



14" INDUSTRIAL BANDSAW

MODEL G0570

INSTRUCTION MANUAL



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WARNING

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

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

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

Table of Contents

INTRODUCTION.....	3
Foreword	3
Contact Info	3
G0570 Machine Data Sheet.....	4
Machine Features	5
SECTION 1: SAFETY.....	6
Safety Instructions for Machinery.....	6
Additional Safety Instructions for Bandsaws.....	8
SECTION 2: CIRCUIT REQUIREMENTS	9
110/220V Operation	9
Grounding.....	10
Extension Cords.....	10
SECTION 3: SET UP	11
Set Up Safety	11
Items Needed For Set Up	11
Unpacking	11
Inventory.....	12
Hardware Recognition Chart.....	13
Clean Up	14
Site Considerations	14
Assembling Stand	15
Body Assembly	16
Table	16
Installing Fence	17
Dust Collection	18
Installing Positive Stop	18
Adjusting Positive Stop	19
Blade Tracking	20
Test Run.....	21
Tensioning Blade	21
Adjusting Support Bearings.....	22
Adjusting Blade Guides.....	23
Calibrating Table Tilt Scale	24
Aligning Table	25
Aligning Fence	25
Miter Gauge	26

SECTION 4: OPERATIONS	27
Operation Safety	27
Overview	27
START/STOP Switch	28
Guide Post	28
Blade Lead	29
Table Tilt	30
Ripping	30
Crosscutting	31
Resawing.....	32
Cutting Curves	33
Stacked Cuts.....	33
Blade Information	34
Blade Changes.....	36
SECTION 5: ACCESSORIES	38
SECTION 6: MAINTENANCE	40
Schedule	40
Cleaning	40
Unpainted Cast Iron	40
Lubrication.....	40
SECTION 7: SERVICE	41
About Service.....	41
Checking V-Belt	41
Tensioning V-Belt.....	41
Replacing V-Belt	42
Wheel Alignment	43
G0570 Wiring Diagram.....	45
G0570 Parts Breakdown	46
G0570 Parts List	50
Troubleshooting.....	52
Warranty and Returns.....	54

INTRODUCTION

Foreword

We are proud to offer the Model G0570 14" Industrial Bandsaw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0570. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0570 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!



Contact Info

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

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

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

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





MACHINE DATA SHEET

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

MODEL G0570 14" INDUSTRIAL BANDSAW

Design Type Floor Model

Overall Dimensions:

Table Size 19³/₄" x 14³/₁₆" x 1¹/₂"
Height From Floor To Table 42¹/₄"
Overall Height 69³/₄"
Overall Width 29³/₄"
Overall Depth (Including Fence) 29¹/₂"
Shipping Weight 215 lbs.
Machine Weight 203¹/₂ lbs.
Crate Size 48¹³/₁₆" L x 22¹³/₁₆" W x 19³/₄" H
Footprint 24¹/₂" W x 17¹/₂" D

Capacities:

Throat Capacity (Left of Blade) 13¹/₂"
Height Capacity 8¹/₈"
Table Tilt 8°L–45°R
Blade Size Range 1¹/₈"–1"
Standard Blade Length 101"
Blade Speeds 3000 FPM

Construction:

Table Precision Ground Cast Iron
Wheels Fully Balanced Cast Iron w/Rubber Tires
Rip Fence Deluxe Extruded Aluminum Fence
Stand Pre-Formed Steel
Guides Ball Bearing Blade Guides

Main Motor:

Type TEFC Capacitor-Start Induction
Horsepower 1¹/₂ HP
Phase / Voltage Single-Phase / 110/220V
Amps 14 / 7A
Cycle / RPM 60 Hertz / 1725 RPM
Switch ON / OFF Push Button
Bearings Shielded & Permanently Lubricated Ball Bearings

Features:

..... 4" Dust Port
..... Magnifying Window Over Fence Scale
..... Hinged Wheel Covers
..... Powder Coat Paint
..... Quick Release Blade Tension

Specifications, while deemed accurate, are not guaranteed.

Machine Features

The instructions in this manual will be easier to understand if you become familiar with the location and names of the features of your bandsaw.

Match up the feature list below with the letters in **Figures 1 & 2** to identify the external bandsaw feature locations.

- A. ON/OFF Switch**—Makes the machine run or stop; however, it does not cut power to the machine and should never be substituted for unplugging the power when required.
- B. Fence Lock Lever**—Locks the fence in place for cutting operations and unlocks the fence for adjustments or removal.
- C. Hinged Wheel Covers**—Allows easy access to wheels and pulleys for maintenance, blade changes or adjustments.
- D. Blade Guide Assemblies**—Two assemblies, one upper and one lower, each consisting of two roller bearings for side-to-side support and a single roller bearing to support the back of the blade.
- E. Table Tilt Scale**—Displays the table tilt angle.
- F. Tracking Control Knob**—Controls blade tension adjustments.
- G. Blade Tension Quick Release**—Releases blade tension immediately for easy blade changes.
- H. Blade Tracking Adjustment Knob**—Adjusts the tilt of the upper wheel, to control how the blade will track on the wheel.
- I. Rack & Pinion Guide Adjustment**—Adjusts the blade guide height.
- J. Guide Post Lock Knob**—Unlocks the guide post for adjustments and locks the guide post in place after adjustments.

- K. Blade Tension Scale**—Displays the blade tension for a range of blade sizes.
- L. Table Trunnion Adjustment Knobs**—Loosens the table trunnions for tilt adjustments and locks the table in place.

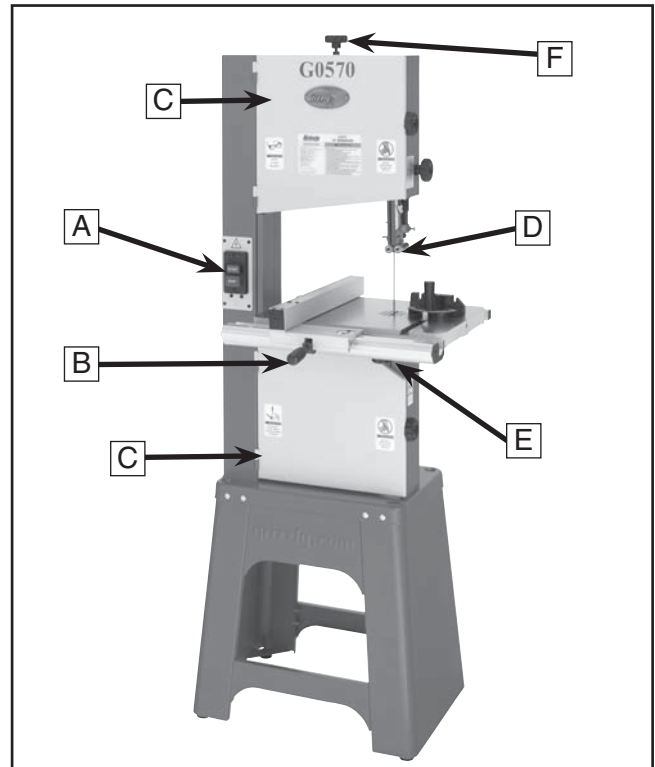


Figure 1. Front view of bandsaw.

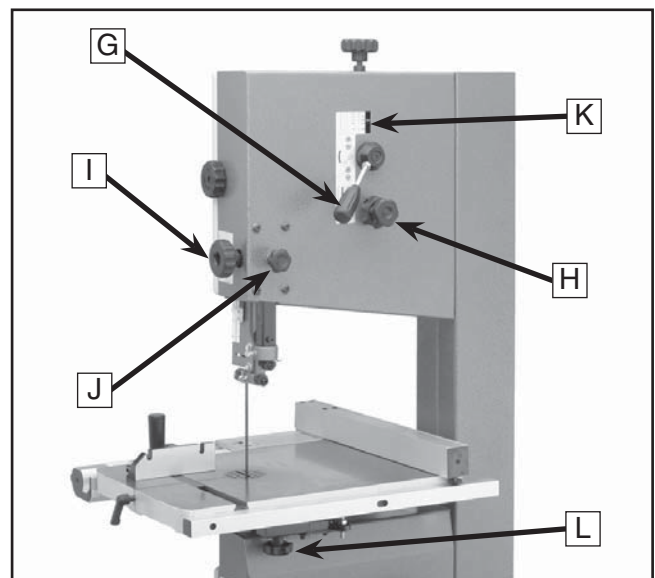


Figure 2. Rear view of bandsaw.



SECTION 1: SAFETY

WARNING

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

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



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



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



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

NOTICE

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

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. MAKE SURE ALL GUARDS ARE IN THEIR CORRECT PLACE AND WORK CORRECTLY BEFORE USING MACHINERY. NEVER OPERATE MACHINE WITHOUT GUARDS.**
- 3. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 4. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 5. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 6. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.

WARNING

Safety Instructions for Machinery

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

WARNING

Additional Safety Instructions for Bandsaws

1. **BLADE CONDITION.** DO NOT operate with a dull, cracked or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.
2. **HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Serious personal injury could occur.
3. **GUARDS.** DO NOT operate this bandsaw without the blade guard in place.
4. **BLADE REPLACEMENT.** When replacing blades, make sure teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned after installing.
5. **WORKPIECE HANDLING.** Always support the workpiece with a table or a support fixture. Always support round stock in a V-block.
6. **CUTTING TECHNIQUES.** Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw OFF and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing work away.
7. **BLADE SPEED.** Blade should be running at full speed before beginning a cut.
8. **WORKPIECE PRESSURE.** Always feed stock evenly and smoothly. DO NOT force or twist blade while cutting, especially when sawing small radii.
9. **CUTTING PROPER MATERIAL.** This machine is not designed to cut metal or any material except wood.
10. **BLADE CONTROL.** Allow blade to come to a complete stop before leaving it unattended. DO NOT attempt stop or slow blade.
11. **MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the power OFF and is disconnected from power source. Wait for all moving parts to come to a complete stop.
12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
13. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

WARNING

Like all machines there is danger associated with the Model G0570. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with caution to reduce the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

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

SECTION 2: CIRCUIT REQUIREMENTS

110/220V Operation

WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0570 features a 1½ HP, 110/220V motor that is prewired for 110V.

Motor Load at 110V	20 Amps
Motor Load at 220V	10 Amps

Circuit Breaker Requirements

Install your machine on a dedicated circuit to reduce the possibility of tripping the circuit breaker. If the circuit breaker frequently trips, have the circuit inspected by a qualified electrician. Never use a larger circuit breaker than stated below, or you will increase the risk of fire.

110V Circuit Breaker	25 Amp
220V Circuit Breaker	15 Amp

Plug Type

The Model G0570 comes prewired with a NEMA 5-15 plug. If you wish to rewire the motor to 220V we recommend using the following plug (see **Figure 3** for an example):

220V Plug & Receptacle 6-15

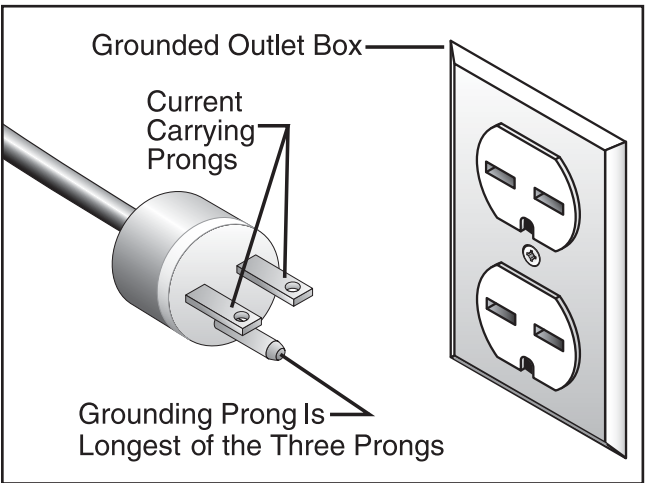
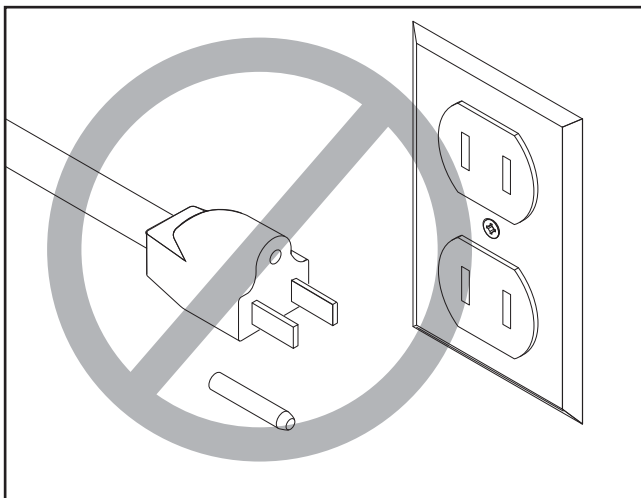
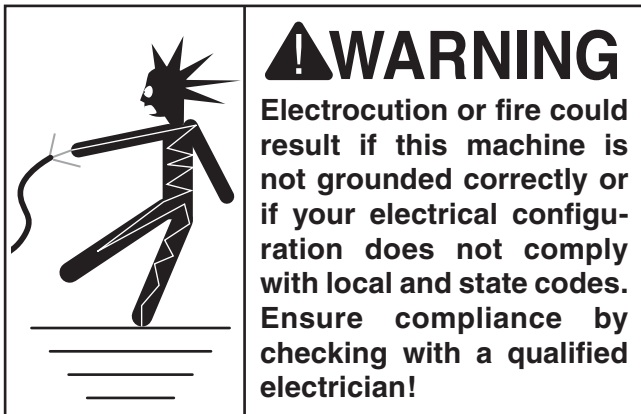


Figure 3. 6-15 plug and receptacle.



Grounding

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with a power cord that has a plug with an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.



! CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.



Extension Cords

110V Operation

If you find it necessary to use an extension cord at 110V with your machine:

- Make sure the cord is rated Standard Service (grade S) or better.
- The extension cord must contain a ground wire and plug pin.
- Use at least a 12 gauge cord if the cord is 50 feet long or less.
- Use at least a 12 gauge cord if the cord is between 51-100 feet.

220V Operation

We do not recommend the use of extension cords on 220V equipment. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

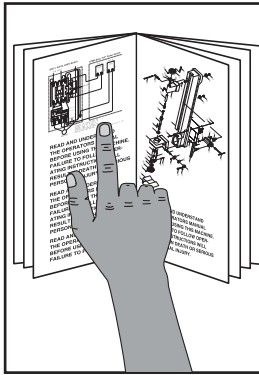
If you find it absolutely necessary to use an extension cord at 220V with your machine:

- Make sure the cord is rated for Standard Service (grade S) or better.
- The extension cord must contain a ground wire and plug prong.
- Use at least a 10 gauge cord if the cord is 50 feet long or less.
- **DO NOT** use a cord longer than 50 feet!



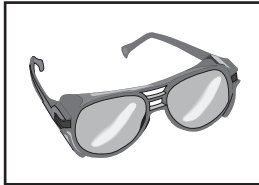
SECTION 3: SET UP

Set Up Safety



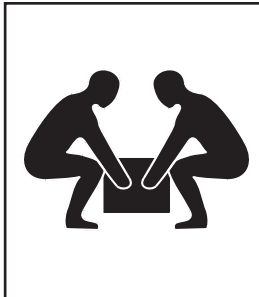
!WARNING

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



!WARNING

Wear safety glasses during the entire set up process!



!WARNING

The Model G0570 is a heavy machine (215 lbs.). DO NOT over-exert yourself while unpacking or moving your machine—get assistance.



Items Needed For Set Up

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

DESCRIPTION	QTY
• Safety Glasses (for each person)	1
• Dust Collection System	1
• 4" Dust Hose (length varies)	1
• 4" Hose Clamp	2
• Wrenches or Sockets 13mm	2
• Wrench or Socket 10mm	1
• Wrench 12mm	1
• Wrenches $\frac{9}{16}$ "	2
• Hex Wrench 4mm	1
• Hex Wrench 5mm	1
• Phillips Screwdriver	1
• Machinist's Square	1
• Ruler	1
• Straightedge	1
• Feeler Gauge, .016"	1



Unpacking

The Model G0570 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

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

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



Inventory

After all the parts have been removed from the two boxes, you should have the following items:

Contents (Figures 4 & 5):

	QTY
A. Body Assembly.....	1
B. Table	1
C. Stand Sides	2
D. Stand Braces, upper	2
E. Stand Braces, lower	2
F. Fence Assembly.....	1
G. Fixed Rail	1
H. Square Rail.....	1
I. Miter Gauge Assembly.....	1
J. Hardware Bag 1	1
—Hex Bolt M8-1.25 x 80	1
—Hex Nut M8-1.25	1
—Hand Knobs M10-1.5.....	2
K. Hardware Bag 2	1
—Flat Washers 10mm	8
—Hex Nuts $\frac{3}{8}$ "-16	8
—Rubber Feet.....	4
—Flange Nuts M6-1	16
—Flat Washers 6mm	16
—Hex Bolts M6-1 x 16	16
—Flange Nuts M8-1.25	8
—Carriage Bolts M8-1.25 x 16.....	8
L. Hardware Bag 3	1
—Flat Washers 6mm	2
—Hex Nut M8-1.25	1
—Lock Washers 6mm.....	2
—Handle M8-1.25	1
—Hex Bolts M6-1 x 20	2
—Cap Screws M6-1 x 16	2
—Adjustment Pad M6-1 x 20	1
—Hex Nut M6-1	1



Figure 4. Body Assembly.

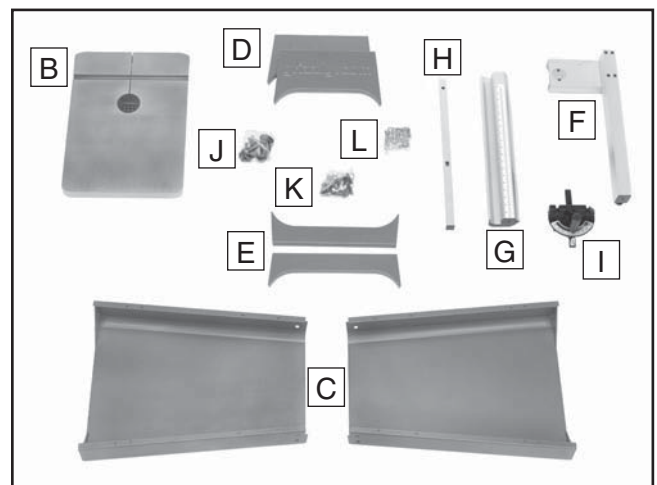


Figure 5. Bandsaw Components

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

○ #10

○ 1/4"

○ 5/16"

○ 3/8"

○ 7/16"

○ 1/2"



Key

4mm ○

6mm ○

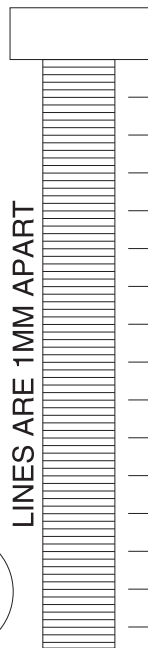
8mm ○

10mm ○

12mm ○

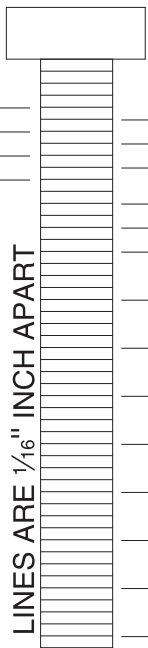
16mm ○

LINES ARE 1MM APART

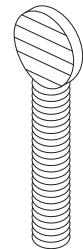


5mm
10mm
15mm
20mm
25mm
30mm
35mm
40mm
45mm
50mm
55mm
60mm
65mm
70mm
75mm

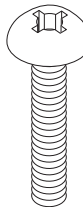
LINES ARE 1/16" INCH APART



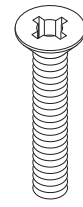
1/4"
3/8"
1/2"
5/8"
5/16"
7/16"
9/16"
3/4"
7/8"
1"
1 1/4"
1 1/2"
1 3/4"
2
2 1/4"
2 1/2"
2 3/4"
3



Thumb
Screw



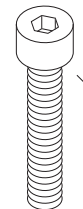
Phillips
Head
Screw



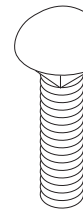
Flat
Head
Screw



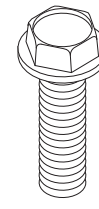
Tap
Screw



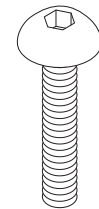
Cap
Screw



Carriage
Bolt



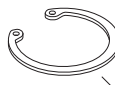
Flange
Bolt



Button
Head
Screw



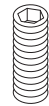
External
Retaining
Ring



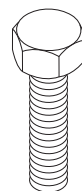
Internal
Retaining
Ring



E-Clip



Setscrew



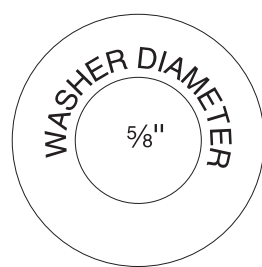
Hex
Bolt



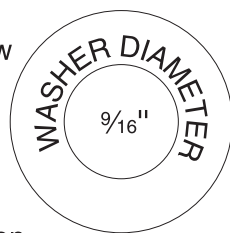
Lock
Nut



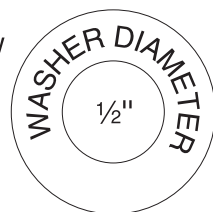
Wing
Nut



WASHER DIAMETER
5/8"



WASHER DIAMETER
9/16"



WASHER DIAMETER
1/2"



WASHER DIAMETER
7/16"



WASHER DIAMETER
3/8"



WASHER DIAMETER
5/16"



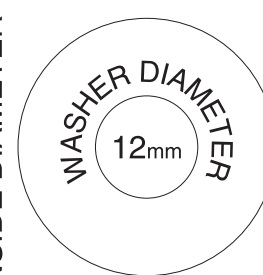
WASHER DIAMETER
1/4"



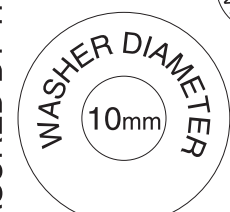
WASHER DIAMETER
3/16"

#10

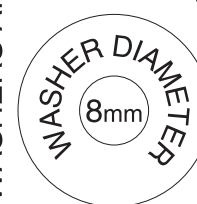
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



WASHER DIAMETER
12mm



WASHER DIAMETER
10mm



WASHER DIAMETER
8mm




WASHER DIAMETER
4mm

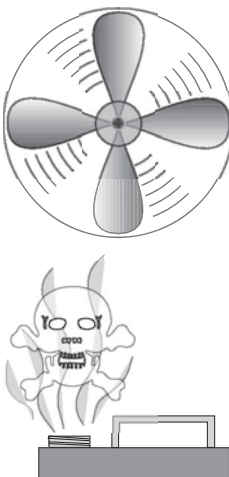


WASHER DIAMETER
6mm

Clean Up

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

	<p>! WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
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	<p>! CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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Site Considerations

Floor Load

The Model G0570 weighs 203 $\frac{1}{2}$ lbs. and has a base footprint of 24 $\frac{1}{2}$ " W x 17 $\frac{1}{2}$ " D. Most commercial floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 6** for the minimum working clearances of the Model G0570.

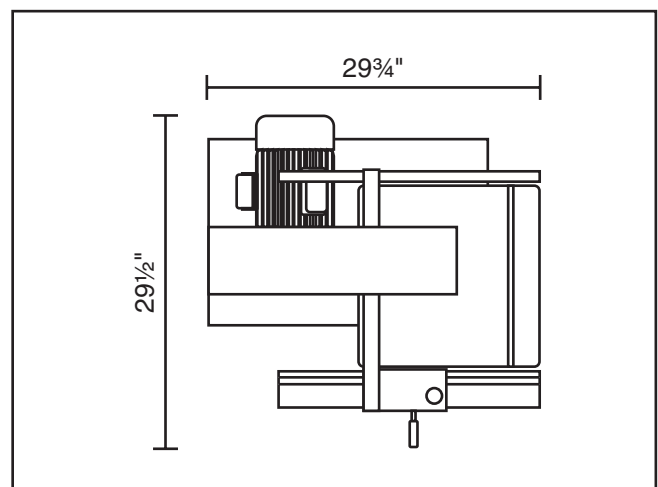


Figure 6. Working clearances.

	<p>! CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
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Assembling Stand

Components and Hardware Needed:		QTY
Stand Braces, upper.....	2	2
Stand Braces, lower.....	2	2
Stand Sides.....	2	2
Hex Bolts M6-1 x 16.....	16	16
Flat Washer 6mm.....	16	16
Flange Nuts M6-1.....	16	16
Rubber Feet.....	4	4
Hex Nuts $\frac{3}{8}$ -16.....	8	8
Flat Washers 10mm.....	8	8

Tools Needed:		QTY
Wrench or Socket 10mm.....	1	1
Wrenches $\frac{9}{16}$ ".....	2	2

To assemble the stand:

1. Attach the upper stand sides to the top of the stands with eight M6-1 x 16 hex bolts, flat washers and flange nuts (**Figure 7**).

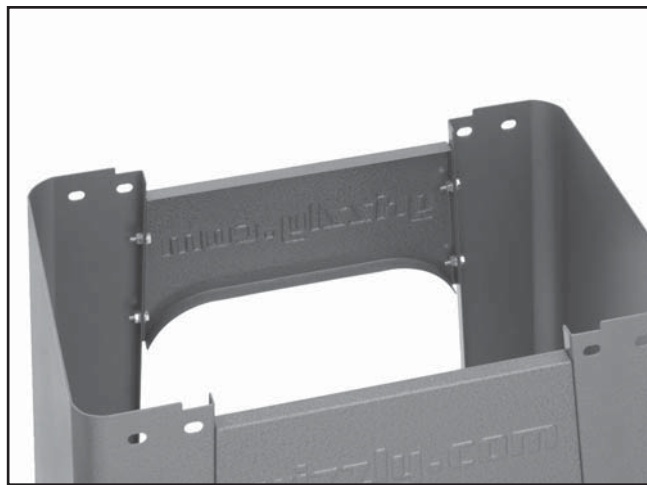


Figure 7. Upper side covers bolted to stands.

2. Attach the lower stand sides to the stand sides (**Figure 8**) with the remaining eight M6-1 x 16 hex bolts, flat washers and flange nuts.

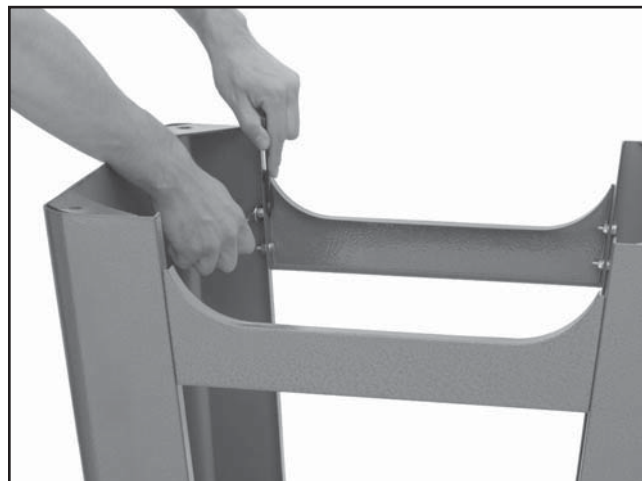


Figure 8. Lower side covers bolted to stands.

3. Turn the assembled stand upside down.
4. Install the rubber feet by threading on a $\frac{3}{8}$ -16 hex nut and 10mm flat washer, inserting them through the holes in the stands, and threading another $\frac{3}{8}$ -16 hex nut and 10mm flat washer as illustrated in **Figure 9**.

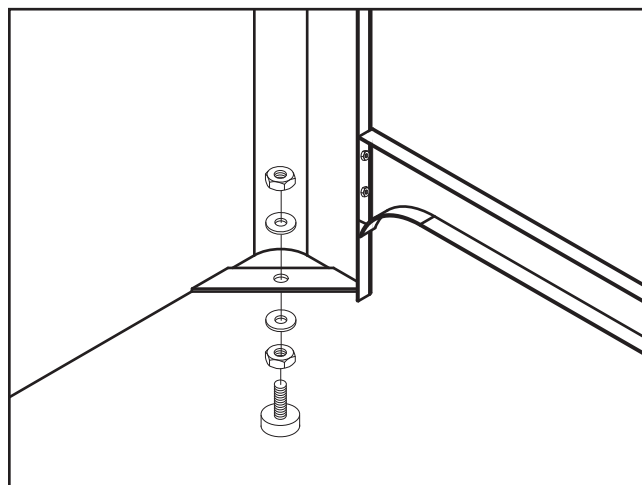



Figure 9. Rubber foot installation.



Body Assembly

Components and Hardware Needed:	QTY
Carriage Bolts M8-1.25 x 16.....	8
Flange Nuts M8-1.25	8
Assembled Stand.....	1
Body Assembly.....	1

Tools Needed:	QTY
Wrench or Socket 13mm.....	1



!WARNING

The Model G0570 is a heavy machine. **DO NOT** over-exert yourself while unpacking or moving your machine—get assistance.

To install the body assembly:

1. With the help of an assistant, align the stand holes with the body assembly holes, and set the body onto the stand.
2. Have your assistant hold the body in place, and secure the body to the stand with the carriage bolts and flange nuts (**Figure 10**).



Figure 10. Securing the body to the stand.



Table

Components and Hardware Needed:	QTY
Table.....	1
Hand Knobs M10-1.5	2

To install the table:

1. Remove the table pin and table insert.
2. Line up the blade with the table slot, move the table over the base, rotate the table, and place the table bolts through the trunnions.
3. Thread the hand knobs onto the table bolts to secure the table (**Figure 11**).

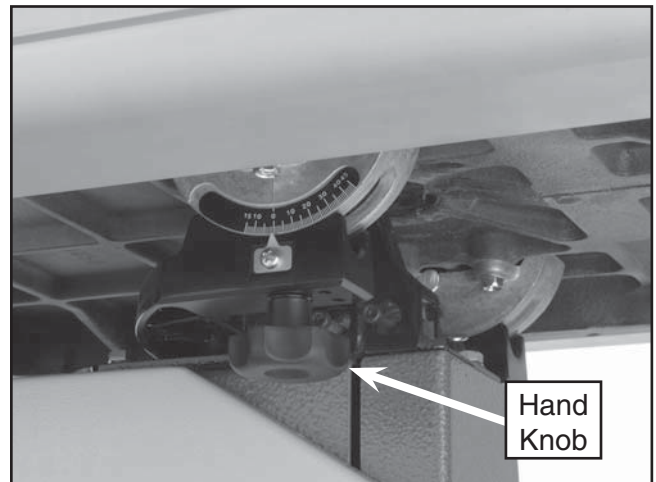


Figure 11. Table installed on trunnions.

4. Re-install the table pin and table insert.



Installing Fence

Components and Hardware Needed:	QTY
Fence Assembly.....	1
Fixed Rail	1
Square Rail.....	1
Flat Washers 6mm	2
Hex Nut M8-1.25	1
Lock Washers 6mm.....	2
Handle M8-1.25.....	1
Hex Bolts M6-1 x 20.....	2
Cap Screws M6-1 x 16.....	2
Adjustment Pad M6-1 x 20.....	1
Hex Nut M6-1	1

Tools Needed:	QTY
Wrench 10mm	1
Wrench 12mm	1
Hex Wrench 5mm.....	1

To install the fence:

1. Fasten the square rail to the back of the table with the cap screws.
2. Attach the fixed rail to the front of the bandsaw table with the hex bolts, flat washers, and lock washers (**Figure 12**).



Figure 12. Installed fixed rail.

3. Insert the adjustment pad into the bottom end of the back of the fence.
4. Thread the M8-1.25 hex nut onto the handle threads, then thread the handle onto the fence.
4. Tighten the hex nut on the handle down to the fence body to prevent the handle from rotating.
5. Pull the handle up and place the fence assembly on the fixed rail as shown in **Figure 13**.

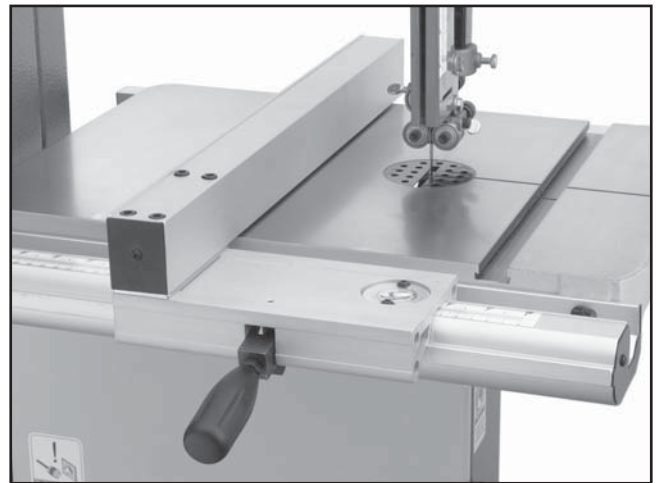


Figure 13. Correctly installed fence.

6. Rotate the adjustment pad so the end of the fence is just above the table, then tighten the hex nut to lock it in place.
7. Push the handle down to lock the fence assembly in place.



Dust Collection

CAUTION

DO NOT operate the Model G0570 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.

Components and Hardware Needed: Qty
4" Dust Hose (length varies) 1
4" Hose Clamps 2

Tools Needed:
Phillips Screwdriver 1

To connect a dust collection hose:

1. Place a hose clamp over the end of the 4" dust hose.
2. Fit the 4" dust hose over the dust port, as shown in **Figure 14**, and tighten.



Figure 14. Dust hose attached to dust port.

3. Tug the hose to make sure it does not come off. Note—A tight fit is necessary for best performance!
4. Connect hose to a dust collection system.



Installing Positive Stop

Components and Hardware Needed: QTY
Hex Bolt M8-1.25 x 80..... 1
Hex Nut M8-1.25 1

Tools Needed: QTY
Wrench 13mm 1

To install the positive stop:

1. Thread the M8-1.25 hex nut halfway onto the M8-1.25 x 80 hex bolt (this is the positive stop bolt).
2. Thread the positive stop bolt into the threaded hole on the trunnion support bracket as shown in **Figure 15**.

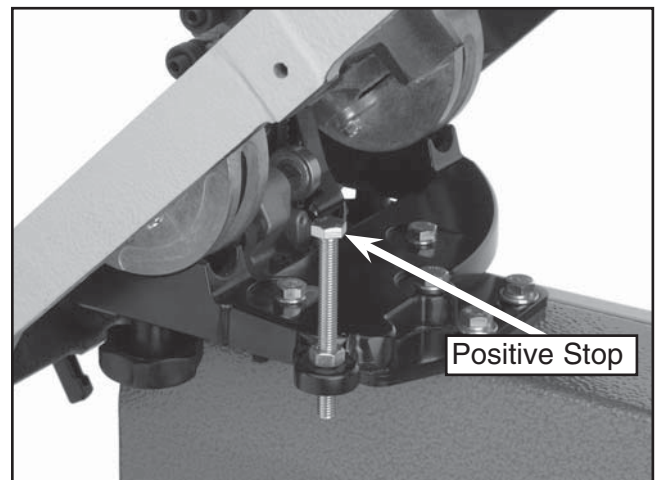


Figure 15. Installed positive stop bolt.



Adjusting Positive Stop

The adjustable positive stop allows the table to be reset 90° to the blade after tilting to the right.

Tools Needed:	QTY
Wrenches 13mm	2
Machinist's Square	1

To set the positive stop:

1. Ensure the blade is correctly tensioned as described in Tensioning Blade instructions on **page 21**.
2. **Unplug the bandsaw!**
3. Loosen the hex nut that locks the positive stop adjusting bolt in place.
4. Raise the guide post and place a machinist's square on the table next to the side of the blade as illustrated in **Figure 16**. Tilt the table until the table rests at 90° to the blade, then secure with the table tilt knobs.
5. Adjust the positive stop bolt to the table.
6. Secure the positive stop bolt by tightening the hex nut against the trunnion bracket. Note—See Calibrating Table Tilt Scale on **page 24**.
7. Check the adjustment for accuracy once you have tightened the hex nut.

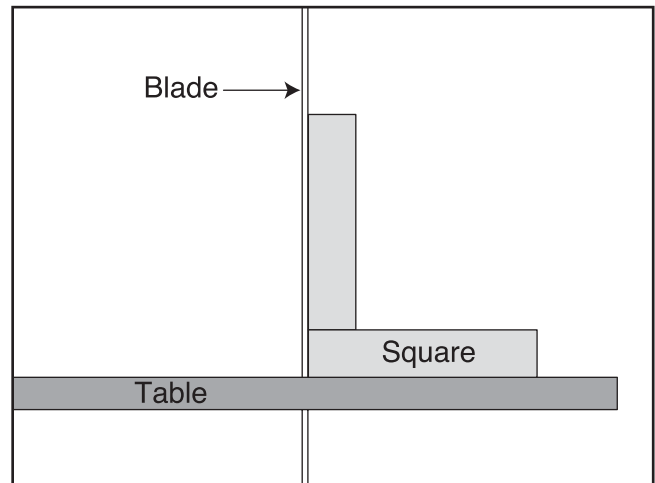


Figure 16. Squaring table to blade.



Blade Tracking

The blade tracking is primarily affected by the tilt of the upper wheel, also known as **Center Tracking**; and the alignment of both wheels, also known as **Coplanar Tracking**. (For Coplanar Tracking, see the Wheel Alignment instructions on page 43.)

The wheels on the Model G0570 were aligned at the factory, so **Center Tracking** is the only adjustment that needs to be performed when the saw is new.

To center track the blade:

1. **Unplug the bandsaw!**
2. Adjust the upper and lower guide bearings and support bearings as far away as possible from the blade.
3. Open the upper wheel cover.
4. Adjust blade tension until the mark on the blade tension scale matches the size of the installed blade.

CAUTION

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

5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 17** for an illustration of this concept.

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

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

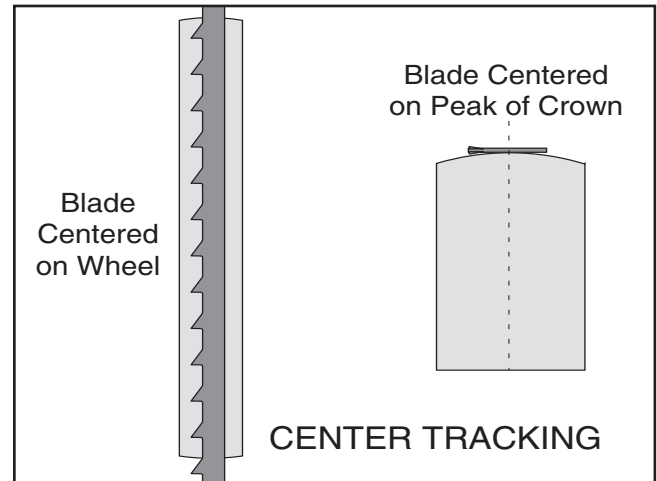


Figure 17. Center tracking profiles.

6. Loosen the lock knob on the tracking control knob threads so that the tracking control knob will rotate for adjustments.
7. Spin the upper wheel with one hand and rotate the tracking control knob with the other hand to make the blade ride in the center of the bandsaw wheel tire. Note—Turn the bandsaw ON to confirm the blade is tracking properly.
8. Tighten the tracking control lock knob and close the upper wheel cover.

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

NOTICE

Changes in the blade tension may change the blade tracking.



Test Run

Once the assembly is complete and you have performed the Blade Tracking instructions, you need to test run the machine to continue with the remainder of the adjustments.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then contact our service department for further assistance.



To test run the machine:

1. Make sure that you have performed the Blade Tracking instructions before continuing with these instructions.
2. Make sure that the blade guides are adjusted as far away from the blade as possible, and that the blade is not touching the table or table insert.
3. Plug the machine into the power source.
4. Press the ON button. Make sure that your hand stays poised over the switch in case you need to quickly turn the machine OFF.
5. Listen to and watch the bandsaw for abnormal noises or actions. The bandsaw should run smoothly with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further—always unplug the machine when investigating or correcting any situation with the machine.



Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is a prerequisite before making many bandsaw adjustments.

To tension the bandsaw blade:

1. Make sure you have performed the Test Run instructions on this page and that the blade is tracking properly.
2. Raise the upper blade guide assembly as high as it will go, and adjust the upper and lower guide blocks as far away from the blade as possible. Note—This procedure will not work if the guide blocks have any contact with the blade.
3. Adjust blade tension until the mark on the blade tension scale matches the size of the installed blade. Note—This scale can only be considered a general guide, complete the following steps to accurately set blade tension.
4. Turn the bandsaw ON.
5. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.
6. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension another quarter turn.
7. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future. Note—Always detension the blade after use to increase blade life and reduce strain on the bandsaw components.

NOTICE

After blade tension and tracking are set correctly, properly adjust the upper and lower support bearings and guide-block assemblies into position before cutting operations.



Adjusting Support Bearings

The support bearings are positioned behind the blade for support during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

Tools Needed: **QTY**
 Feeler Gauge .016" 1

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Familiarize yourself with the support bearing controls shown in **Figure 18**.

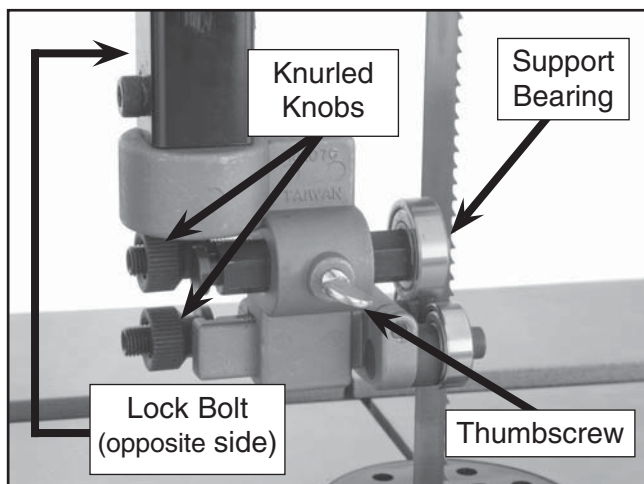


Figure 18. Support bearing controls.

4. Loosen the assembly lock bolt.
5. Rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing as illustrated in **Figure 19**.

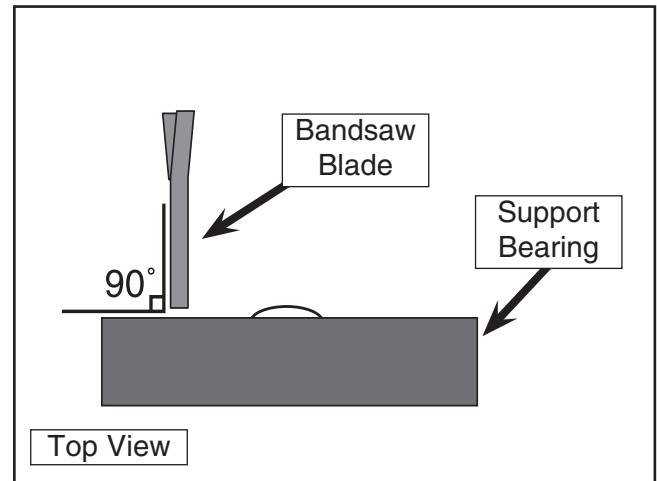


Figure 19. Blade should be perpendicular (90°) to the face of the support bearing.

6. Tighten the assembly lock bolt.
7. Loosen the thumbscrew on the support bearing adjustment shaft.
8. Place the feeler gauge between the support bearing and the blade, and use the upper knurled knob to position the bearing .016" away from the back of the blade as illustrated in **Figure 20**.

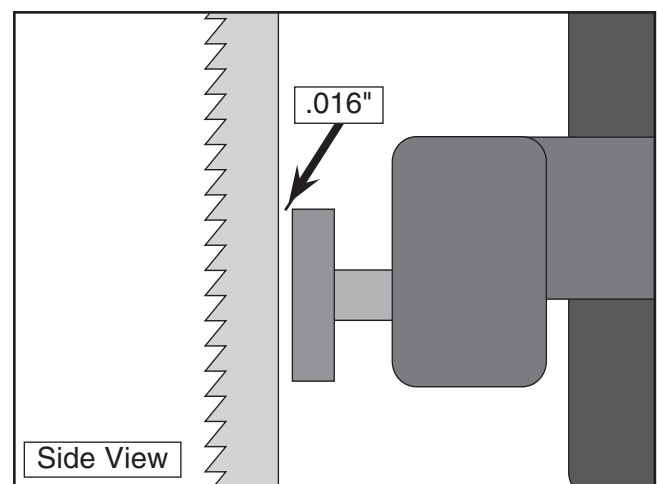


Figure 20. Blade should be aligned approximately .016" away from the bearing edge.

Note—For a quick gauge, fold a dollar bill in half twice (four thicknesses of a dollar bill is approximately .016") and place it between the support bearing and the blade as shown in **Figure 21**.



Figure 21. Dollar bill folded twice to make a quick .016" gauge.

9. Tighten the thumbscrew to keep the support bearing locked in place.

NOTICE

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

Adjusting Blade Guides

The blade guides provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side.

Tools Needed: QTY
Hex Wrench 4mm..... 1

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Familiarize yourself with the blade guide controls shown in **Figure 22**.

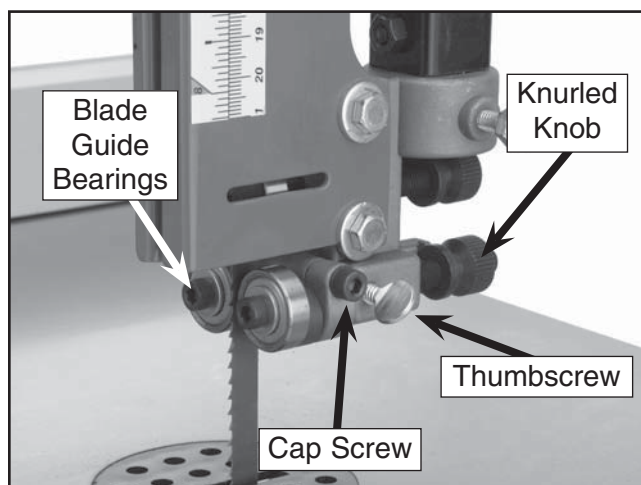


Figure 22. Blade guide controls.

4. Loosen the thumbscrew on the lateral adjustment rod.
5. Rotate the lower knurled knob to position the blade guides, so the edges of the bearings are $\frac{1}{16}$ " behind the blade gullets as illustrated in **Figure 23**. Note—The $\frac{1}{16}$ " spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the guide bearings as far forward as possible to the blade gullets, and still maintain the proper support bearing spacing adjustment.



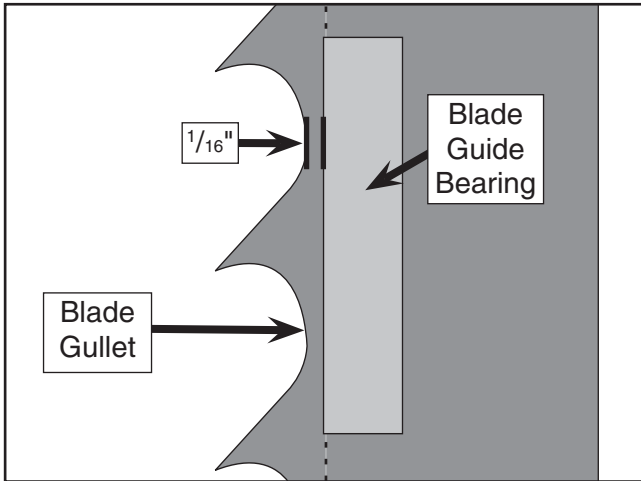


Figure 23. Lateral adjustment of blade guides.

NOTICE

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

6. Tighten the thumbscrew on the lateral adjustment rod.
7. Loosen the cap screws.
8. With the 4mm hex wrench, rotate the center portion of the blade guide bearings to position the bearings .004" away from the blade. Note—.004" is approximately the thickness of a piece of paper.
9. Tighten the cap screw to lock the blade guide bearings in position.

NOTICE

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



Calibrating Table Tilt Scale

The pointer on the table tilt scale must be calibrated in order for the scale reading to be accurate.

Tools Needed:

Phillips Screwdriver 1

QTY

To calibrate the pointer on the table tilt scale:

1. Make sure that the blade is tensioned and is tracking correctly, and that the table is 90° to the blade.
2. Loosen the screw on the pointer (**Figure 24**), but do not remove it.

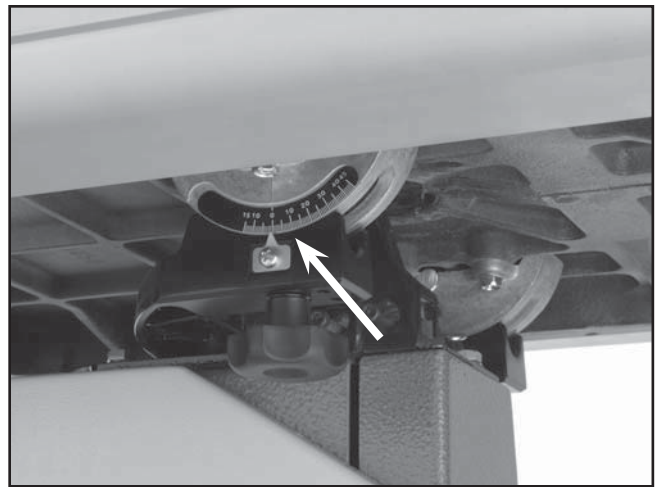


Figure 24. Table tilt scale.

3. Align the tip of the pointer with the 0° mark on the table tilt scale.
4. Tighten the screw on the pointer so that the pointer is locked in place.



Aligning Table

To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a $\frac{3}{4}$ " blade installed.

Tools Needed:	QTY
Wrench 10mm	1
Straightedge	1
Ruler	1

To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Loosen the trunnion bolts that secure the trunnions to the table.
4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade. Note—Make sure the straightedge does not go across a tooth.
5. Use a fine ruler to gauge the distance between the straightedge and the miter slot. The distance you measure should be the same at both the front and the back of the table.
6. Adjust the table as needed for proper alignment.
7. Tighten the trunnion bolts.



Aligning Fence

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

Tools Needed:	QTY
Hex Wrench 5mm.....	1

To align the fence parallel with the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and remount it next to the miter slot.
2. Loosen the 4 cap screws located on the top face of the fence (**Figure 25**).

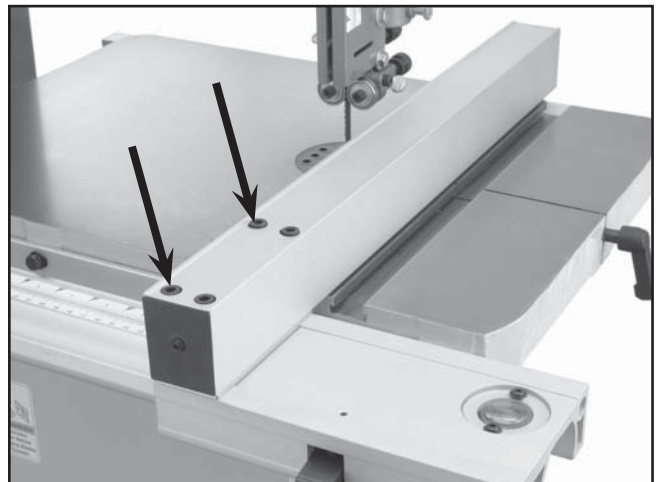


Figure 25. Fence cap screws.

3. Adjust the fence face parallel with the edge of the miter slot.
4. Tighten the 4 cap screws, being careful not to move the fence.



Miter Gauge

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

Tools Needed:	QTY
Machinist's Square	1
Phillips Screwdriver	1

To calibrate the miter gauge:

1. Use a machinist's square with one edge against the face of the miter gauge and the other against the blade face as shown in **Figure 26**.

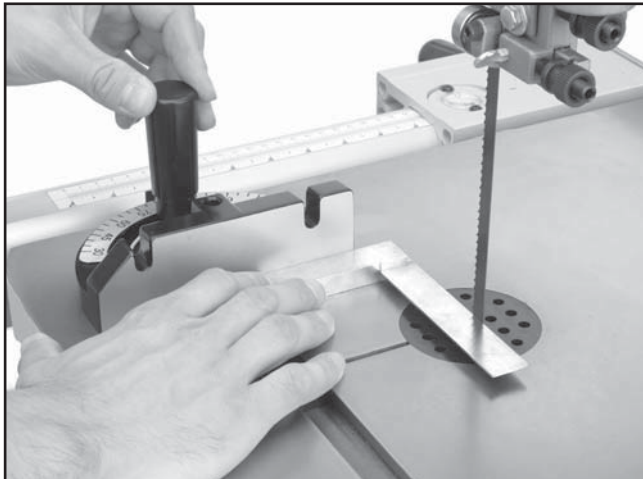


Figure 26. Squaring miter gauge to blade.

2. Loosen the lock knob on the miter gauge and adjust it flush with the edge of the square.
3. Tighten the lock knob, and verify the setting. **Note**—Sometimes the tightening procedure can affect the adjustment.
4. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.
5. Retighten the screw that secures the angle pointer.

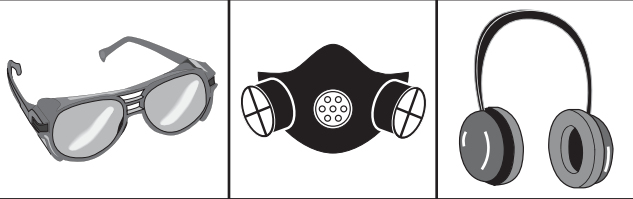


SECTION 4: OPERATIONS

Operation Safety

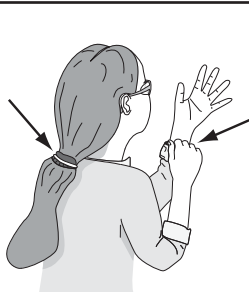
!WARNING

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



!WARNING

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



NOTICE

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



Overview

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

Straight Cuts

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

Irregular Cuts

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

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

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

- Replace and clean blades as necessary and make adjustments periodically to keep the saw always running in top condition.
- Use light and even pressure while cutting. Light contact with the blade will permit easier line following and prevent undue friction.
- Avoid trying to turn sharp corners because this will twist the blade. Remember, you must saw around corners.
- Misuse of the saw or using incorrect techniques is unsafe and results in frustration and poor cuts. Remember—the blade does the cutting with the operator's guidance.



START/STOP Switch

The START/STOP switch on the Model G0570 14" Industrial Bandsaw is located on the column for easy access (**Figure 27**). Immediately turn the machine OFF if at any time during operation of the bandsaw a safety hazard present itself.



Figure 27. G0570 START/STOP switch.

	<p>⚠ CAUTION</p> <p>Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
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Guide Post

The guide post, shown in **Figure 28**, connects the upper blade guide assembly to the bandsaw. The guidepost allows the blade guide assembly to move up or down via rack and pinion adjustment. In order to cut accurately, the blade guide assembly must be no more than 1" from the top of the workpiece at all times—this positioning provides the greatest support to the blade.

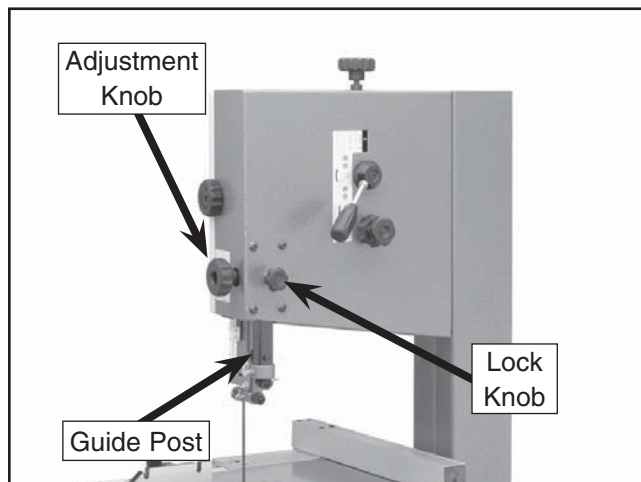


Figure 28. Guide post controls.

To adjust guide post:

1. Make sure that the blade tension, blade tracking, support bearing and blade guides are adjusted correctly.
2. Loosen the guide post lock knob shown in **Figure 28**.
3. Raise/lower the guide post with the adjustment knob to within 1" from the top of the workpiece to the bottom of the blade guide assembly.
4. Lock the guide post in place with the lock knob.



Blade Lead

It is common for a bandsaw blade to wander off the cut line when sawing as shown in **Figure 29**. This is called blade lead. It is commonly caused by a dull or abused blade, or improper tension. If none of these are an issue, perform the following instructions.

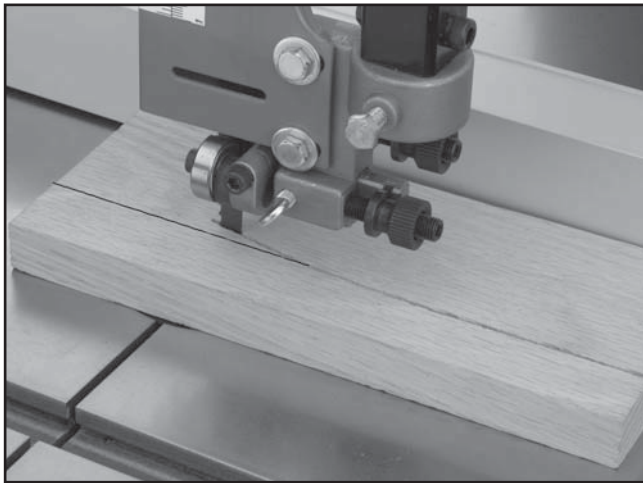


Figure 29. Blade leading away from line of cut.

To correct blade lead:

1. Check that the miter slot or fence is parallel to the blade line, and correct if necessary.
2. Check for proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by skewing the fence or adjusting the table.

To skew your fence:

1. Cut a piece of scrap wood approximately $\frac{3}{4}$ " thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.

2. Slide the fence out of the way and cut free-hand along the line. Stop at the halfway point. Turn the bandsaw OFF and wait for the blade to stop.
3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.
4. Loosen the four cap screws on top of the fence.
5. Skew the fence so it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.
6. While maintaining the skew, tighten the cap screws.

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut halfway through the board on the line by pushing it into the blade.
3. Let the saw come to a complete stop.
4. Loosen the table mounting bolts. Shift the table to compensate for the blade lead.
5. Repeat **steps 1-4** until the blade cuts straight.
6. Tighten the table bolts.



Table Tilt

The bandsaw table will tilt 8° left and 45° right to provide a wide range of cutting options. Remove the positive stop bolt to tilt the table to the left.

To tilt the table:

1. Loosen the two plastic knobs underneath the table that lock the table trunnion.
2. Position the table to the desired angle of tilt. Refer to the angle gauge on the front table trunnion for the tilting angle.
3. Retighten both hand knobs.



Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

CAUTION

DO NOT operate the Model G0570 without an adequate dust collection system. This machine creates substantial amounts of wood dust while in operation. Failure to use a dust collection system can result in short and long-term respiratory illness.

To rip with the Model G0570:

1. Adjust the fence to match the width of the cut on your workpiece and lock the fence in place.
2. Make sure all safety precautions have been taken and start the bandsaw.
3. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 30** shows a typical ripping operation. Note—If you are cutting narrow pieces, use a push stick to protect your fingers.



Figure 30. Ripping with a push stick.

WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may be pulled into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!



Crosscutting

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

To crosscut with the Model G0570:

1. Mark the workpiece on the edge where you want to begin the cut.
2. Move the fence out of the way. Place the workpiece evenly against the miter gauge.
3. Line up the mark with the blade.
4. After all safety precautions have been met, turn the bandsaw ON. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 31** shows a typical cross-cutting operation.

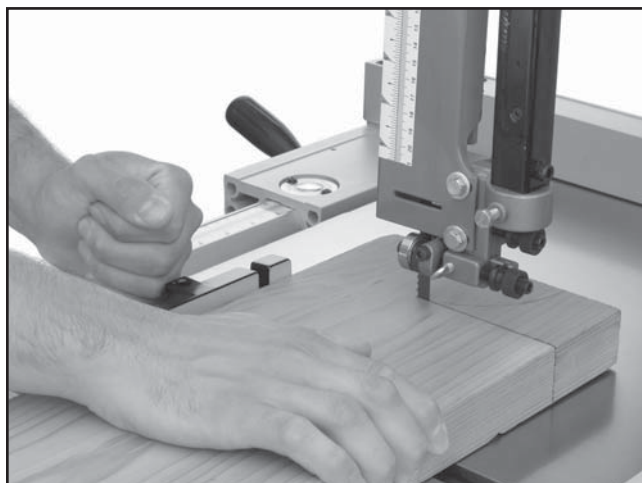


Figure 31. Crosscutting with miter gauge.



Resawing

Resawing (**Figure 32**) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw. Maximum cutting height for this bandsaw is 8¹/₈".

The Model G0570 14" Industrial Bandsaw is capable of resawing, provided the saw is properly set up. Attempting to resaw too wide or too dense of a board may put excessive strain on the blade and cause breakage.

One of the most important considerations when resawing is blade selection. Generally, the wider blade, the better. In most applications, a hook or a skip tooth style will be desirable. Also, since most resawn lumber will be planed smooth, you should choose blades with fewer teeth-per-inch (from 3 to 6). While blades with fewer teeth-per-inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.

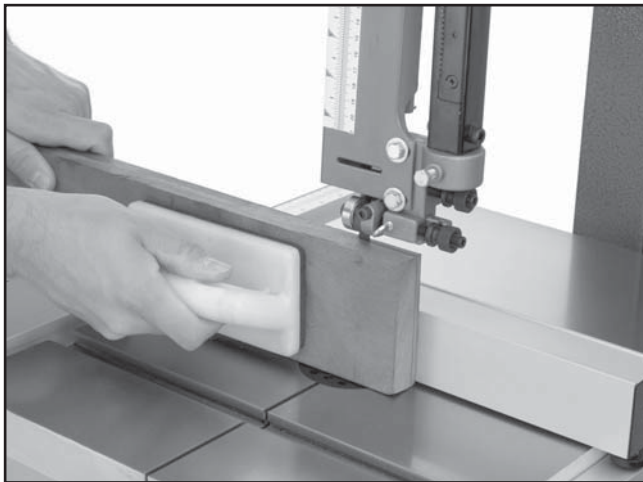


Figure 32. Resawing lumber.

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the table is perpendicular to the blade.
2. Use the widest blade your bandsaw will accept. NOTE—The blade must also be sharp and clean.
3. Use a fence to guide the workpiece.
4. Set your fence to the desired width of cut and lock it in place.
5. Support the ends of the board if necessary.
6. Turn the bandsaw ON.
7. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece.



Cutting Curves

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

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

NOTICE

The list below displays blade widths and the corresponding minimum radii each size of blade for the Model G0570.

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



Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece cut from the top to the bottom of the stack.

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads!)
3. On the face of the top piece, lay out the shape you intend to cut.
4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.

Continued on next page ➡

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 33**.

⚠ CAUTION

Cutting into brad nails that are used to secure the multiple pieces can cause the blade to break and may cause an injury to the operator. Be extremely careful of where you are cutting when performing this operation.

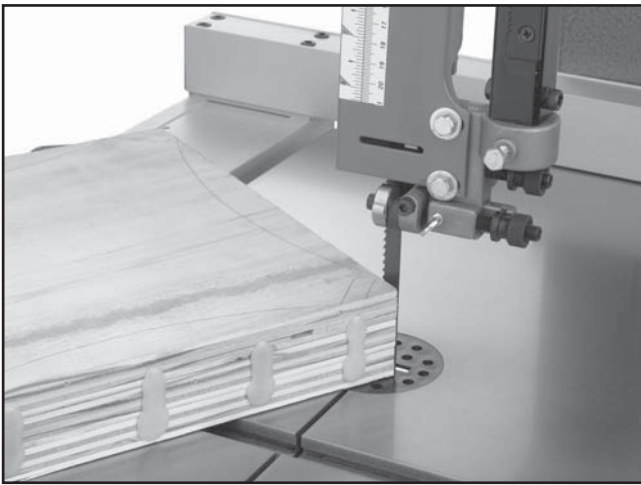


Figure 33. Cutting multiple pieces at once.



Blade Information

Selecting the right blade requires a knowledge of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0570 is designed for blades that are 101" long. Refer to the current Grizzly catalog for prices and ordering information.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0570 can use blades from $\frac{1}{8}$ " to 1" in width. Always pick the size of blade that best suits your application.

- **Curve Cutting**—Use the chart in **Figure 34** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

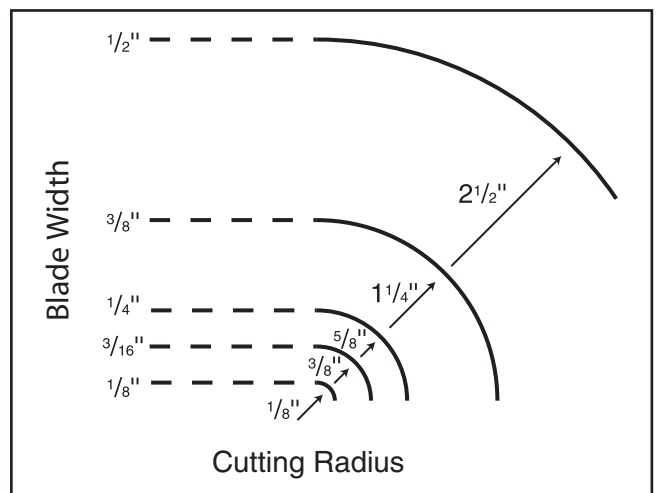


Figure 34. Blade width radii.

- **Straight Cutting**—Use the largest width blade that you own. The Model G0570 will accept blades up to 1" wide. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines, but function poorly at cutting small curves because of their size.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as “Tooth Style.”

Figure 35 shows the three main categories of tooth style:

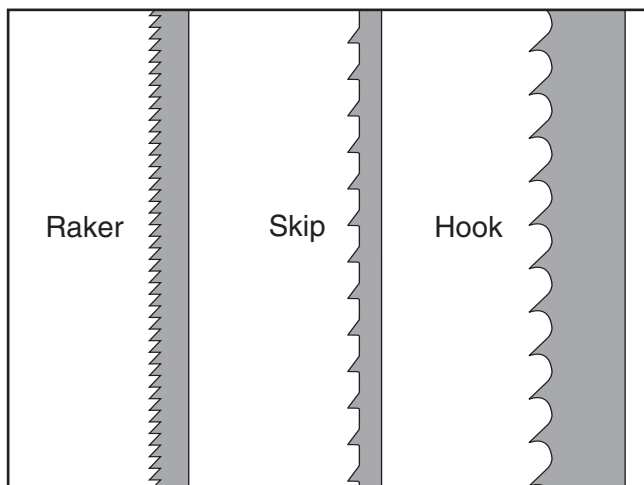


Figure 35. Raker, Skip & Hook tooth styles.

- **Raker**—This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on Raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but do not cut fast and generate more heat while cutting.
- **Skip**—This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.
- **Hook**—The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Usually measured as TPI (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

Blade Care

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

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

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

Blade Breakage

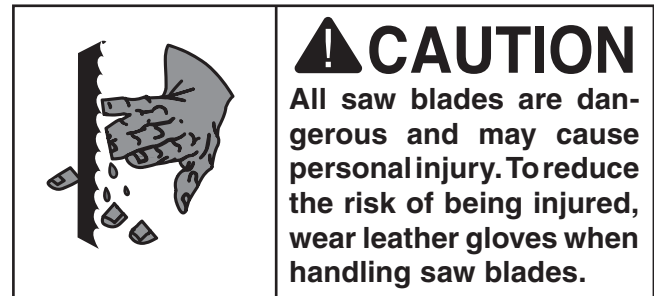
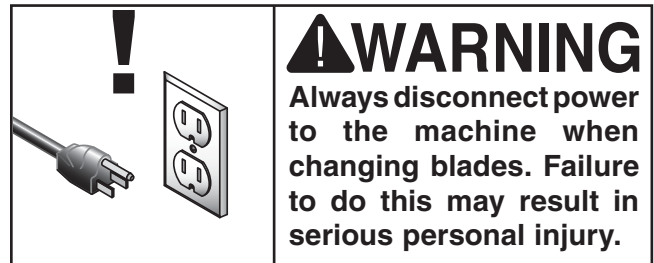
Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Faulty alignment and adjustment of the guides.
- Forcing or twisting a wide blade around a curve of short radius.
- Feeding the workpiece into the blade too fast.
- Tooth dullness or absence of sufficient set.
- Incorrect tension.
- Top blade guide assembly set too high above the work piece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.



Blade Changes



To remove the blade:

1. **Unplug the bandsaw!**
2. Release the blade tension by turning the blade tension quick release lever to the left.
3. Remove the table insert and the table pin. Adjust the upper and lower guide bearings as far away as possible from the blade.
4. Open the upper and lower wheel covers, and with gloved hands, slide the blade off both wheels.
5. Rotate the blade 90° and slide through the slot in the table.

To replace the blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table. Note—If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it right side-out.
2. Slip the blade through the guides, and mount it on the upper and lower wheels (**Figure 36**).



Figure 36. Placing blade on the wheels.

3. Tighten the blade tension quick release.
4. Apply tension to the blade by turning the tension control knob. Rotate the upper wheel slowly by hand as tension is applied to allow the blade to center itself on the wheel. Adjust tracking if needed.
5. Adjust tension as described on **page 21**.
6. Adjust the upper/lower guide bearings and the support bearings.
7. Close the wheel covers.
8. Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.



SECTION 5: ACCESSORIES

Replacement Blades

Replacement blades for the Model G0570 Bandsaw. Hook blades are signified by the "H" after the TPI, raker blades are signified by the "R" after TPI, and skip blades are signified by the "S" after the TPI.

MODEL	TYPE	WIDTH	GAUGE	TPI
H2453	Carbon	1/8"	0.025	14R
H2454	Carbon	1/8"	0.025	18R
H2455	Carbon	3/16"	0.025	4S
H2456	Carbon	3/16"	0.025	10R
H2457	Carbon	1/4"	0.025	4H
H2458	Carbon	1/4"	0.025	6H
H2459	Carbon	1/4"	0.025	10R
H2460	Carbon	1/4"	0.025	14R
H2461	Carbon	1/4"	0.025	18R
H2462	Carbon	3/8"	0.025	4H
H2463	Carbon	3/8"	0.025	6H
H2464	Carbon	3/8"	0.025	10R
H2465	Carbon	3/8"	0.025	14R
H2466	Carbon	1/2"	0.025	6H
H2467	Carbon	1/2"	0.025	10R
H2468	Carbon	1/2"	0.025	14R
H2469	Carbon	3/4"	0.032	3H
H2470	Carbon	3/4"	0.032	6H

Call 1-800-523-4777 To Order

G7984—Face Shield

H1298—Dust Sealed Safety Glasses

H1300—UV Blocking, Clear Safety Glasses

H2347—Uvex® Spitfire Safety Glasses

H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



Figure 37. Our most popular safety glasses.

H1302—Standard Earmuffs

H4979—Deluxe Twin Cup Hearing Protector

H4977—Work-Tunes Radio Headset Earmuffs

Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 38. Our most popular earmuffs.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Disposable Cartridge Filter Pair P100

Wood dust is now considered a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 39. Half-mask respirator and disposable cartridge filters.

H3788—G96® Gun Treatment 12 oz. Spray
H3789—G96® Gun Treatment 4.5 oz. Spray

This triple action gun treatment cleans, lubricates and protects all metal parts. Contains solvents that completely remove all traces of rust and corrosion and leaves no gummy residue.



Figure 40. G96® Gun Treatment spray.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz. Spray

Used on cast iron table surfaces and other unpainted metal surfaces to reduce rust and corrosion. This product is perfect for keeping tools clean, especially during long-term storage.



Figure 41. SLIPIT® gel and spray.

G1955—OxiSolv® Blade & Bit Cleaner

Used to clean the gummy pitch and residue from saw blades and router bits, this high quality cleaner will make blades and bits last longer while improving cutting action.



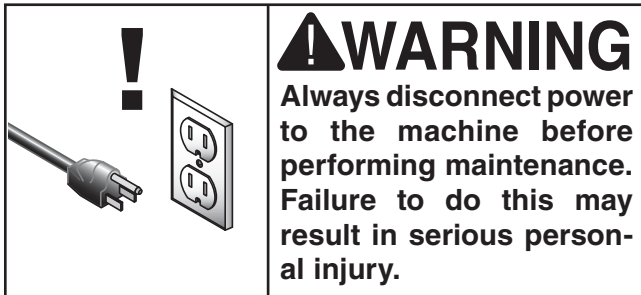
Figure 42. G1955 OxiSolv® spray.

Call 1-800-523-4777 To Order



Call 1-800-523-4777 To Order

SECTION 6: MAINTENANCE



Schedule

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

Daily Check:

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

Monthly Check:

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



Cleaning

Cleaning the Model G0570 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. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.



Unpainted Cast Iron

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

Keep tables rust-free with regular applications of products like , G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Section 5: Accessories on **page 39** for more details).



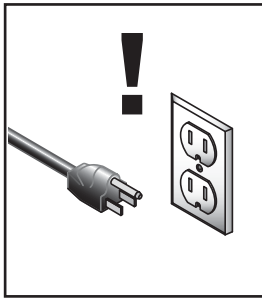
Lubrication

Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or bearing supply store.

For adjustment controls, an occasional “shot” of light oil is just about all that is necessary. Wipe off any sawdust with a clean cloth, towel or dry paint brush, and spray on the lubricant. Do not get oil on the pulleys or V-belt because it could cause belt deterioration and slipping.



SECTION 7: SERVICE



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

About Service

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

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

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



Checking V-Belt

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

To check the V-belt:

1. **Unplug the bandsaw!**
2. Open the lower wheel cover.
3. Push the center of the V-belt. Note the amount of deflection. If deflection is more than approximately $\frac{3}{4}$ " with moderate pressure from your thumb or finger, tighten the V-belt.
4. Note the condition of the V-belt. If the V-belt is cracked, frayed, or glazed; it should be replaced as soon as convenient.



Tensioning V-Belt

Tools Needed:	QTY
Hex Wrench 6mm.....	1
Wrench 13mm	1

To tension the V-belt:

1. **Unplug the bandsaw!**
2. Open the lower wheel cover.
3. Loosen the motor mount screw shown in **Figure 43**.

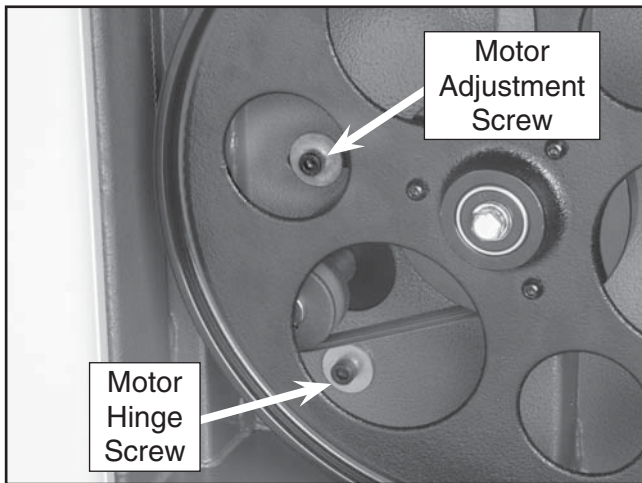


Figure 43. Motor mount screws.

4. Move the body of the motor, sliding the adjustment screw to the left-hand side (facing bandsaw front) of the adjustment slot.
5. Hold the motor in position with one hand and tighten the motor adjustment screw with the other hand.
6. Push the center of the V-belt. If deflection is approximately $\frac{3}{4}$ " with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more than $\frac{3}{4}$ ", repeat **steps 3-6**.
7. When the V-belt tension is correct, tighten the motor hinge screw and close the lower wheel cover.



Replacing V-Belt

Tools Needed:	QTY
Hex Wrench 6mm.....	1
Wrench 13mm	1

To replace the V-belt:

1. **Unplug the bandsaw!**
2. Open both wheel covers, and remove the blade.
3. Loosen the motor mount bolt shown in **Figure 43**.

4. Move the body of the motor so that the motor adjustment bolt slides to the right-hand side (facing bandsaw front) of the adjustment slot and pull the V-belt off of the motor pulley.
5. Unthread the wheel mount bolt shown in **Figure 44** and slide the lower wheel off of the bearing shaft.

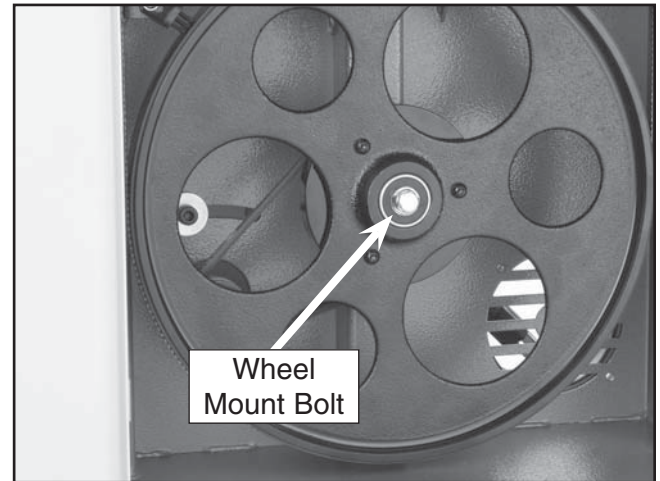


Figure 44. Wheel mount bolt.

6. Slip the old V-belt off of the wheel pulley and install the new V-belt in its place.
7. Install the lower wheel back onto the bearing shaft and replace/tighten the wheel mount bolt.
8. Position the V-belt over the motor pulley. Move the body of the motor so that the motor adjustment bolt slides to the left-hand side (facing bandsaw front) of the adjustment slot.
9. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.
10. Check the V-belt tension and adjust if necessary as described in the Tensioning V-Belt instructions.
11. When the V-belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.



Wheel Alignment

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

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

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

Components and Hardware Needed: Qty
Board 2" x 4" x 42³/₄" 1

Tools Needed:

Wrench 13mm 1
Tape Measure 1
Circular Saw 1
Jointer..... 1

To check if your wheels are coplanar:

1. The body of the bandsaw does not allow you to place a regular straightedge across both wheels at the same time. We’ve found a simple way to overcome this situation. All you need is a 42³/₄" x 2" x 4" board, a jointer and a circular saw. Run the 2" x 4" across a jointer on the side to be placed against the wheels, then cut two 1³/₄" x 3" notches; one 13" from the top of the board, another 13³/₄" away from the bottom. Refer to **Figure 45** for more details on how to make this gauge. Note—A jointer is ideal for making the 2" x 4" straight, but ripping a straight cut on a table saw will also work.
2. After you’ve made your coplanarity gauge, remove the fence and table, then open both wheel covers.
3. Make sure the guide blocks and rear support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.
4. Place your gauge up against both wheels in the positions shown in **Figure 46**.

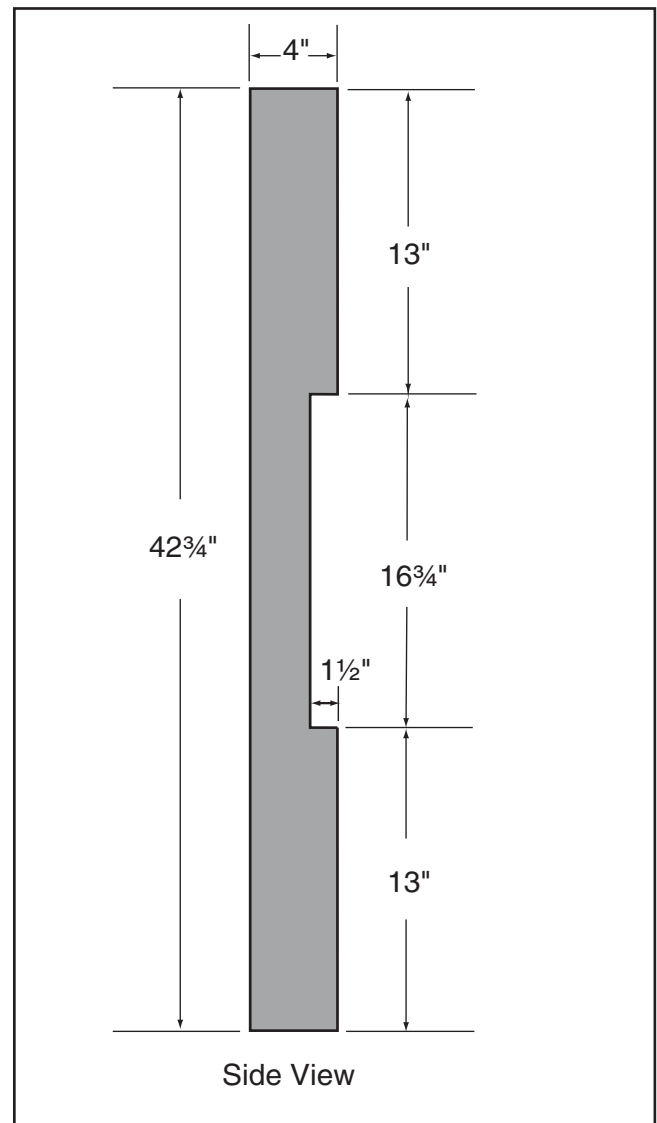


Figure 45. Dimensions of coplanarity gauge.

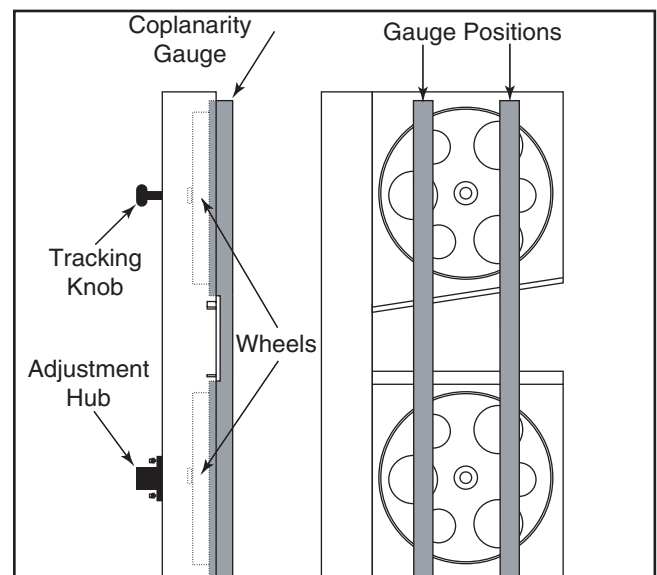


Figure 46. Checking for coplanarity.

5. The adjustment hub allows you to move the lower wheel in the desired direction. Turning all the bolts clockwise in equal amounts pushes the wheel forward. Turning all the bolts counterclockwise brings the wheel backward, closer to the adjustment hub. Used individually, each bolt can control the direction that the wheel tilts.
6. Adjust the tracking knob to get both wheels parallel. If the wheels won't go parallel to each other, then move the lower wheel at the adjustment hub so they line up.
7. If the wheels will go parallel but not coplanar, then move the lower wheel at the adjustment hub (**Figure 47**) as necessary.
8. **Figure 48** shows the positions of the wheels when coplanar. When your wheels are coplanar, readjust the guide blocks and rear support bearings, and replace the wheel covers.

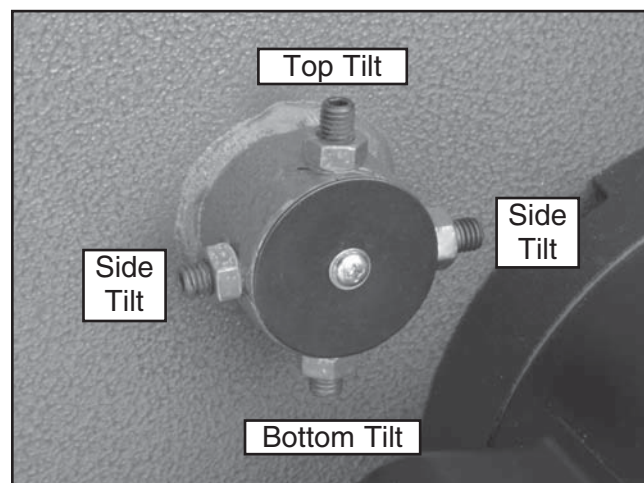


Figure 47. Lower wheel adjustment control.



Note—The blade may track slightly off center when the wheels are coplanar. This is natural because the blade will be balanced on the crown of the tire, rather than just in the center of the tire. This will be more noticeable with larger blades.

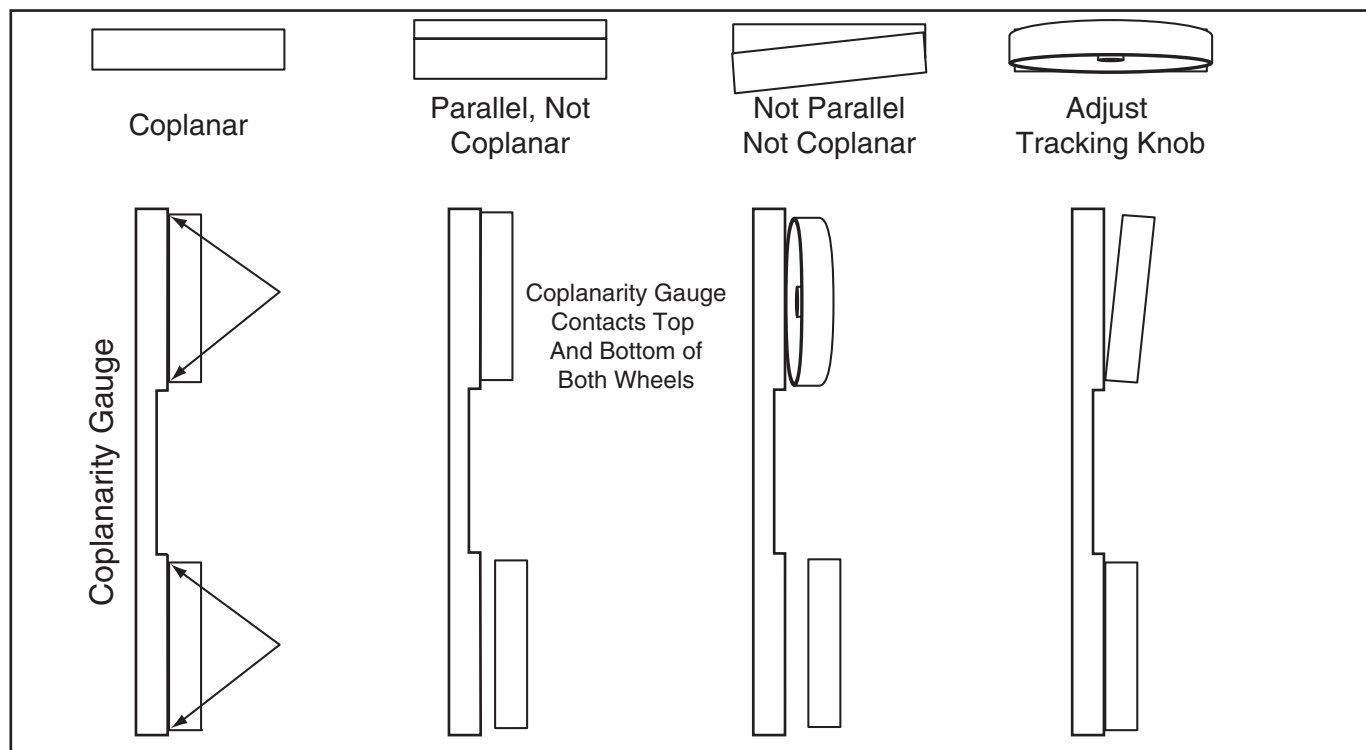
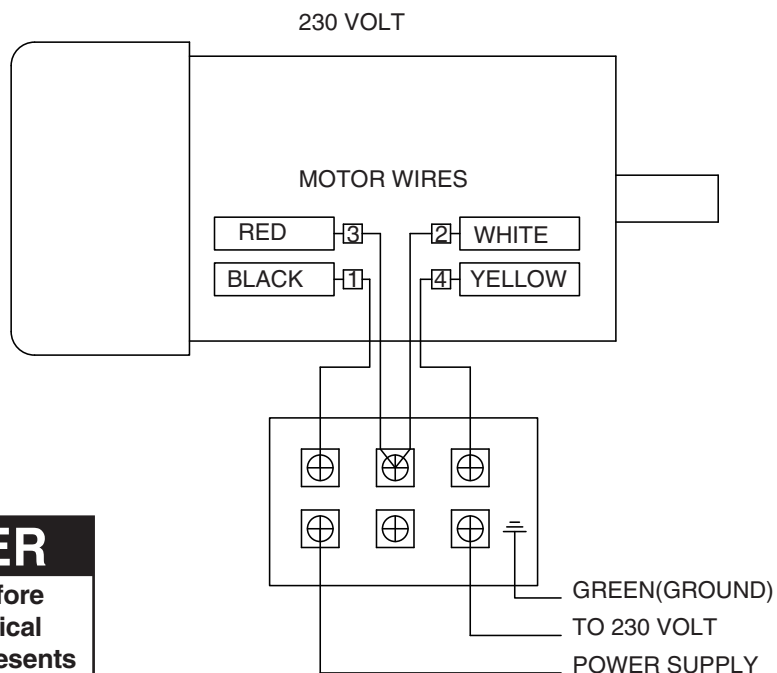
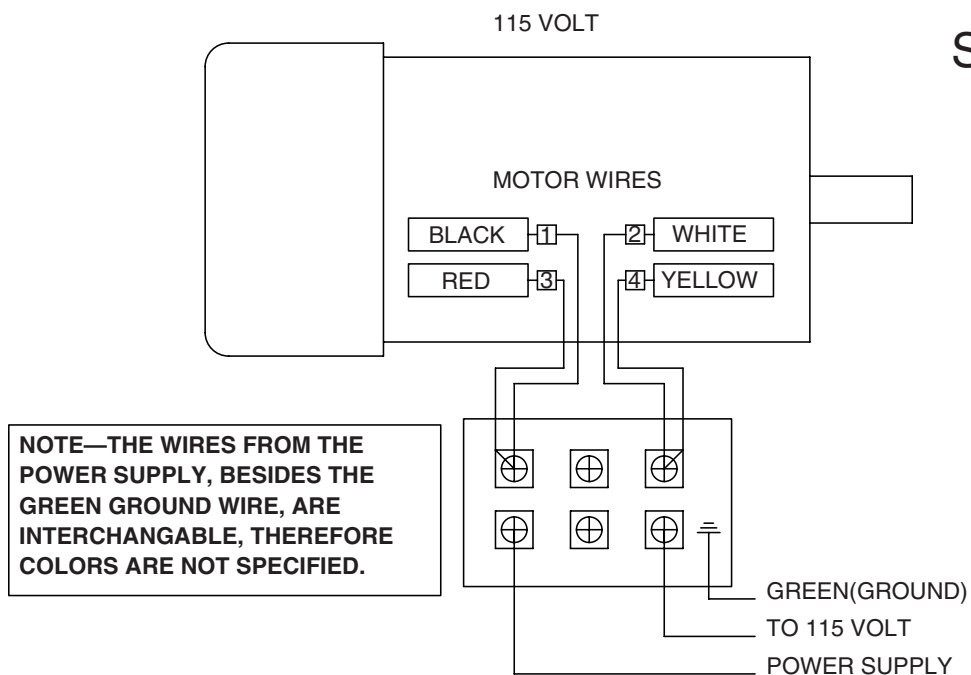


Figure 48. Coplanarity diagram.



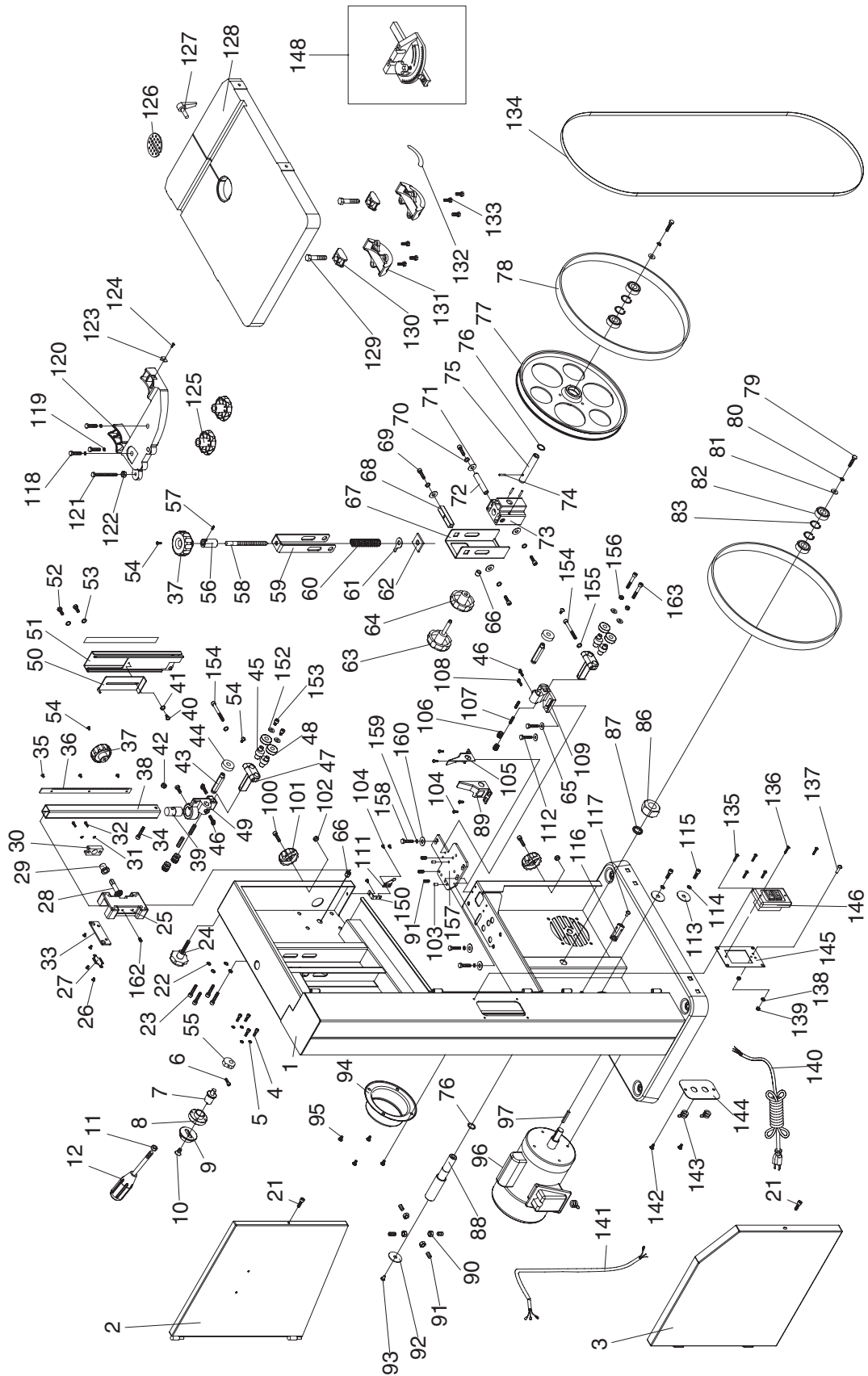
G0570 110V/220V Single-Phase



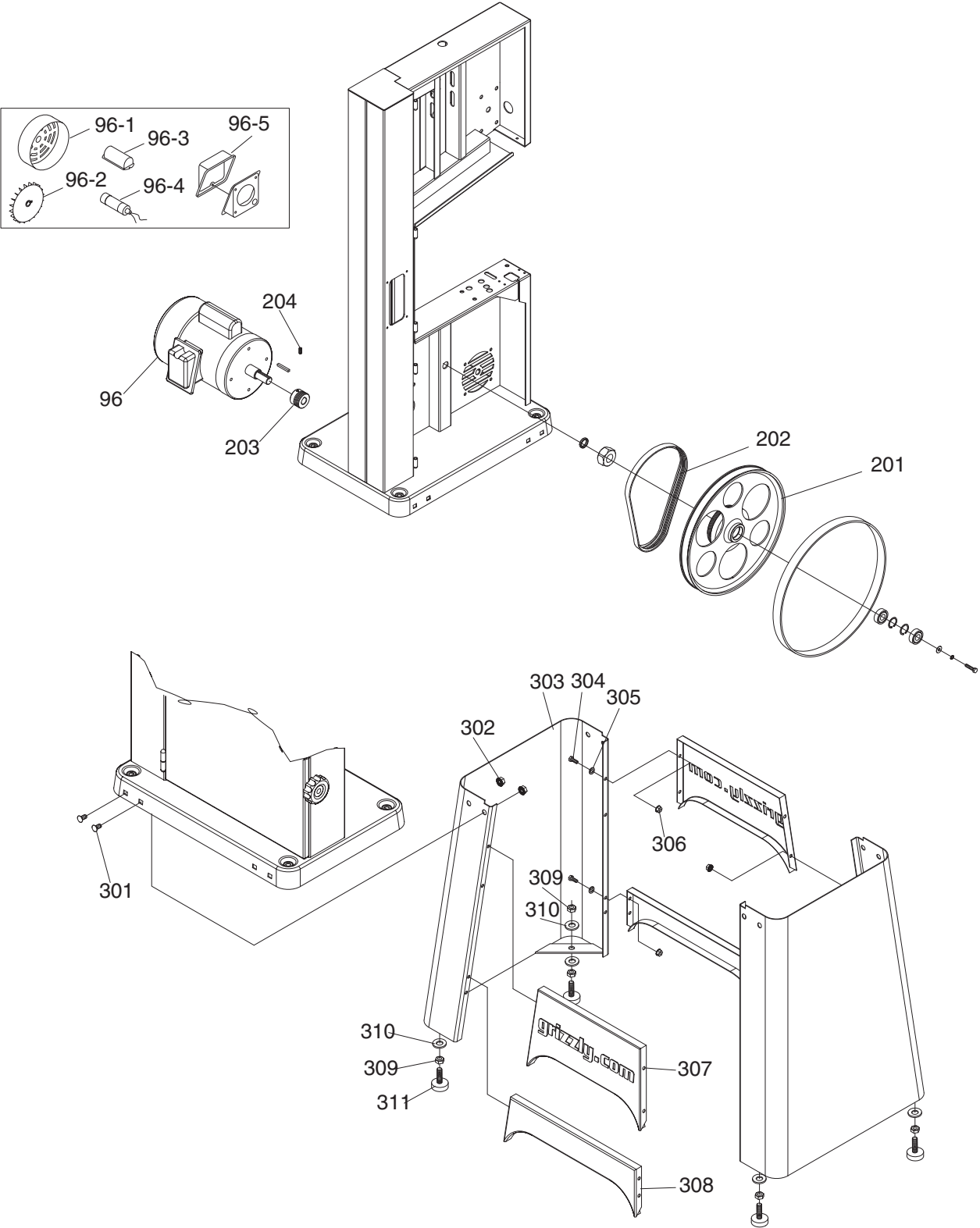
⚠ DANGER

Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

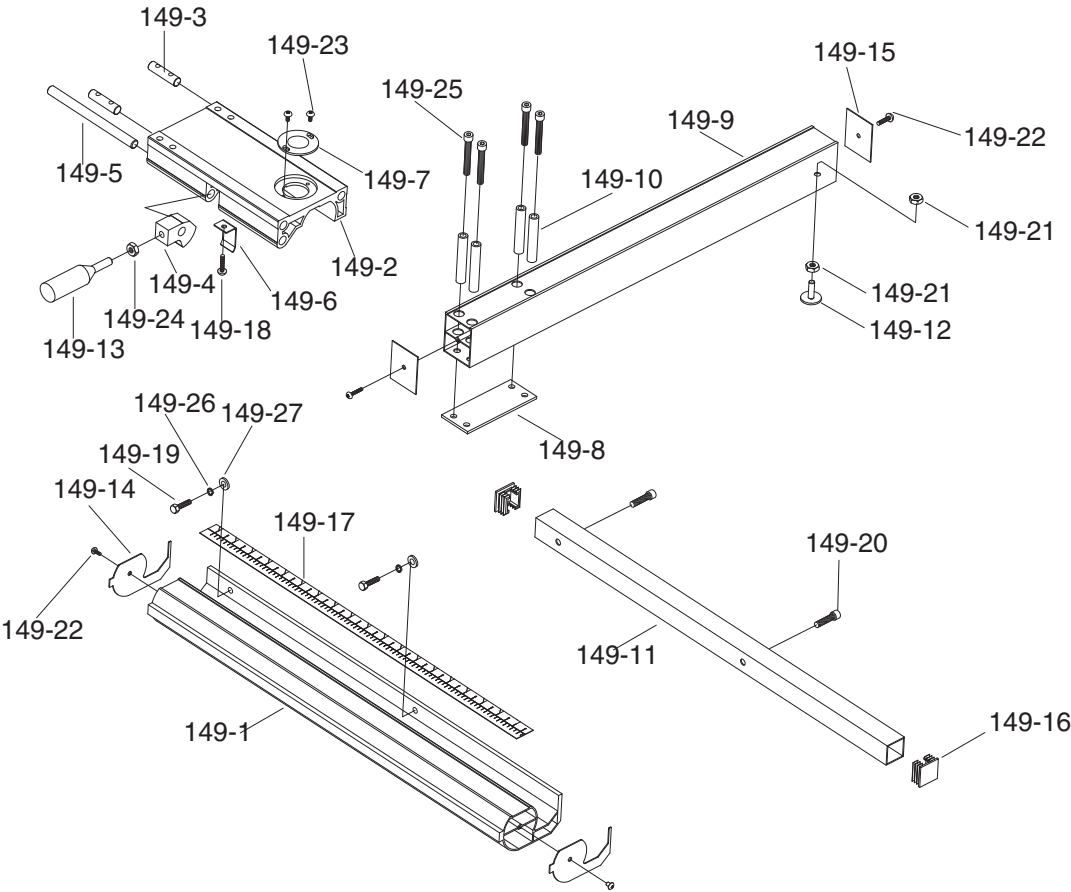
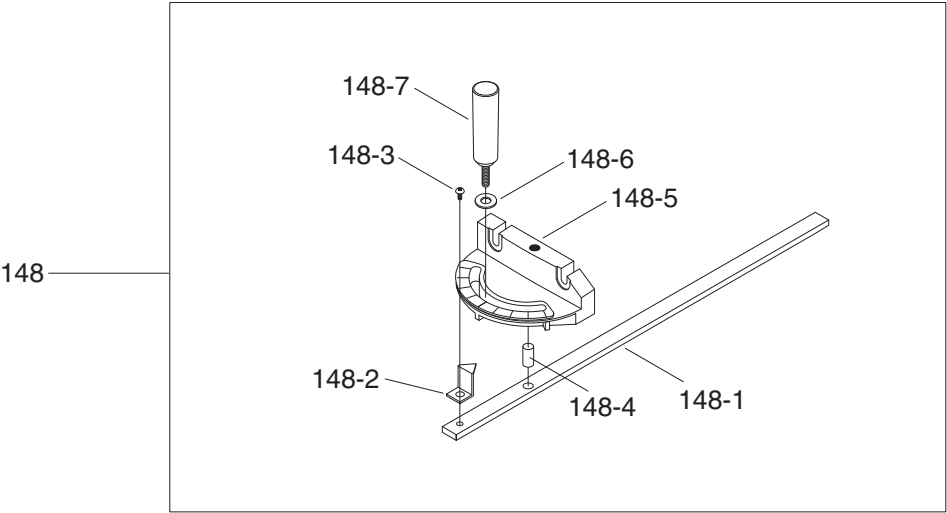
G0570 Parts Breakdown



G0570 Parts Breakdown



G0570 Parts Breakdown



G0570 Parts List

REF PART # DESCRIPTION

1	P0570001	BODY
2	P0570002	UPPER DOOR ASSEMBLY
3	P0570003	LOWER DOOR ASSEMBLY
4	PSB04M	CAP SCREW M6-1 X 10
5	PLW03M	LOCK WASHER 6MM
6	PSB33M	CAP SCREW M5-.8 X 12
7	P0570007	BIAS SHAFT
8	P0570008	BIAS SHAFT CLAMP SEAT
9	P0570009	ADJUSTMENT SHOE
10	PSB14M	CAP SCREW M8-1.25 X 20
11	PN03M	HEX NUT M8-1.25
12	P0570012	HANDLE
21	PSB04M	CAP SCREW M6-1 X 10
22	PLW04M	LOCK WASHER 8MM
23	PSB14M	CAP SCREW M8-1.25 X 20
24	P0570024	LOCK KNOB M8-1.25 X 20
25	P0570025	UPPER SUPPORT BRACKET POST
26	PFH27M	FLAT HD SCR M4-.7 X 5
27	P0570027	SPRING TENSIONER
28	P0570028	ADJUST GEAR
29	P0570029	BUSHING
30	P0570030	GEAR HOUSING
31	PLW03M	LOCK WASHER 6MM
32	PSB04M	CAP SCREW M6-1 X 10
33	P0570033	COVER PLATE
34	PSB48M	CAP SCREW M6-1 X 35
35	PFH27M	FLAT HD SCR M4-.7 X 5
36	P0570036	RACK GEAR
37	P0570037	HAND KNOB M10-1.5
38	P0570038	GUIDE POST
39	P0570039	CHANGE SHAFT
40	P0570040	SLIDE PLATE
41	P0570041	PLASTIC WASHER 6MM
42	PLN03M	LOCK NUT M6-1

REF PART # DESCRIPTION

43	P0570043	SPACING SLEEVE
44	P6000	BALL BEARING 6000ZZ
45	P0570045	BIAS SHAFT
46	PTS001M	THUMB SCREW M6-1 X 16
47	P0570047	SUPPORT BRACKET
48	P608ZZ	BALL BEARING 608ZZ
49	P0570049	UPPER SUPPORT BRACKET POST
50	P0570050	FREE BOARD
51	P0570051	BLADE COVER
52	PB04M	HEX BOLT M6-1 X 10
53	PW03M	FLAT WASHER 6MM
54	PFS06M	FLANGE SCREW M6-1 X 8
55	P0570055	CAM
56	P0570056	FIXED SPACER
57	PSS07M	SET SCREW M5-.8 X 5
58	P0570058	ADJUST SCREW
59	P0570059	SUPPORT SEAT
60	P0570060	SPRING
61	P0570061	INDICATOR
62	P0570062	FREE NUT
63	P0570063	LOCK KNOB M8-1.25 X 45
64	P0570064	KNOB M8-1.25
65	PW03M	FLAT WASHER 6MM
66	P0570066	PULL NUT M8-1.25
67	P0570067	UPPER WHEEL FIXED BRACKET
68	P0570068	FREE KEY 12 X 12
69	PSB14M	CAP SCREW M8-1.25 X 20
70	PLW04M	LOCK WASHER 8MM
71	PW01M	FLAT WASHER 8MM
72	P0570072	REVOLVING SPINDLE
73	P0570073	UPPER WHEEL ADJ BRACKET
74	PRP10M	ROLL PIN 5 X 36
75	P0570075	UPPER WHEEL SHAFT
76	P0570076	WAVY WASHER 15 X 22

G0570 Parts List

REF PART # DESCRIPTION

77	P0570077	UPPER WHEEL
78	P0570078	WHEEL TIRE
79	PB03M	HEX BOLT M8-1.25 X 16
80	PLW04M	LOCK WASHER 8MM
81	PW01M	FLAT WASHER 8MM
82	P6202	BALL BEARING 6202ZZ
83	PR21M	INT RETAINING RING 35MM
86	PN15M	HEX NUT M18-1.5
87	PLW12M	LOCK WASHER 18MM
88	P0570088	LOWER WHEEL SHAFT
89	P0570089	LEFT COVER
90	PN03M	HEX NUT M8-1.25
91	PSS09M	SET SCREW M8-1.25 X 20
92	P0570092	COVER
93	PFS01M	FLANGE SCREW M5-.8 X 8
94	P0570094	DUST PORT
95	PFS11M	FLANGE SCREW M6-1 X 10
96	P0570096	MOTOR 1.5HP
96-1	P0570096-1	FAN COVER
96-2	P0570096-2	FAN
96-3	P0570096-3	CAPACITOR COVER
96-4	PC300	CAPACITOR 300 MFD, 125V
96-5	P0570096-5	ELECTRICAL BOX
97	PK34M	KEY 5 X 5 X 20
100	PSB02M	CAP SCREW M6-1 X 20
101	P0570101	LATCH 6MM
102	PLN03M	LOCK NUT M6-1
103	P0570103	PIN
104	PFS03M	FLANGE SCREW M5-.8 X 6
105	P0570105	RIGHT COVER
106	P0570106	ADJUSTING NUT M8-1.25
107	P0570107	ADJUSTING SCREW M8-1.25 X 40
108	PTS003M	THUMB SCREW M6-1 X 12
109	P0570109	LOWER SUPPORT BRACKET POST

REF PART # DESCRIPTION

111	P0570111	POINTER
112	PB02M	HEX BOLT M6-1 X 12
113	PW01M	FLAT WASHER 8MM
114	PLW04M	LOCK WASHER 8MM
115	PSB31M	CAP SCREW M8-1.25 X 25
116	P0570116	BRUSH
117	PFS01M	FLANGE SCREW M5-.8 X 8
118	PB26M	HEX BOLT M8-1.25 X 30
119	PLW04M	LOCK WASHER 8MM
120	P0570120	TRUNNION SUPPORT BRACKET
121	PB82M	HEX BOLT M8-1.25 X 80
122	PN03M	HEX NUT M8-1.25
123	P0570123	POINTER
124	PS19M	PHLP HD SCR M5-.8 X 6
125	P0570125	LOCK KNOB M10-1.5
126	P0570126	TABLE INSERT
127	P0570127	TABLE PIN
128	P0570128	TABLE
129	PB73M	HEX BOLT M10-1.5 X 50
130	P0570130	TRUNNION CLAMP SHOES
131	P0570131	TRUNNION
132	P0570132	SCALE
133	PFB01M	FLANGE BOLT M6-1 X 12
134	P0570134	SAW BLADE 101" x 3/8" x 0.5 x 6TPI
135	PFS01M	FLANGE SCREW M5-.8 X 8
136	PS38M	PHLP HD SCR M4-.7 X 10
137	PS08M	PHLP HD SCR M5-.8 X 12
138	PTLW02M	EXT TOOTH WASHER 5MM
139	PN06M	HEX NUT M5-.8
140	PWRCRD110L	POWER CORD 110V, W/PLUG
141	P0570141	MOTOR CORD
142	PFS01M	FLANGE SCREW M5-.8 X 8
143	P0570143	STRAIN RELIEF
144	P0570144	PLATE

G0570 Parts List

REF PART # DESCRIPTION

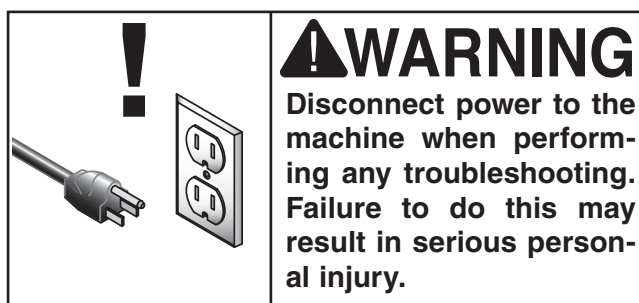
145	P0570145	SWITCH PLATE
146	P0570146	SWITCH
148	P0570148	MITER GAUGE BODY ASSEMBLY
148-1	P0570148-1	GUIDE BAR
148-2	P0570148-2	POINTER
148-3	PFS01M	FLANGE SCREW M5-.8 X 8
148-4	P0570148-4	PIN 6.5 X 10
148-5	P0570148-5	MITER GAUGE BODY
148-6	P0570148-6	NYLON WASHER
148-7	P0570148-7	HANDLE
149	P0570149	RIP FENCE ASSEMBLY
149-1	P0570149-1	FIXED BASE L=540
149-2	P0570149-2	ADJUST BASE
149-3	P0570149-3	FIXED SHAFT
149-4	P0570149-4	CAM
149-5	P0570149-5	SHAFT
149-6	P0570149-6	SPRING PIECE
149-7	P0570149-7	VIEW WINDOW
149-8	P0570149-8	PLATE
149-9	P0570149-9	FENCE L=505
149-10	P0570149-10	BUSHING
149-11	P0570149-11	SQUARE RAIL L=540
149-12	P0570149-12	ADJUSTMENT PAD M6-1 X 20
149-13	P0570149-13	HANDLE
149-14	P0570149-14	END CAP
149-15	P0570149-15	END CAP
149-16	P0570149-16	PLUG
149-17	P0570149-17	SCALE
149-18	PFS05M	FLANGE SCREW M4-.7 X 10
149-19	PB08M	HEX BOLT M6-1 X 20
149-20	PSB01M	CAP SCREW M6-1 X 16
149-21	PN01M	HEX NUT M6-1
149-22	PHTEK3M	TAP SCREW 3.5 X 8

REF PART # DESCRIPTION

149-23	PFS04M	FLANGE SCREW M4-.7 X 6
149-24	PN03M	HEX NUT M8-1.25
149-25	PSB83M	CAP SCREW M6-1 X 55
149-26	PLW03M	LOCK WASHER 6MM
149-27	PW03M	FLAT WASHER 6MM
150	P0570150	POINTER BRACKET
152	PW02M	FLAT WASHER 5MM
153	PSB33M	CAP SCREW M5-.8 X 12
154	PSB78M	CAP SCREW M5-.8 X 40
155	PLW01M	LOCK WASHER 5MM
156	PN06M	HEX NUT M5-.8
157	P0570157	FIXED PLATE
158	PB09M	HEX BOLT M8-1.25 X 20
159	PLW04M	LOCK WASHER 8MM
160	PW01M	FLAT WASHER 8MM
162	PSS02M	SET SCREW M6-1 X 6
163	PSB79M	CAP SCREW M5-.8 X 35
201	P0570201	LOWER WHEEL ASSEMBLY
202	P0570202	BELT 210J05
203	P0570203	MOTOR PULLEY
204	PSS01M	SET SCREW M6-1 X 10
301	PCB06M	CARRIAGE BOLT M8-1.25 X 16
302	PFN01M	FLANGE NUT M8-1.25
303	P0570303	STAND SIDE
304	PB83M	HEX BOLT M6-1 X 16
305	PW03M	FLAT WASHER 6MM
306	PFN02M	FLANGE NUT M6-1
307	P0570307	SIDE BRACE, UPPER
308	P0570308	SIDE BRACE, LOWER
309	PN08	HEX NUT 3/8-16
310	PW04M	FLAT WASHER 10MM
311	P0570311	RUBBER PAD

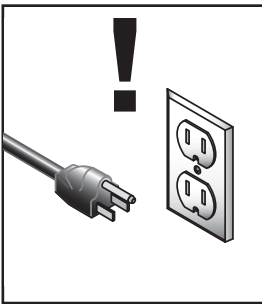
Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor will not start.	<ol style="list-style-type: none"> 1. Low voltage. 2. Open circuit in motor or loose connections. 	<ol style="list-style-type: none"> 1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	<ol style="list-style-type: none"> 1. Short circuit in line cord or plug. 	<ol style="list-style-type: none"> 1. Repair or replace cord or plug for damaged insulation and shorted wires.
Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).	<ol style="list-style-type: none"> 1. Power line overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long. 3. General overloading of power company facilities. 	<ol style="list-style-type: none"> 1. Reduce load on power line. 2. Increase wire sizes or reduce length of the circuit. 3. Request a power check from the power company.
Motor overheats.	<ol style="list-style-type: none"> 1. Motor overloaded. 2. Air circulation through the motor restricted. 	<ol style="list-style-type: none"> 1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> 1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded. 	<ol style="list-style-type: none"> 1. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Blade slows when cutting. Blade makes a squealing noise, especially on start-up.	<ol style="list-style-type: none"> 1. V-belt loose. 2. V-belt worn out. 	<ol style="list-style-type: none"> 1. Tighten V-belt (page 41). 2. Replace V-belt (page 42).
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> 1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective. 	<ol style="list-style-type: none"> 1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belts (page 42).
Vibration when running or cutting.	<ol style="list-style-type: none"> 1. Loose or damaged blade. 2. Worn arbor bearings. 	<ol style="list-style-type: none"> 1. Tighten or replace blade. 2. Check/replace arbor bearings.



Troubleshooting

Symptom	Possible Cause	Possible Solution
Wood cuts slow or smokes during cut.	<ol style="list-style-type: none"> 1. Worn or dull blade. 2. Blade installed backwards. 	<ol style="list-style-type: none"> 1. Replace blade (page 36). 2. Check blade rotation as described in "Test Run" on and reverse blade if necessary.
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean out dust port. 2. Three options: <ul style="list-style-type: none"> —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a stronger dust collector.



! WARNING

Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury.



Warranty and Returns

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

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

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

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

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

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

WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone Number _____ E-Mail _____ FAX _____

MODEL: G0570 14" Bandsaw Serial # _____ Order _____

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

CUT ALONG DOTTED LINE

1. How did you learn about us?

___Advertisement ___Friend
___Catalog ___Card Deck
___World Wide Web
___Other _____

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

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

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

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

4. What is your annual household income?

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

5. What is your age group?

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

6. How long have you been a woodworker?

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

7. How would you rank your woodworking skills?

___Simple ___Advanced
___Intermediate ___Master Craftsman

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

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

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

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

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

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

12. Which portable/hand held power tools do you own?

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

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

___Builders Hardware ___Hand Tools
___Fasteners ___Wood Components
___Other _____

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

16. Do you think your purchase is good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

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

___Yes ___No

19. Comments: _____

FOLD ALONG DOTTED LINE



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Here



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P.O. BOX 2069
BELLINGHAM, WA 98227-2069



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MODEL G0570 14" INDUSTRIAL BANDSAW 1-1/2 HP

Product Dimensions:

Weight..... 203 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 67-3/4 x 27-3/4 x 29-1/2 in.
Footprint (Length x Width)..... 17-1/2 x 24-1/2 in.

Shipping Dimensions:

Type..... Not Available
Content..... Not Available
Weight..... 219 lbs.
Length x Width x Height..... 23 x 49 x 20

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 14A at 110V, 7A at 220V
Minimum Circuit Size..... 30A at 110V, 15A at 220V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6 ft.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Switch Type..... On/Off Push Button

Motors:

Main

Horsepower..... 1.5 HP
Phase..... Single-Phase
Amps..... 14A/7A
Speed..... 1725 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer V-Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Main Specifications

Bandsaw Size..... 14 in.
Max Cutting Width (Left of Blade)..... 13-1/2 in.
Max Cutting Height (Resaw Height)..... 7-7/8 in.
Blade Speeds..... 3000 FPM

Blade Information

Standard Blade Length..... 101 in.
Blade Length Range..... 100 – 101-1/2 in.
Blade Width Range..... 1/8 – 3/4 in.
Type of Blade Guides..... Ball Bearing

Table Information

Table Length.....	14-3/16 in.
Table Width.....	19-3/4 in.
Table Thickness.....	1-1/2 in.
Table Tilt.....	Left 5, Right 45 deg.
Floor-to-Table Height.....	42-1/4 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	Yes

Construction Materials

Table.....	Precision Ground Cast Iron
Fence.....	Deluxe Extruded Aluminum
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Pre-Formed Steel
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Rubber
Wheel Cover	Pre-Formed Steel
Paint Type/Finish.....	Powder Coated

Other Related Information

Wheel Diameter.....	13-3/4 in.
Wheel Width.....	1-1/8 in.
Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D2057A

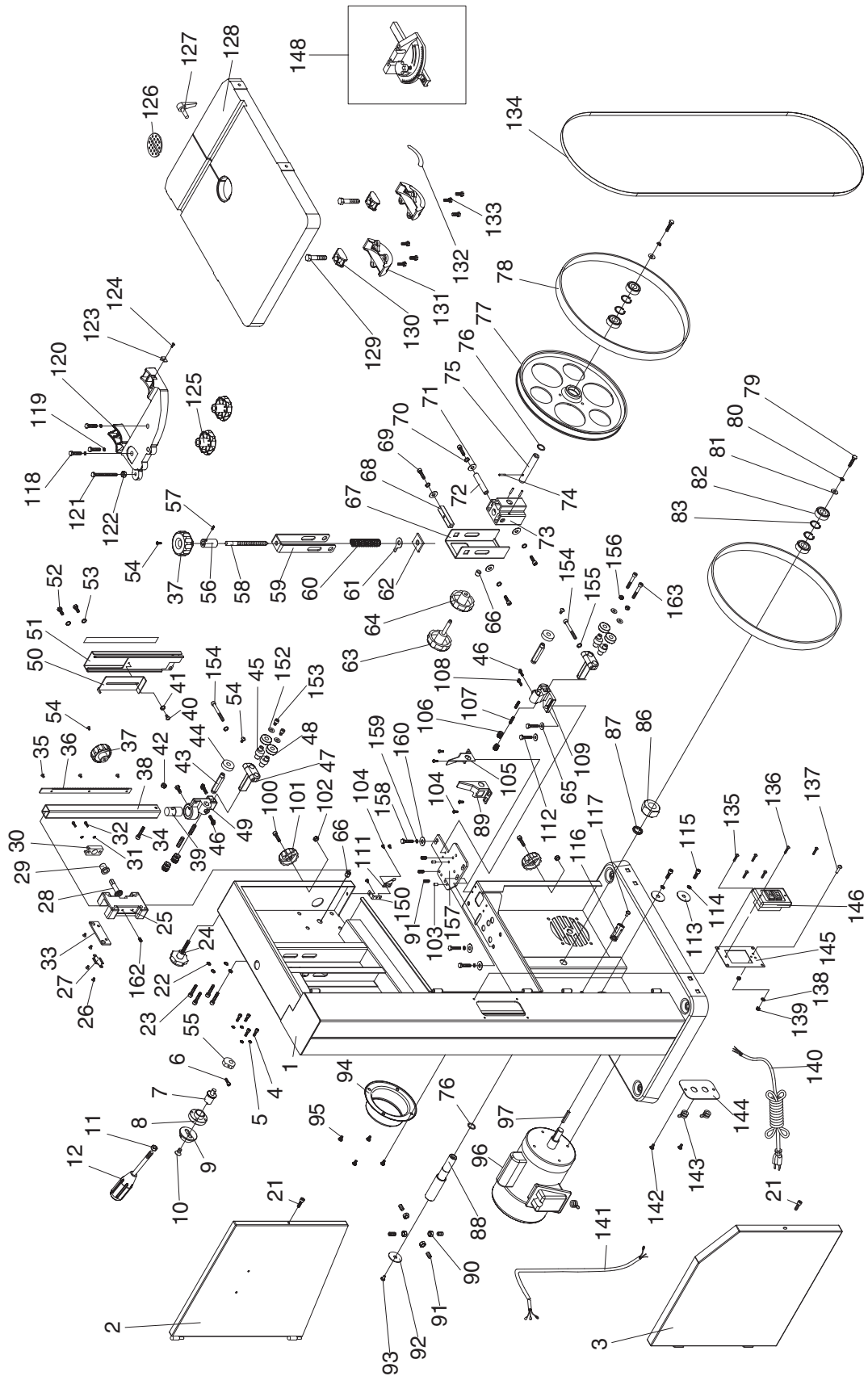
Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label on Upper Wheel Cover
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

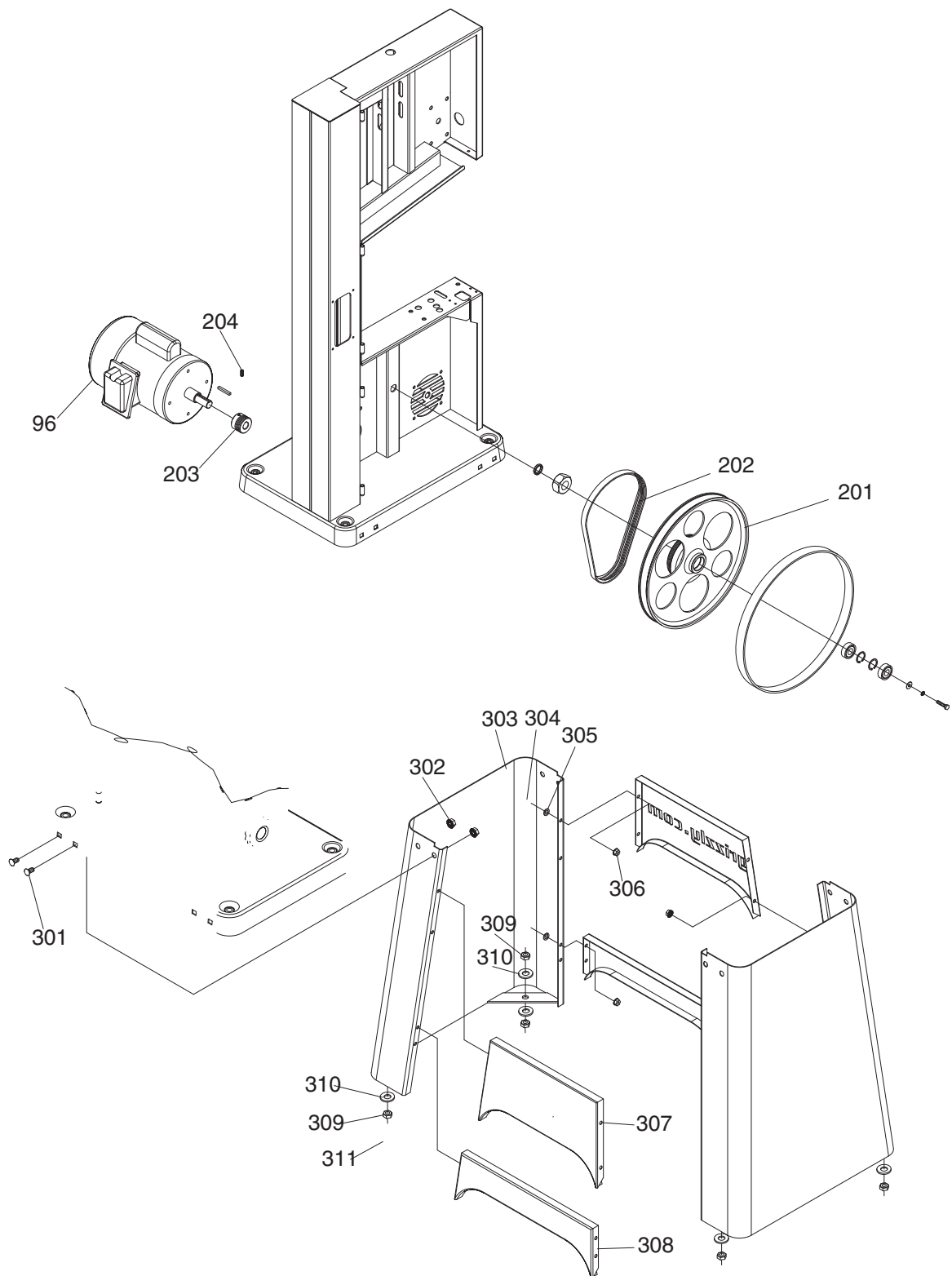
Features:

Magnifying Window Over Fence Scale
Hinged Wheel Covers
Quick Release Blade Tension
Welded Steel and Reinforced Frame

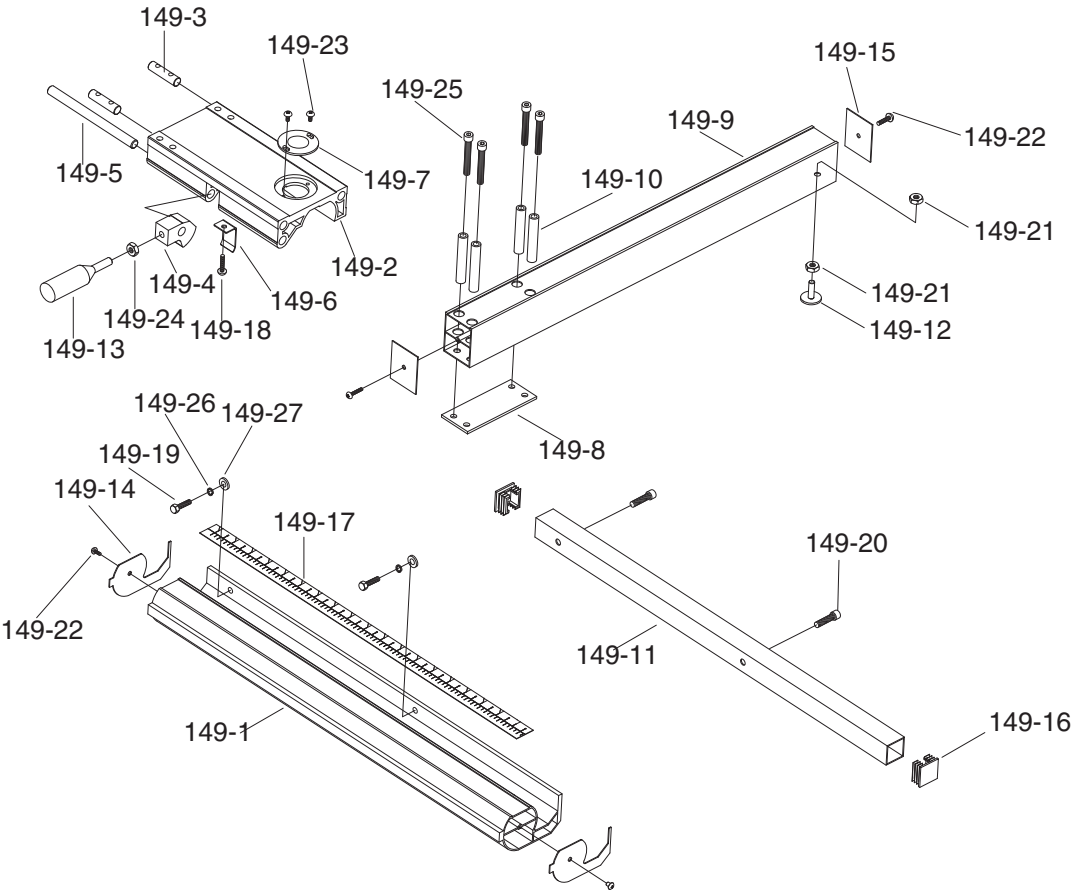
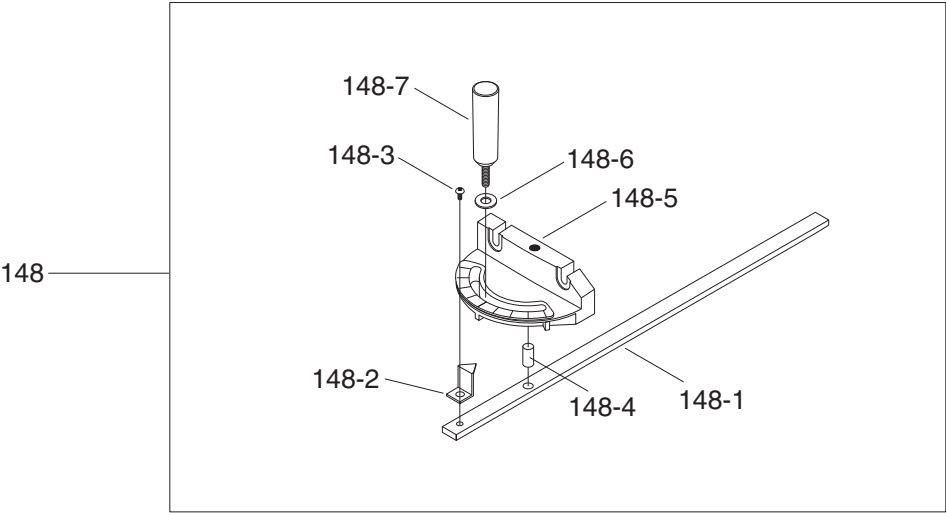
G0570 Parts Breakdown



G0570 Parts Breakdown



G0570 Parts Breakdown



G0570 Parts List

REF PART # DESCRIPTION

1	P0570001	BODY
2	P0570002	UPPER DOOR ASSEMBLY
3	P0570003	LOWER DOOR ASSEMBLY
4	PSB04M	CAP SCREW M6-1 X 10
5	PLW03M	LOCK WASHER 6MM
6	PSB33M	CAP SCREW M5-.8 X 12
7	P0570007	BIAS SHAFT
8	P0570008	BIAS SHAFT CLAMP SEAT
9	P0570009	ADJUSTMENT SHOE
10	PSB14M	CAP SCREW M8-1.25 X 20
11	PN03M	HEX NUT M8-1.25
12	P0570012	HANDLE
21	PSB04M	CAP SCREW M6-1 X 10
22	PLW04M	LOCK WASHER 8MM
23	PSB14M	CAP SCREW M8-1.25 X 20
24	P0570024	LOCK KNOB M8-1.25 X 20
25	P0570025	UPPER SUPPORT BRACKET POST
26	PFH27M	FLAT HD SCR M4-.7 X 5
27	P0570027	SPRING TENSIONER
28	P0570028	ADJUST GEAR
29	P0570029	BUSHING
30	P0570030	GEAR HOUSING
31	PLW03M	LOCK WASHER 6MM
32	PSB04M	CAP SCREW M6-1 X 10
33	P0570033	COVER PLATE
34	PSB48M	CAP SCREW M6-1 X 35
35	PFH27M	FLAT HD SCR M4-.7 X 5
36	P0570036	RACK GEAR
37	P0570037	HAND KNOB M10-1.5
38	P0570038	GUIDE POST
39	P0570039	CHANGE SHAFT
40	P0570040	SLIDE PLATE
41	P0570041	PLASTIC WASHER 6MM
42	PLN03M	LOCK NUT M6-1

REF PART # DESCRIPTION

43	P0570043	SPACING SLEEVE
44	P6000	BALL BEARING 6000ZZ
45	P0570045	BIAS SHAFT
46	PTS001M	THUMB SCREW M6-1 X 16
47	P0570047	SUPPORT BRACKET
48	P608ZZ	BALL BEARING 608ZZ
49	P0570049	UPPER SUPPORT BRACKET POST
50	P0570050	FREE BOARD
51	P0570051	BLADE COVER
52	PB04M	HEX BOLT M6-1 X 10
53	PW03M	FLAT WASHER 6MM
54	PFS06M	FLANGE SCREW M6-1 X 8
55	P0570055	CAM
56	P0570056	FIXED SPACER
57	PSS07M	SET SCREW M5-.8 X 5
58	P0570058	ADJUST SCREW
59	P0570059	SUPPORT SEAT
60	P0570060	SPRING
61	P0570061	INDICATOR
62	P0570062	FREE NUT
63	P0570063	LOCK KNOB M8-1.25 X 45
64	P0570064	KNOB M8-1.25
65	PW03M	FLAT WASHER 6MM
66	P0570066	PULL NUT M8-1.25
67	P0570067	UPPER WHEEL FIXED BRACKET
68	P0570068	FREE KEY 12 X 12
69	PSB14M	CAP SCREW M8-1.25 X 20
70	PLW04M	LOCK WASHER 8MM
71	PW01M	FLAT WASHER 8MM
72	P0570072	REVOLVING SPINDLE
73	P0570073	UPPER WHEEL ADJ BRACKET
74	PRP10M	ROLL PIN 5 X 36
75	P0570075	UPPER WHEEL SHAFT
76	P0570076	WAVY WASHER 15 X 22

G0570 Parts List

REF PART # DESCRIPTION

77	P0570077	UPPER WHEEL
78	P0570078	WHEEL TIRE
79	PB03M	HEX BOLT M8-1.25 X 16
80	PLW04M	LOCK WASHER 8MM
81	PW01M	FLAT WASHER 8MM
82	P6202	BALL BEARING 6202ZZ
83	PR21M	INT RETAINING RING 35MM
86	PN15M	HEX NUT M18-1.5
87	PLW12M	LOCK WASHER 18MM
88	P0570088	LOWER WHEEL SHAFT
89	P0570089	LEFT COVER
90	PN03M	HEX NUT M8-1.25
91	PSS09M	SET SCREW M8-1.25 X 20
92	P0570092	COVER
93	PFS01M	FLANGE SCREW M5-.8 X 8
94	P0570094	DUST PORT
95	PFS11M	FLANGE SCREW M6-1 X 10
96	P0570096	MOTOR 1.5HP
96-1	P0570096-1	FAN COVER
96-2	P0570096-2	FAN
96-3	P0570096-3	CAPACITOR COVER
96-4	PC300	CAPACITOR 300 MFD, 125V
96-5	P0570096-5	ELECTRICAL BOX
97	PK34M	KEY 5 X 5 X 20
100	PSB02M	CAP SCREW M6-1 X 20
101	P0570101	LATCH 6MM
102	PLN03M	LOCK NUT M6-1
103	P0570103	PIN
104	PFS03M	FLANGE SCREW M5-.8 X 6
105	P0570105	RIGHT COVER
106	P0570106	ADJUSTING NUT M8-1.25
107	P0570107	ADJUSTING SCREW M8-1.25 X 40
108	PTS003M	THUMB SCREW M6-1 X 12
109	P0570109	LOWER SUPPORT BRACKET POST

REF PART # DESCRIPTION

111	P0570111	POINTER
112	PB02M	HEX BOLT M6-1 X 12
113	PW01M	FLAT WASHER 8MM
114	PLW04M	LOCK WASHER 8MM
115	PSB31M	CAP SCREW M8-1.25 X 25
116	P0570116	BRUSH
117	PFS01M	FLANGE SCREW M5-.8 X 8
118	PB26M	HEX BOLT M8-1.25 X 30
119	PLW04M	LOCK WASHER 8MM
120	P0570120	TRUNNION SUPPORT BRACKET
121	PB82M	HEX BOLT M8-1.25 X 80
122	PN03M	HEX NUT M8-1.25
123	P0570123	POINTER
124	PS19M	PHLP HD SCR M5-.8 X 6
125	P0570125	LOCK KNOB M10-1.5
126	P0570126	TABLE INSERT
127	P0570127	TABLE PIN
128	P0570128	TABLE
129	PB73M	HEX BOLT M10-1.5 X 50
130	P0570130	TRUNNION CLAMP SHOES
131	P0570131	TRUNNION
132	P0570132	SCALE
133	PFB01M	FLANGE BOLT M6-1 X 12
134	P0570134	SAW BLADE 101" x 3/8" x 0.5 x 6TPI
135	PFS01M	FLANGE SCREW M5-.8 X 8
136	PS38M	PHLP HD SCR M4-.7 X 10
137	PS08M	PHLP HD SCR M5-.8 X 12
138	PTLW02M	EXT TOOTH WASHER 5MM
139	PN06M	HEX NUT M5-.8
140	PWRCRD110L	POWER CORD 110V, W/PLUG
141	P0570141	MOTOR CORD
142	PFS01M	FLANGE SCREW M5-.8 X 8
143	P0570143	STRAIN RELIEF
144	P0570144	PLATE

G0570 Parts List

REF PART # DESCRIPTION

145	P0570145	SWITCH PLATE
146	P0570146	SWITCH
148	P0570148	MITER GAUGE BODY ASSEMBLY
148-1	P0570148-1	GUIDE BAR
148-2	P0570148-2	POINTER
148-3	PFS01M	FLANGE SCREW M5-.8 X 8
148-4	P0570148-4	PIN 6.5 X 10
148-5	P0570148-5	MITER GAUGE BODY
148-6	P0570148-6	NYLON WASHER
148-7	P0570148-7	HANDLE
149	P0570149	RIP FENCE ASSEMBLY
149-1	P0570149-1	FIXED BASE L=540
149-2	P0570149-2	ADJUST BASE
149-3	P0570149-3	FIXED SHAFT
149-4	P0570149-4	CAM
149-5	P0570149-5	SHAFT
149-6	P0570149-6	SPRING PIECE
149-7	P0570149-7	VIEW WINDOW
149-8	P0570149-8	PLATE
149-9	P0570149-9	FENCE L=505
149-10	P0570149-10	BUSHING
149-11	P0570149-11	SQUARE RAIL L=540
149-12	P0570149-12	ADJUST SCREW M6-1 X 20
149-13	P0570149-13	HANDLE
149-14	P0570149-14	END CAP
149-15	P0570149-15	END CAP
149-16	P0570149-16	PLUG
149-17	P0570149-17	SCALE
149-18	PFS05M	FLANGE SCREW M4-.7 X 10
149-19	PB08M	HEX BOLT M6-1 X 20
149-20	PSB01M	CAP SCREW M6-1 X 16
149-21	PN01M	HEX NUT M6-1
149-22	PHTEK3M	TAP SCREW 3.5 X 8

REF PART # DESCRIPTION

149-23	PFS04M	FLANGE SCREW M4-.7 X 6
149-24	PN03M	HEX NUT M8-1.25
149-25	PSB83M	CAP SCREW M6-1 X 55
149-26	PLW03M	LOCK WASHER 6MM
149-27	PW03M	FLAT WASHER 6MM
150	P0570150	POINTER BRACKET
152	PW02M	FLAT WASHER 5MM
153	PSB33M	CAP SCREW M5-.8 X 12
154	PSB78M	CAP SCREW M5-.8 X 40
155	PLW01M	LOCK WASHER 5MM
156	PN06M	HEX NUT M5-.8
157	P0570157	FIXED PLATE
158	PB09M	HEX BOLT M8-1.25 X 20
159	PLW04M	LOCK WASHER 8MM
160	PW01M	FLAT WASHER 8MM
162	PSS02M	SET SCREW M6-1 X 6
163	PSB79M	CAP SCREW M5-.8 X 35
201	P0570201	LOWER WHEEL ASSEMBLY
202	P0570202	BELT 210J05
203	P0570203	MOTOR PULLEY
204	PSS01M	SET SCREW M6-1 X 10
301	PCB06M	CARRIAGE BOLT M8-1.25 X 16
302	PFN01M	FLANGE NUT M8-1.25
303	P0570303	STAND SIDE
304	PB83M	HEX BOLT M6-1 X 16
305	PW03M	FLAT WASHER 6MM
306	PFN02M	FLANGE NUT M6-1
307	P0570307	SIDE BRACE, UPPER
308	P0570308	SIDE BRACE, LOWER
309	PN08	HEX NUT 3/8-16
310	PW04M	FLAT WASHER 10MM
311	P0570311	RUBBER PAD