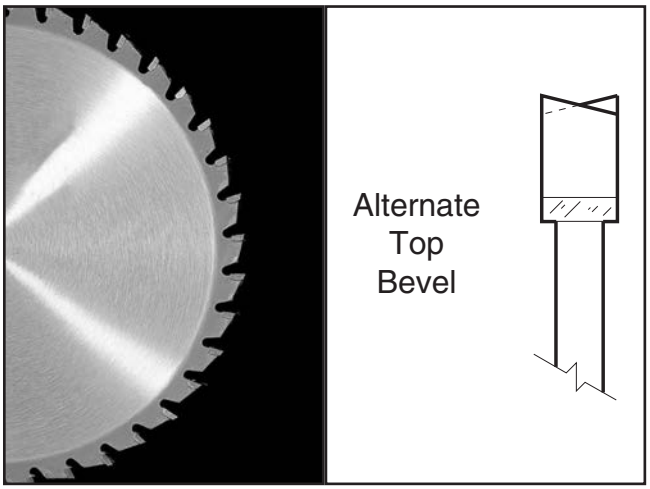


Figure 80. Crosscutting blade.

Combination Blade Features:
- Designed to cut both with and across grain
- 50–80 teeth
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile
- Teeth are arranged in groups
- Gullets are small and shallow (similar to a cross-cut blade), then large and deep (similar to a ripping blade

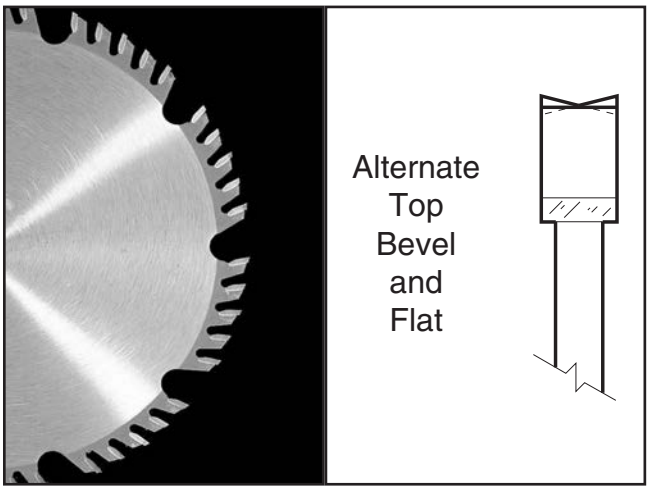


Figure 81. Combination blade.

Laminate Blade Features:

- Best for cutting plywood or veneer
- 100–120 teeth
- Triple chip tooth profile
- Very shallow gullet

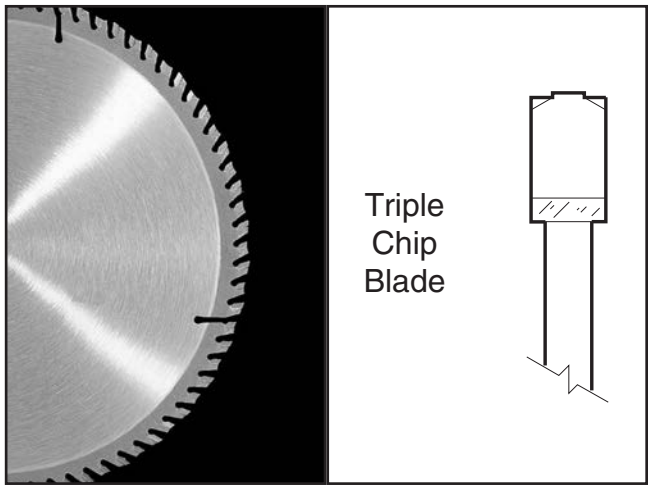


Figure 82. Laminate blade.

Thin Kerf Blade: A blade with thinner kerf than a standard blade. Since the splitter/riving knife included with this table saw is sized for standard blades, thin kerf blades cannot be used on this saw.

Changing Main Blade

The Model G0820 performs best when using sharp, high-quality blades. Whenever the main blade starts to get dull, resharpen or replace it with a new blade.

NOTICE

The Model G0820 does not ship with a 12" main blade. Refer to *Blade Requirements* and *Blade Selection* beginning on *Page 44* when purchasing the main blade.

Tools Needed	Qty
Hex Wrench 8mm	1
Wrench 30mm	1
T-Handle Wrench 8mm	1
Leather Gloves	1 Pair

To change main blade:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust blade tilt to 0° and raise blade all the way up.

3. Remove blade guard from splitter/riving knife.

4. Move sliding table all the way right to expose blade cover, then open blade cover.

5. Insert T-handle wrench through table top hole (see **Figure 83**) and into one of the holes in main blade pulley under table. This will keep blade arbor from rotating during next step.

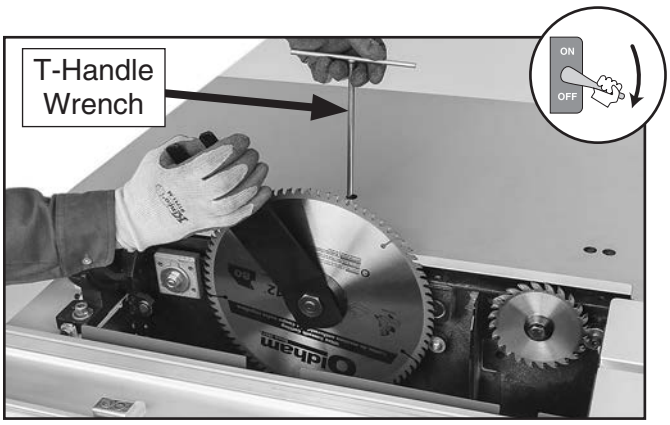


Figure 83. Loosening main blade arbor nut.

⚠CAUTION

Before proceeding with the next steps, wear leather gloves to protect your hands when handling saw and scoring blades.

6. While holding T-handle wrench with one hand, rotate arbor nut clockwise until you can remove nut, flange, and blade (see **Figure 84**).

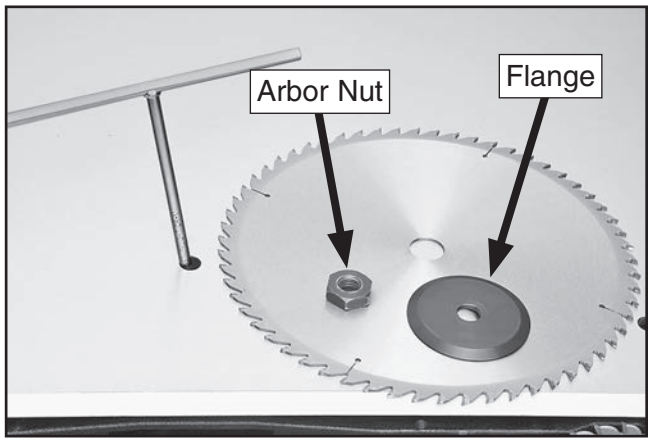


Figure 84. Main blade arbor nut and flange.

7. Install new blade, flange, and arbor nut in reverse order from removal, making sure upper blade teeth face RIGHT (see **Figure 85**), then tighten arbor nut.

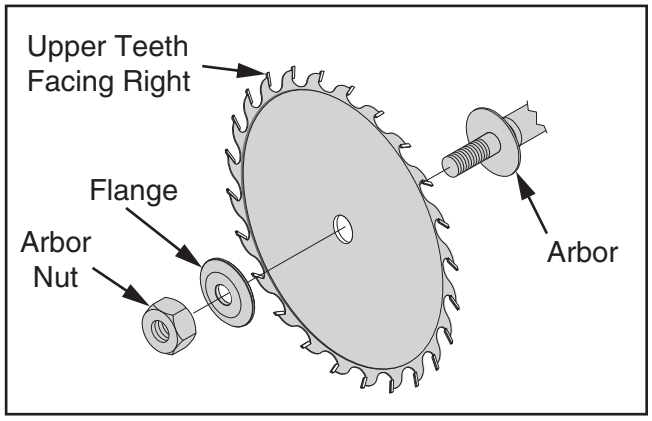


Figure 85. Order of assembly when installing main blade on arbor.

8. Close blade cover, re-install blade guard onto splitter/riving knife, then move sliding table back to center of machine.

9. Check scoring blade alignment with main blade, and adjust if necessary (see **Aligning Scoring Blade** on **Page 48**).

Replacing & Aligning Scoring Blade

The scoring blade rotates in the opposite direction from the main blade and makes a shallow cut into the workpiece surface. This prevents workpiece tearout.

The scoring blade included with the Model G0820 has wedge-shaped teeth that narrow at the top, as shown in **Figure 86**. With this style of scoring blade, the kerf thickness is adjusted by changing the height of the scoring blade. Raising the scoring blade higher increases the kerf thickness.

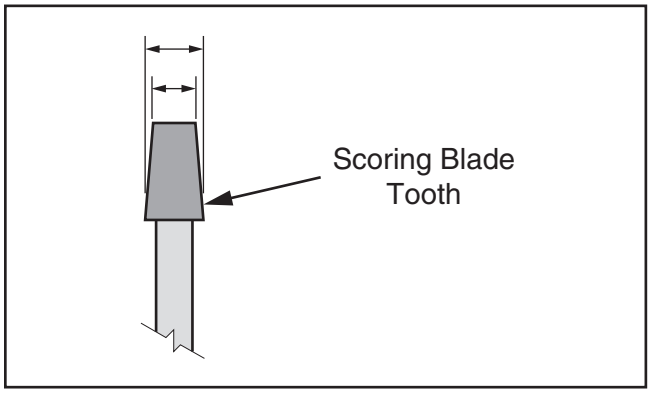


Figure 86. Scoring blade tooth that narrows at the top.

Replacing Scoring Blade

Tools Needed	**Qty**
Combo Wrench 19mm	1
Arbor Wrench	1

To replace scoring blade:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust blade tilt to 0° and raise blade all the way up.

3. Remove splitter/riving knife if it is installed.

4. Move sliding table all the way right to expose blade cover, then open blade cover.

5. Slide arbor wrench behind scoring blade onto flats of arbor (see **Figure 87**) to prevent blade from spinning.

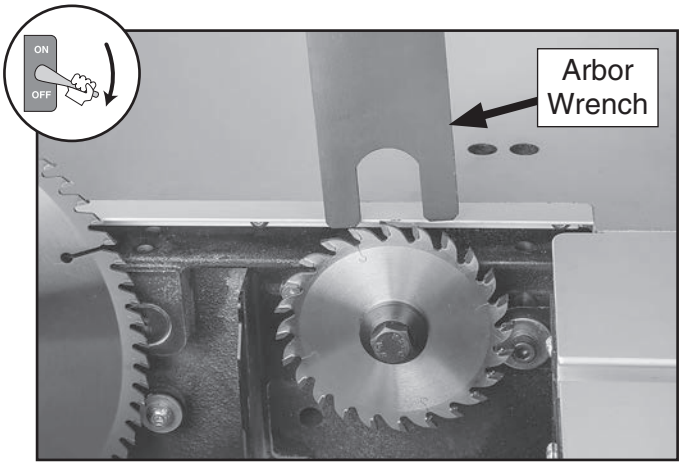


Figure 87. Inserting arbor wrench behind scoring blade to prevent blade from spinning.

6. Unthread arbor hex bolt counterclockwise (left-hand threads), and remove arbor hex bolt, flange, and blade (**see Figure 88**).

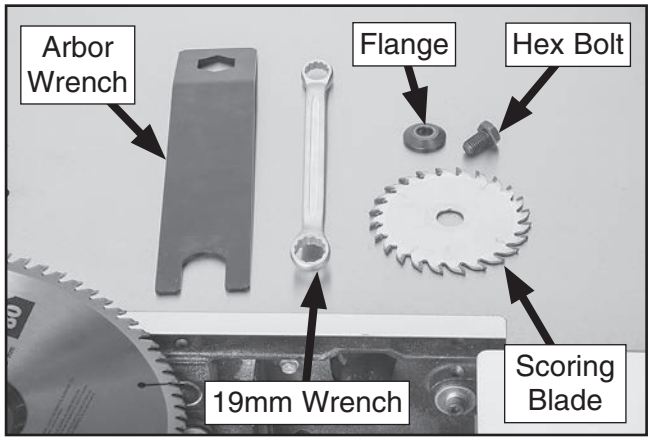


Figure 88. Scoring blade, flange, arbor hex bolt, 19mm wrench, and arbor wrench.

7. Install scoring blade set, flange, and arbor hex bolt in reverse order from removal, making sure upper blade teeth face LEFT (see **Figure 89**), then tighten arbor hex bolt.

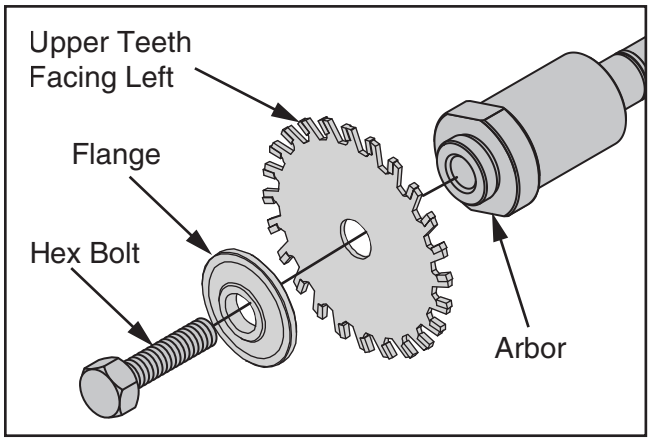


Figure 89. Scoring blade order of assembly.

8. Align scoring blade with main blade, as instructed in next subsection.

Aligning Scoring Blade

The goal in this procedure is to adjust the scoring blade vertical and horizontal positions so that the scoring kerf is the same width as the main blade kerf and is aligned with it. This will require placing the straightedge on both sides of the blades multiple times as you make adjustments.

Tools Needed	Qty
Hex Wrench 8mm	1
T-Handle Wrench 8mm	1
Straightedge	1

To adjust scoring blade position:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust blade tilt to 0° and raise blade all the way up.

3. If splitter/riving knife is installed, remove blade guard.

4. Move sliding table all the way forward to expose the blade cover, lock it in place, then open blade cover.

5. Align scoring blade horizontally to main blade body by:

   a. Positioning straightedge against flat of main blade body (not teeth) and extending it over scoring blade body.

   b. Inserting T-handle wrench into right hole shown in **Figure 90**, engaging it with adjustment bolt under table, then rotating wrench to align bodies of blades.

   Note: *Rotating T-handle wrench clockwise moves scoring blade left and counterclockwise moves it right.*

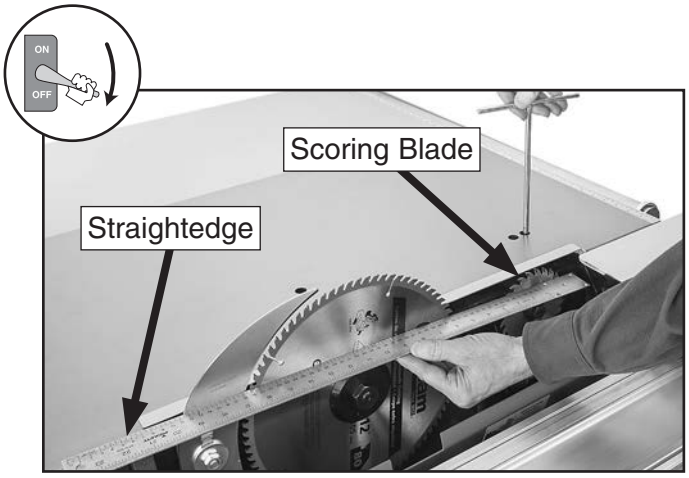


Figure 90. Adjusting horizontal position of scoring blade.

6. Align scoring blade kerf to main blade kerf by:

   a. Positioning straightedge on one side of main blade flat on table and against main blade teeth and scoring blade teeth.

   b. Inserting T-handle wrench into left hole shown in **Figure 91**, engaging it with adjustment bolt under table, then rotating wrench to position scoring blade, so edge of scoring blade teeth are aligned with main blade teeth.

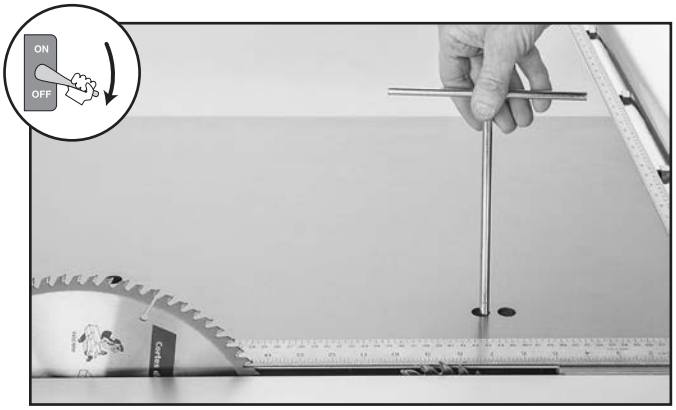


Figure 91. Adjusting vertical height of scoring blade.

7. Repeat **Step 6** for other side of blades to verify kerf thickness matches and scoring blade is aligned with main blade.

8. Close blade cover, properly reposition blade guard, and slide table back to center of machine.

9. Perform a test cut and check for chip-out. If there is chip-out, repeat this procedure until corrected.

Setting Up Crosscut Fence

Before using the crosscut fence to perform cutting operations, it must be set up properly. This includes positioning the crosscut fence on the crosscut table, adjusting the crosscut fence distance from the blade, and positioning the crosscut table along the sliding table.

Positioning Crosscut Fence

The crosscut fence can be mounted in the front or rear position (see **Figure 92**) depending upon the size of the workpiece and which position will provide the safest operation.

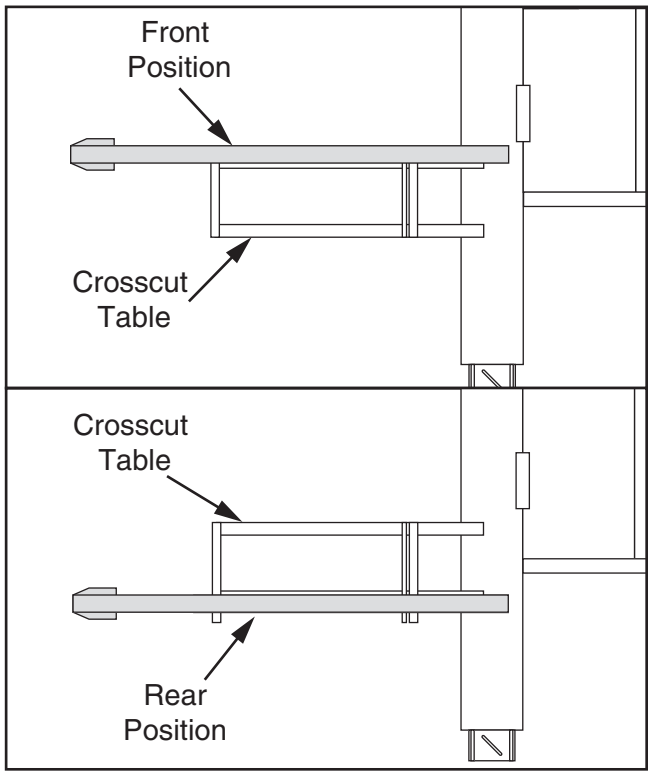


Figure 92. Crosscut fence front and rear table mounting positions.

Whenever the crosscut fence is moved between the front and rear positions, you must verify the fence is square to the blade, and the 0° stop bolts are properly adjusted before using the fence. Refer to **Squaring Crosscut Fence to Blade** on **Page 77** for further details.

To position crosscut fence:

1. DISCONNECT MACHINE FROM POWER!

2. Unthread and remove knob bolts shown in **Figure 93**.

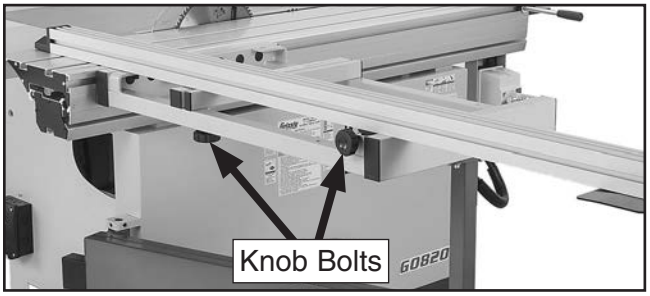


Figure 93. Locations of knob bolts securing crosscut fence.

3. Lift fence and loosen pivot bolt (see **Figure 94**).

4. Re-insert pivot bolt into front or rear hole, and re-insert angle scale T-bolt into angle scale slot (see **Figure 94**).

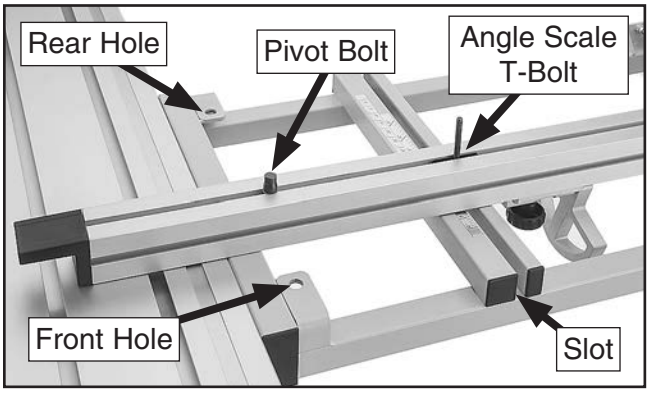


Figure 94. Crosscut fence pivot bolt.

5. Rotate fence so stop block is against 0° stop bolt (see **Figure 95**).

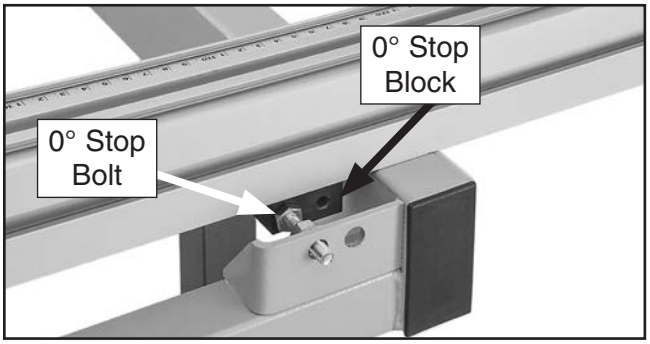


Figure 95. Stop block against 0° stop bolt.

Calibrating Crosscut Fence

To accurately use the crosscut fence scale and ensure the end cap does not contact the blade, the distance between the crosscut fence and the blade must be properly adjusted.

Tool Needed	Qty
Precision Ruler	1

To adjust distance between crosscut fence and blade:

1. DISCONNECT MACHINE FROM POWER!

2. Perform "To Position Crosscut Fence" procedure starting on **Page 49**.

3. Move crosscut table (refer to **Positioning Crosscut Table Along Sliding Table** for instructions) so fence end cap is aligned with center of blade body (see **Figure 96**).

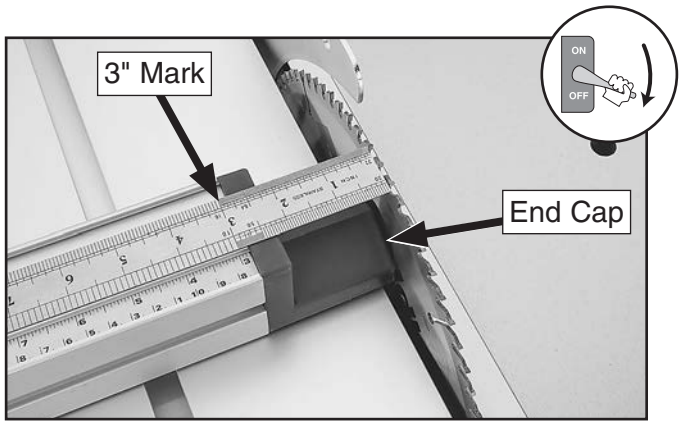


Figure 96. End cap aligned with blade.

4. Place precision ruler against a blade tooth, as shown in **Figure 96**, then adjust fence so that 3" mark on fence scale is exactly 3" from blade tooth.

5. Without disturbing pivot bolt position, lift fence up (see **Figure 94**), tighten pivot bolt, then re-insert pivot bolt into hole.

6. Repeat measurement in **Step 3**.

   — If measurement is not exactly 3", repeat **Step 4** until it is.

7. Re-install knob bolts removed earlier to secure setting.

Positioning Crosscut Table Along Sliding Table

The crosscut table can be positioned as necessary along the sliding table (see **Figure 97**).

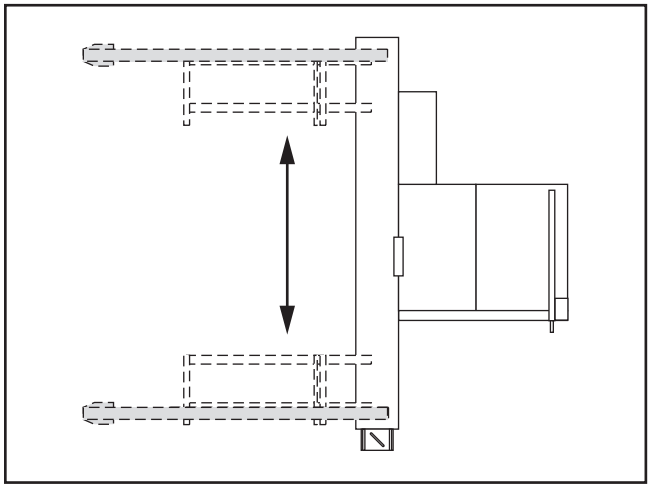


Figure 97. Crosscut table positions along sliding table.

To position crosscut table along sliding table:

1. DISCONNECT MACHINE FROM POWER!

2. Use sliding table lock lever (see **Figure 98**) to secure table in position.

Figure 98. Location of sliding table lock lever.

3. Loosen crosscut table lock lever shown in **Figure 99**.

Figure 99. Location of crosscut table lock lever.

4. Position crosscut table along sliding table T-slot to desired position, then retighten lock lever to secure table.

Rip Cutting

The Model G0820 has the capability of rip cutting large panels (see **Figure 100**). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

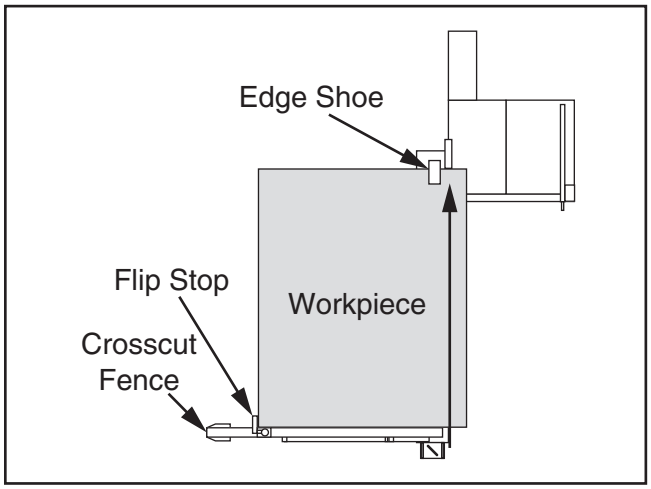


Figure 100. Rip cut with sliding table and crosscut fence.

The edge shoe (see **Figure 100**) is used to stabilize the front end of a workpiece when otherwise unsecured.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (see **Figure 101**). Smaller, lighter boards are easier to slide across the stationary cast-iron table surface to the right of the saw blade.

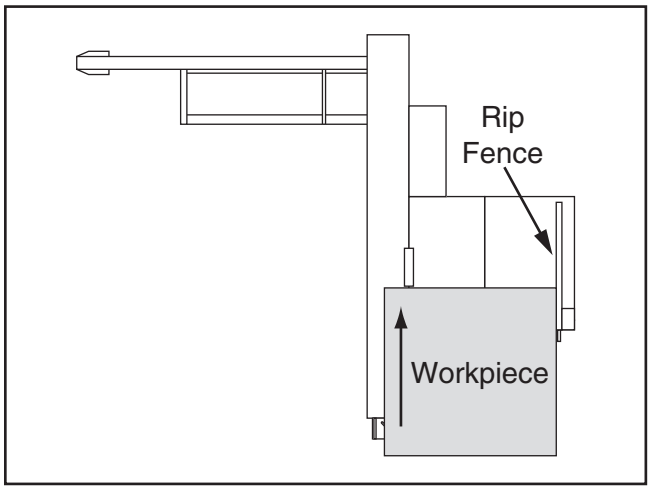


Figure 101. Traditional rip cut with rip fence.

Determine which cutting operation will be best suited for the workpiece to be ripped.

- To use the sliding table, read the instructions titled “Rip Cutting with Sliding Table.”
- To use the machine as a traditional table saw, skip ahead to “Rip Cutting with Rip Fence.”

Rip Cutting with Sliding Table

1. Position crosscut fence on crosscut table according to cutting operation (see **Setting Up Crosscut Fence** on **Page 49**) and rotate it until 0° stop block touches 0° stop bolt (see **Figure 102**).

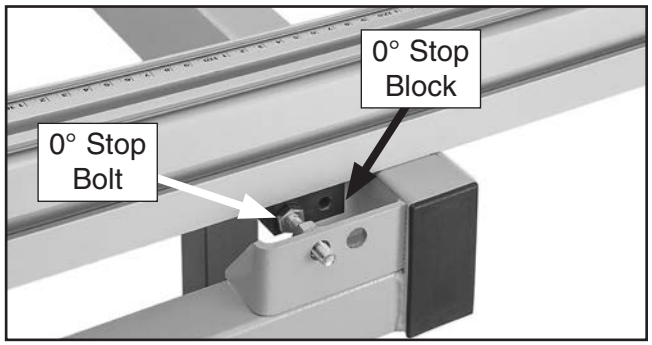


Figure 102. Stop block against 0° stop bolt.

2. Check to make sure fence is at 0°. If necessary, adjust it as described in **Squaring Crosscut Fence to Blade**t on **Page 77**.

3. Calibrate crosscut fence (refer to **Page 50** for further details).

4. Set flip stop to desired width of cut (see **Figure 103**) by loosening flip stop knob bolt, sliding flip stop until it aligns with desired mark on scale, and retightening knob bolt.

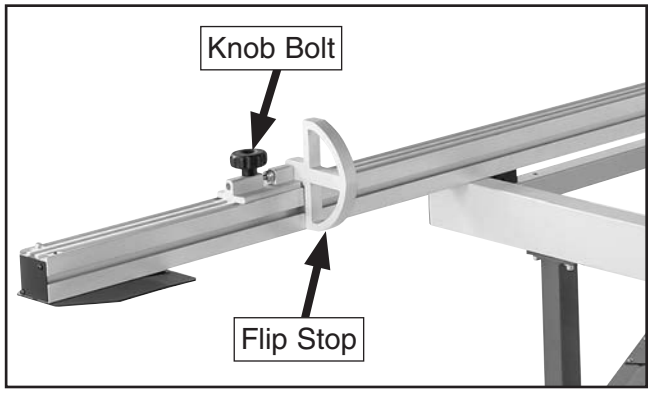


Figure 103. Location of flip stop and flip stop knob bolt.

5. Load workpiece onto table saw. The setup should look similar to **Figure 100** on **Page 51**.

6. Take all necessary safety precautions, then perform cutting operation.

Rip Cutting with Rip Fence

1. Move crosscut table and fence to front of sliding table, and lock them in place with crosscut table lock lever (see **Figure 104**).

Figure 104. Location of crosscut table lock lever.

2. Lock sliding table in place with sliding table lock lever (see **Figure 105**).

Figure 105. Location of sliding table lock lever.

3. Loosen slide lock lever shown in **Figure 106**.

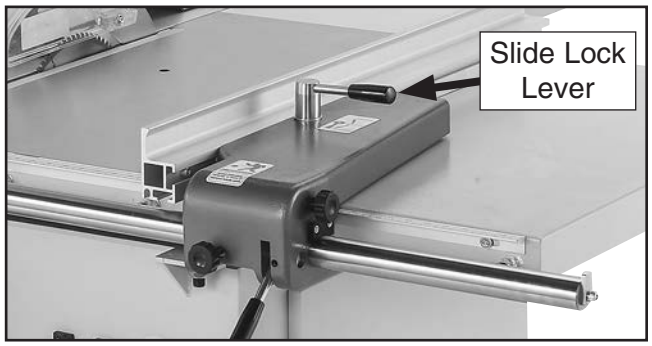


Figure 106. Location of slide lock lever.

4. Place fence in vertical position (see **Figure 107**) for thicker workpieces, or in horizontal position for thinner workpieces and for angled cuts where blade is tilted over fence.

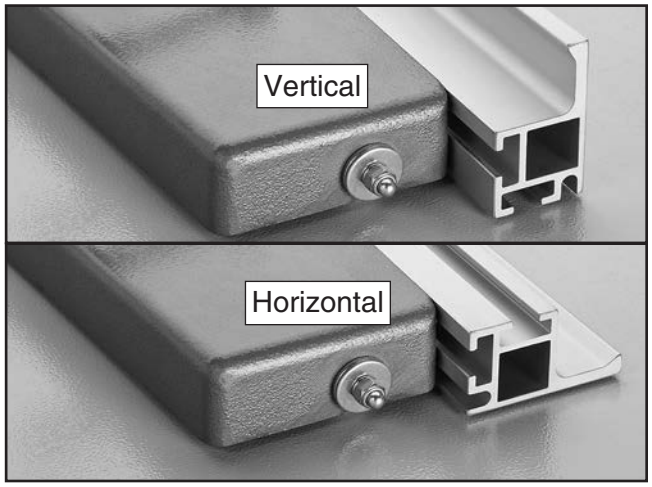


Figure 107. Rip fence positions.

5. Position leading edge of rip fence so it extends across extension wing, as shown in **Figure 108**, then retighten lock lever.

6. Lift rip fence lock lever (see **Figure 108**) and adjust fence to approximate width of cut.

7. Tighten micro-adjust lock knob (see **Figure 108**), then turn micro-adjust knob to fine tune width of cut.

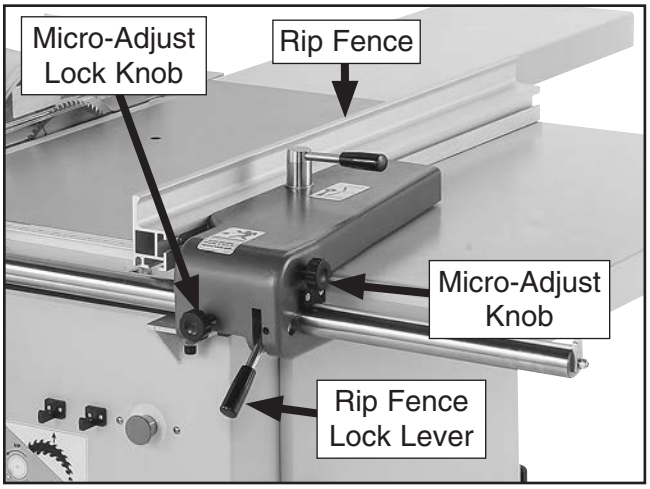


Figure 108. Proper position of rip fence.

8. Push rip fence lock lever down to secure fence assembly in position.

9. Load workpiece onto table saw. The setup should look similar to **Figure 101** on **Page 51**.

10. Take all necessary safety precautions, then perform cutting operation.

Crosscutting

The Model G0820 can crosscut full-size panels with the fence in the front or rear position, although it is easier to load full-size panels with the crosscut fence mounted in the front position (see **Figure 109**).

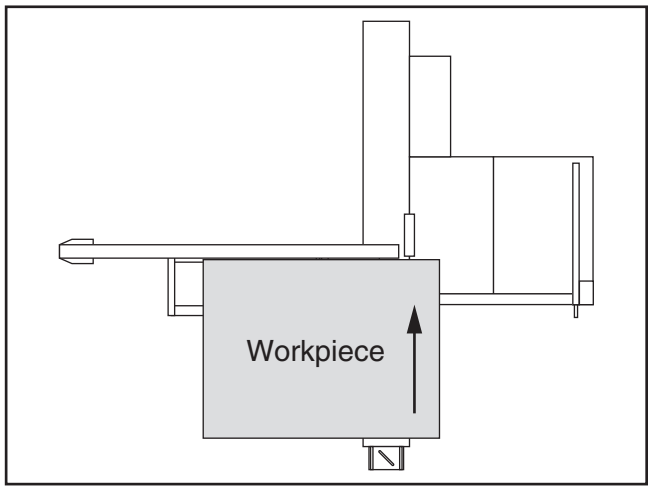


Figure 109. Crosscut with fence mounted in front position.

Mounting the crosscut fence in the rear position (see **Figure 110**) gives greater stability for crosscutting smaller panels.

The edge shoe is used to stabilize the front end of the workpiece when otherwise unsecured.

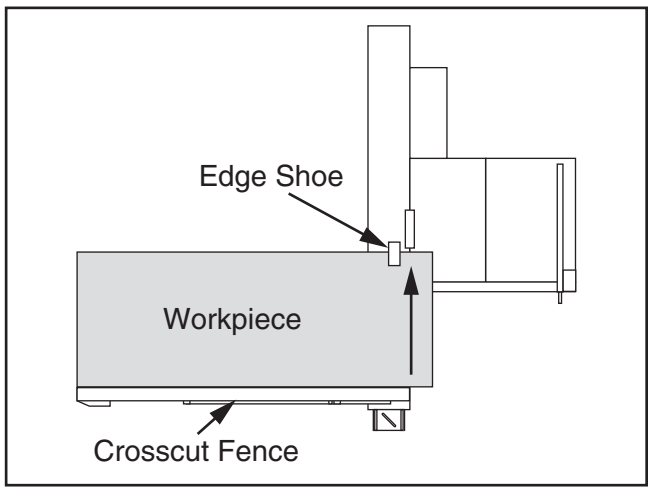


Figure 110. Crosscut with fence mounted in rear position.

When set up properly, the crosscut fence can support workpieces while using the rip fence as a cut-off gauge, as shown in **Figure 111**.

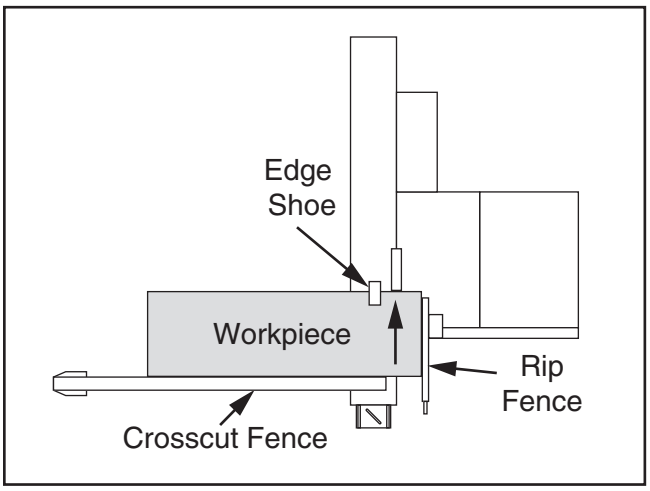


Figure 111. Crosscutting using rip fence as a cut-off gauge.

Determine which cutting operation will be best suited for the workpiece to be crosscut.

— If you will be crosscutting full-size panels, then skip ahead to **Crosscutting Full-Size Panels**.

— If you will be crosscutting smaller panels, then skip ahead to **Crosscutting Smaller Panels**.

— If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to **Crosscutting Using Rip Fence as Cut-Off Gauge**.

To understand how to move the crosscut table, read **Positioning Crosscut Table Along Sliding Table** on **Page 50**.

Crosscutting Full-Size Panels

1. Install crosscut fence in front mounting location shown in **Figure 112**.

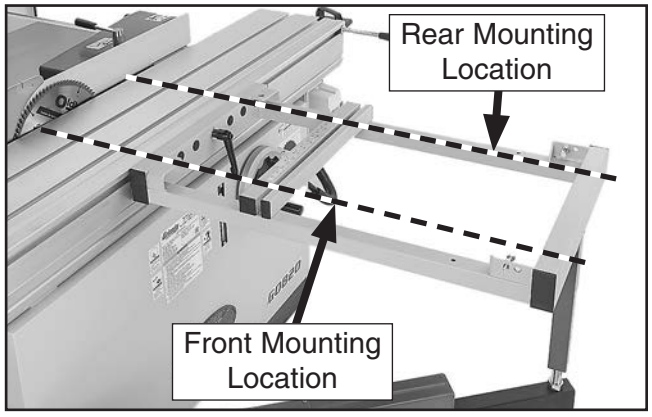


Figure 112. Crosscut fence mounting locations.

2. Check to make sure fence is at 0°, and if necessary, adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 77**.

3. Adjust distance between crosscut fence and blade (refer to **Page 50** for further details).

4. Set flip stop to desired width of cut.

5. Load workpiece onto table saw in front mounting location shown in **Figure 109**.

6. Take all necessary safety precautions, then perform cutting operation.

Crosscutting Smaller Panels

1. Install crosscut fence in rear mounting location shown in **Figure 110** and lock it in place.

2. Perform **Steps 2 & 3** in **Crosscutting Full-Size Panels.**

3. Set flip stop to desired width of cut.

4. Load workpiece onto table saw in rear mounting location, shown in **Figure 110**. If necessary, use edge shoe to secure workpiece to sliding table.

5. Take all necessary safety precautions, then perform cutting operation.

Crosscutting Using Rip Fence as Cut-Off Gauge

1. Install crosscut fence in rear position of crosscut table, as illustrated in **Figure 111** on **Page 54**.

2. Perform **Steps 2 & 3** in **Crosscutting Full-Size Panels.**

3. Set rip fence to desired width of cut.

4. Slide leading end of rip fence behind front edge of blade (see **Figure 113** for an example).

   IMPORTANT: *This step is critical to reducing the risk of blade binding and kickback.*

5. Load workpiece onto table saw and against rip fence. The setup should look similar to **Figure 113**.

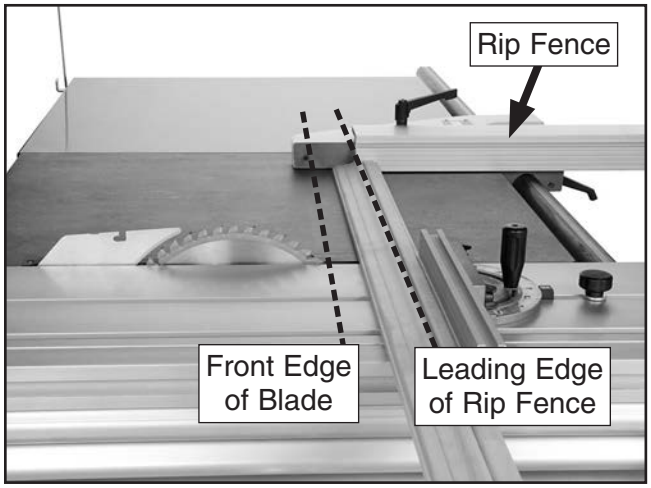


Figure 113. Example photo of correct rip fence position when using it as a cut-off gauge (blade guard removed for clarity).

6. Take all necessary safety precautions, then perform cutting operation.

Miter Cutting

The crosscut fence can be positioned for miter cuts from 0° to 45° (see **Figure 114**) using the front or rear crosscut table holes. The angle scale on top of the crosscut table has a resolution of 1°.

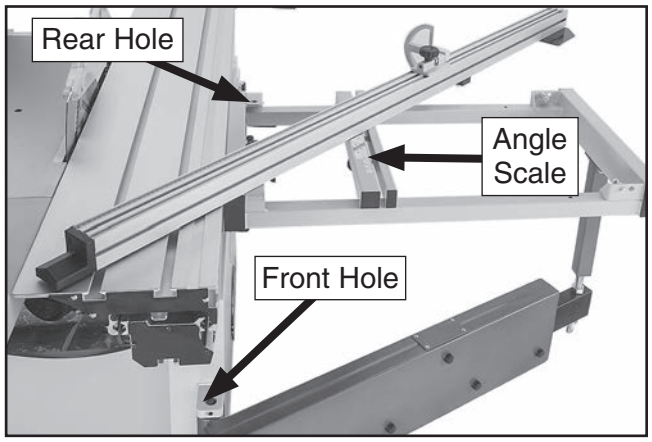


Figure 114. Crosscut fence positioned for miter cut.

To perform a miter cut:

1. DISCONNECT MACHINE FROM POWER!

2. Position crosscut table to provide greatest amount of workpiece support, then lock it in place.

3. Install fence pivot bolt into front or rear holes shown in **Figure 114** to position table for desired angle of cut (see **Figures 115–116**).

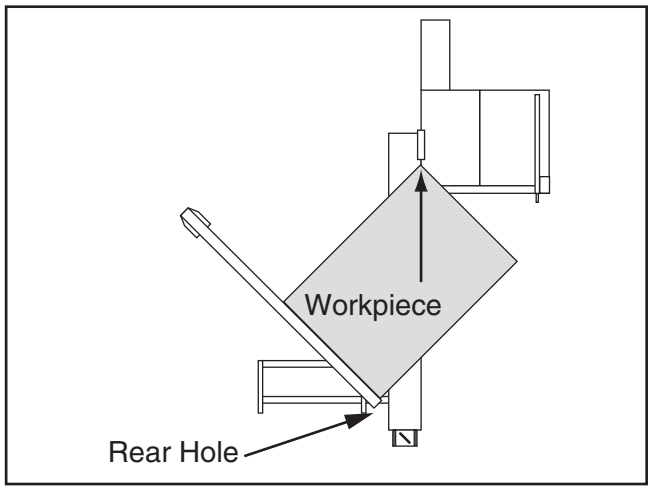


Figure 115. Crosscut fence mounted in rear hole for miter cuts from 0° to 45°.

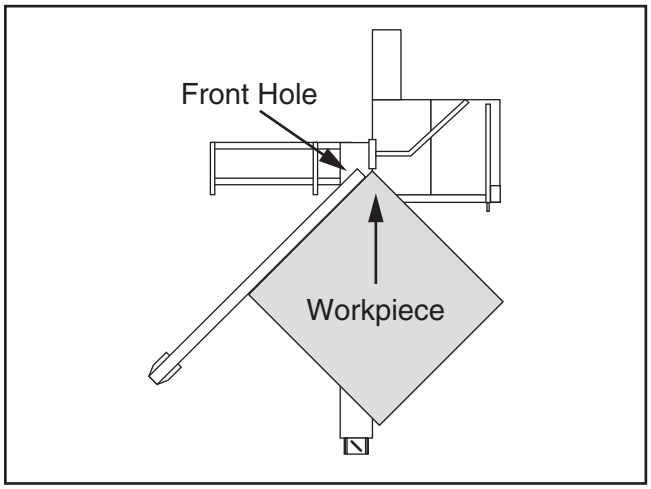


Figure 116. Crosscut fence mounted in front hole for miter cuts from 0° to 45°.

4. Install angle scale knob bolt (see **Figure 117**).

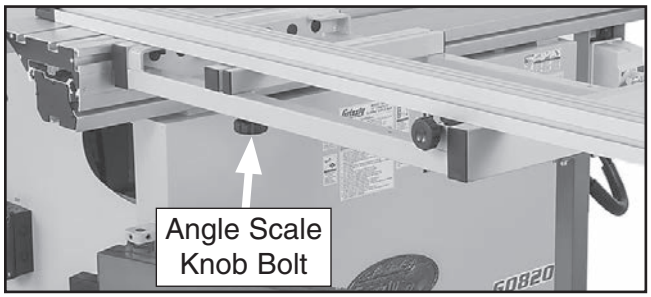


Figure 117. Location of angle scale knob bolt.

5. Pivot crosscut fence to desired angle, making sure fence end cap is clear of blade so it will not be cut during operation.

6. Tighten angle scale knob bolt to secure setting.

⚠WARNING

If the crosscut fence moves during cutting, kickback could occur and cause serious personal injury. Always make sure crosscut fence is properly secured before using it.

7. Set flip stop according to length of workpiece you want to cut off to left of blade.

8. Load workpiece onto crosscut table. The setup should look similar to **Figures 115–116**.

9. Take all necessary safety precautions, connect saw to power, then perform cutting operation.

Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece.

Typically, dadoes can be cut using either a dedicated dado blade or a standard saw blade. However, since the Model G0820 cannot accept dado blades, a standard blade must be used.

To use standard saw blade to cut a dado:

1. DISCONNECT MACHINE FROM POWER!

2. Mark width of dado cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is lying on table.

3. Raise blade to desired depth of dado channel.

4. Align workpiece with blade to cut one dado side, as shown in **Figure 118**, then align rip fence with workpiece.

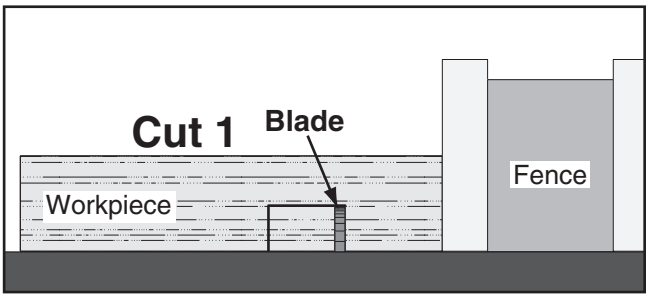


Figure 118. First cut for a single-blade dado.

5. Reconnect saw to power and turn saw ***ON***.

6. Allow blade to reach full speed, then perform the cutting operation.

7. Adjust fence and repeat cutting operation on other side of dado channel, as shown in **Figure 119.**

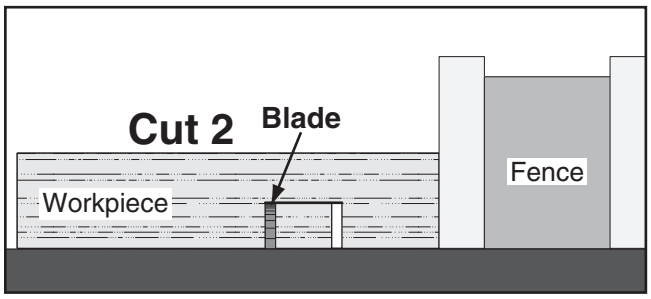


Figure 119. Second cut for a single-blade dado.

8. Make additional cuts (see **Figure 120**) in center of dado to clear out necessary material. Dado is complete when channel is completely cleared out.

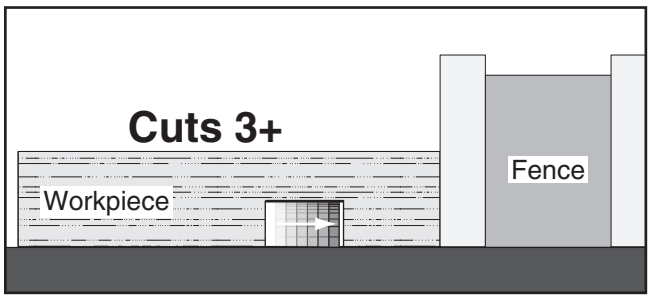


Figure 120. Additional single-blade dado cuts.

⚠WARNING

Adjust rip fence to properly support workpiece for each of the dado cuts. This will reduce likelihood of kickback and injury.

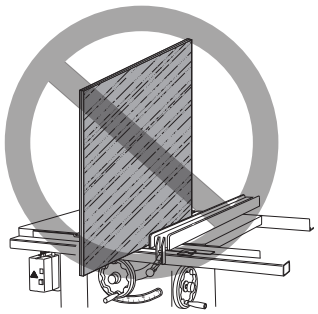
Rabbet Cutting

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece.

Typically, rabbets can be cut with either a dado blade or a standard saw blade. However, because the Model G0820 cannot accept dado blades, rabbets must be cut with a standard saw blade only.

A ripping blade is typically the best blade to use for cutting rabbets when using a standard blade because it removes sawdust very efficiently. (See **Page 44** for blade details.) Also, a sacrificial fence is not required when cutting rabbets with a standard blade.

⚠WARNING



DO NOT place a tall board on edge when cutting a rabbet. Overly tall workpieces cannot be properly supported with the fence and can easily shift during operation, causing kickback or loss of control. Instead, use another tool to cut these types of rabbets.

To cut rabbets with standard blade:

1. DISCONNECT MACHINE FROM POWER!

2. Mark width of rabbet cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is lying on table.

⚠CAUTION

Always use push sticks, featherboards, push paddles, and other safety accessories whenever possible to increase safety and control during operations which require removal of blade guard. ALWAYS replace blade guard after operation is complete.

3. Raise blade to desired depth of rabbet channel desired.

4. Stand workpiece on edge, as shown in **Figure 121,** then adjust rip fence so blade is aligned with inside of rabbet channel.

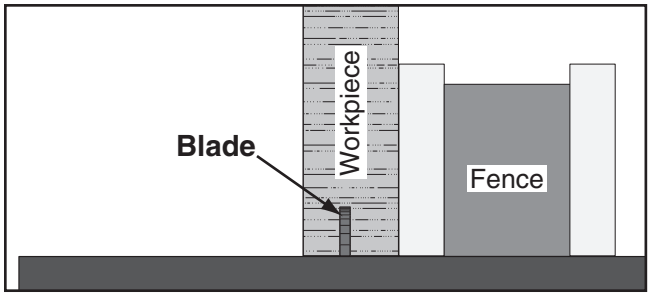


Figure 121. First rabbet cut.

5. Reconnect saw to power source, then perform cut.

6. Lay workpiece flat on table, as shown in **Figure 122**, adjust saw blade height to intersect with first cut, then perform second cut to complete rabbet.

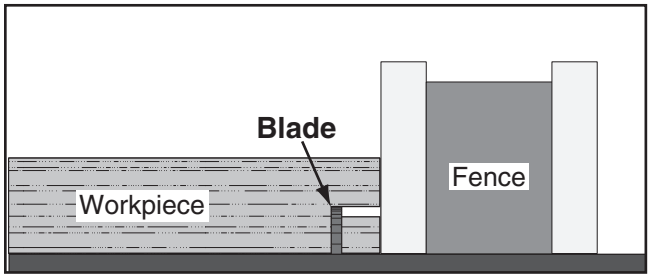


Figure 122. Second cut to create a rabbet.

Resawing

⚠WARNING

Resawing operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when resawing. Any tilting or movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

Resawing is the process of cutting a thick piece of stock into one or more thinner pieces. Although resawing can be done with a table saw, we strongly recommend that you use a bandsaw instead.

A bandsaw is the ideal machine for resawing, and resawing with one is fairly easy and safe. A table saw is not intended for resawing, and resawing with one is difficult and dangerous due to the increased risk of kickback from binding and deep cuts, and the increased risk of injury from having to remove the blade guard.

If you insist on resawing with a table saw, DO NOT do so without using a resaw barrier and wearing safety glasses and a full face shield.

The following instructions describe how to build a resaw barrier that can be used with the rip fence when resawing to reduce the risk of injury.

IMPORTANT: *This table saw can only resaw wood that is less than 8" tall, and the rip fence must be used (rather than the sliding table).*

Making a Resaw Barrier

The resaw barrier acts in tandem with the rip fence when resawing to provide tall support for the workpiece to minimize the probability of it binding against the blade and causing kickback.

Tools Needed:	**Qty**
Table Saw	1
Jointer and Planer	Recommended
Clamps	2 Minimum
Drill and Drill Bits	1

Components Needed for Resaw Barrier:

Wood* ¾" x 5½" x Length of Fence	1
Wood* ¾" x 3" x Length of Fence	1
Wood Screws #8 x 2"	8
Wood Glue	As Needed

**Only use furniture-grade plywood or kiln-dried hardwood to prevent warping.*

To build resaw barrier:

1. Cut wood pieces to sizes specified above. If using hardwood, cut pieces oversize, then joint and plane them to correct size to make sure they are square and flat.

2. Pre-drill and countersink four holes approximately ⅜" from bottom of 5½" tall wood piece.

3. Glue end of 3" board, then clamp boards at a 90° angle with larger board in vertical position, as shown in **Figure 123**, and fasten together with wood screws.

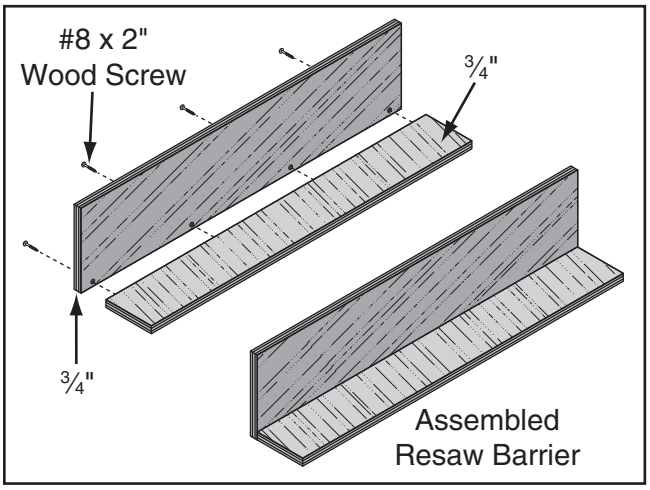


Figure 123. Resaw barrier.

Resawing Operations

The table saw motor is pushed to its limits when resawing. If the motor starts to bog down, slow down your feed rate. Motor overloading and blade wear can be reduced by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.

Components Needed for Resawing:

Ripping Blade 12" 1
Clamps 2
Shop-Made Resaw Barrier 1

⚠WARNING

You may experience kickback during this procedure. Stand to the side of the blade path and wear safety glasses and a full face shield to reduce risk of injury.

To perform resawing operations:

1. DISCONNECT MACHINE FROM POWER!
2. Raise blade guard up and out of the way.
3. Install rip fence in vertical position.
4. Place workpiece against rip fence and slide resaw barrier against workpiece (see **Figure 124**).

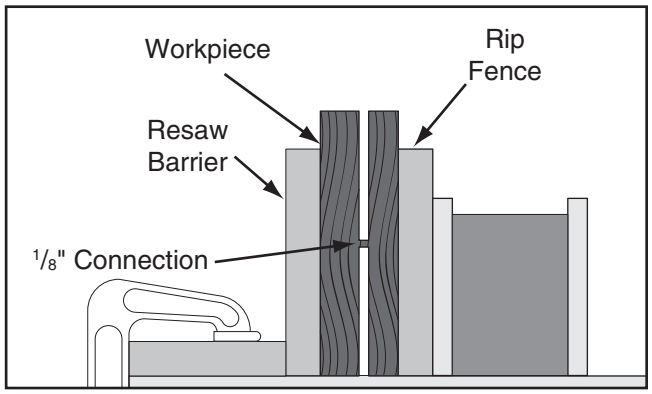


Figure 124. Ideal completed resaw cut.

5. Clamp resaw barrier to table top.
6. Connect saw to power, lower blade completely below table, and slide workpiece over blade to make sure it moves smoothly and fits between resaw barrier and rip fence.
7. Raise blade approximately 1", or close to half the height of the workpiece, whichever is less.
8. Turn machine ***ON***, and use push stick to feed workpiece through blade using a slow, steady feed rate.
9. Flip workpiece end for end, keeping same side against rip fence, and run workpiece through blade.
10. Repeat **Steps 7–9** until blade is close to half the height of workpiece to be resawn.

    IMPORTANT: *The ideal completed resaw cut will leave approximately ⅛" connection when the resawing is complete, as shown in* ***Figure 124****. Leaving a ⅛" connection will reduce risk of kickback.*

11. Turn saw ***OFF***, then separate parts of workpiece and hand plane remaining ridge.
12. When finished resawing, remove resaw barrier and reposition blade guard over blade.

SECTION 5: SHOP MADE SAFETY ACCESSORIES

Featherboards

Easily made from scrap stock, featherboards provide an added degree of protection against kickback, especially when used together with push sticks. They also maintain pressure on the workpiece to keep it against the fence or table while cutting, which makes the operation easier and safer because the cut can be completed without the operator's hands getting near the blade. The angled ends and flexibility of the fingers allow the workpiece to move in only one direction.

Making a Featherboard

This sub-section covers the two basic types of featherboards: 1) Those secured by clamps, and 2) those secured with the miter slot.

Material Needed for Featherboard
Hardwood ¾" x 3" x 10" (Minimum)
Hardwood ¾" x 6" x 28" (Maximum) 1

Additional Material Needed for Mounting Featherboard in Miter Slot
Hardwood ⅜" x (Miter Slot Width) x 5"L 1
Wing Nut ¼"-20.....1
Flat Head Screw ¼"-20 x 2".....1
Flat Washer ¼"-20.....1

To make a featherboard:

1. Cut hardwood board approximately ¾" thick to size. The length and width of board can vary according to your design. Most featherboards are 10"–28" long and 3"–6" wide. Make sure wood grain runs parallel with length of featherboard, so fingers you will create in **Step 3** will bend without breaking.

2. Cut a 30° angle at one end of board.

CAUTION

We recommend using a bandsaw for making fingers in the next step because it tends to be safer. A table saw can be used, but it will over-cut the underside of the ends, produce a thicker kerf, and require you to stop the blade half-way through the cut, which can be dangerous.

3. Make a series of end cuts with grain ⅜"–¼" apart and 2"–3" long, as shown in **Figure 125** (A). Alternatively, start cuts at 2"-3" deep, then make them progressively deeper, as shown in **Figure 125** (B).

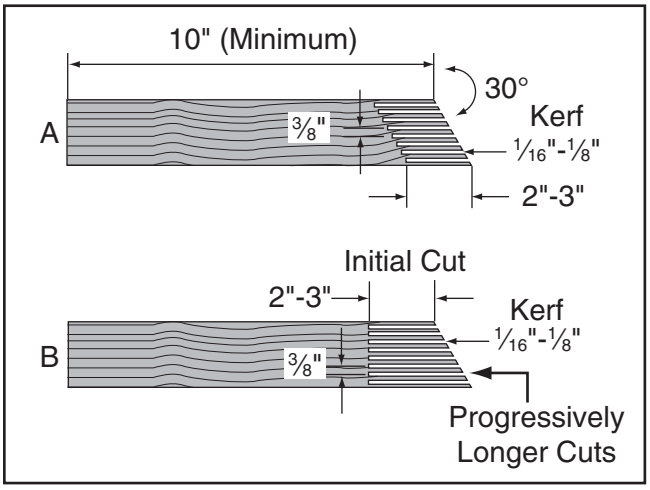


Figure 125. Patterns for featherboards (top view shown).

IMPORTANT: Cuts made across grain result in weak fingers that easily break when flexed. When made correctly, fingers should withstand flexing from moderate pressure. To test the finger flexibility, push firmly on the ends with your thumb. If the fingers do not flex, they are likely too thick (the cuts are too far apart).

NOTICE

Only Steps 1–3 are required to make a clamp-mounted featherboard. Refer to Page 63 for instructions on clamping.

4. Rout ¼"–⅜" wide slot 4"–5" long in workpiece and 1"–2" from short end of featherboard (see **Figure 126**).

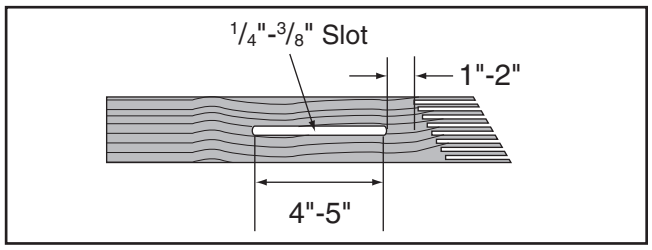


Figure 126. Slot routed in featherboard.

5. Cut miter bar that will fit in table miter slot approximately 5" long, as shown in **Figure 127.**

Tip: *Consider making the miter bar longer for larger featherboards—approximately half the length of the total featherboard—to support the force applied to the featherboard during use.*

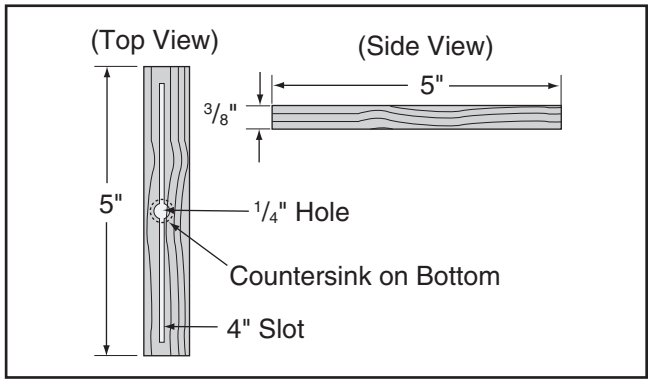


Figure 127. Miter bar pattern.

6. Drill ¼" hole in center of bar, then countersink bottom to fit ¼"-20 flat head screw.

7. Mark 4" line through center of countersunk hole in center, then use jig saw with narrow blade to cut it out.

8. Assemble miter bar and featherboard with ¼"-20 x flat head screw, flat washer, and a wing nut or a star knob (see **Figure 128**). Congratulations! Your featherboard is complete.

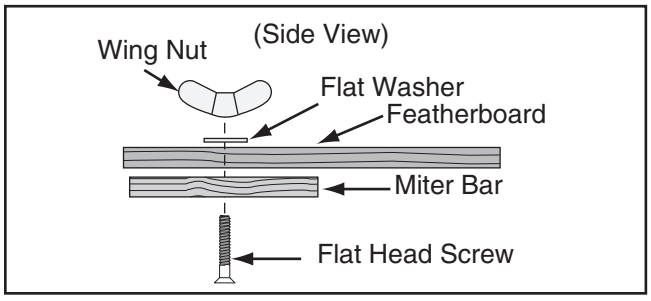


Figure 128. Assembling miter slot featherboard components.

Note: *The routed slot, countersink hole, and the flat head screw are essential for the miter bar to clamp into the miter slot. When the wing nut is tightened, it will draw the flat head screw upward into the countersunk hole. This will spread the sides of the miter bar and force them into the walls of the miter slot, locking the featherboard in place.*

Tip: *The length of the flat head screw depends on the thickness of the featherboard—though 1½" to 2" lengths usually work.*

Now, proceed to **Mounting Featherboard in Miter Slot** on **Page 63**.

Mounting Featherboards w/Clamps

1. Lower saw blade, then adjust fence to desired width and secure it.

2. Place workpiece against fence, making sure it is 1" in front of blade.

3. Place featherboard on table away from blade so all fingers point forward and contact workpiece (see **Figure 129**).

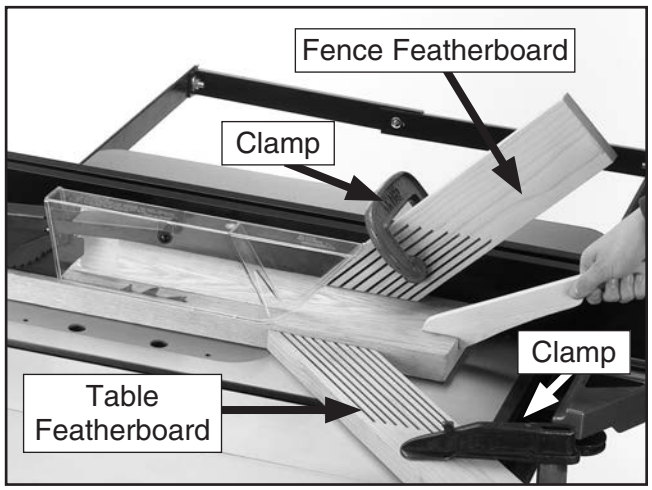


Figure 129. Example of featherboards secured with clamps.

4. Secure featherboard to table with clamp.

5. Check featherboard by pushing it with your thumb to ensure it is secure.

   — If featherboard moves, tighten clamp more.

6. Mount second featherboard to fence with another clamp (see **Figure 129**), then repeat **Step 5** to ensure it is secure.

Mounting Featherboard in Miter Slot

1. Lower saw blade, then adjust fence to desired width and secure it.

2. Place workpiece evenly against fence, making sure it is 1" in front of blade.

3. Slide featherboard miter bar into miter slot, making sure fingers slant toward blade, as shown in **Figure 130**.

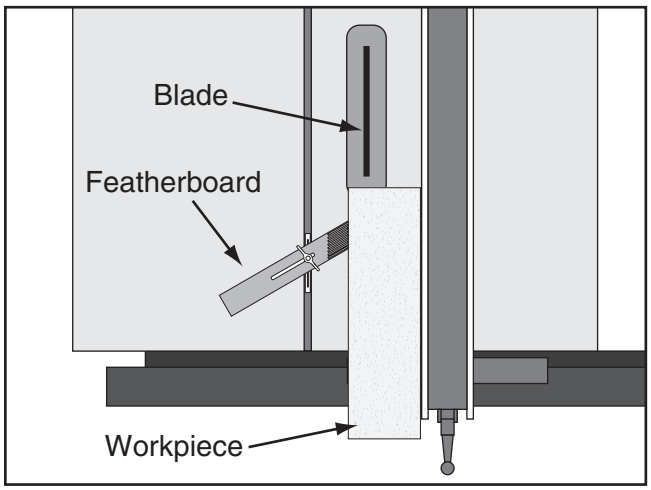


Figure 130. Featherboard installed in miter slot and supporting workpiece for ripping cut.

4. Position fingered edge of featherboard against edge of workpiece, so that all of fingers contact workpiece. Slide featherboard toward blade until first finger is nearly even with end of workpiece, which should be 1" away from blade.

5. Double-check workpiece and featherboard to ensure they are properly positioned as described in **Step 4**. Then secure featherboard to table. Check featherboard by hand to make sure it is tight.

   Note: *The featherboard should be placed firmly enough against the workpiece to keep it against the fence but not so tight that it is difficult to feed the workpiece.*

Push Sticks

When used correctly, push sticks reduce the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push stick can also absorb damage that would have otherwise happened to hands or fingers.

Using a Push Stick

Use push sticks whenever your hands will get within 12" of the blade. To maintain control when cutting large workpieces, start the cut by feeding with your hands then use push sticks to finish the cut, so your hands are not on the end of the workpiece as it passes through the blade.

Feeding: Place the notched end of the push stick against the end of the workpiece (see inset **Figure** below), and move the workpiece into the blade with steady downward and forward pressure.

Supporting: A second push stick can be used to keep the workpiece firmly against the fence while cutting. When using a push stick in this manner, only apply pressure before the blade; otherwise, pushing the workpiece against or behind the blade will increase the risk of kickback (see "Push Stick Prohibition Zone" in the **Figure** below).

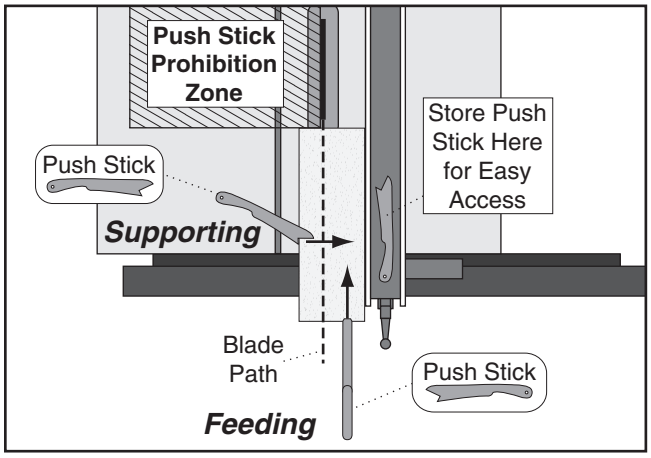


Figure 131. Using push sticks to rip narrow stock.

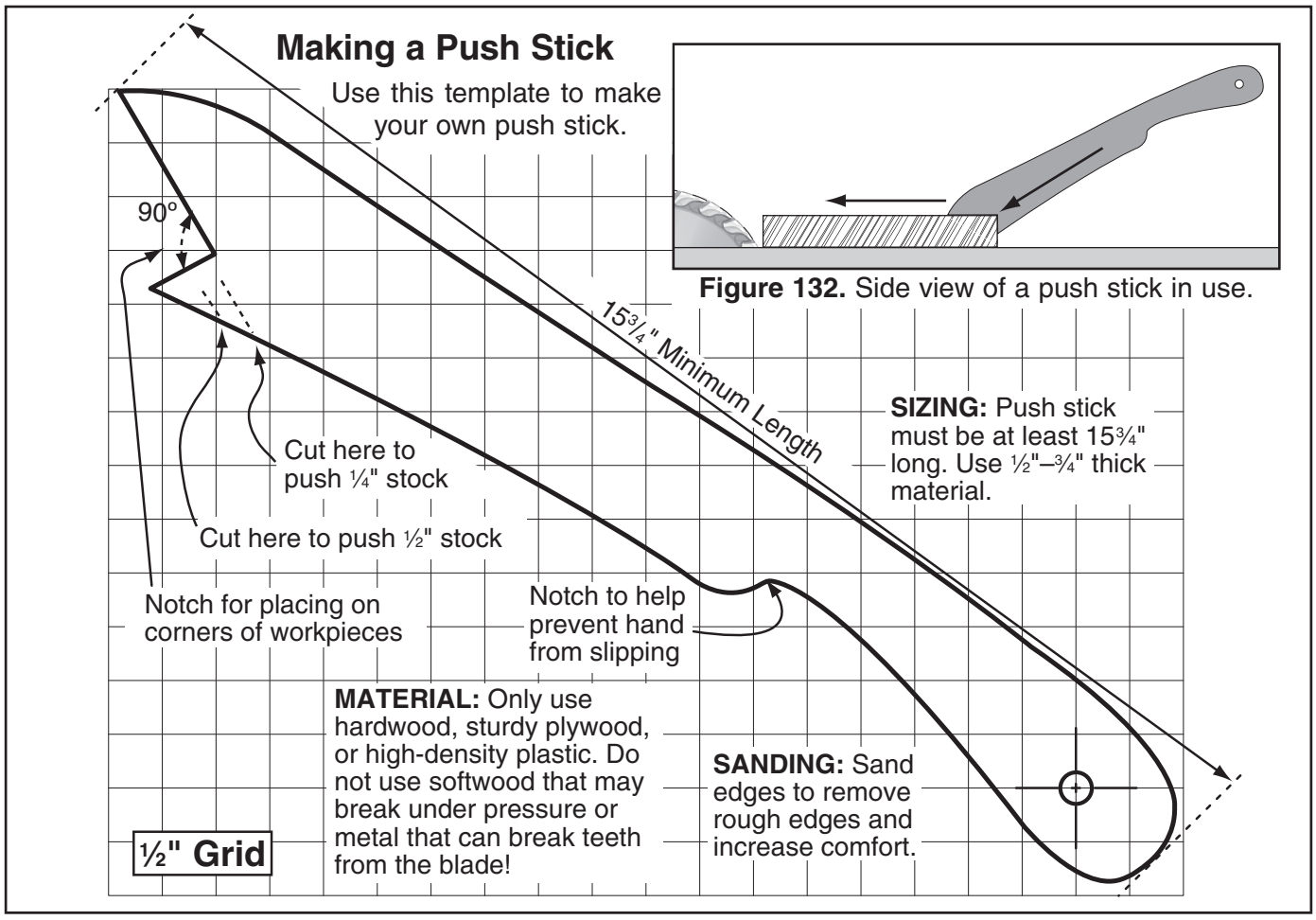


Figure 132. Side view of a push stick in use.

Figure 133. Template for a basic shop-made push stick (not shown at actual size).

Push Blocks

When used correctly, a push block reduces the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push block often takes the damage that would have otherwise happened to hands or fingers.

Using a Push Block

A push block can be used in place of or in addition to a push stick for feeding workpieces into the blade. Due to their design, push blocks allow the operator to apply firm downward pressure on the workpiece that could not otherwise be achieved with a push stick.

The push block design on this page can be used in two different ways (see inset **Figure** below). Typically, the bottom of the push block is used until the end of the workpiece reaches the blade.

The notched end of the push block is then used to push the workpiece the rest of the way through the cut, keeping the operator's hands at a safe distance from the blade. A push stick is often used at the same time in the other hand to support the workpiece during the cut (see "Using a Push Stick" on previous page).

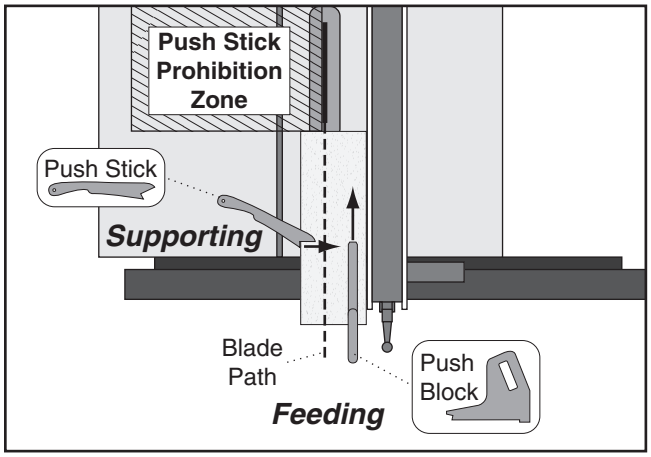


Figure 135. Using a push block and push stick to make a rip cut.

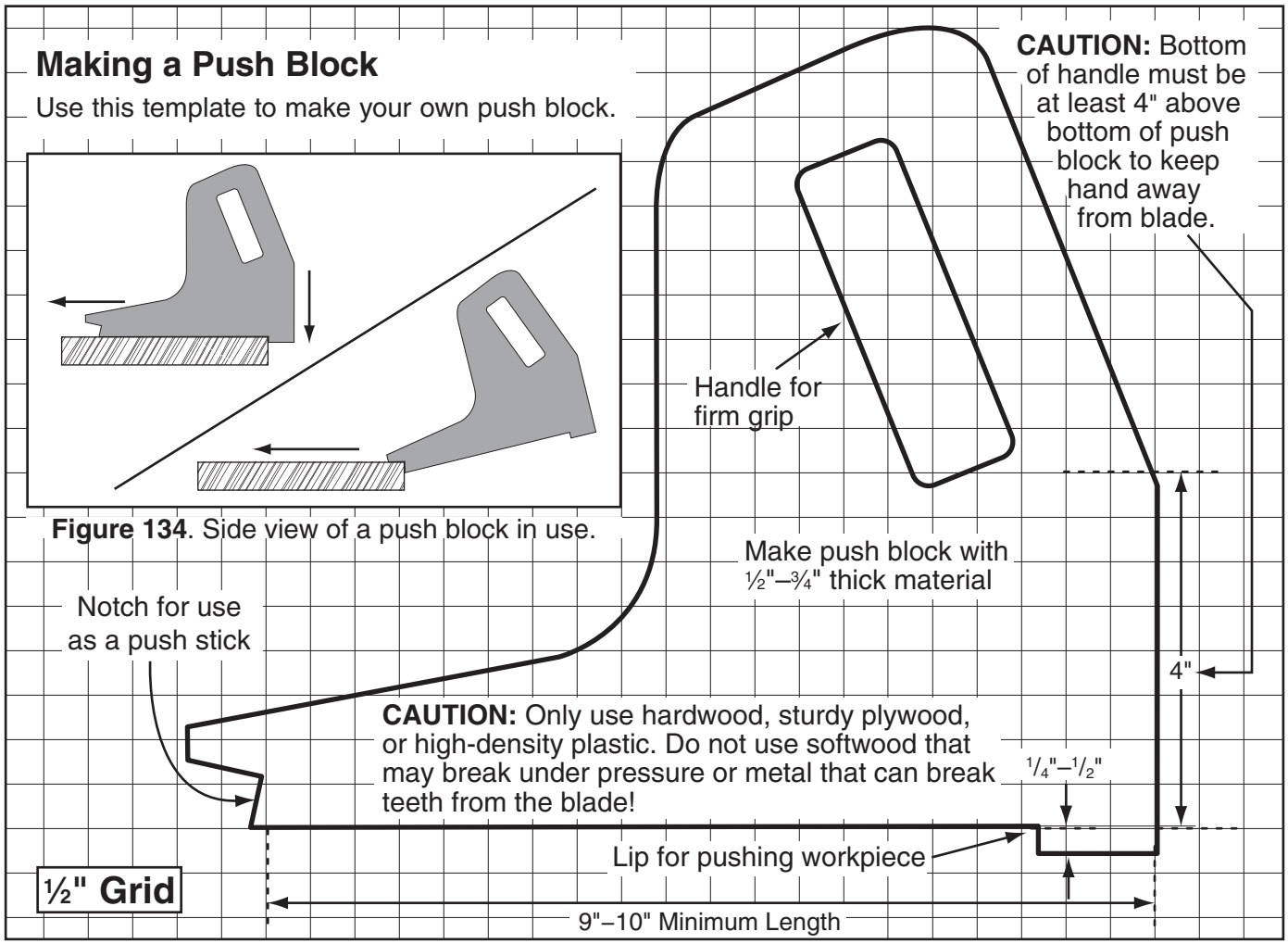


Figure 134. Side view of a push block in use.

Figure 136. Template for a shop-made push block (shown at 50% of full size).

SECTION 6: AFTERMARKET ACCESSORIES FROM GRIZZLY

⚠WARNING

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

NOTICE

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

T26419—Syn-O-Gen Synthetic Grease
Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.

Figure 137. T26419 Syn-O-Gen Synthetic Grease.

T23037—Replacement Scoring Blade

Figure 138. Model T23037 Scoring Blade.

H4754—Duraline HI-A/T, Melamine & Veneer 80T
For chipless cutting of two sided melamine, vinyl, polyester, and kortron. Recommended for thin, low pressure, two-sided laminates and veneer plywood. For thin veneers on flakeboard - fire-retardant, laminated (1 or 2 sides), masonite, fiber board, lumbercore, glue-ups, hard/soft woods and chemically impregnated wood. Arbor bore size is 1" and kerf is 0.125".

Figure 139. 12" 80T Duraline HI-A/T saw blade.

T26700—12" Carbide-Tipped Ripping Blade, 40T
ATB grind on micro-grain carbide tips ensure consistent performance over a long cutting life. Arbor bore size is 1" and kerf is 0.125". This 40-tooth blade is designed for ripping and cross cutting.

Figure 140. 12" 40T Carbide-tipped saw blade.

G0572—Hanging Air Filter with Remote
This Hanging Air Filter has a convenient remote control and features a three-speed motor, automatic shutoff timer, 1-micron secondary filter, and 5-micron primary filter. Air flow is 556, 702, and 1044 CFM. Overall size is 26" long x 19¼" wide x 15" high. Approximate shipping weight is 58 lbs.

Figure 141. G0572 Hanging Air Filter with Remote.

W1732—Adjustable Roller Stand
Specifications:
- Roller size: 19½" long x 2" dia., 9 each
- Minimum stand length: 19½"
- Maximum stand length: 54"
- Minimum stand height: 24½"
- Maximum stand height: 38"
- Casters: Polyurethane, 4¼" dia., locking
- Legs: Independently adjustable
- Maximum weight capacity: 300 lbs.

Multiple stands can be connected for unlimited rolling capacity

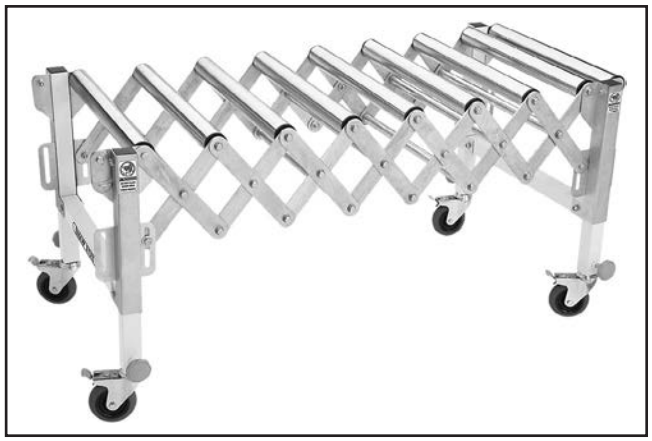
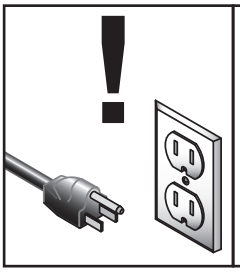


Figure 142. W1732 Adjustable Roller Stand.

G0777HEP—1.5 HP Ultra-Quiet Cyclone Dust Collector
Specifications:
- Motor: 1½ HP, 110V/220V, single-phase, TEFC, prewired 110V
- Airflow capacity: 880 CFM at 1.9" SP
- Maximum static pressure: 9"
- Filtration: Primary is 99.9% at 0.2-2 microns, secondary is 99.97% at 0.3 microns
- Intake port: 6"
- Cartridge filter surface area: 48 sq. ft.
- Sound rating: 70-72 dB
- Overall size: 44"W x 72½"H x 34"D
- Approximate shipping weight: 210 lb.

Figure 143. G0777 Ultra-Quiet Cyclone Dust Collector.

SECTION 7: MAINTENANCE



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Schedule

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

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

Weekly Maintenance:
- Clean sliding table surface and grooves.
- Clean and protect cast iron-table.
- Clean rip fence and slide ways.

Monthly Maintenance:
- Clean/vacuum dust buildup from inside cabinet and off motors.
- Check/replace belts for proper tension, damage or wear (**Page 73**).

Every 6–12 Months:
- Lubricate trunnions (**Page 69**).
- Lubricate leadscrews (**Page 70**).
- Lubricate sliding table ways (**Page 70**).

Cleaning & Protecting

Cleaning the Model G0820 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 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 **Figure 144** for more details).

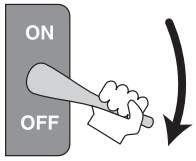
G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 Oz. Spray
G2871—Boeshield® T-9 12 Oz. Spray
G2870—Boeshield® T-9 4 Oz. Spray
H3788—G96® Gun Treatment 12 Oz. Spray
H3789—G96® Gun Treatment 4.5 Oz. Spray

Figure 144. Recommended products for protecting unpainted cast iron/steel parts on machinery.

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 lubrication 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.



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Items Needed	Qty
NLGI#2 Grease or Equivalent	As Needed
Grease Gun	1
Mineral Spirits	As Needed
Clean Shop Rags	As Needed
Light Machine Oil	As Needed

Trunnions

Lubrication Type ... T26419 or NLGI#2 Equivalent
Amount ..... 1-2 Dabs
Lubrication Frequency ..... 6–12 Months

To grease the blade-height trunnion, move the blade all the way down and smear a dab of grease into the trunnion groove shown in **Figure 145**, then move the blade through its full range of movement to spread the grease.

To grease the blade-tilt trunnions, move the sliding table out of the way, open the blade guard, then tilt the blade to 0°. From the front of the saw, smear a dab of grease in the front of the trunnion grooves on both sides. Now, tilt the blade to 45° and reach inside the cabinet and smear a dab of grease into the back of the trunnion grooves on both sides. Tilt the blade through its full range of movement to spread the grease.

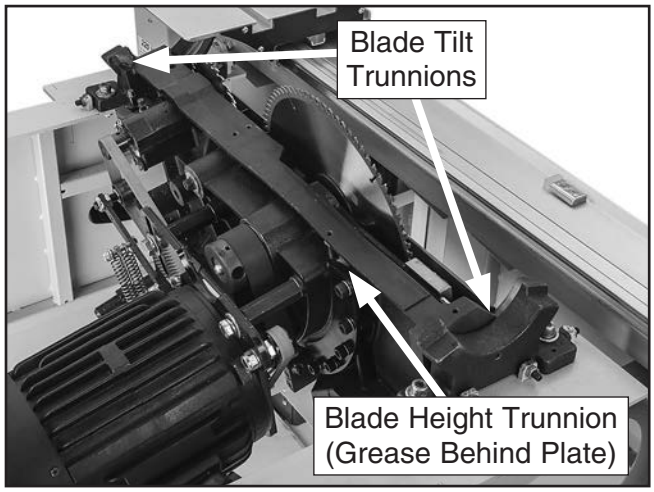


Figure 145. Trunnion lubrication locations (table removed for clarity).

Leadscrews

Lubrication Type ... T26419 or NLGI#2 Equivalent
Amount .....Dab
Lubrication Frequency .....6–12 Months

Clean the threads of the elevation and tilt leadscrews (see **Figure 146**) with a stiff brush and mineral spirits. When dry, apply a thin coat of lubricant into the threads with a brush, and tilt the blade back and forth and raise and lower it a few times to distribute the grease.

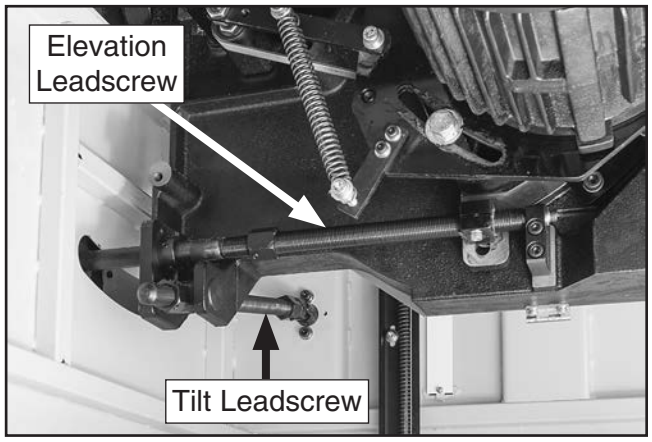


Figure 146. Elevation leadscrew locations.

Sliding Table Ways

Lubrication Type ..... Light Machine Oil
Amount .....Thin Coat
Lubrication Frequency .....6–12 Months

Steel ways (see **Figure 147**) on both sides of the sliding table fit between the top and the base and allow these parts to slide past each other. Clean the ways with mineral spirits and shop rags, then apply a thin coat of light machine oil with a shop rag. Move the sliding table through its full range of movement several times to evenly distribute the oil.

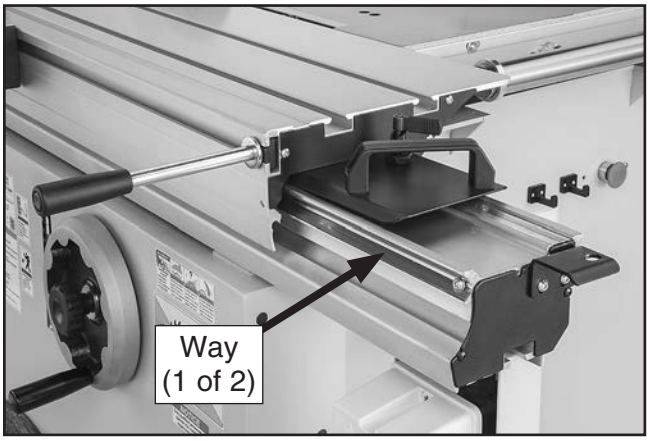
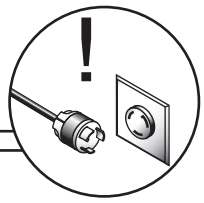


Figure 147. Sliding table way (1 of 2).

SECTION 8: SERVICE

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

Troubleshooting



Motor & Electrical

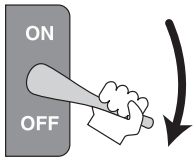
Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips immediately upon startup.	1. Spindle lever not engaged. 2. Emergency Stop button engaged/not reset. 3. Power supply switched OFF or at fault. 4. Blade guard limit switch engaged/at fault. 5. Cabinet door open/door safety switch at fault. 6. Power supply circuit breaker tripped or fuse blown. 7. Thermal overload relay has tripped. 8. Contactor not energized/has poor contacts. 9. Wires are disconnected, damaged, or connected incorrectly. 10. ON button or Emergency Stop button at fault. 11. Motor at fault.	1. Engage spindle lever. 2. Rotate button head to reset. 3. Ensure power supply switch is on; ensure power supply has correct voltage. 4. Move blade guard to working position; replace faulty limit switch. 5. Close door/replace faulty safety switch. 6. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 7. Reset; adjust trip load dial if necessary; replace. 8. Test all legs for power/replace. 9. Fix or replace damaged, disconnected, or misconnected wires. 10. Replace faulty switch button. 11. Test/repair/replace.
Blades rotate in opposite direction than they should.	1. Incoming power supply connected out-of-phase.	1. Reverse R & T incoming power connections in junction box (**Page 35**).
Machine stalls or is underpowered.	1. Cutting improper workpiece material. 2. Feed rate/cutting speed too fast. 3. Workpiece crooked; fence loose or misadjusted. 4. Belt(s) slipping. Oil/grease on belt(s). 5. Motor wired incorrectly. 6. Machine undersized for task. 7. Motor overheated. 8. Dull blades. 9. Pulley slipping on shaft. 10. Magnetic switch contactor at fault (not energized/has poor contacts).	1. Only cut proper workpiece material (**Page 39**). 2. Decrease feed rate/cutting speed. 3. Straighten or replace workpiece/adjust fence. 4. Tension/clean/replace belt(s); ensure pulleys are aligned. 5. Wire motor correctly. 6. Use correct, sharp blade; reduce feed rate or depth of cut. 7. Clean motor, let cool, and reduce workload. 8. Sharpen/replace blades. 9. Replace loose pulley/key/set screw. 10. Test all legs for power/replace.

Machine Operation

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component is loose/broken. 2. Blade dull, damaged, or otherwise at fault. 3. Worn, damaged, or loose belts. 4. Pulley loose. 5. Machine incorrectly mounted or sits unevenly on floor. 6. Motor fan rubbing on fan cover. 7. Arbor bearings at fault. 8. Motor bearings at fault.	1. Tighten loose fasteners. Replace stripped or damaged bolts/nuts. Use thread-locking fluid, if necessary. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Tighten belt. Replace worn or damaged belts (**Page 73**). 4. Tighten fasteners. Re-align/replace shaft, pulley, set screw, and key as required. 5. Tighten/replace anchor studs in floor; relocate/shim machine. 6. Fix/replace fan cover; replace loose/damaged fan. 7. Replace arbor bearings; replace arbor. 8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Workpiece has burned edges, binds, or kicks back.	1. Sliding table or rip fence not parallel with blade. 2. Riving knife not aligned with blade. 3. Blade is warped.	1. Make sliding table parallel to blade (**Page 76**). 2. Align riving knife with main blade (**Page 43**). 3. Replace blade (**Page 45**).
Workpiece has chip out on the bottom edge.	1. Scoring blade height incorrect. 2. Scoring blade not aligned with main blade. 3. Scoring blade kerf does not match main blade.	1. Adjust height of scoring blade (**Page 48**). 2. Align scoring blade (**Page 48**). 3. Adjust scoring blade kerf (**Page 48**).
Sliding table saw does not cut square.	1. Sliding table not parallel with blade. 2. Crosscut fence not perpendicular to blade.	1. Make sliding table parallel to blade (**Page 76**). 2. Adjust crosscut fence perpendicular to blade (**Page 77**).
Rip fence hits table top when sliding across table.	1. Rail too low. 2. Rip fence roller too low.	1. Raise front rail (**Page 79**). 2. Adjust rip fence roller (**Page 79**).
Blade tilt does not stop at perfect 90˚(0˚), or 45˚.	1. Blade tilt stop nuts are out of adjustment.	1. Adjust stop nuts (**Page 75**).
Rip fence scale is not accurate.	1. Rip fence scale out of calibration or was not set up correctly.	1. Adjust rip fence scale (**Page 79**).
Tilt or blade height handwheels difficult to turn.	1. Lock knob tight. 2. Leadscrews caked with dust. 3. Stop nuts hitting end of tilt leadscrew travel.	1. Loosen lock knob. 2. Clean off dust and lubricate leadscrews/gears. 3. Turn handwheel in opposite direction.

Belt Service

Over time, belts will stretch and wear. To maintain efficient power transfer to the blade, make sure the belts are properly tensioned and in good condition. If belts show any glazing, fraying, or cracking, replace them. We recommend replacing both the main and scoring blade belts at the same time for convenience.



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Items Needed **Qty**
Open-End Wrench 19mm..... 1

Tensioning Scoring Blade Belt

Proper tension of the scoring blade flat belt is automatically maintained by a spring between the tensioner pulley and motor shown in **Figure 148**.

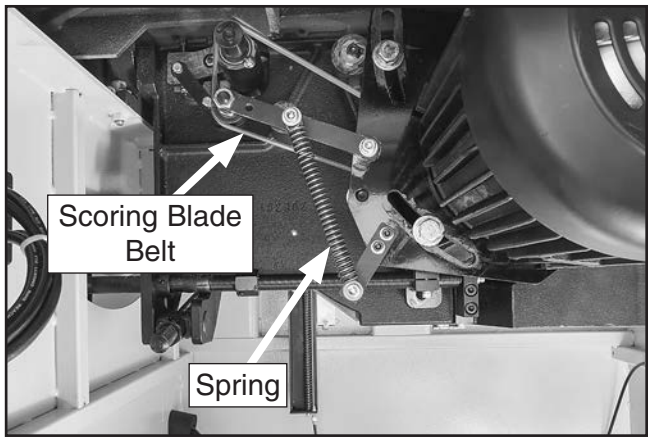


Figure 148. Location of scoring blade spring.

Tensioning Main Motor Belt

1. DISCONNECT MACHINE FROM POWER!
2. Open motor cabinet door.
3. Loosen pivot bolt and two adjustment bolts shown in **Figure 149**.

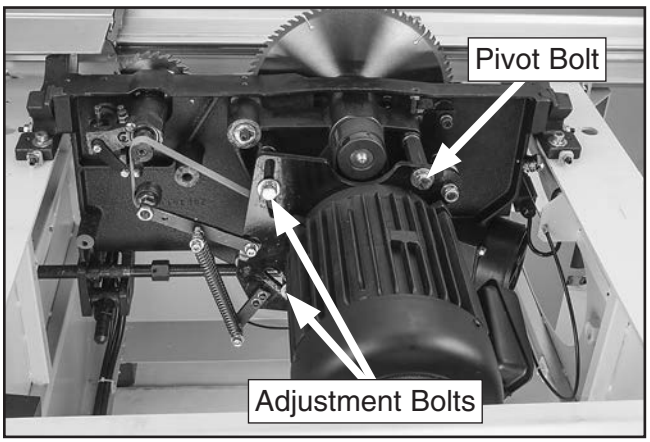


Figure 149. Locations of adjustment and pivot bolts (cast-iron table removed).

4. Push motor down until there is approximately ¼" deflection when you use moderate pressure between pulleys, as illustrated in **Figure 150**, then re-tighten bolts loosened earlier in **Step 3**.

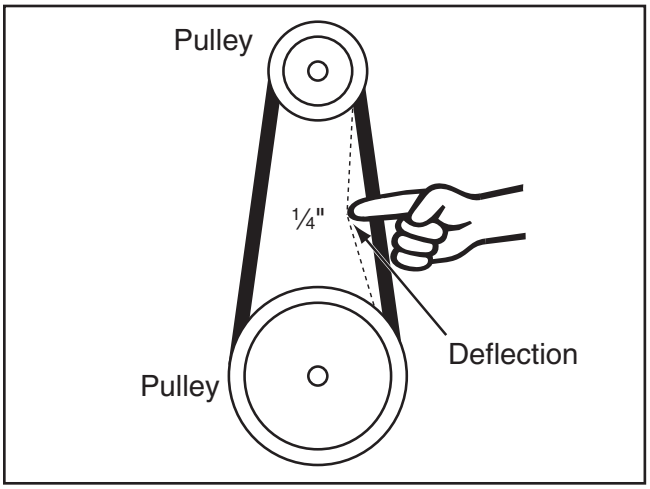


Figure 150. Testing for the correct amount of belt tension.

5. Close motor cabinet door.

Replacing Main Belt & Scoring Belt

1. DISCONNECT MACHINE FROM POWER!

2. Open motor cabinet door.

3. Loosen pivot bolt and two adjustment bolts (see **Figure 151**).

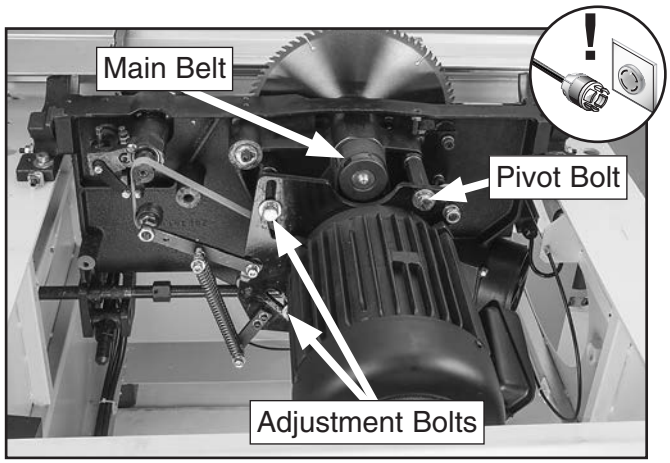


Figure 151. Locations of adjustment and pivot bolts (cast-iron table removed for clarity).

4. Raise motor to top position, then tighten bolts loosened in **Step 3**.

5. Remove scoring belt, then remove main belt from pulleys.

6. Replace main belt (shown in **Figure 151 & 152**), then place scoring belt onto pulleys, as shown in **Figure 152**.

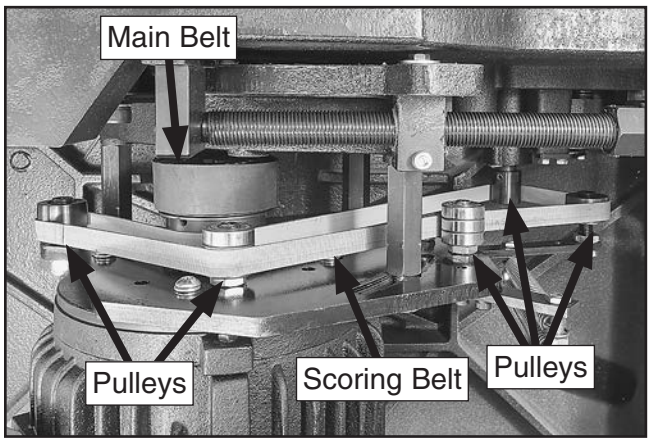


Figure 152. Scoring belt installed onto pulleys (cast-iron table removed for clarity).

7. Loosen pivot bolt and two adjustment bolts (see **Figure 151**), and lower motor to apply proper belt tension (see **Tensioning Main Belt** on **Page 73**).

8. Tighten pivot bolt and two adjustment bolts.

9. Close motor cabinet door.

Blade Tilt Calibration

The blade tilt stops are calibrated at the factory, but they can be recalibrated if they change during the life of the machine. The 0° stop positions the blade square to the table.

Tools Needed	Qty
Hex Wrench 3mm	1
Open-End Wrench 8mm	1
Machinist's Squares, 90° & 45°	1 Ea.

0° Stop

1. DISCONNECT MACHINE FROM POWER!

2. Move blade tilt to 0° and raise main blade as high as it will go.

3. Open cabinet door and identify stop nuts shown in **Figure 153**.

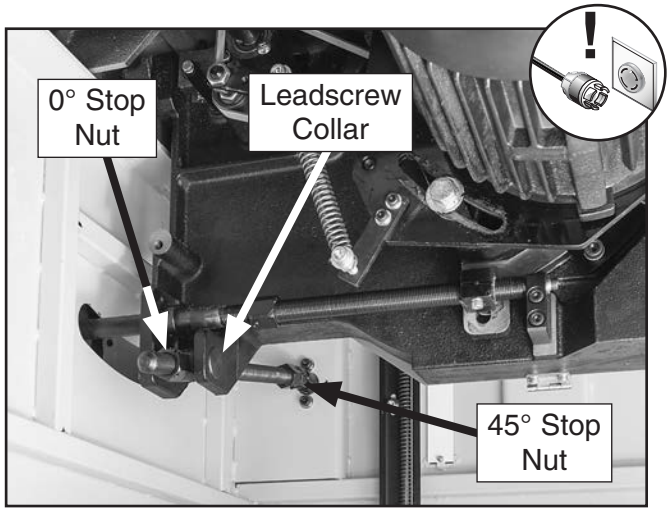


Figure 153. Blade tilt stop nuts.

4. Use machinist's square to check if main blade is square to table (see **Figure 154**).

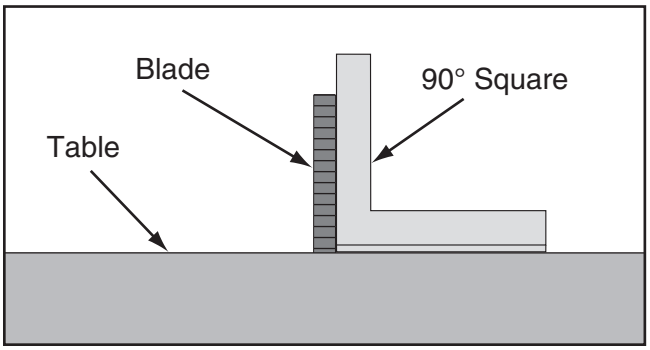


Figure 154. Machinist's square against blade and table.

   a. If main blade is *not* square to table, loosen the two set screws on 0° stop nut, then loosen stop nut away from leadscrew collar.

   b. Adjust main blade tilt angle so that it is square to table.

   c. Thread 0° stop nut against leadscrew collar and retighten set screws.

45° Stop

Use a similar procedure for the 45° stop nut shown in **Figure 153**, as previously instructed for the 0° stop nut.

Tilt Scale Calibration

If necessary, the blade tilt scale on the front of the saw can be adjusted by using the hex nuts shown on the tilt scale cable in **Figure 155**. These are accessed inside the cabinet.

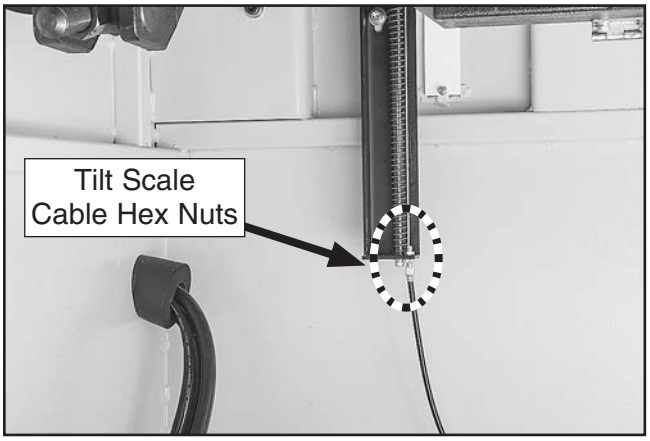


Figure 155. Tilt scale cable hex nuts.

Sliding Table Parallel Adjustment

The sliding table is adjusted parallel with the main blade at the factory, but it can re-adjusted if necessary.

Tools Needed	Qty
Felt Tip Pen	1
90° Square	1
Precise Measuring Tool	1
Wrench or Socket 17mm	1
Wrench or Socket 19mm	1

To adjust sliding table parallel with main blade:

1. DISCONNECT MACHINE FROM POWER!

2. Raise main blade as high as it will go and adjust tilt angle to 0° (verify with square).

3. Mark one blade tooth with felt tip pen. This will be your reference point when taking measurements in following steps.

4. Move sliding table all the way forward, and measure distance “A” shown in **Figure 156**, which is between marked blade tooth and edge of sliding table miter slot.

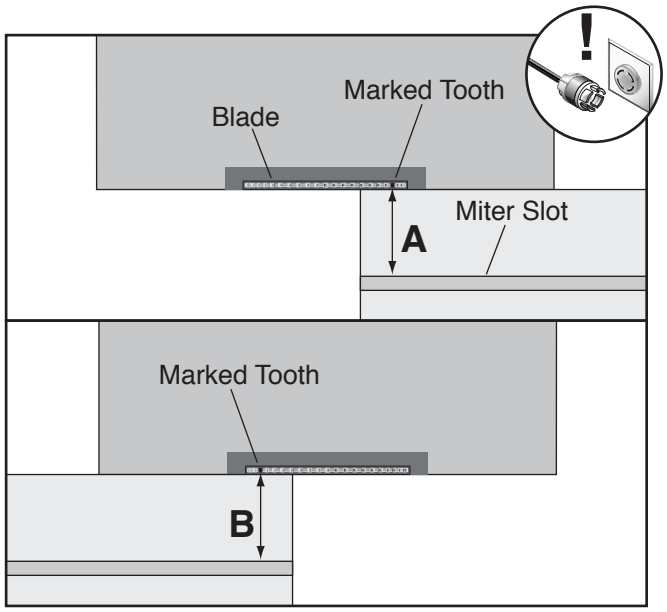


Figure 156. Measuring distance between miter slot and blade at each end of sliding table.

5. Rotate blade 180°, move sliding table all the way back, then measure distance “B” shown in **Figure 156**.

   — If “A” and “B” measurements are same or difference is 0.004" or less, no adjustments to table parallelism need be made.

   — If difference is greater than 0.004", then sliding table parallelism must be adjusted. Proceed to **Step 6**.

6. Loosen hex nuts on sliding table T-bolts to allow sliding table to move in next step (refer to **Figures 157–158**), and loosen hex nuts on each adjustment bolt**.**

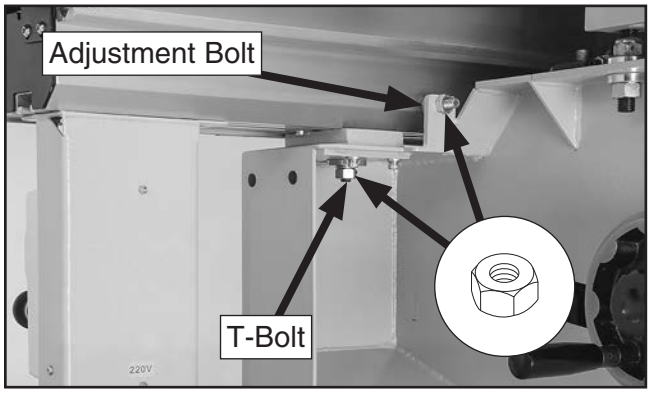


Figure 157. Front parallelism adjustment bolt and T-bolt.

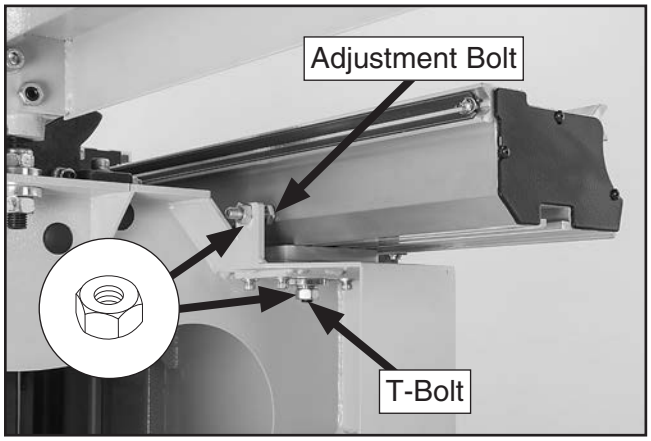


Figure 158. Rear parallelism adjustment bolt and T-bolt.

7. Turn adjustment bolt under each end of sliding table to make sliding table parallel with main blade.

8. Once sliding table parallelism is within 0.004" from one end to the other, retighten hex nuts.

Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a 32" x 32" piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

Note: *Getting accurate results with this procedure is a matter of trial-and-error and patience.*

To square crosscut fence with the blade:

1. Make sure sliding table is parallel with main blade (refer to **Sliding Table Parallel Adjustment** on **Page 76** for detailed instructions).

2. Unthread 0° stop block knob bolt and loosen angle scale knob bolt (see **Figure 159**) to allow fence to pivot.

Figure 159. Locations of knob bolts securing crosscut fence.

3. Move crosscut fence stop block against 0° stop bolt (see **Figure 160**), then retighten angle scale knob bolt to secure fence in place.

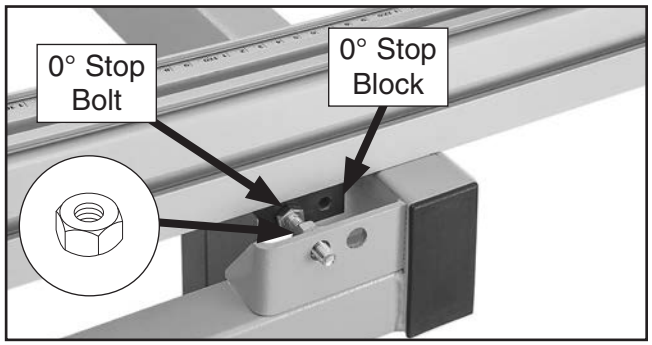


Figure 160. Stop block against 0° stop bolt.

4. Prepare scrap test piece by cutting it to 32" x 32" square, then number all four sides 1–4 (see **Figure 161**).

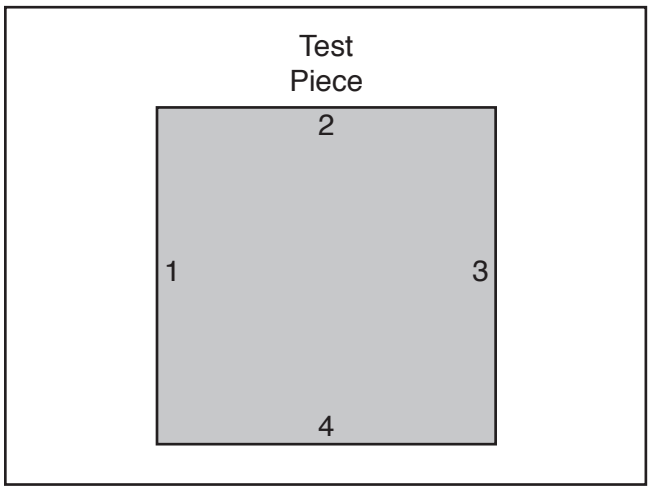


Figure 161. Fence adjustment test piece.

5. Use crosscut fence to cut ½" off of each side of test piece, then cut side 1 again (make five cuts total).

6. Measure test piece diagonally from corner-to-corner, as shown in **Figure 162**.

   — If both measurements are within 1/16", then you are finished with this procedure.

   — If both measurements are not within 1/16", then crosscut fence needs to be adjusted. Proceed to **Step 7**.

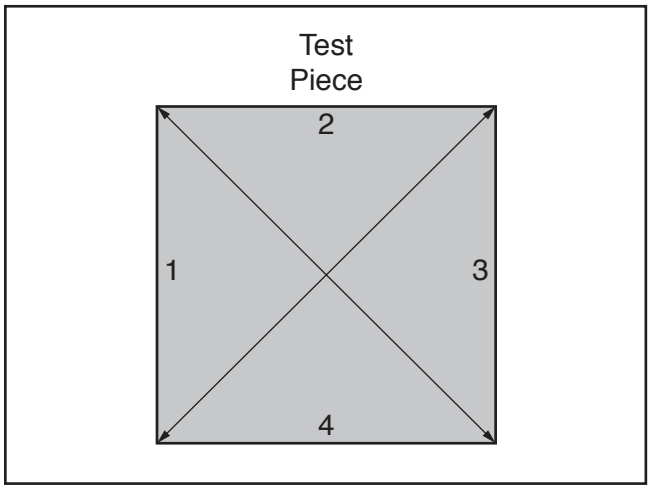


Figure 162. Diagonals to measure on test piece.

7. Loosen angle scale knob bolt (see **Figure 159** on **Page 77**) to allow fence to pivot.

8. Loosen hex nut on the 0° stop bolt shown in **Figure 160** on the previous page, rotate 0° stop bolt to square crosscut fence, then retighten hex nut.

9. Move crosscut fence stop block against 0° stop bolt, then retighten angle scale knob bolt to secure fence in place.

10. Repeat **Steps 5–6** until both measurements are within 1/16".

Riving Knife Mounting Block

The riving knife and splitter/riving knife must be aligned with the blade when installed. If either one is not aligned with the blade, then the workpiece will be forced sideways during the cut, which will increase the risk of kickback.

The riving knife and splitter/riving knife mount to a block that can be repositioned to correctly align the riving knife or splitter/riving knife to the blade. The mounting block adjusts by turning the set screws in each corner of the block. **Figure 163** shows the set screws associated with controlling the mounting block position. Have patience when adjusting the mounting block, because it requires trial-and-error to perform with accuracy.

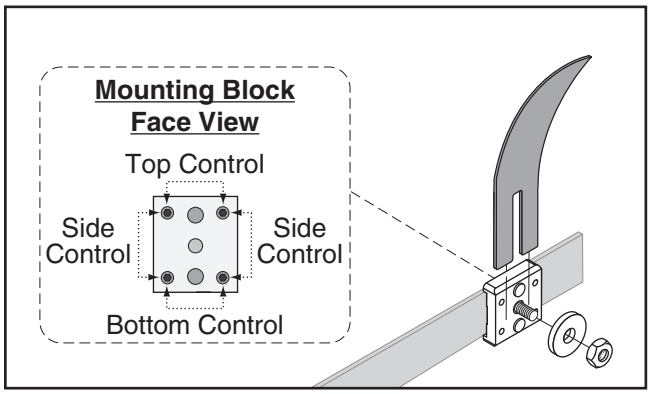


Figure 163. Riving knife and splitter/riving knife mounting block adjustment controls.

All adjustment and alignment positions for the riving knife and splitter/riving knife are covered on **Page 43** in the subsection **Riving Knife Installation & Removal,** and on **Page 41** in the subsection **Splitter/Riving Knife Installation & Removal**. The mounting block should not be adjusted unless you have been unable to mount the riving knife or splitter/riving knife as instructed by these procedures.

Tools Needed	**Qty**
Straightedge	1
Open-End Wrench 17mm	1
Hex Wrench 2.5mm	1

To adjust riving knife mount block:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust blade tilt to 0° and raise blade all the way up.

3. Move sliding table all the way to right to expose blade cover.

4. Open blade cover (see **Figure 164**) to gain access to riving knife mounting block.

5. Loosen hex nut that secures riving knife to mounting block (see **Figure 164**), and remove riving knife (or splitter/riving knife).

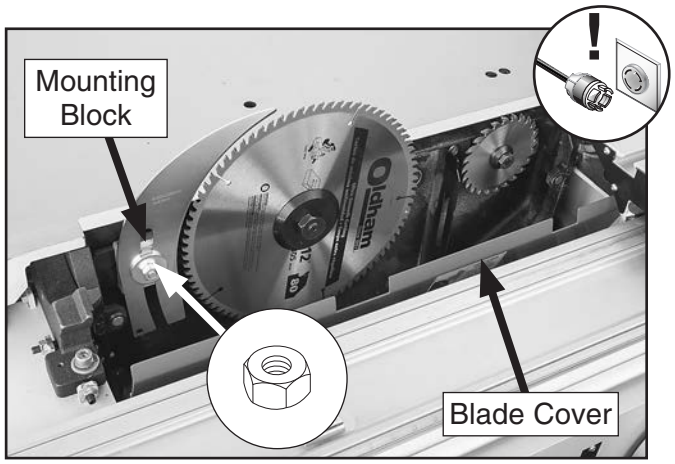


Figure 164. Blade cover open.

6. Adjust each pair of set screws that controls the direction required to move mounting block so riving knife can be aligned with blade. Make sure to move both set screws in even increments.

7. Re-install riving knife and check alignment with blade. Repeat **Step 6** as necessary until riving knife is properly aligned with blade.

   Note: *If you discover that riving knife is bent and cannot be properly aligned with the blade, it is possible to bend it into alignment, but make sure that the final result is precisely aligned so the risk of kickback is not increased. If the riving knife is bent, and you cannot easily bend it back into alignment, we recommend replacing it with a new one.*

8. Properly re-install riving knife as described on **Page 43**, close blade cover, and move sliding table back to center position.

Calibrating Rip Fence

There are three adjustments that affect the accuracy and operation of the rip fence: 1) Height above the table, 2) parallelism with the blade, and 3) rip fence scale position. If your cuts are not square when using the rip fence, check these adjustments. Parallelism is an important safety adjustment and the rip fence MUST be parallel with blade to minimize the risk of kickback.

Height Above Table

The rip fence and base should ride as close to the table surface as possible without touching it and with an even gap along the length. This is accomplished by adjusting the rip fence rail and the roller at the end of the fence base.

Tools Needed	Qty
Hex Wrench 6, 8mm	1 Ea
Open-End Wrenches 13mm	2
Open-End Wrench 19mm	1

To adjust rip fence height above table:

1. Observe gap between fence base and table along entire length.

   — If rail end of fence body is too low, loosen hex nuts that secure rail, raise rail until fence body gap is even, then re-tighten rail hex nuts.

   — If far end of fence base is too low, loosen fence lock and pivot rip fence base upwards to access wheel underneath (see **Figure 165**). Loosen acorn nut, adjust wheel position, retighten acorn nut, and place rip fence base back on table.

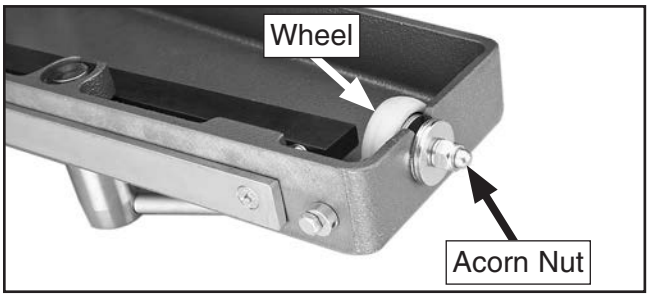


Figure 165. Rip fence base roller controls.

Parallelism To Blade

⚠CAUTION

Parallelism is an important safety adjustment. Rip fence MUST be parallel with blade to minimize risk of kickback.

Tool Needed	Qty
Open-End Wrench 19mm	1
Hex Wrench 4, 8mm	1 Ea

To adjust rip fence parallel to main blade:

1. DISCONNECT MACHINE FROM POWER!
2. Raise main blade all the way up and tilt to 0°.
3. Remove blade guard cover from splitter/riving knife if installed.
4. Slide rip fence as close to main blade as possible and check gap that remains.

   — If gap between rip fence and main blade is not even at both ends, loosen rail hex nuts and adjust one end in or out until fence is parallel with blade, then retighten hex nuts.

5. Re-install blade guard cover.

Calibrating Rip Fence Scale

Tool Needed	Qty
Hex Wrench 4, 8mm	1 Ea

To calibrate rip fence scale:

1. DISCONNECT MACHINE FROM POWER!
2. Remove blade guard cover from splitter/riving knife if installed.
3. Make sure rip fence is parallel with main blade, then move it against blade so that it just touches teeth.
4. Observe reading on scale underneath rip fence (see **Figure 166**).

   — If scale is not at "0", loosen button head cap screws that secure it to table, and adjust it until it reads "0".

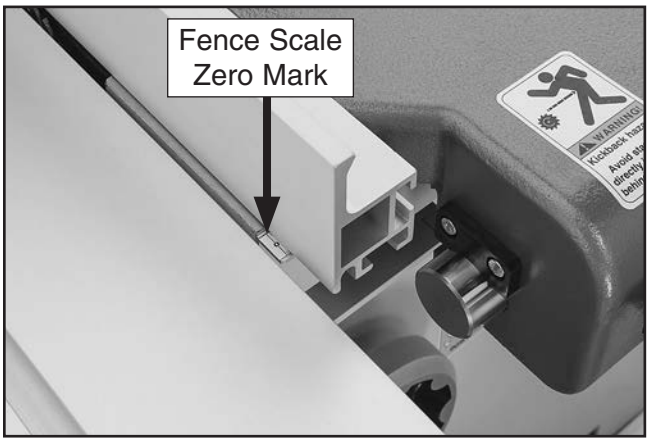


Figure 166. Rip fence scale zero mark.

5. Re-install blade guard cover.

SECTION 9: 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.

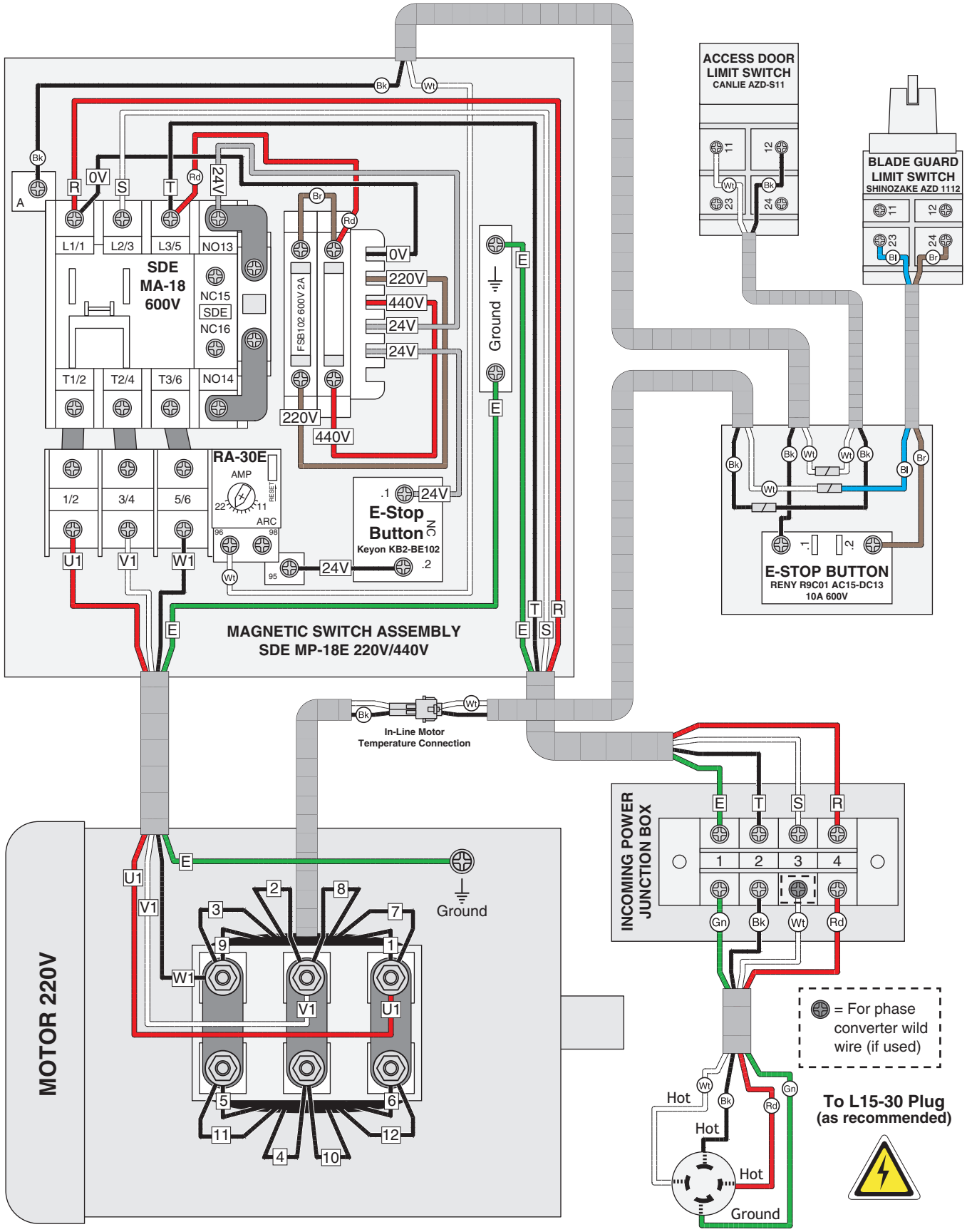
NOTICE

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

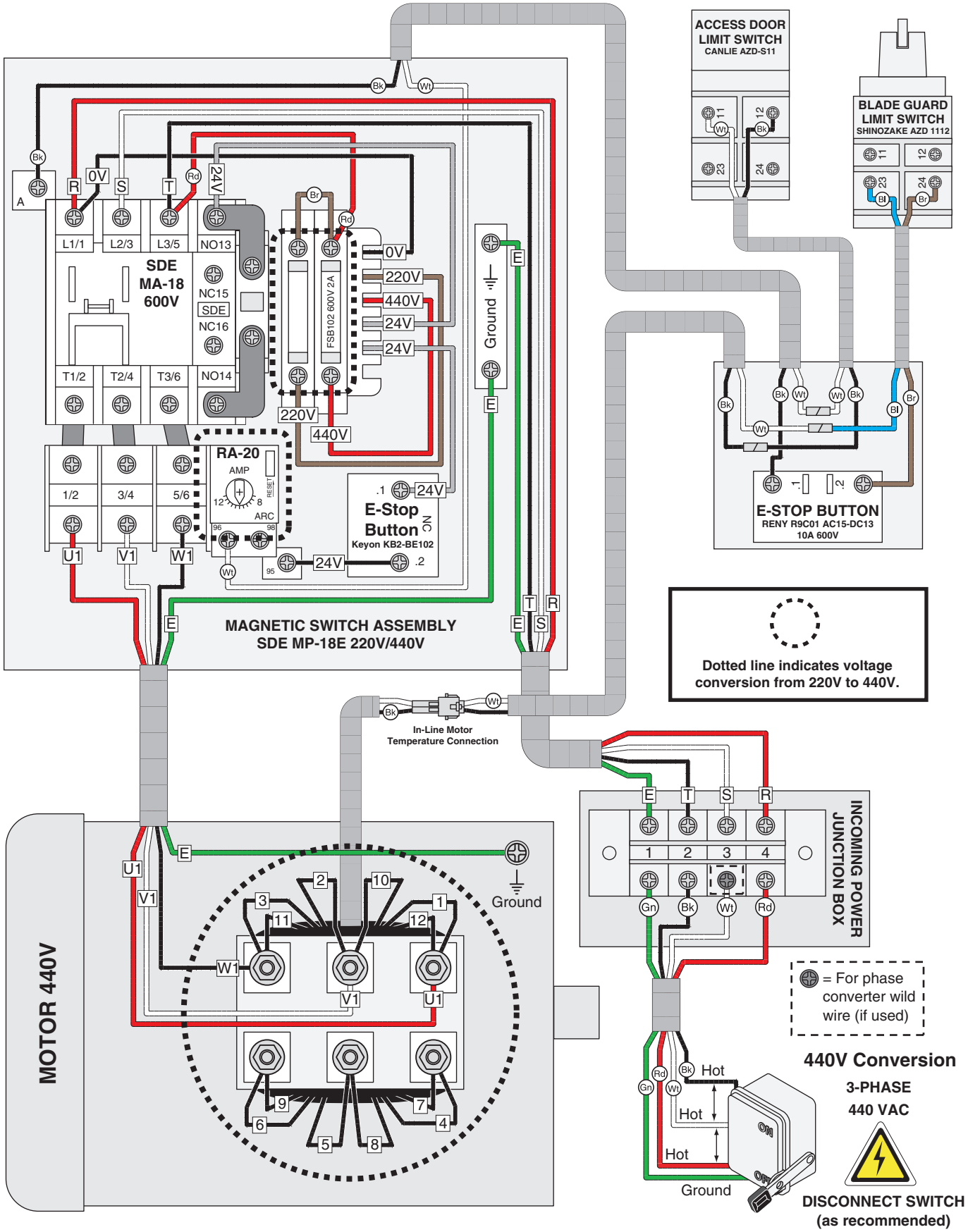
BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram 220V



STOP *READ ELECTRICAL SAFETY ON PAGE 81!*

Wiring Diagram 440V



Wiring Photos

Figure 167. Motor wiring (220V).

Figure 170. Access door limit switch wiring.

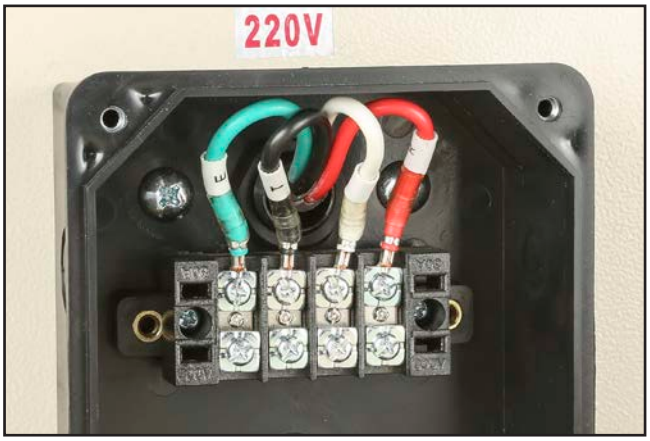


Figure 168. Incoming power wiring connections.

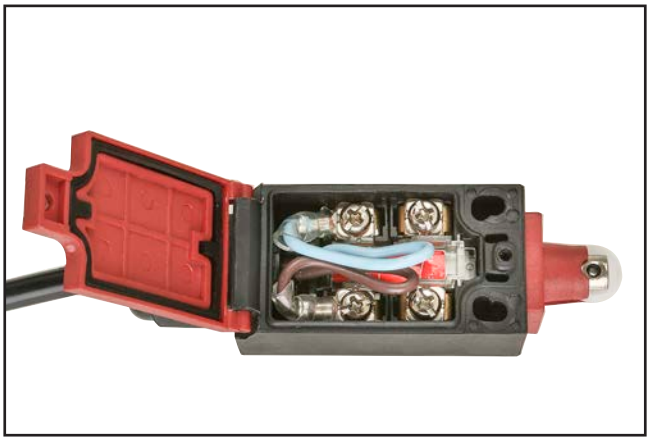


Figure 171. Blade guard limit switch wiring.

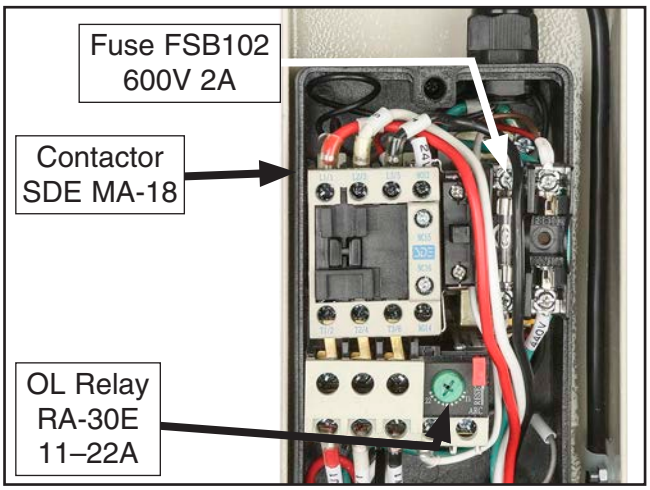


Figure 169. Magnetic switch wiring (220V).

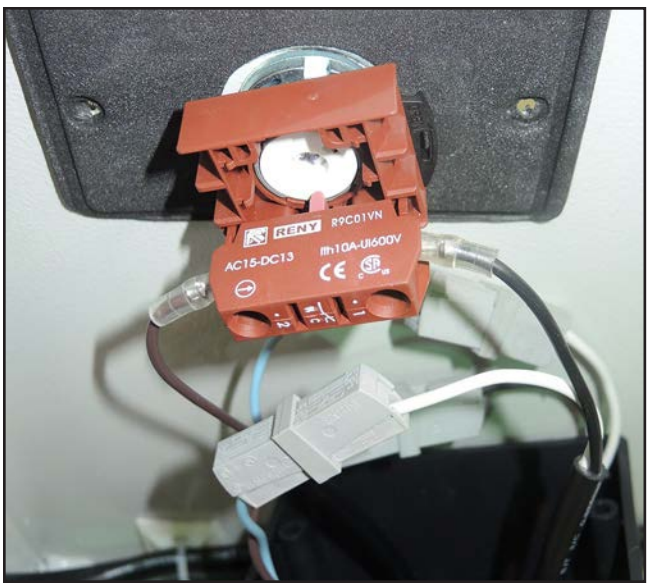


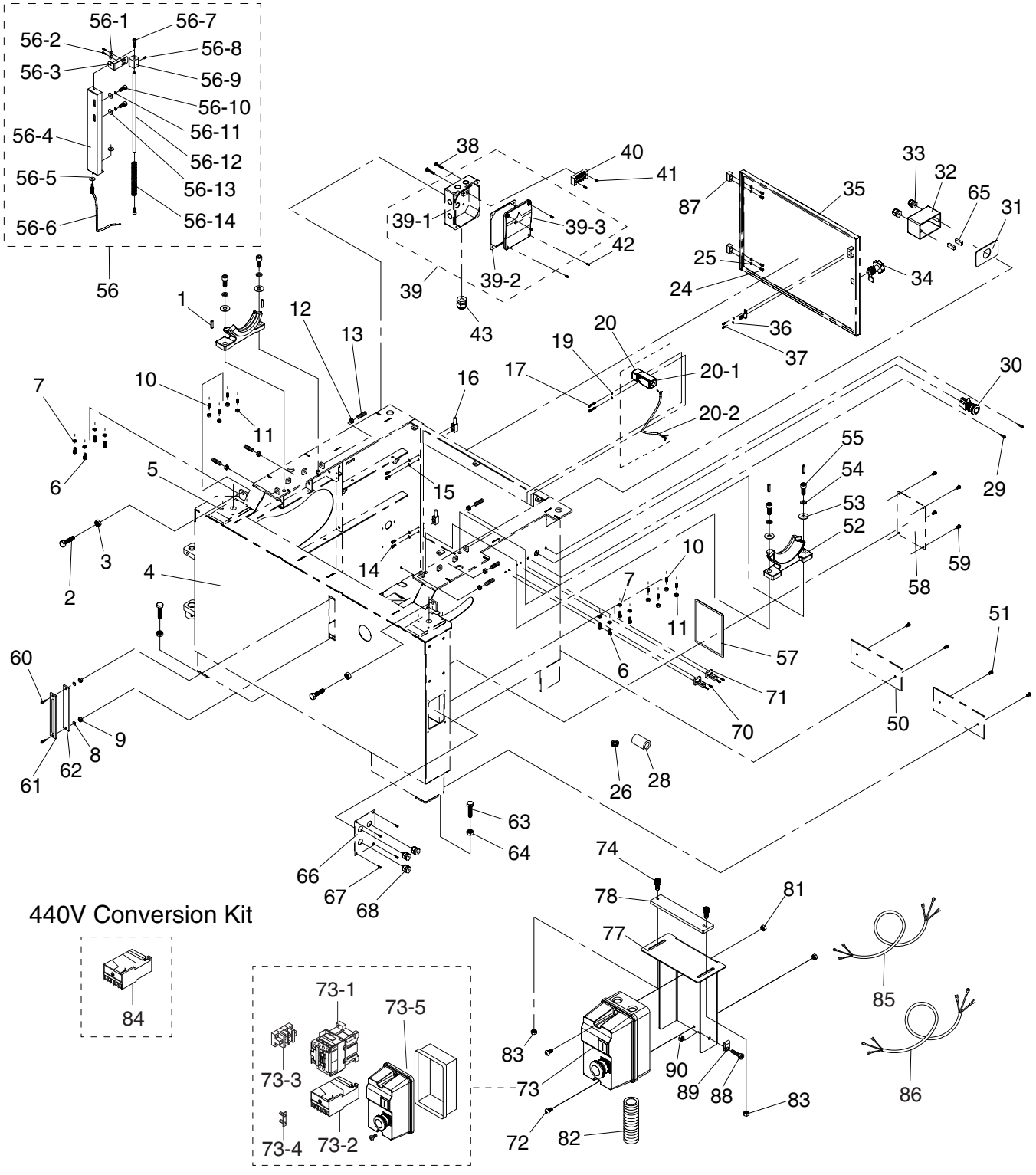
Figure 172. Cabinet E-stop button wiring.

STOP *READ ELECTRICAL SAFETY ON PAGE 81!*

SECTION 10: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call **(800) 523-4777** or visit **www.grizzly.com/parts** to check for availability.

Body

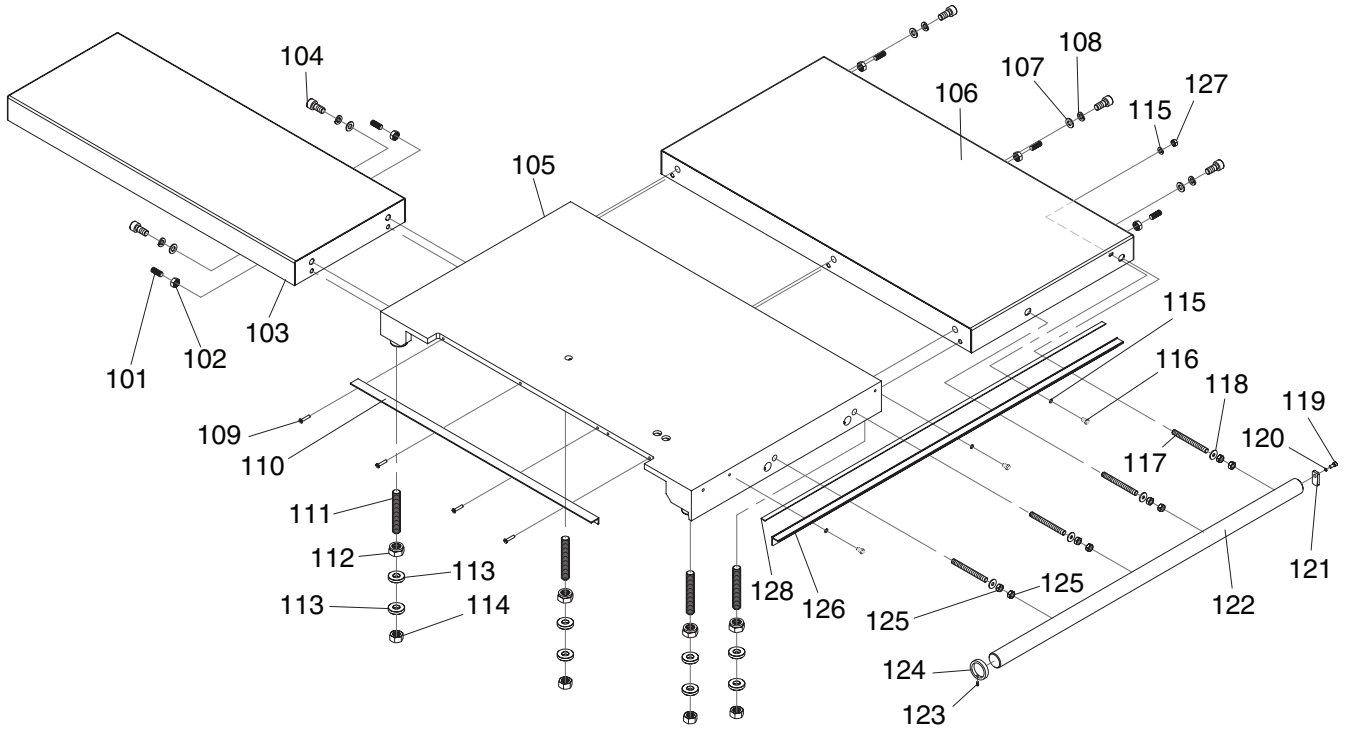


Body Parts List

REF	PART #	DESCRIPTION
1	P08200001	ROLL PIN 6 X 25
2	P08200002	HEX BOLT M10-1.5 X 40
3	P08200003	HEX NUT M10-1.5
4	P08200004	SAW BODY
5	P08200005	TABLE PLATE
6	P08200006	CAP SCREW M6-1 X 12
7	P08200007	LOCK WASHER 6MM
8	P08200008	FLAT WASHER 4MM
9	P08200009	HEX NUT M4-.7
10	P08200010	SET SCREW M6-1 X 20
11	P08200011	HEX NUT M6-1
12	P08200012	HEX NUT M8-1.25
13	P08200013	SET SCREW M8-1.25 X 25
14	P08200014	CAP SCREW M5-.8 X 6
15	P08200015	LOCK WASHER 5MM
16	P08200016	HINGE POST
17	P08200017	PHLP HD SCR M4-.7 X 30
19	P08200019	FLAT WASHER 4MM
20	P08200020	LIMIT SWITCH ASSEMBLY
20-1	P08200020-1	LIMIT SWITCH AZD-S11
20-2	P08200020-2	SWITCH CORD 18G X 2W X 16"
24	P08200024	CAP SCREW M5-.8 X 8
25	P08200025	LOCK WASHER 5MM
26	P08200026	HOLE CAP 22MM
28	P08200028	SPONGE SEAL 5 X 20
29	P08200029	TAP SCREW M5 X 20
30	P08200030	E-STOP BUTTON RENY R9C01VN
31	P08200031	SWITCH BOX MOUNTING PAD
32	P08200032	SWITCH BOX
33	P08200033	STRAIN RELIEF PG13 TYPE-1
34	P08200034	ACCESS DOOR LATCH
35	P08200035	ACCESS DOOR
36	P08200036	LOCK WASHER 4MM
37	P08200037	PHLP HD SCR M4-.7 X 25
38	P08200038	BUTTON HD CAP SCR M6-1 X 20
39	P08200039	JUNCTION BOX ASSEMBLY
39-1	P08200039-1	JUNCTION BOX
39-2	P08200039-2	COVER SEAL
39-3	P08200039-3	JUNCTION BOX COVER
40	P08200040	TERMINAL 4P
41	P08200041	PHLP HD SCR M5-.8 X 8
42	P08200042	BUTTON HD CAP SCR M5-.8 X 12
43	P08200043	STRAIN RELIEF PG20 TYPE-3
50	P08200050	SKID PLATE
51	P08200051	PHLP HD SCR M6-1 X 10
52	P08200052	TRUNNION BASE
53	P08200053	FLAT WASHER 10MM
54	P08200054	LOCK WASHER 10MM
55	P08200055	CAP SCREW M10-1.5 X 35

REF	PART #	DESCRIPTION
56	P08200056	TILT INDICATOR ASSEMBLY
56-1	P08200056-1	FLAT WASHER 5MM
56-2	P08200056-2	PHLP HD SCR M5-.8 X 10
56-3	P08200056-3	POINTER
56-4	P08200056-4	SUPPORT PLATE
56-5	P08200056-5	FLAT WASHER 6MM
56-6	P08200056-6	STEEL WIRE
56-7	P08200056-7	CAP SCREW M5-.8 X 10
56-8	P08200056-8	SET SCREW M5-.8 X 10
56-9	P08200056-9	POINTER MOUNT BLOCK
56-10	P08200056-10	CAP SCREW M6-1 X 12
56-11	P08200056-11	LOCK WASHER 6MM
56-12	P08200056-12	SHAFT
56-13	P08200056-13	FLAT WASHER 6MM
56-14	P08200056-14	COMPRESSION SPRING 10-1/2" X 3/4"
57	P08200057	COVER SEAL
58	P08200058	COVER PLATE
59	P08200059	BUTTON HD CAP SCR M6-1 X 12
60	P08200060	PHLP HD SCR M4-.7 X 20
61	P08200061	TILT SCALE COVER
62	P08200062	TILT SCALE
63	P08200063	HEX BOLT M16-2 X 50
64	P08200064	HEX NUT M16-2
65	P08200065	TERMINAL 4P
66	P08200066	STRAIN RELIEF PLATE
67	P08200067	BUTTON HD CAP SCR M6-1 X 12
68	P08200068	STRAIN RELIEF PG20 TYPE-3
70	P08200070	TAP SCREW M4 X 10
71	P08200071	HANGER HOOK
72	P08200072	PHLP HD SCR M4-.7 X 12
73	P08200073	MAG SWITCH ASSY SDE MP-18E
73-1	P08200073-1	CONTACTOR SDE MA-18 24V
73-2	P08200073-2	OL RELAY SDE RA-30E 11-22A
73-3	P08200073-3	FUSE 2A 600V 0.25" FAST-ACTING, GLASS
73-4	P08200073-4	GROUND TERMINAL BLOCK 2-POSITION
73-5	P08200073-5	SWITCH BOX
74	P08200074	CAP SCREW M5-.8 X 25
77	P08200077	SWITCH MOUNTING PLATE
78	P08200078	MOUNTING PLATE SPACER
81	P08200081	HEX NUT M4-.7
82	P08200082	FLEXIBLE CONDUIT NFE-08B (PLASTIC)
83	P08200083	HEX NUT M5-.8
84	P08200084	440V CONVERSION, OL RELAY SDE RA-20 8-12A
85	P08200085	E-STOP CORD 18AWG 2W X 96"
86	P08200086	POWER CORD 12AWG 4W X 96"
87	P08200087	HINGE RECEIVER
88	P08200088	HEX BOLT M5-.8 X 12
89	P08200089	WIRE LOOP CLAMP
90	P08200090	HEX NUT M5-.8

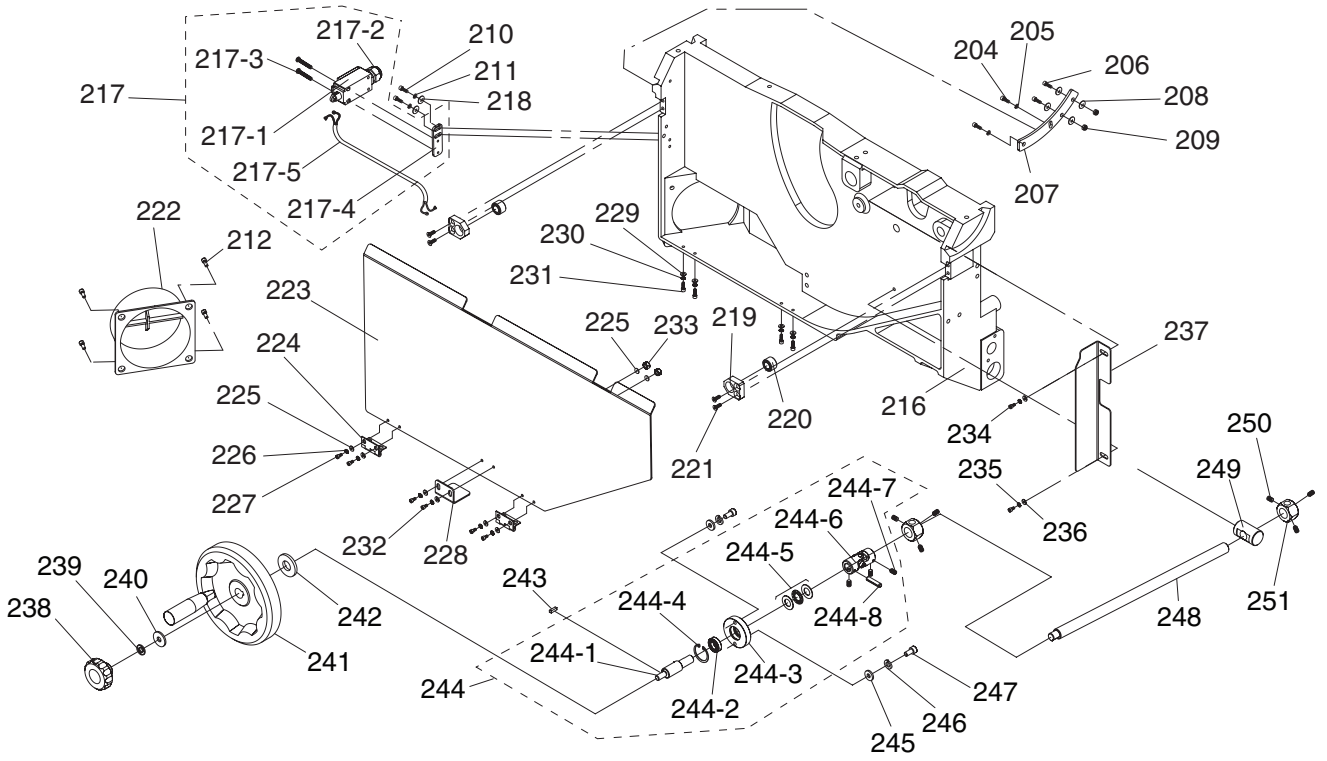
Main Tables



REF	PART #	DESCRIPTION
101	P08200101	SET SCREW M10-1.5 X 20
102	P08200102	HEX NUT M10-1.5
103	P08200103	EXTENSION WING (LEFT)
104	P08200104	CAP SCREW M10-1.5 X 25
105	P08200105	MAIN TABLE
106	P08200106	EXTENSION WING (RIGHT)
107	P08200107	FLAT WASHER 10MM
108	P08200108	LOCK WASHER 10MM
109	P08200109	BUTTON HD CAP SCR M6-1 X 12
110	P08200110	TABLE INSERT
111	P08200111	SET SCREW M16-2 X 100
112	P08200112	LOCK NUT M16-2
113	P08200113	FLAT WASHER 16MM
114	P08200114	HEX NUT M16-2

REF	PART #	DESCRIPTION
115	P08200115	FLAT WASHER 6MM
116	P08200116	BUTTON HD CAP SCR M6-1 X 12
117	P08200117	STUD-FT M12-1.75 X 115
118	P08200118	FLAT WASHER 12MM
119	P08200119	CAP SCREW M8-1.25 X 16
120	P08200120	LOCK WASHER 8MM
121	P08200121	RIP FENCE END STOP
122	P08200122	ROUND RAIL
123	P08200123	SET SCREW M6-1 X 10
124	P08200124	RIP FENCE STOP RING
125	P08200125	HEX NUT M12-1.75
126	P08200126	RIP FENCE SCALE PLATE
127	P08200127	HEX NUT M6-1
128	P08200128	RIP FENCE SCALE

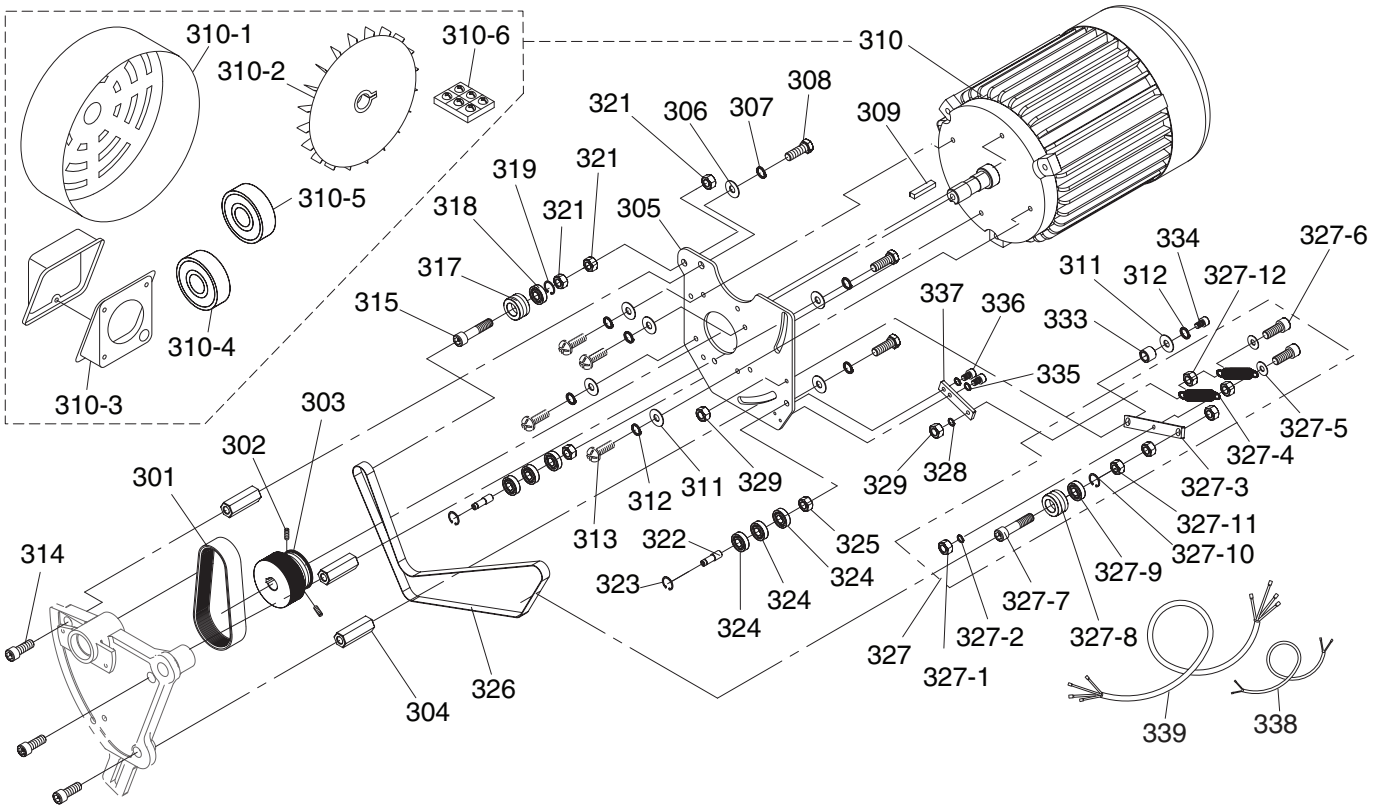
Blade Enclosure



REF	PART #	DESCRIPTION
204	P08200204	CAP SCREW M6-1 X 12
205	P08200205	LOCK WASHER 6MM
206	P08200206	CAP SCREW M5-.8 X 16
207	P08200207	HOUSING ANGLE PLATE
208	P08200208	FLAT WASHER 5MM
209	P08200209	LOCK NUT M5-.8
210	P08200210	CAP SCREW M5-.8 X 12
211	P08200211	LOCK WASHER 5MM
212	P08200212	HEX BOLT M8-1.25 X 12
216	P08200216	BLADE ENCLOSURE
217	P08200217	LIMIT SWITCH ASSY
217-1	P08200217-1	LIMIT SWITCH AZD-S11
217-2	P08200217-2	STRAIN RELIEF PG11 TYPE-3
217-3	P08200217-3	PHLP HD SCR M4-.7 X 35
217-4	P08200217-4	LIMIT SWITCH MOUNTING PLATE
217-5	P08200217-5	CORD 18AWG 2W X 72"
218	P08200218	FLAT WASHER 5MM
219	P08200219	MAGNET MOUNTING BRACKET
220	P08200220	MAGNET
221	P08200221	FLAT HD CAP SCR M6-1 X 20
222	P08200222	DUST PORT 5"
223	P08200223	BLADE ENCLOSURE COVER
224	P08200224	ENCLOSURE HINGE
225	P08200225	FLAT WASHER 5MM
226	P08200226	LOCK WASHER 5MM
227	P08200227	CAP SCREW M5-.8 X 8
228	P08200228	COVER SUPPORT BRACKET
229	P08200229	FLAT WASHER 5MM
230	P08200230	LOCK WASHER 5MM

REF	PART #	DESCRIPTION
231	P08200231	CAP SCREW M5-.8 X 10
232	P08200232	CAP SCREW M5-.8 X 16
233	P08200233	HEX NUT M5-.8
234	P08200234	CAP SCREW M6-1 X 10
235	P08200235	LOCK WASHER 6MM
236	P08200236	FLAT WASHER 6MM
237	P08200237	ENCLOSURE END PLATE
238	P08200238	KNOB 12-LOBE M10-1.25
239	P08200239	LOCK WASHER 10MM
240	P08200240	FLAT WASHER 10MM
241	P08200241	HANDWHEEL TYPE-11 200D X 16B-K
242	P08200242	SPACER
243	P08200243	KEY 7 X 7 X 20
244	P08200244	HANDWHEEL SHAFT ASSY
244-1	P08200244-1	HANDWHEEL SHAFT
244-2	P08200244-2	BALL BEARING 6902-2RS
244-3	P08200244-3	SHAFT MOUNTING RING
244-4	P08200244-4	EXT RETAINING RING 28MM
244-5	P08200244-5	THRUST BEARING NTB1528+AS
244-6	P08200244-6	U-JOINT 14MM PIN-AND-BLOCK
244-7	P08200244-7	SET SCREW M6-1 X 6
244-8	P08200244-8	ROLL PIN 6 X 26MM
245	P08200245	FLAT WASHER 8MM
246	P08200246	LOCK WASHER 8MM
247	P08200247	CAP SCREW M8-1.25 X 20
248	P08200248	STUD-SE M20-2.5 X 415
249	P08200249	PIVOT COUPLER
250	P08200250	SET SCREW M6-1 X 6
251	P08200251	SET NUT M20-2.5

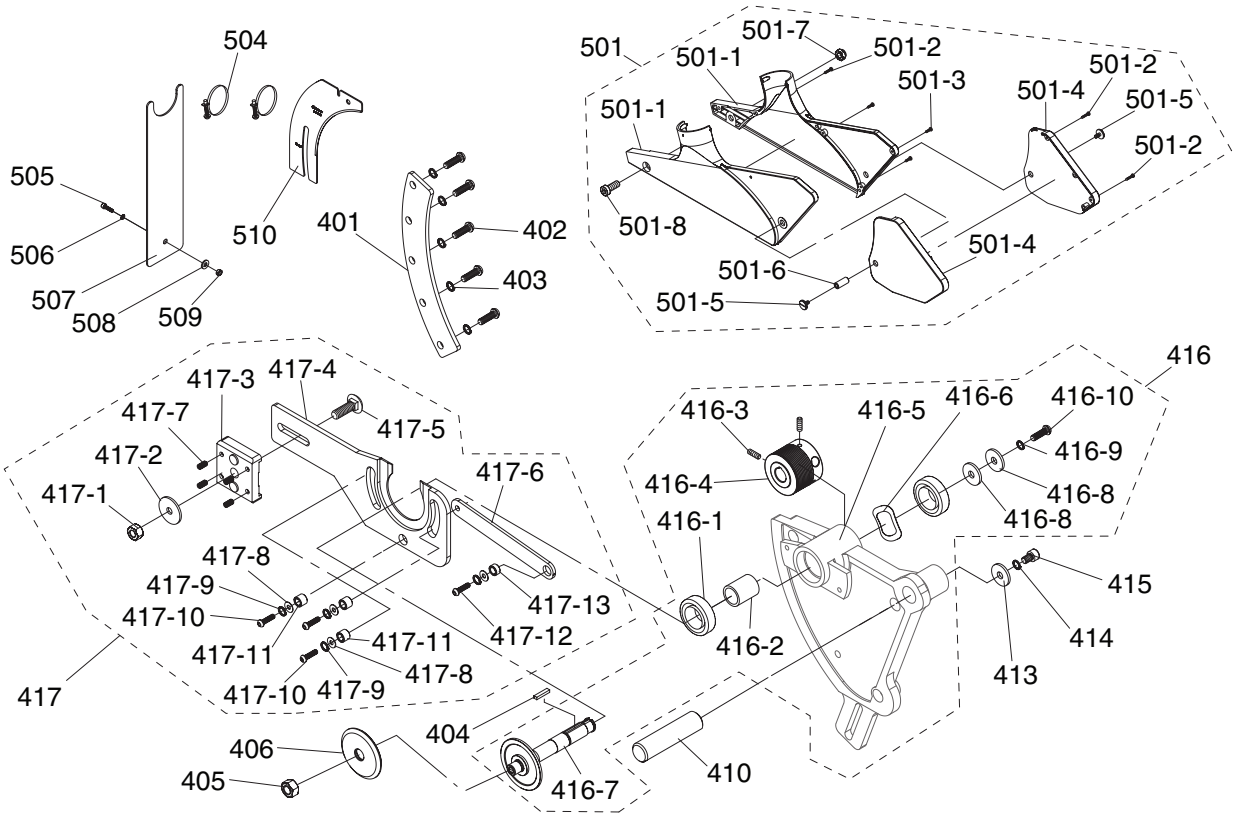
Main Motor



REF	PART #	DESCRIPTION
301	P08200301	V-BELT 180PJ13 RIBBED
302	P08200302	SET SCREW M6-1 X 8
303	P08200303	DUAL PULLEY
304	P08200304	HEX SHAFT SPACER
305	P08200305	MOTOR MOUNTING PLATE
306	P08200306	FLAT WASHER 12MM
307	P08200307	LOCK WASHER 12MM
308	P08200308	HEX BOLT M12-1.75 X 35
309	P08200309	KEY 8 X 7 X 40
310	P08200310	MOTOR 7.5 HP 220V/440V 3-PH
310-1	P08200310-1	MOTOR FAN COVER
310-2	P08200310-2	MOTOR FAN
310-3	P08200310-3	MOTOR JUNCTION BOX
310-4	P08200310-4	MOTOR BEARING 6206ZZ
310-5	P08200310-5	MOTOR BEARING 6205ZZ
310-6	P08200310-6	TERMINAL BAR 3P
311	P08200311	FLAT WASHER 8MM
312	P08200312	LOCK WASHER 8MM
313	P08200313	PHLP HD SCR M8-1.25 X 25
314	P08200314	CAP SCREW M12-1.75 X 30
315	P08200315	CAP SCREW M12-1.75 X 50
317	P08200317	IDLER PULLEY
318	P08200318	BALL BEARING 6001-2RS
319	P08200319	EXT RETAINING RING 28MM
321	P08200321	HEX NUT M12-1.75
322	P08200322	PULLEY BEARING SHAFT

REF	PART #	DESCRIPTION
323	P08200323	EXT RETAINING RING 10MM
324	P08200324	BALL BEARING 6200-2RS
325	P08200325	HEX NUT M12-1.75
326	P08200326	FLAT BELT 15 X 1160
327	P08200327	PULLEY TENSIONER ASSY
327-1	P08200327-1	HEX NUT M8-1.25
327-2	P08200327-2	LOCK WASHER 8MM
327-3	P08200327-3	TENSIONER PLATE
327-4	P08200327-4	EXTENSION SPRING 180 X 16 X 2
327-5	P08200327-5	FLAT WASHER 8MM
327-6	P08200327-6	HEX BOLT M8-1.25 X 40
327-7	P08200327-7	CAP SCREW M12-1.75 X 50
327-8	P08200327-8	IDLER PULLEY
327-9	P08200327-9	BALL BEARING 6001-2RS
327-10	P08200327-10	EXT RETAINING RING 28MM
327-11	P08200327-11	HEX NUT M12-1.75
327-12	P08200327-12	HEX NUT M8-1.25
328	P08200328	LOCK WASHER 8MM
329	P08200329	HEX NUT M8-1.25
333	P08200333	SPACER
334	P08200334	CAP SCREW M8-1.25 X 25
335	P08200335	LOCK WASHER 6MM
336	P08200336	CAP SCREW M6-1 X 16
337	P08200337	LOWER TENSIONER PLATE
338	P08200338	E-STOP CORD 18AWG 2W X 72"
339	P08200339	MOTOR CORD 12AWG 4W X 108"

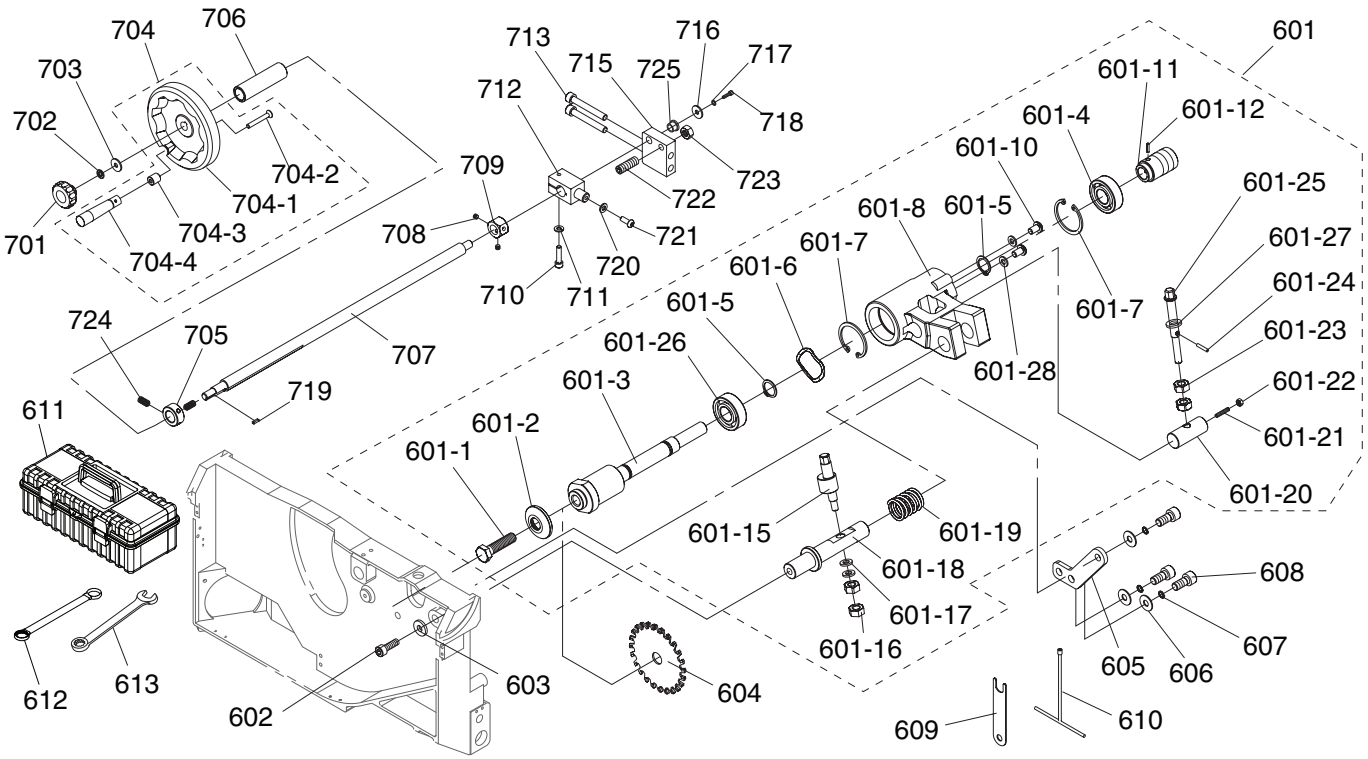
Main Blade Arbor & Dust Hood



REF	PART #	DESCRIPTION
401	P08200401	GIB PLATE
402	P08200402	BUTTON HD CAP SCR M10-1.5 X 25
403	P08200403	LOCK WASHER 10MM
404	P08200404	KEY 5 X 5 X 20
405	P08200405	ARBOR NUT M16-2
406	P08200406	ARBOR FLANGE 1"
410	P08200410	PIVOT SHAFT
413	P08200413	FENDER WASHER 8MM
414	P08200414	LOCK WASHER 8MM
415	P08200415	CAP SCREW M8-1.25 X 20
416	P08200416	MAIN BLADE ARBOR ASSY
416-1	P08200416-1	BALL BEARING 6206LLB
416-2	P08200416-2	ARBOR SPACER
416-3	P08200416-3	SET SCREW M6-1 X 8
416-4	P08200416-4	MAIN BLADE ARBOR PULLEY
416-5	P08200416-5	ARBOR SUPPORT BRACKET
416-6	P08200416-6	WAVE WASHER 47 X 60MM
416-7	P08200416-7	MAIN BLADE ARBOR 25.4MM
416-8	P08200416-8	FENDER WASHER 8MM
416-9	P08200416-9	LOCK WASHER 8MM
416-10	P08200416-10	BUTTON HD CAP SCR M8-1.25 X 20
417	P08200417	RIVING KNIFE MOUNTING ASSY
417-1	P08200417-1	HEX NUT M10-1.5
417-2	P08200417-2	FENDER WASHER 10MM
417-3	P08200417-3	RIVING KNIFE MOUNTING BLOCK
417-4	P08200417-4	MOUNTING PLATE

REF	PART #	DESCRIPTION
417-5	P08200417-5	CARRIAGE BOLT M10-1.5 X 35
417-6	P08200417-6	LINK ARM
417-7	P08200417-7	SET SCREW M5-.8 X 10
417-8	P08200417-8	FENDER WASHER 8MM
417-9	P08200417-9	LOCK WASHER 8MM
417-10	P08200417-10	BUTTON HD CAP SCR M8-1.25 X 20
417-11	P08200417-11	BUSHING
417-12	P08200417-12	BUTTON HD CAP SCR M8-1.25 X 20
417-13	P08200417-13	LINK PLATE BUSHING
501	P08200501	BLADE GUARD ASSEMBLY
501-1	P08200501-1	BLADE GUARD
501-2	P08200501-2	PHLP HD SCR M3-.5 X 16
501-3	P08200501-3	PHLP HD SCR M3-.5 X 12
501-4	P08200501-4	FRONT PIVOT GUARD
501-5	P08200501-5	PHLP HD SCR M5-.8 X 10
501-6	P08200501-6	SHAFT
501-7	P08200501-7	LOCK NUT M10-1.5
501-8	P08200501-8	CAP SCREW M10-1.5 X 25
504	P08200504	HOSE CLAMP 2-1/2"
505	P08200505	CAP SCREW M10-1.5 X 25
506	P08200506	LOCK WASHER 10MM
507	P08200507	HOSE SUPPORT PLATE
508	P08200508	FLAT WASHER 10MM
509	P08200509	HEX NUT M10-1.5
510	P08200510	SPLITTER/RIVING KNIFE

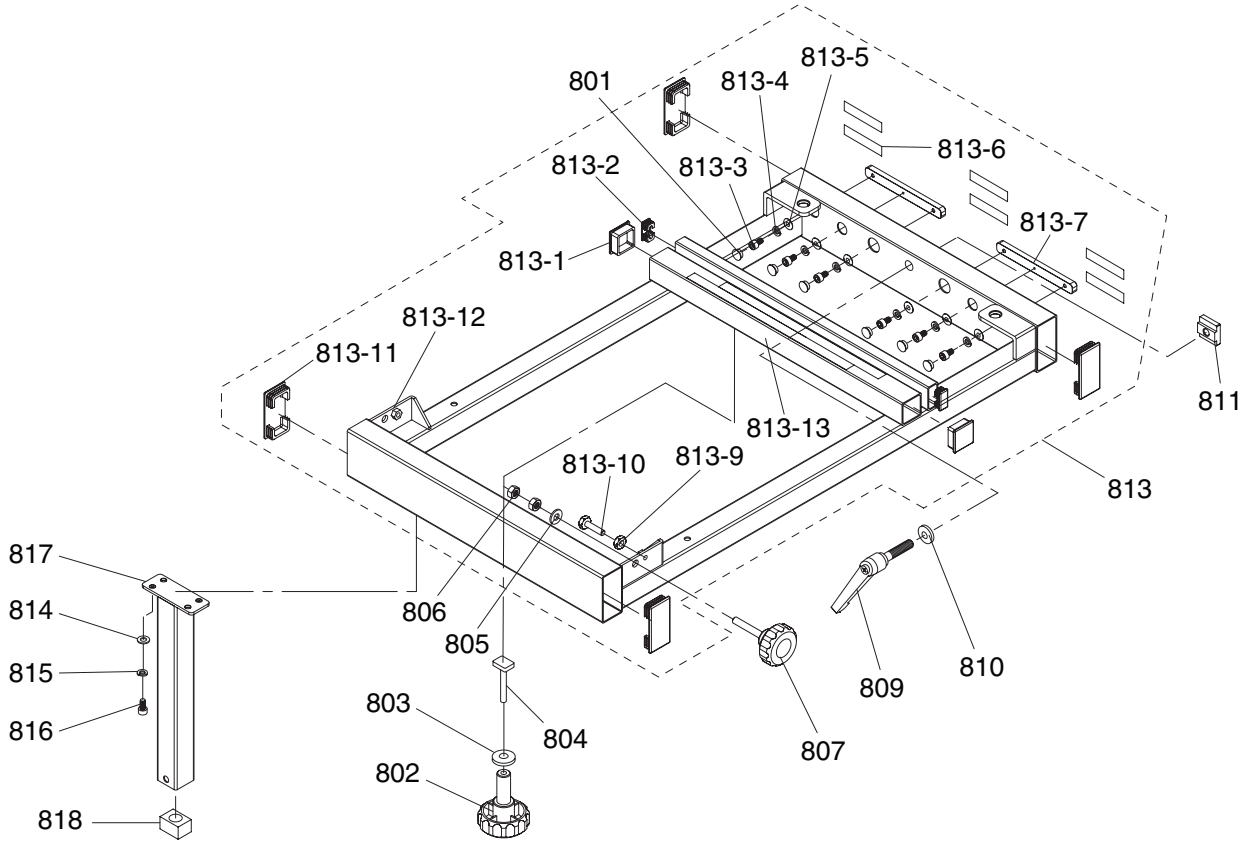
Scoring Blade Arbor & Handwheel



REF	PART #	DESCRIPTION
601	P08200601	SCORING BLADE PULLEY ASSY
601-1	P08200601-1	HEX BOLT M12-1.75 X 20
601-2	P08200601-2	SCORING BLADE FLANGE
601-3	P08200601-3	SCORING BLADE ARBOR
601-4	P08200601-4	BALL BEARING 6202ZZ
601-5	P08200601-5	INT RETAINING RING 15MM
601-6	P08200601-6	WAVE WASHER 26 X 34MM
601-7	P08200601-7	INT RETAINING RING 35MM
601-8	P08200601-8	SCORING BLADE ARBOR HOUSING
601-10	P08200601-10	HEX BOLT M6-1 X 12
601-11	P08200601-11	SCORING BLADE ARBOR PULLEY
601-12	P08200601-12	ROLL PIN 5 X 25
601-15	P08200601-15	ECCENTRIC SHAFT
601-16	P08200601-16	LOCK NUT M6-1
601-17	P08200601-17	COMPRESSION SPRING 15 X 6.2 X 0.5T
601-18	P08200601-18	ELEVATION SHAFT
601-19	P08200601-19	COMPRESSION SPRING 26.5 X 22.5 X 2.5MM
601-20	P08200601-20	BUSHING
601-21	P08200601-21	SET SCREW M6-1 X 25
601-22	P08200601-22	HEX NUT M6-1
601-23	P08200601-23	HEX NUT M8-1.25
601-24	P08200601-24	ROLL PIN 2.5 X 12
601-25	P08200601-25	CONNECTION BOLT
601-26	P08200601-26	BALL BEARING 6003LLB
601-27	P08200601-27	FLAT WASHER 8MM
601-28	P08200601-28	FLAT WASHER 6MM
602	P08200602	CAP SCREW M8-1.25 X 16
603	P08200603	FENDER WASHER 8MM
604	P08200604	SCORING BLADE 120MM DIA X 20MM BORE
605	P08200605	FIXED PLATE
606	P08200606	FLAT WASHER 6MM
607	P08200607	LOCK WASHER 6MM
608	P08200608	CAP SCREW M6-1 X 16

REF	PART #	DESCRIPTION
609	P08200609	SCORING BLADE ARBOR WRENCH
610	P08200610	T-HANDLE WRENCH 8MM
611	P08200611	TOOLBOX
612	P08200612	WRENCH 17 X 19 CLOSED ENDS
613	P08200613	WRENCH 30MM COMBO
701	P08200701	KNOB 12-LOBE M8-1.25
702	P08200702	FLAT WASHER 10MM
703	P08200703	FENDER WASHER 10MM
704	P08200704	HANDWHEEL ASSEMBLY
704-1	P08200704-1	HANDWHEEL TYPE-11 200D X 16B-K
704-2	P08200704-2	FLAT HD SCR M6-1 X 12
704-3	P08200704-3	SPACER
704-4	P08200704-4	HANDWHEEL HANDLE
705	P08200705	LOCK COLLAR
706	P08200706	SLEEVE
707	P08200707	CONNECTING SHAFT
708	P08200708	SET SCREW M6-1 X 6
709	P08200709	SHAFT LOCK COLLAR
710	P08200710	CAP SCREW M6-1 X 30
711	P08200711	LOCK WASHER 6MM
712	P08200712	CONNECTING SHAFT GUIDE
713	P08200713	CAP SCREW M8-1.25 X 50
715	P08200715	LOCATING BLOCK
716	P08200716	FLAT WASHER 6MM
717	P08200717	LOCK WASHER 6MM
718	P08200718	CAP SCREW M6-1 X 12
719	P08200719	KEY 5 X 5 X 20
720	P08200720	FLAT WASHER 6MM
721	P08200721	CAP SCREW M6-1 X 10
722	P08200722	SET SCREW M10-1.5 X 35
723	P08200723	HEX NUT M10-1.5
724	P08200724	SET SCREW M6-1 X 8
725	P08200725	SELF-LUBRICATING BEARING 16 X 10MM

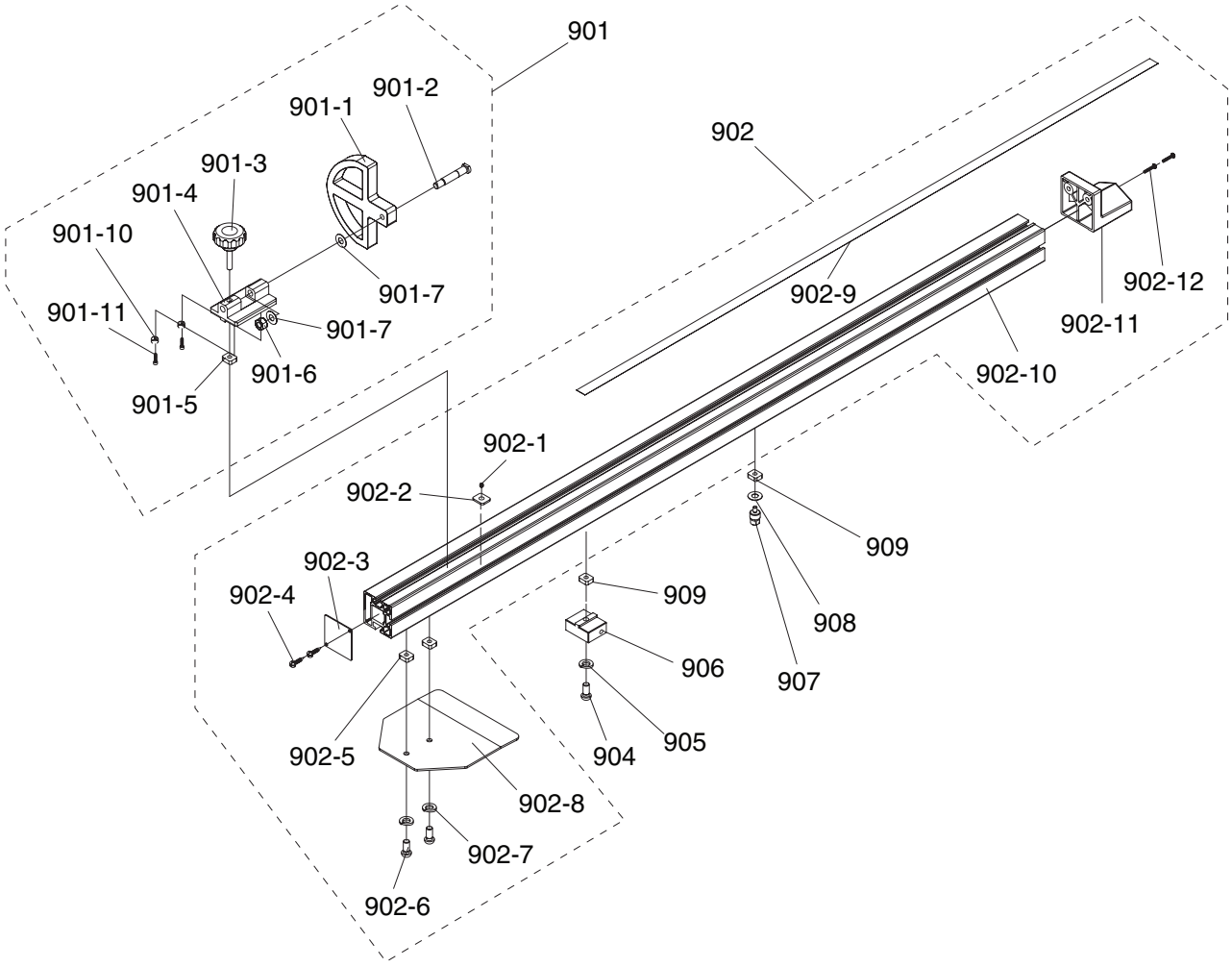
Crosscut Table



REF	PART #	DESCRIPTION
801	P08200801	SCREW CAP
802	P08200802	KNOB M8-1.25 X 50
803	P08200803	FENDER WASHER 8MM
804	P08200804	T-BOLT M8-1.25 X 60
805	P08200805	FLAT WASHER 8MM
806	P08200806	HEX NUT M8-1.25
807	P08200807	KNOB M8-1.25 X 50
809	P08200809	ADJ HANDLE 95L M12-1.75 X 57
810	P08200810	FLAT WASHER 12MM
811	P08200811	T-NUT M12-1.75
813	P08200813	CROSSCUT TABLE ASSY
813-1	P08200813-1	FRAME END-CAP 38 X 38MM
813-2	P08200813-2	FRAME END-CAP 40 X 20MM
813-3	P08200813-3	BUTTON HD CAP SCR M6-1 X 16

REF	PART #	DESCRIPTION
813-4	P08200813-4	LOCK WASHER 6MM
813-5	P08200813-5	FLAT WASHER 6MM
813-6	P08200813-6	CUSHION PAD 5 X 55MM
813-7	P08200813-7	T-SLOT ALIGNMENT PLATE
813-9	P08200813-9	HEX NUT M8-1.25
813-10	P08200813-10	HEX BOLT M8-1.25 X 30
813-11	P08200813-11	FRAME END-CAP 80 X 40MM
813-12	P08200813-12	CROSSCUT TABLE FRAME
813-13	P08200813-13	MITER ANGLE SCALE
814	P08200814	FLAT WASHER 6MM
815	P08200815	LOCK WASHER 6MM
816	P08200816	CAP SCREW M6-1 X 16
817	P08200817	SUPPORT LEG
818	P08200818	END PLUG

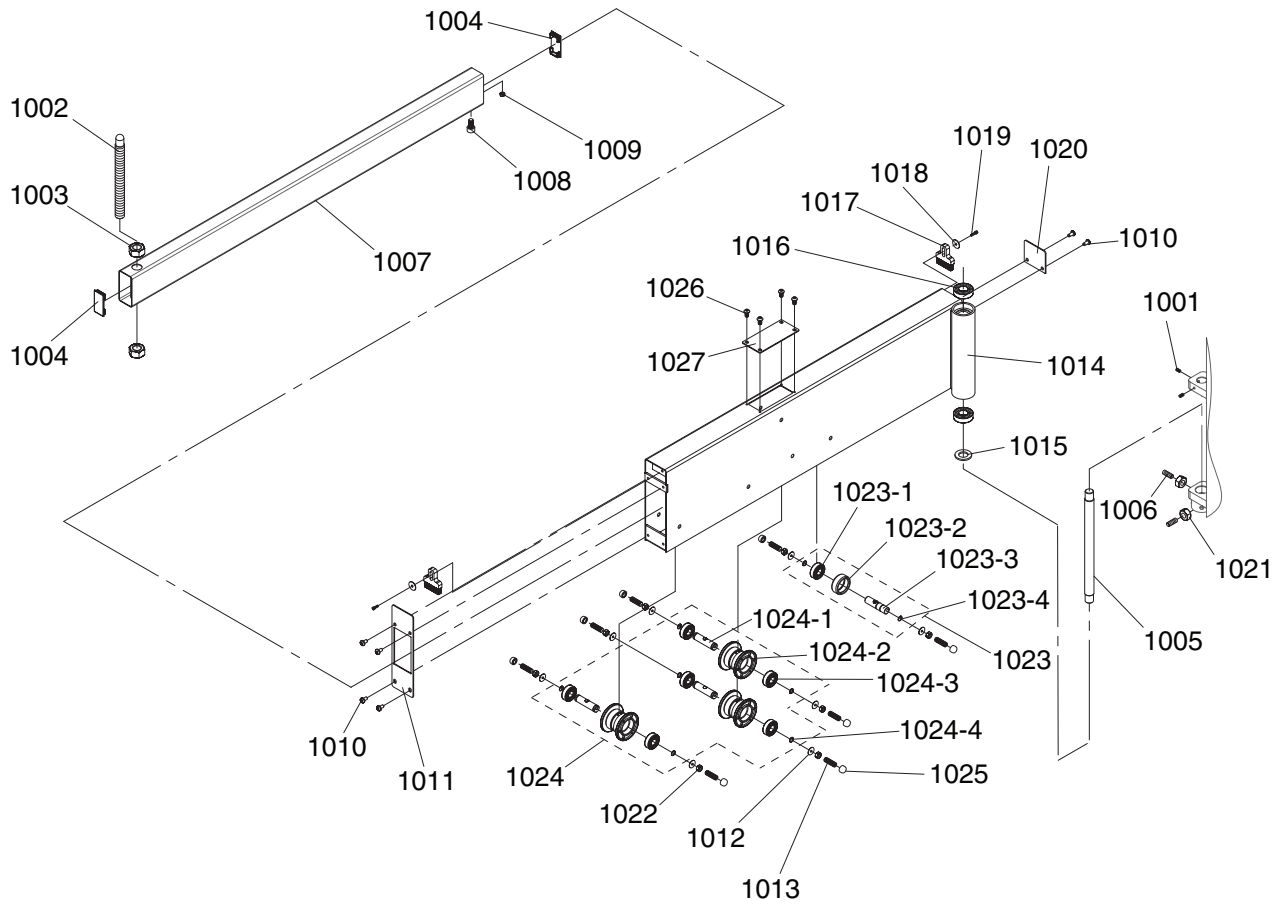
Crosscut Fence



REF	PART #	DESCRIPTION
901	P08200901	FLIP-STOP ASSEMBLY
901-1	P08200901-1	FLIP-STOP
901-2	P08200901-2	PIVOT SHAFT
901-3	P08200901-3	KNOB BOLT M8-1.25 X 40
901-4	P08200901-4	FLIP-STOP BRACKET
901-5	P08200901-5	SQUARE NUT M8-1.25
901-6	P08200901-6	LOCK NUT M10-1.5
901-7	P08200901-7	FLAT WASHER 10 X 18 X 0.5T COPPER
901-10	P08200901-10	SLEEVE
901-11	P08200901-11	CAP SCREW M3-.5 X 12
902	P08200902	CROSSCUT FENCE ASSEMBLY
902-1	P08200902-1	SET SCREW M5-.8 X 5
902-2	P08200902-2	SQUARE NUT M5-.8 (THIN)
902-3	P08200902-3	EXTENSION FENCE END CAP
902-4	P08200902-4	TAP SCREW M4-.7 X 10

REF	PART #	DESCRIPTION
902-5	P08200902-5	T-SLOT NUT M8-1.25
902-6	P08200902-6	BUTTON HD CAP SCR M8-1.25 X 16
902-7	P08200902-7	LOCK WASHER 8MM
902-8	P08200902-8	STOCK SUPPORT PLATE
902-9	P08200902-9	FENCE SCALE 0"–78"
902-10	P08200902-10	CROSSCUT MAIN FENCE
902-11	P08200902-11	CROSSCUT MAIN FENCE END CAP
902-12	P08200902-12	PHLP HD SCR M4-.7 X 10
904	P08200904	CAP SCREW M8-1.25 X 35
905	P08200905	LOCK WASHER 8MM
906	P08200906	FLIP-STOP CLAMP BLOCK
907	P08200907	ROTATE SHAFT
908	P08200908	FLAT WASHER 10MM NYLON
909	P08200909	SQUARE NUT M8-1.25

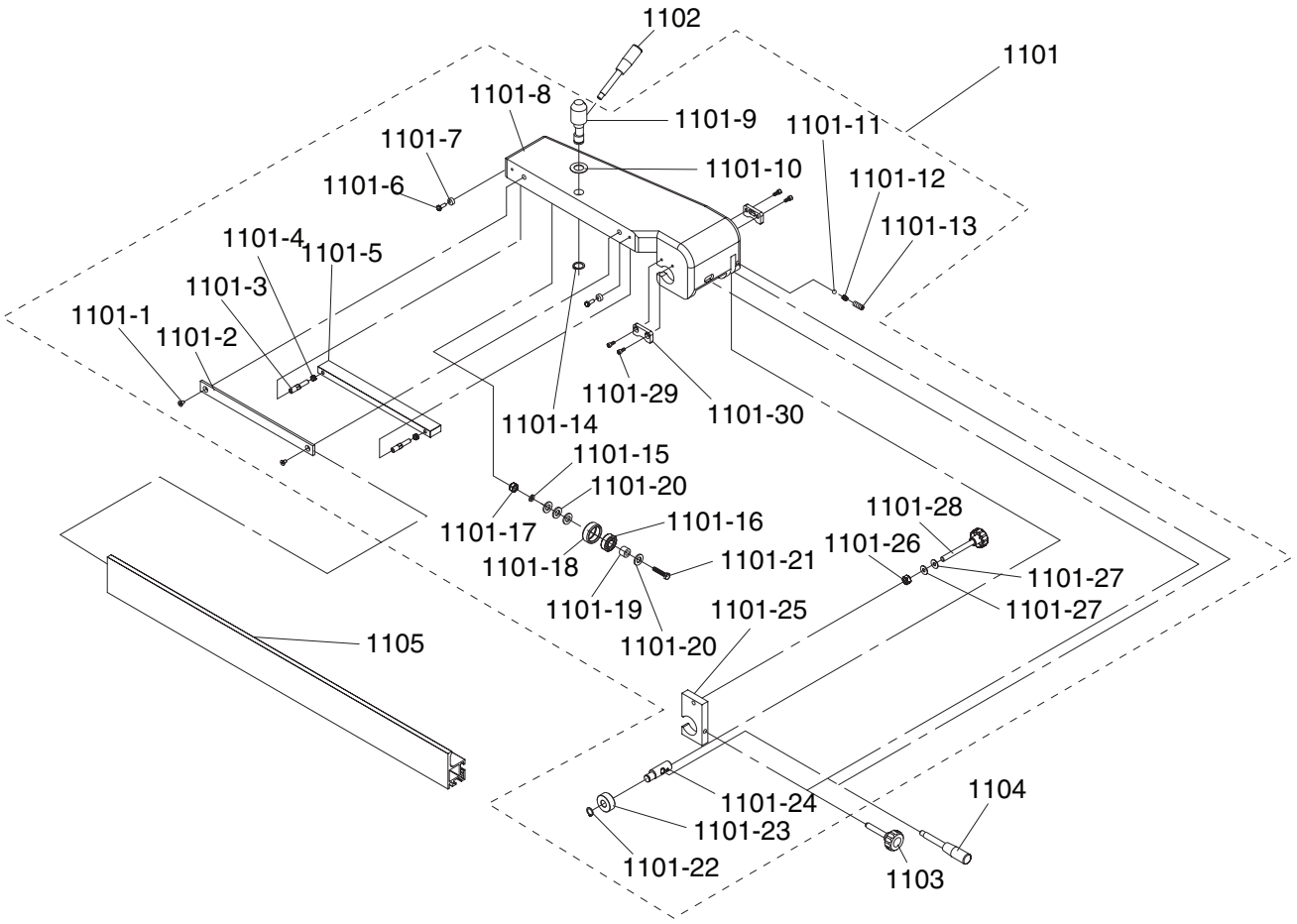
Crosscut Swing-Arm



REF	PART #	DESCRIPTION
1001	P08201001	SET SCREW M10-1.5 X 10
1002	P08201002	CROSS-CUT PIVOT ROD M20-2.5 X 215
1003	P08201003	HEX NUT M20-2.5
1004	P08201004	SLIDING TUBE END CAP
1005	P08201005	PIVOT SHAFT
1006	P08201006	SET SCREW M10-1.5 X 20
1007	P08201007	SLIDING TUBE
1008	P08201008	CAP SCREW M8-1.25 X 20
1009	P08201009	HEX NUT M8-1.25
1010	P08201010	BUTTON HD CAP SCR M6-1 X 10
1011	P08201011	SWING ARM END CAP (LH)
1012	P08201012	FLAT WASHER 8MM
1013	P08201013	SET SCREW M8-1.25 X 25
1014	P08201014	SWING ARM
1015	P08201015	FLAT WASHER 20MM
1016	P08201016	BALL BEARING 6004ZZ
1017	P08201017	BRUSH
1018	P08201018	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
1019	P08201019	CAP SCREW M6-1 X 20
1020	P08201020	SWING ARM END CAP (RH)
1021	P08201021	HEX NUT M10-1.5
1022	P08201022	HEX NUT M8-1.25
1023	P08201023	TUBE ROLLER ASSEMBLY (UPPER)
1023-1	P08201023-1	BALL BEARING 6202ZZ
1023-2	P08201023-2	ROLLER
1023-3	P08201023-3	ROLLER SHAFT
1023-4	P08201023-4	EXT RETAINING RING 15MM
1024	P08201024	TUBE ROLLER ASSEMBLY (LOWER)
1024-1	P08201024-1	ROLLER SHAFT
1024-2	P08201024-2	ROLLER
1024-3	P08201024-3	BALL BEARING 6202ZZ
1024-4	P08201024-4	EXT RETAINING RING 15MM
1025	P08201025	SET SCREW PROTECTIVE CAP 13MM
1026	P08201026	BUTTON HD CAP SCR M5-.8 X 8
1027	P08201027	SWING-ARM TOP PLATE

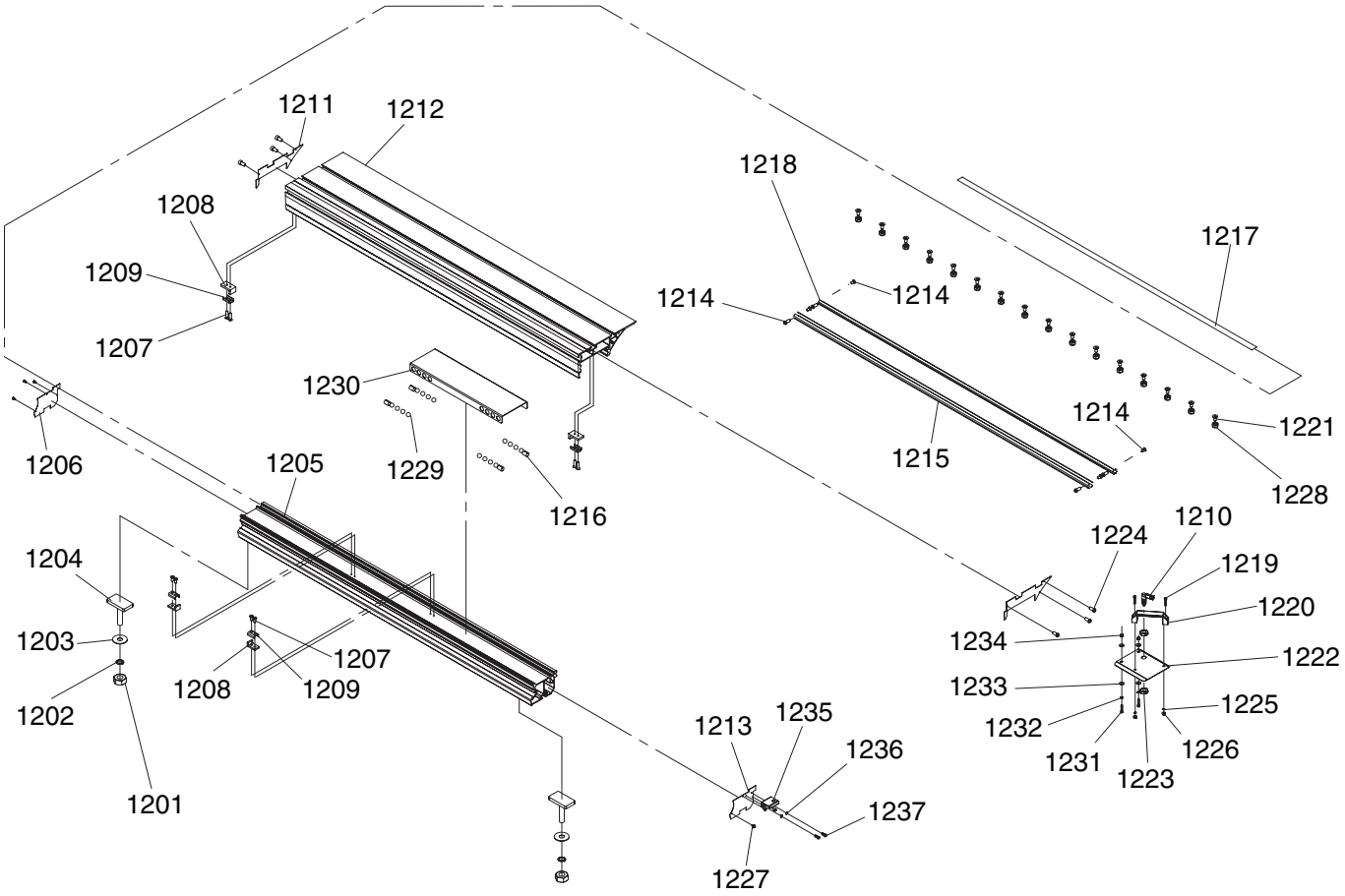
Rip Fence



REF	PART #	DESCRIPTION
1101	P08201101	RIP FENCE ASSEMBLY
1101-1	P08201101-1	FLAT HD SCR M6-1 X 16
1101-2	P08201101-2	FENCE T-SLOT PLATE
1101-3	P08201101-3	THREADED SHAFT M8-1.25 X 16
1101-4	P08201101-4	LOCK NUT M8-1.25
1101-5	P08201101-5	ALIGNMENT PLATE
1101-6	P08201101-6	HEX BOLT M6-1 X 16
1101-7	P08201101-7	ECCENTRIC RING
1101-8	P08201101-8	RIP FENCE BODY
1101-9	P08201101-9	ECCENTRIC SHAFT
1101-10	P08201101-10	FLAT WASHER 20MM
1101-11	P08201101-11	STEEL BALL 8MM
1101-12	P08201101-12	COMPRESSION SPRING 9 X 7.5 X 1MM
1101-13	P08201101-13	SET SCREW M10-1.5 X 10
1101-14	P08201101-14	EXT RETAINING RING 20MM
1101-15	P08201101-15	LOCK WASHER 8MM
1101-16	P08201101-16	BALL BEARING 6202ZZ
1101-17	P08201101-17	ACORN NUT M8-1.25

REF	PART #	DESCRIPTION
1101-18	P08201101-18	SPACER
1101-19	P08201101-19	BUSHING
1101-20	P08201101-20	FENDER WASHER 8MM
1101-21	P08201101-21	HEX BOLT M8-1.25 X 35
1101-22	P08201101-22	EXT RETAINING RING 15MM
1101-23	P08201101-23	SPACER
1101-24	P08201101-24	RAIL LOCK SHAFT
1101-25	P08201101-25	FENCE RAIL BRACKET
1101-26	P08201101-26	LOCK NUT M10-1.5
1101-27	P08201101-27	FLAT WASHER 10MM
1101-28	P08201101-28	KNOB BOLT M10-1.5 X 110
1101-29	P08201101-29	CAP SCREW M6-1 X 10
1101-30	P08201101-30	RAIL WIPER
1102	P08201102	LEVER HANDLE M10-1.5 X 12, 140L
1103	P08201103	KNOB BOLT M10-1.5 X 55
1104	P08201104	LEVER HANDLE M10-1.5 X 12, 140L
1105	P08201105	FENCE 36" (ALUMINUM)

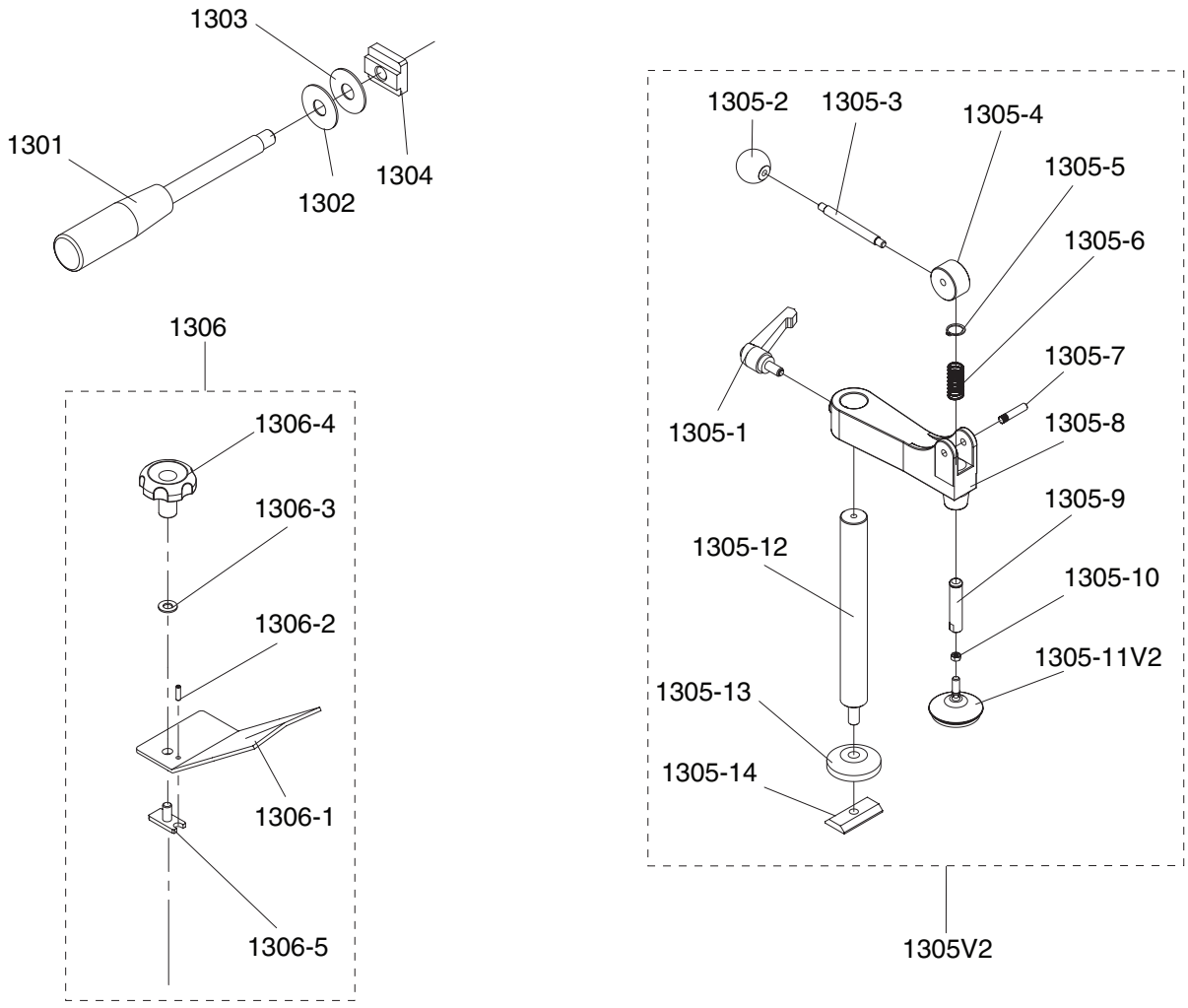
Sliding Table



REF	PART #	DESCRIPTION
1201	P08201201	HEX NUT M12-1.75
1202	P08201202	LOCK WASHER 12MM
1203	P08201203	FLAT WASHER 12MM
1204	P08201204	T-SLOT BOLT M12-1.75 X 50
1205	P08201205	SLIDING TABLE BASE
1206	P08201206	SLIDING TABLE BASE END CAP (LH)
1207	P08201207	FLAT HD SCR M6-1 X 30
1208	P08201208	STOP BLOCK (RUBBER)
1209	P08201209	STOP BLOCK BRACKET
1210	P08201210	PIN LOCK
1211	P08201211	SLIDING TABLE END COVER (R/L)
1212	P08201212	SLIDING TABLE TOP 1600MM
1213	P08201213	SLIDING TABLE BASE END COVER (RH)
1214	P08201214	BUTTON HD CAP SCR M6-1 X 10
1215	P08201215	STEEL RAIL
1216	P08201216	COTTON PAD
1217	P08201217	COVER STRIP
1218	P08201218	ADHESIVE STRIP
1219	P08201219	CAP SCREW M8-1.25 X 16

REF	PART #	DESCRIPTION
1220	P08201220	PULL HANDLE
1221	P08201221	FLAT HD SCR M10-1.5 X 20
1222	P08201222	HANDLE MOUNTING PLATE
1223	P08201223	HEX NUT M16-1.5
1224	P08201224	BUTTON HD CAP SCR M5-.8 X 12
1225	P08201225	LOCK WASHER 8MM
1226	P08201226	HEX NUT M8-1.25
1227	P08201227	TAP SCREW M4-.7 X 12
1228	P08201228	LOCK NUT M10-1.5
1229	P08201229	STEEL BALL 16.6MM
1230	P08201230	SLIDING PLATE
1231	P08201231	BUTTON HD CAP SCR M6-1 X 16
1232	P08201232	LOCK WASHER 6MM
1233	P08201233	FLAT WASHER 6MM
1234	P08201234	HEX NUT M6-1
1235	P08201235	END CAP BRACKET
1236	P08201236	LOCK WASHER 6MM
1237	P08201237	BUTTON HD CAP SCR M6-1 X 12

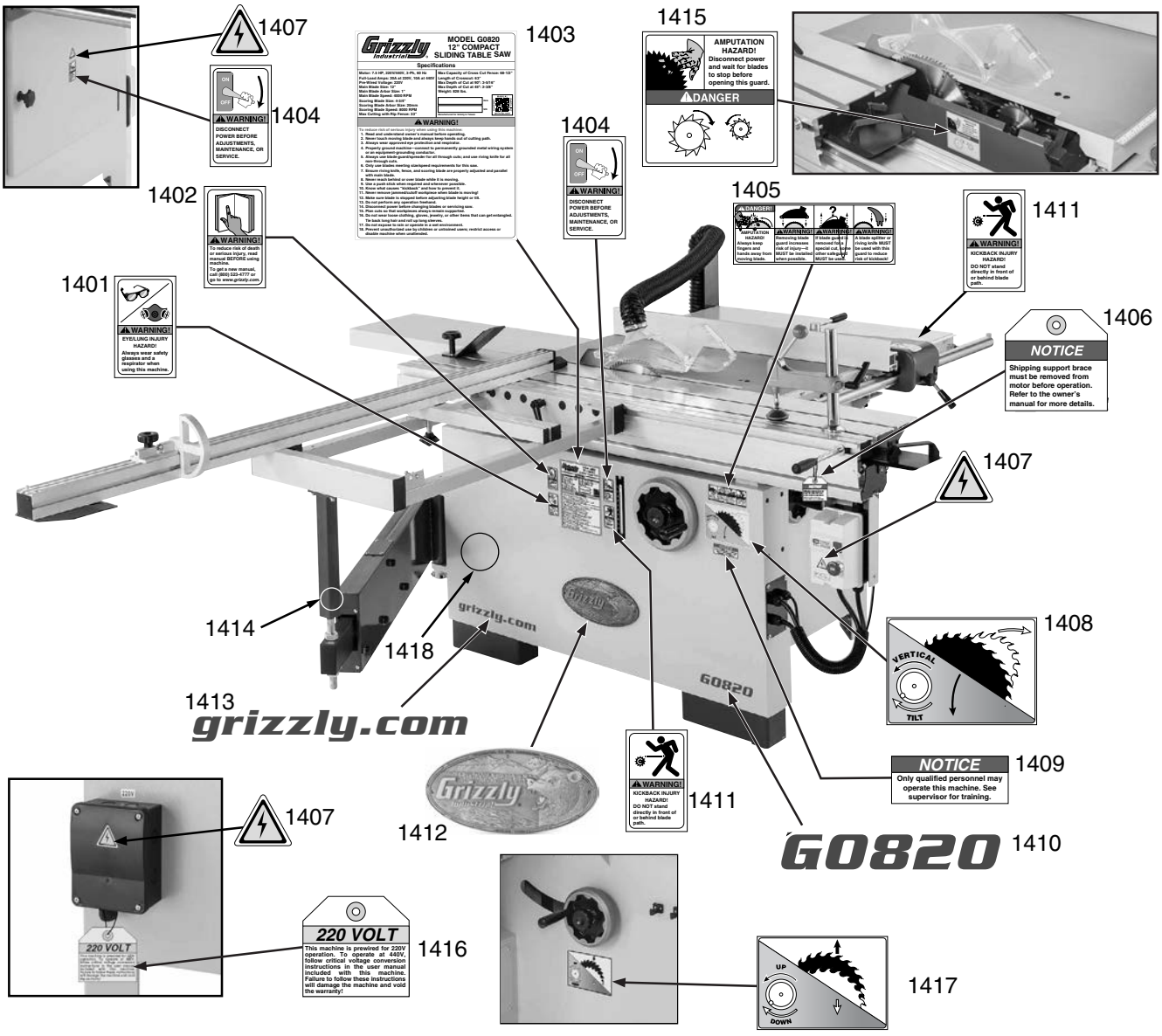
Sliding Table Accessories



REF	PART #	DESCRIPTION
1301	P08201301	LEVER HANDLE M12-1.75 X 20, 215L
1302	P08201302	FLAT WASHER 12MM
1303	P08201303	FLAT WASHER 12MM COPPER
1304	P08201304	T-SLOT NUT M12-1.75
1305V2	P08201305V2	HOLD-DOWN ASSEMBLY V2.10.17
1305-1	P08201305-1	ADJ HANDLE 70L M10-1.5 X 25
1305-2	P08201305-2	BALL KNOB M8-1.25
1305-3	P08201305-3	STUD-DE M8-1.25 X 100, 10MM
1305-4	P08201305-4	CAM
1305-5	P08201305-5	EXT RETAINING RING 14MM
1305-6	P08201305-6	COMPRESSION SPRING 40 X 18 X 1.6MM
1305-7	P08201305-7	FLUTED PIVOT PIN
1305-8	P08201305-8	HOLD-DOWN BRACKET

REF	PART #	DESCRIPTION
1305-9	P08201305-9	HOLD-DOWN SHAFT
1305-10	P08201305-10	HEX NUT 5/16-18
1305-11V2	P08201305-11V2	HOLD-DOWN PAD V2.10.17
1305-12	P08201305-12	SUPPORT SHAFT
1305-13	P08201305-13	SHAFT BASE
1305-14	P08201305-14	T-NUT 14MM W/HOLE M12-1.75
1306	P08201306	EDGE SHOE ASSEMBLY
1306-1	P08201306-1	EDGE SHOE PLATE
1306-2	P08201306-2	ROLL PIN 5 X 16
1306-3	P08201306-3	FLAT WASHER 10MM
1306-4	P08201306-4	KNOB M10-1.5
1306-5	P08201306-5	T-SLOT BOLT M10-1.5 X 25

Labels & Cosmetics



REF	PART #	DESCRIPTION
1401	P08201401	GLASSES/RESPIRATOR LABEL
1402	P08201402	READ MANUAL LABEL
1403	P08201403	MACHINE ID LABEL
1404	P08201404	DISCONNECT HARDWIRED LABEL
1405	P08201405	TABLE SAW BLADE GUARD LABEL
1406	P08201406	SHIPPING BRACE TAG
1407	P08201407	ELECTRICITY LABEL
1408	P08201408	BLADE TILT LABEL
1409	P08201409	QUALIFIED PERSONNEL LABEL

REF	PART #	DESCRIPTION
1410	P08201410	MODEL NUMBER LABEL
1411	P08201411	KICKBACK HAZARD LABEL
1412	P08201412	GRIZZLY NAMEPLATE
1413	P08201413	GRIZZLY.COM LABEL
1414	P08201414	TOUCH-UP PAINT, GRIZZLY GREEN
1415	P08201415	AMPUTATION DANGER LABEL
1416	P08201416	PREWIRED 220V TAG
1417	P08201417	BLADE ELEVATION LABEL
1418	P08201418	TOUCH-UP PAINT, GREY PUTTY

⚠WARNING

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

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.