MODEL G0636X/G0636XB
17" ULTIMATE BANDSAW
OWNER'S MANUAL
(For models manufactured since 09/18)

C SA® US
181721

#BL9291 PRINTED IN TAIWAN V5.07.19

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

INTRODUCTION

Contact Info

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

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

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

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

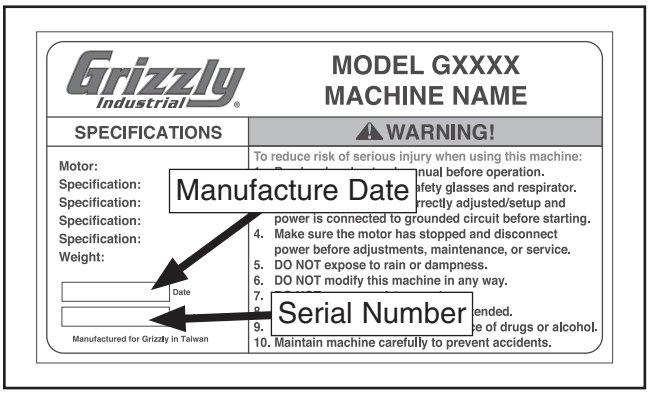
Manual Accuracy

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

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

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

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



MACHINE DATA SHEET

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

Model Number	G0636X	G0636XB
Product Dimensions		
Weight	620 lbs.	
Width (side-to-side) x Depth (front-to-back) x Height	35¼" x 33¾" x 78½"	
Footprint (Length x Width)	29½" x 23½"	
Shipping Dimensions		
Type	Wood Slate Crate	
Content	Machine	
Weight	784 lbs.	776 lbs.
Length x Width x Height	36½" x 27½" x 88"	37 x 28 x 88
Electrical		
Power Requirement	230V, Single-Phase, 60 Hz	
Full Load Current	22A	
Minimum Circuit Size	30A	
Switch	Magnetic with Thermal Overload Protection	
Switch Voltage	230V	
Cord & Plug Included	No	
Recommended Plug/Outlet Type	L6-30	
Motor		
Type	TEFC Capacitor Start Induction	
Horsepower	5 HP	
Voltage	230V	
Phase	Single-Phase	
Amperage	22A	
Speed	1725 RPM	
Cycle	60 Hz	
Power Transfer	Belt Drive	
Bearings	Shielded & Permanently Lubricated	

Model Number	G0636X	G0636XB
Operation		
Blade Speeds	4500 FPM	
Table Tilt	Left 5°, Right 45°	
Cutting Capacities		
Maximum Cutting Height	16"	
Maximum Capacity Left of Blade	16½"	
Blade Information		
Standard Blade Length	162"	
Blade Length Range	160–162	
Blade Width Range	⅛"–1⅜"	
Blade Guides	Ball Bearings	
Guide Post Type	Square Steel Tubing	
Table Dimensions		
Length x Width x Thickness	21" x 25½" x 2"	
Floor to Table Height	35½"	
Fence Information		
Locks in Front	Yes	
Locks in Rear	No	
Adjustable for Blade Lead	Yes	
Construction		
Table	Precision-Ground Cast Iron	
Rip Fence	Cast Iron Fence with Extruded Aluminum Resaw Fence	
Base	Pre-Formed Steel	
Body	One-Piece Reinforced Steel	
Wheels	Computer-Balanced Cast Iron	
Wheel Tires	Rubber	
Wheel Covers	Pre-Formed Steel	
Trunnions	Cast Iron	
Paint	Powder Coated	
Other Related Information		
Foot Brake	Yes	No
Motor Brake	No	Yes
Wheel Diameter	17"	
Dust Ports	2 x 4"	
Mobile Base Model	D2058A	
Other Specifications		
Country of Origin	Taiwan	
Warranty	1 Year	
Serial Number Location	ID Label on Top Wheel Cover	
Assembly Time	1 Hour	

Identification

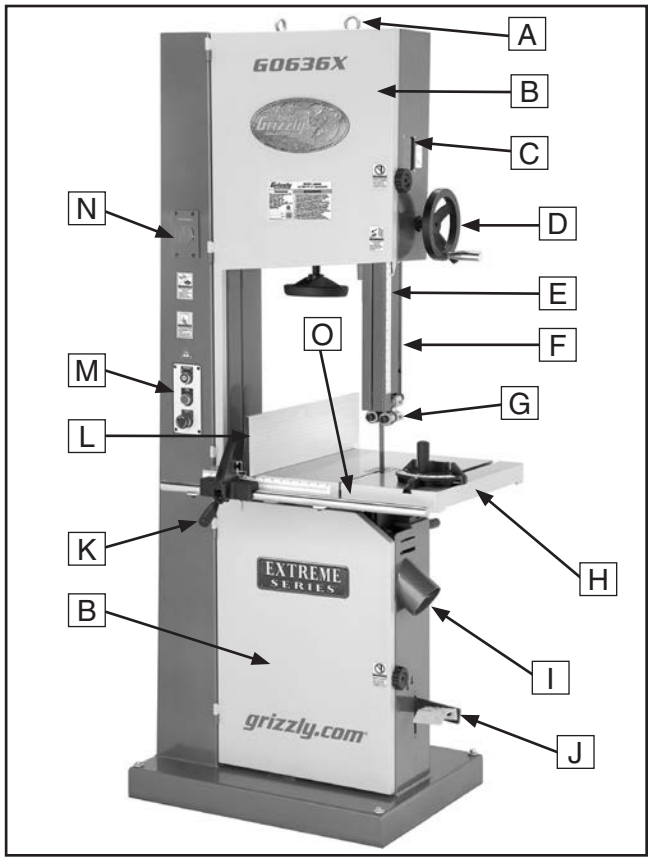


Figure 1. G0636X front view.

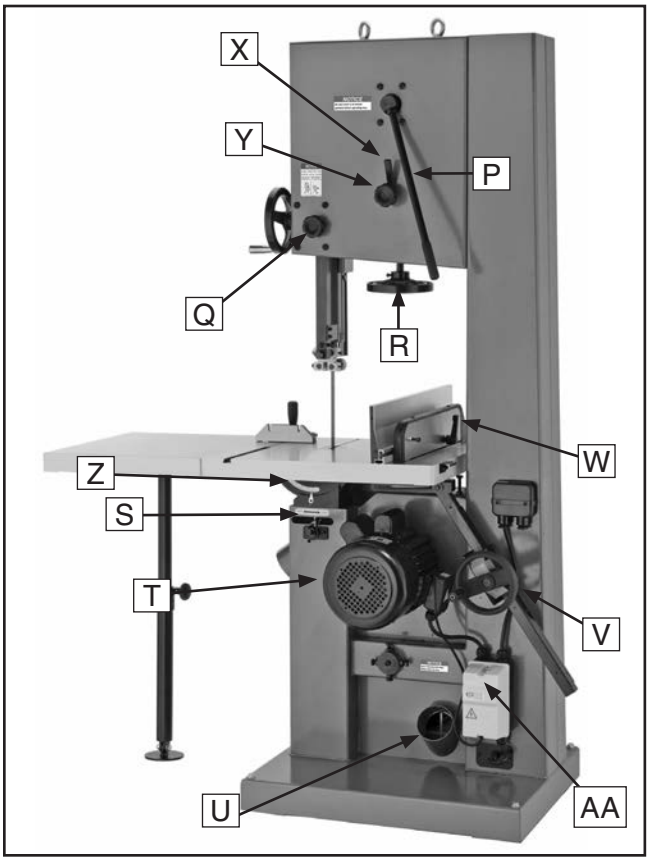
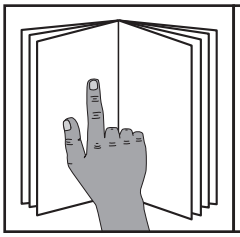


Figure 2. G0636X rear view.

A. Eye Bolt
B. Hinged Wheel Cover
C. Blade Tracking Window
D. Guide Post Handwheel
E. Cutting Height Scale
F. Guide Post
G. Ball Bearing Blade Guides
H. Miter Gauge
I. 4" Dust Port
J. Foot Brake
K. Fence Lock Lever
L. Resaw Fence
M. Key Switch, Start & Stop Buttons
N. Blade Tension Scale
O. Rail

P. Quick-Release Blade Tension Lever
Q. Guide Post Lock Knob
R. Blade Tension Handwheel
S. Table Tilt Lock Lever
T. Motor
U. 4" Dust Port
V. Table Tilt Handwheel
W. Rip Fence
X. Blade Tracking Lock Lever
Y. Blade Tracking Knob
Z. Table Tilt Scale
AA. Magnetic Switch



WARNING

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

Controls & Components

Front Controls

A. Power Switch: Disables ON/OFF buttons when key is turned to "0" position. Remove key to lock switch and prevent unauthorized use of machine.

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

B. ON Button: Starts motor only if OFF button is popped out and power switch is turned to "1" position.

C. OFF Button: Disables ON button. Enable ON button by twisting OFF button clockwise.

D. Blade Tension Scale: Allows for easy monitoring of blade tension.

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

F. Blade Tracking Window: Allows for easy monitoring of blade tracking (refer to **Page 19**).

G. Fence, Rail, and Miter Gauge: Allows for controlled cutting at various angles.

H. Foot Brake (G0636X): Cuts power to motor and allows bandsaw blade to be quickly brought to a stop.

Rear Controls

I. Guide Post Handwheel and Lock Knob: Moves blade guide support quickly to the desired height on the guide post; locks setting (refer to **Page 36**).

J. Quick Release Blade Tension Lever: Releases blade tension for quick blade changes.

K. Blade Tracking Knob and Lock Lever: Moves and locks blade tracking.

L. Table Tilt Lock Lever: Locks or unlocks the table at the current angle.

M. Table Tilt Handwheel: Tilts the table up to 5° to the left or 45° to the right (refer to **Page 35**).

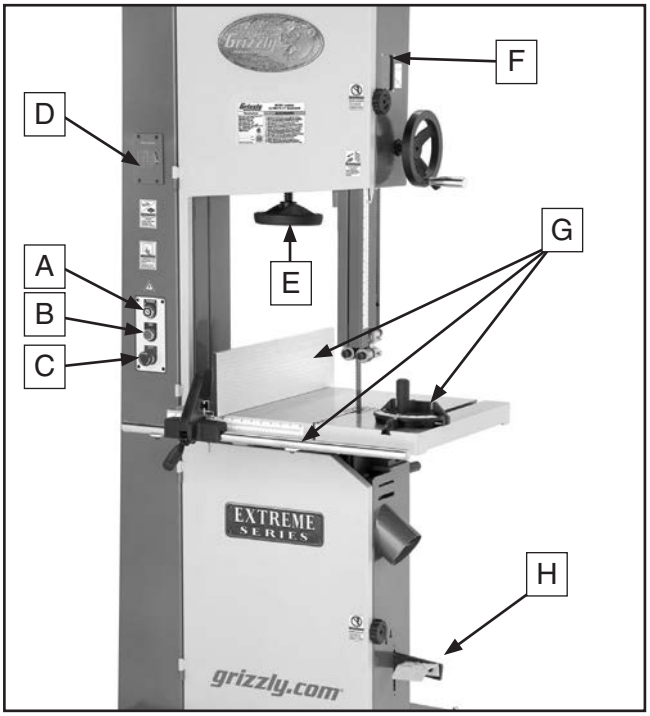


Figure 3. Front controls.

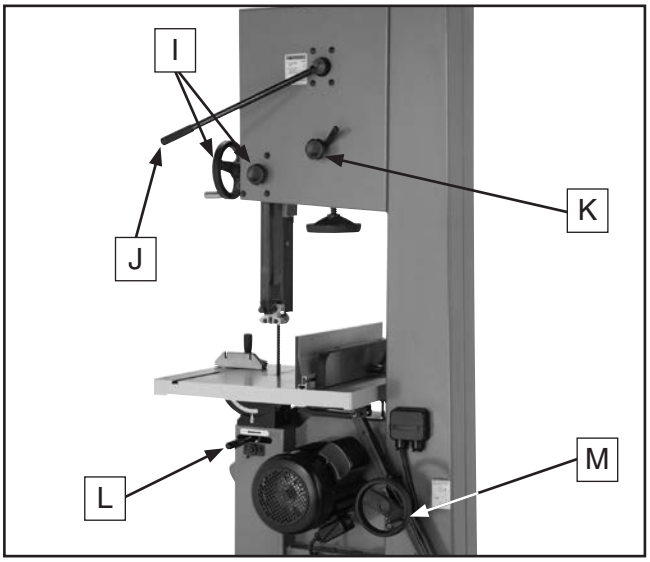


Figure 4. Rear controls.

G0636XB Motor Brake

The Model G0636XB has a motor brake that activates and quickly stops the blade when the OFF button is pressed.

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Bandsaws

⚠WARNING

Serious cuts, amputation, or death can occur from contact with the moving saw blade during operation or if blade breakage occurs. To reduce this risk, anyone operating this machine MUST completely heed the hazards and warnings below.

HAND PLACEMENT. Placing hands or fingers in line with blade during operation may result in serious injury if hands slip or workpiece moves unexpectedly. Do not position fingers or hands in line with blade, and never reach under table while blade is moving.

SMALL/NARROW WORKPIECES. If hands slip during a cut while holding small workpieces with fingers, serious personal injury could occur. Always support/feed small or narrow workpieces with push sticks, push blocks, jig, vise, or some type of clamping fixture.

BLADE SPEED. Cutting workpiece before blade is at full speed could cause blade to grab workpiece and pull hands into blade. Allow blade to reach full speed before starting cut. DO NOT start machine with workpiece contacting blade.

FEED RATE. To avoid risk of workpiece slipping and causing operator injury, always feed stock evenly and smoothly.

BLADE CONDITION. Dull blades require more effort to perform cut, increasing risk of accidents. Do not operate with dirty, dull, cracked or badly worn blades. Inspect blades for cracks and missing teeth before each use. Always maintain proper blade tension and tracking while operating.

CLEARING JAMS AND CUTOFFS. Always stop bandsaw and disconnect power before clearing scrap pieces that get stuck between blade and table insert. Use brush or push stick, not hands, to clean chips/cutoff scraps from table.

BLADE CONTROL. To avoid risk of injury due to blade contact, always allow blade to stop on its own. DO NOT try to stop or slow blade with your hand or the workpiece.

GUARDS/COVERS. Blade guards and covers protect operator from the moving bandsaw blade. The wheel covers protect operator from getting entangled with rotating wheels or other moving parts. ONLY operate this bandsaw with blade guard in proper position and wheel covers completely closed.

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

UPPER BLADE GUIDE SUPPORT. To reduce exposure of operator to blade and provide maximum blade support while cutting, keep upper blade guides adjusted to just clear workpiece.

CUTTING TECHNIQUES. To avoid blade getting pulled off wheels or accidentally breaking and striking operator, always turn bandsaw ***OFF*** and wait for blade to come to a complete stop before backing workpiece out of blade. DO NOT back workpiece away from blade while bandsaw is running. DO NOT force or twist blade while cutting, especially when sawing small curves. This could result in blade damage or breakage.

WORKPIECE SUPPORT. To maintain maximum control and reduce risk of blade contact/breakage, always ensure adequate support of long/large workpieces. Always keep workpiece flat and firm against table/fence when cutting to avoid loss of control. If necessary, use a jig or other workholding device.

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 230V ..... 22 Amps

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

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

Circuit Requirements for 230V

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

Nominal Voltage 230V/240V
Cycle ..... 60 Hz
Phase 1-Phase
Power Supply Circuit ..... 30 Amps
Plug/Receptacle ..... NEMA L6-30
Cord ..... "S"-Type, 3-Wire, 10 AWG, 300 VAC

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

⚠CAUTION

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

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

Grounding Instructions

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

The power cord and plug specified under "Circuit Requirements for 230V" on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see following figure).

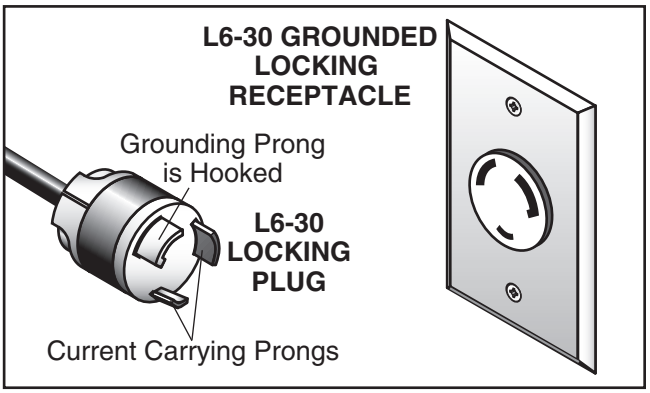
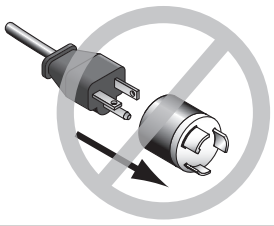


Figure 5. Typical L6-30 plug and receptacle.

⚠WARNING

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

⚠CAUTION



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

⚠WARNING

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

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

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

Extension Cords

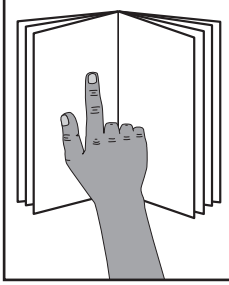
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

Minimum Gauge Size .....10 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

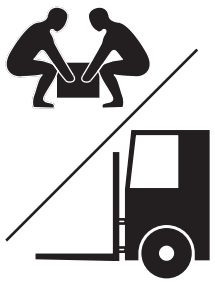


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

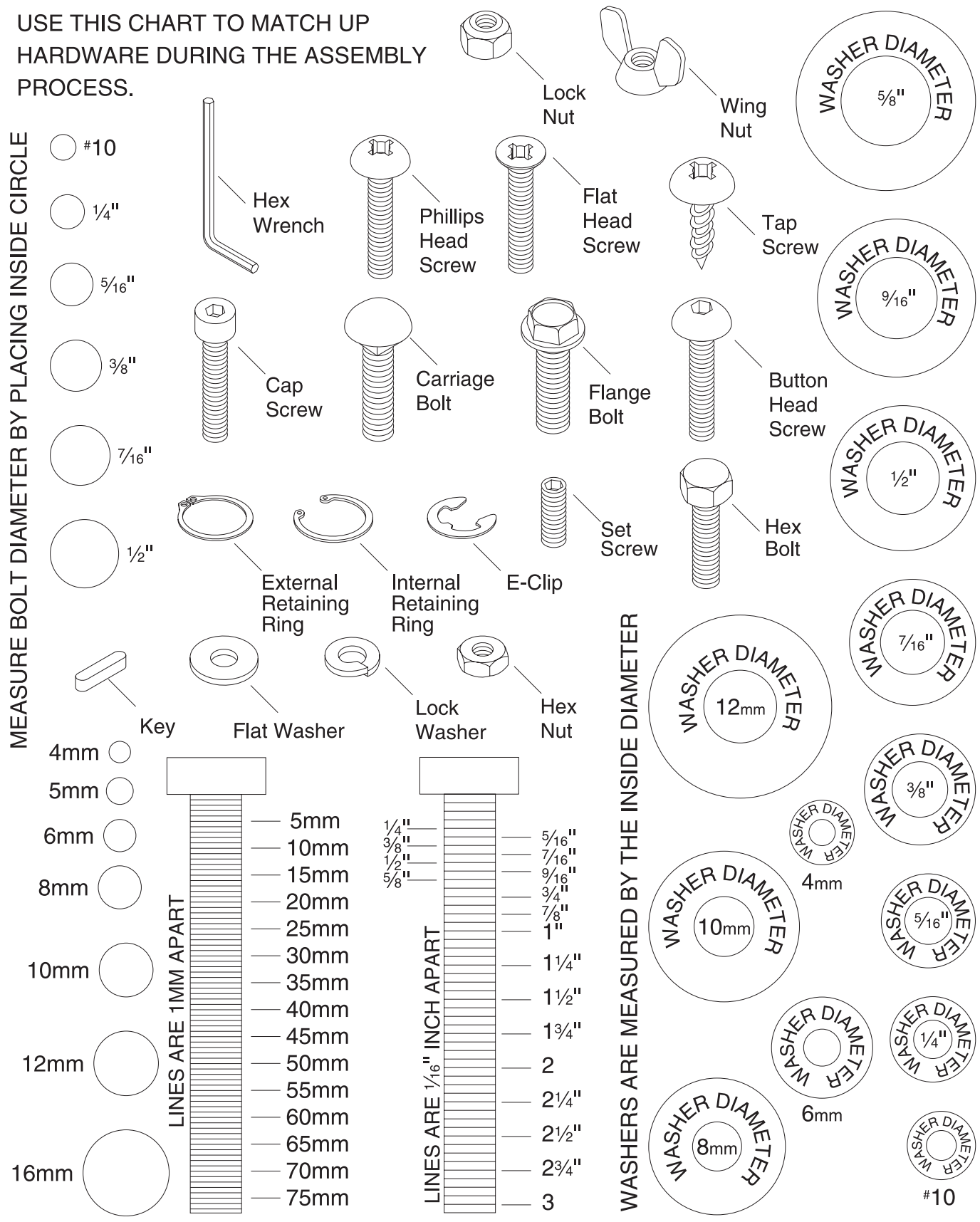
Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags	As Needed
• Forklift, 1000 lb. Capacity	1
• Chain or Strap w/Hook, 1000 lb. Capacity	1
• Machinist's Square	1
• Straightedge 3'	1
• Dust Collection System	1
• Dust Hoses 4"	2
• Hose Clamps 4"	2

Unpacking

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

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

Hardware Recognition Chart



Inventory

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

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

Inventory Items (Figure 6)	Qty
A. Bandsaw (not shown)	1
B. Resaw Fence	1
C. Fence Rail	1
D. Cast Iron Fence Assembly	1
E. Guide Post Handwheel	1
F. Knobs M8-1.25 x 20 (Fence Rail)	2
G. Lock Handle M8-1.25 x 44 (Fence)	1
H. Miter Gauge	1
I. Wrenches 10/13mm, 17/19mm	1 Ea.
J. Hex Wrenches 5, 6mm	1 Ea.
K. Square Plate (Fence Rail)	1
L. Slotted Plates (Fence Rail)	2
M. Fender Washers 8mm (Resaw Fence)	4
N. Lock Washer 8mm (Fence Rail)	1
O. Lock Washers 6mm (Fence Rail)	3
P. Flat Washers 6mm (Fence Rail)	3
Q. Eye Bolts M10-1.5 x 15	2
R. Moving Plate (Resaw Fence)	1
S. Cap Screw M8-1.25 x 20 (Fence Rail)	1
T. Cap Screws M6-1 x 20 (Fence Rail)	3

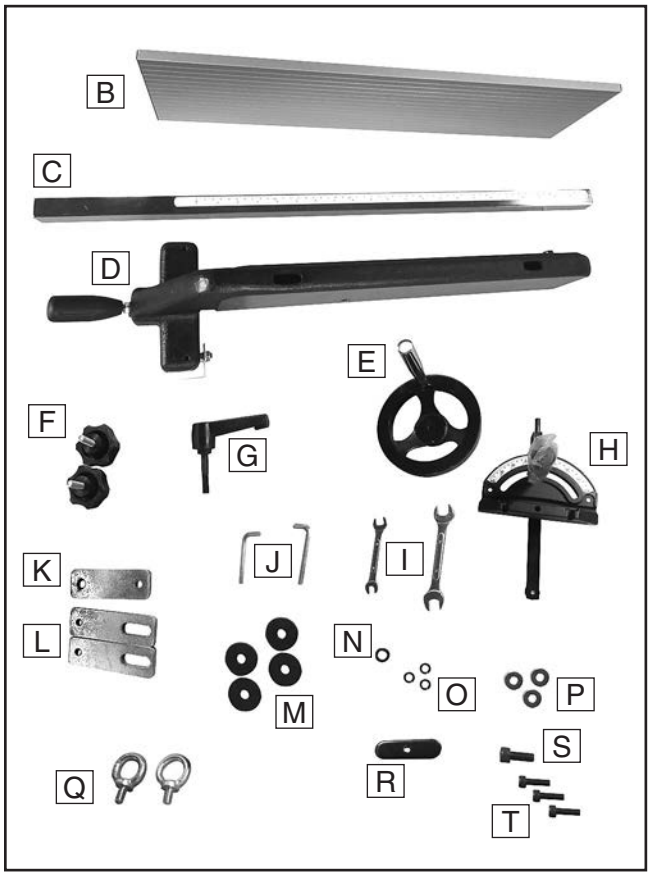


Figure 6. Loose inventory components.

NOTICE

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

Cleanup

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

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

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

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

Basic steps for removing rust preventative:

1. Put on safety glasses.

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

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

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

⚠WARNING

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

⚠CAUTION

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

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

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

Figure 7. T23692 Orange Power Degreaser

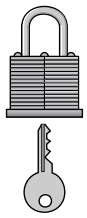
Site Considerations

Weight Load

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

Space Allocation

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



⚠CAUTION

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

Physical Environment

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

Electrical Installation

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

Lighting

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

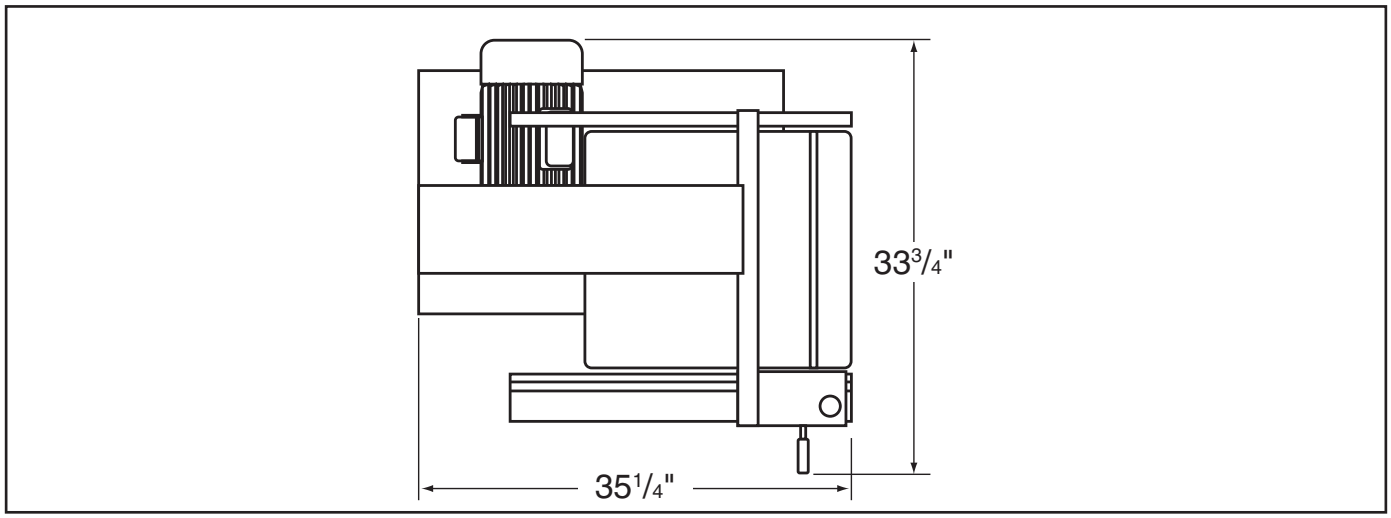


Figure 8. Minimum working clearances.

Moving & Placing Base Unit

⚠WARNING

This is an extremely heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and a forklift or a hoist when removing the machine from the crate. Use a chain or a lifting strap with a minimum of 1000 lbs. lifting capacity. If the chain or lifting strap breaks, serious personal injury may occur.

Take special care when moving this bandsaw. Only use the following methods to lift or move this bandsaw.

To move and place the bandsaw:

1. Use a forklift to move the bandsaw on the pallet to its final location.

2. Unbolt the bandsaw from the pallet.

3. Install the eye bolts shown in **Figure 9**, making sure they are threaded all the way in, then place the lifting hooks through the eye bolts and lift slowly with a forklift.

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

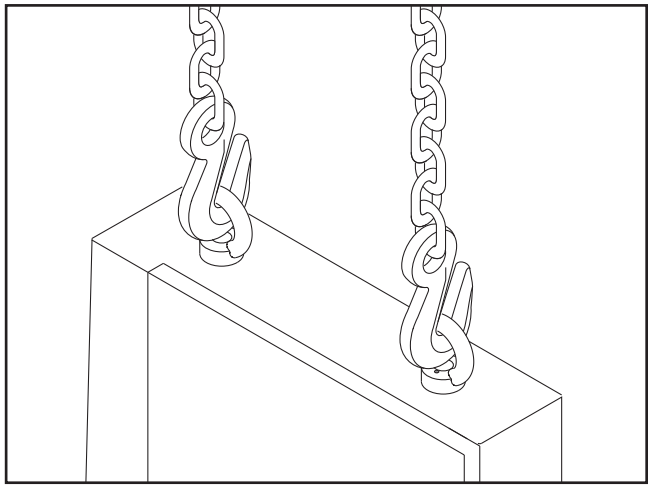


Figure 9. Lifting the bandsaw.

To move and place the bandsaw using wood shims:

1. Use a forklift to move the bandsaw on the pallet to its final location.

2. Carefully place the forklift forks under the head and install a 1x4 shim between the head and the left fork and a 2x4 shim between the head and right fork so the bandsaw is level, as shown in **Figure 10**.

3. Unbolt the bandsaw from the pallet.

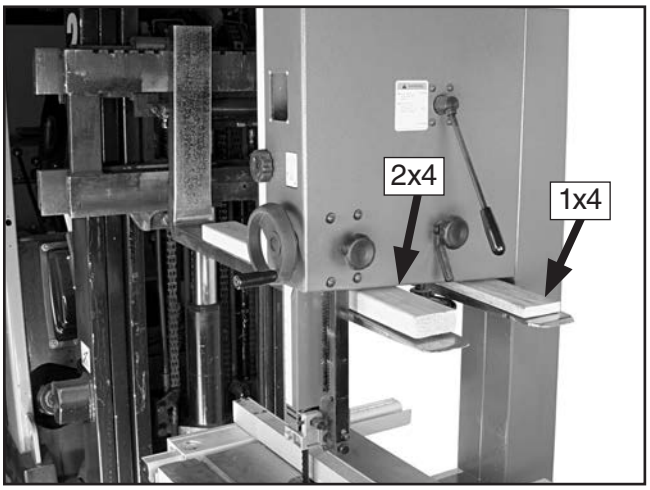


Figure 10. Example of lifting bandsaw with forklift using wood shims.

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

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

Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. However, you must level your machine with a precision level.

You may also mount your machine to a mobile base (see **Figure 12**) that has wheel locking or wheel retracting capabilities that keep the mobile base from rolling when the bandsaw is in use. We recommend using the Grizzly Model D2058A mobile base.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 11**) and anchor studs are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

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

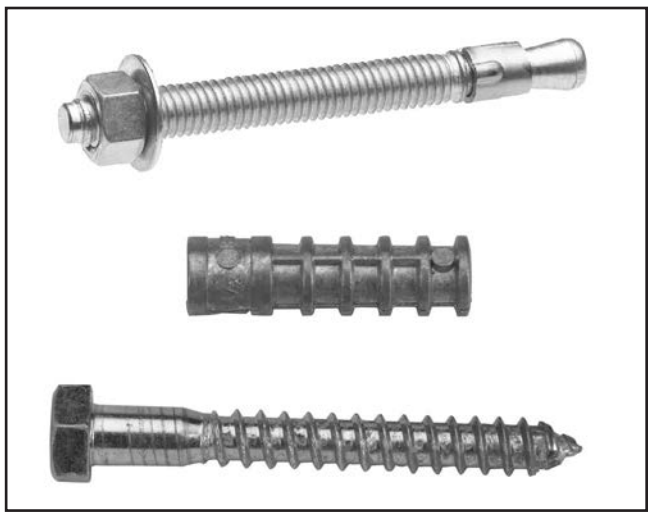


Figure 11. Typical fasteners for mounting to concrete floors.

Figure 12. Bandsaw mounted on D2058A mobile base.

Guide Post Handwheel

To install the guide post handwheel:

1. Insert the guide post handwheel onto the shaft, and secure it with the cap screw on the flat side of the shaft, as shown in **Figure 13.**

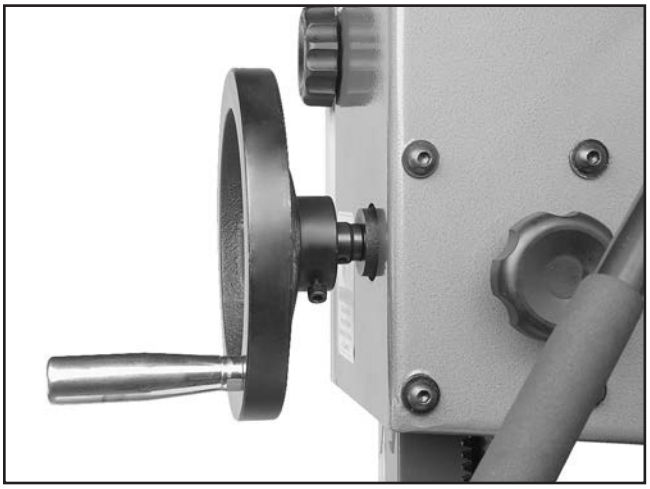


Figure 13. Guide post handwheel installed.

Blade Tracking

⚠WARNING

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

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 52**.)

The wheels on this bandsaw were aligned at the factory, so Center Tracking is the only adjustment that needs to be performed.

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the upper and lower blade guides are adjusted away from the blade (see **Page 25**).

3. Move the quick tension lever to the tightened position and turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade thickness (see **Figure 14)**.

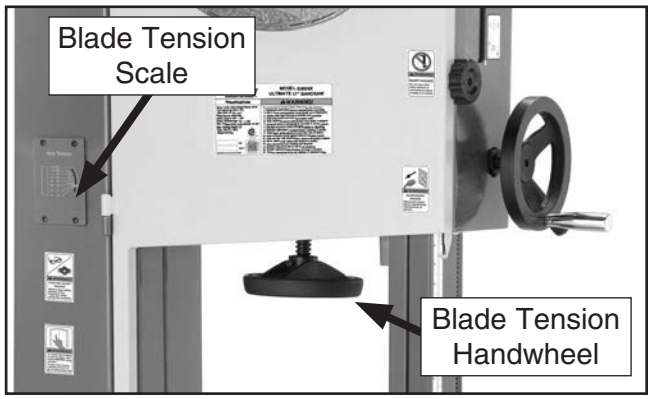


Figure 14. Blade tensioning controls.

4. Open the upper wheel cover.

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 15** 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 center 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.

⚠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.

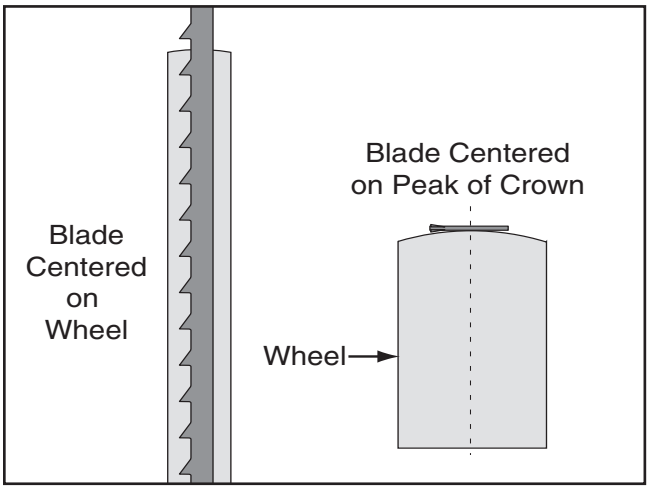


Figure 15. Center tracking profiles.

6. Loosen the lock lever (**Figure 16**) so that the blade tracking knob can rotate.

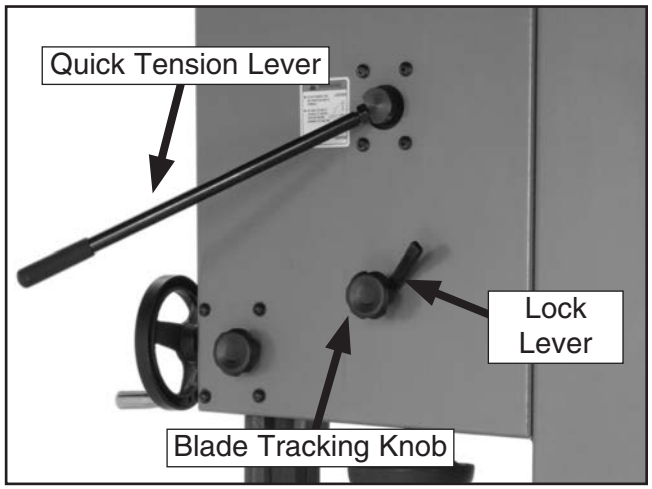


Figure 16. Blade tracking controls.

7. Spin the upper wheel with one hand and rotate the blade tracking knob with the other hand to make the blade ride in the center of the bandsaw wheel tire.

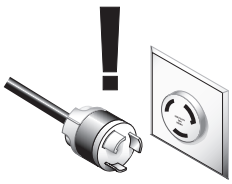
8. Tighten the lock lever and close the upper wheel cover.

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

NOTICE

Changes in the blade tension may change the blade tracking.

Positive Stop



WARNING

Personal injury or death can occur if the bandsaw starts during table adjustments. Disconnect power from the bandsaw before performing table adjustments.

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

To set the positive stop:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the blade tension to the appropriate level for the blade size on the blade tension scale (see **Page 25**).

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

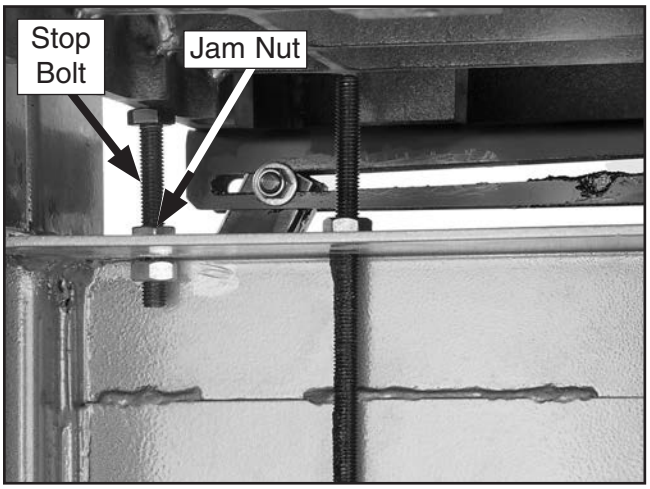


Figure 17. Positive stop bolt and jam nut (as viewed from front).

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 18**. Adjust the table square with the blade using the table tilt handwheel, then secure with the table tilt lock lever.

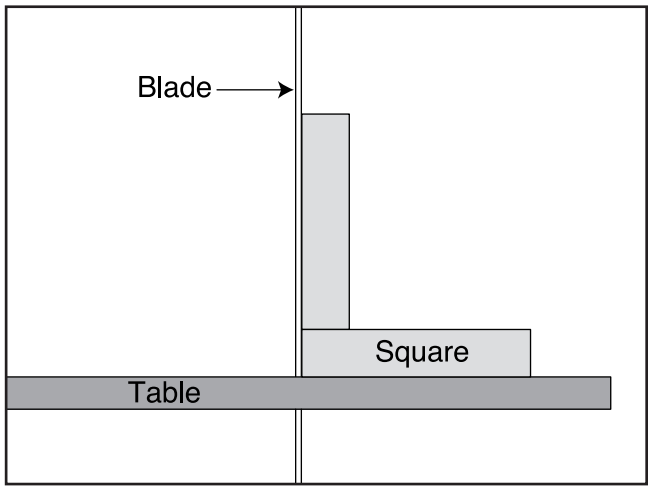


Figure 18. Squaring table to blade.

5. Adjust the positive stop bolt so it just touches the table and secure it by tightening the jam nut against the bandsaw.

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

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

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

Dust Collection

⚠CAUTION

DO NOT operate the Model G0636X without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

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

To connect a dust collection hose:

1. Fit a 4" dust hose over each dust port, as shown in **Figure 19**, and secure in place with a hose clamp.

2. Tug each hose to make sure it does not come off. **Note:** *A tight fit is necessary for proper performance.*

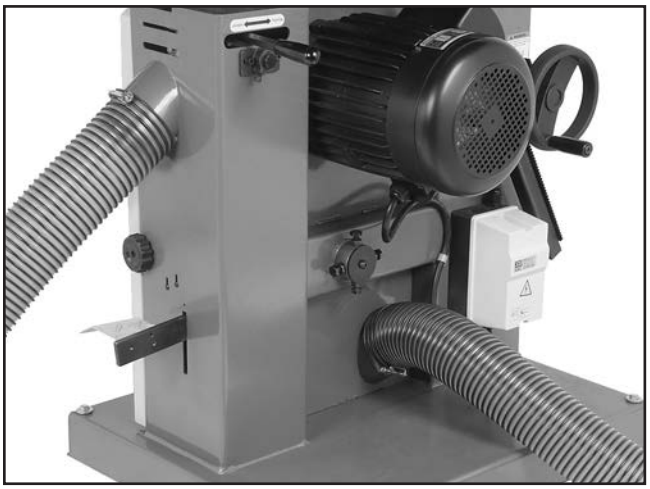


Figure 19. Dust hoses attached to dust port.

Installing Fence

The fence assembly mounts directly to the work table. Ensure all fence and rail fasteners remain tight for best performance.

To install the fence:

1. Install slotted plates on each end of work table using (2) M8-1.25 knobs and (2) 8mm fender washers, as shown in **Figure 20**.

2. Install square plate using (1) M8-1.25 x 20 cap screw, (1) 8mm fender washer, and (1) 8mm lock washer, as shown in **Figure 20**.

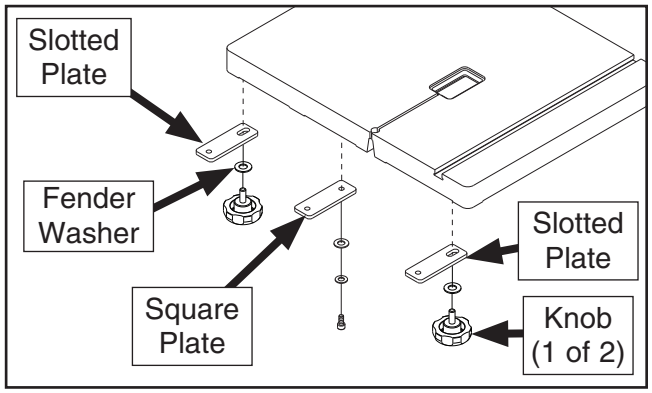


Figure 20. Fence plate attachment points.

3. Attach fence rail to plates installed in **Steps 1 & 2** using (3) M6-1 x 20 cap screws, (3) 6mm flat washers, and (3) 6mm lock washers, as shown in **Figure 21**.

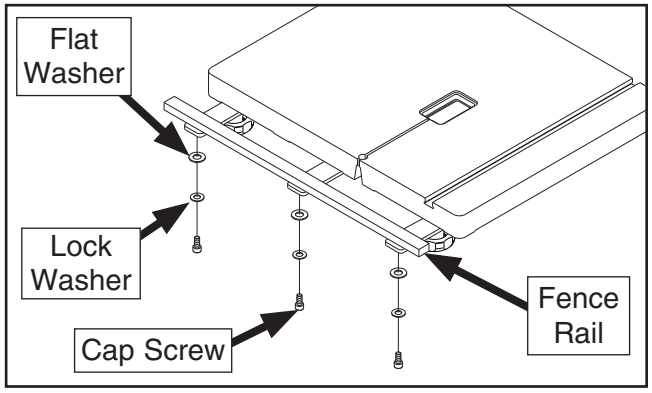


Figure 21. Fence rail attachment points.

4. Install the fence handle on the fence, if it is not already installed.

5. Tighten the hex nut on the fence handle against the fence pivot block (see **Figure 22**).

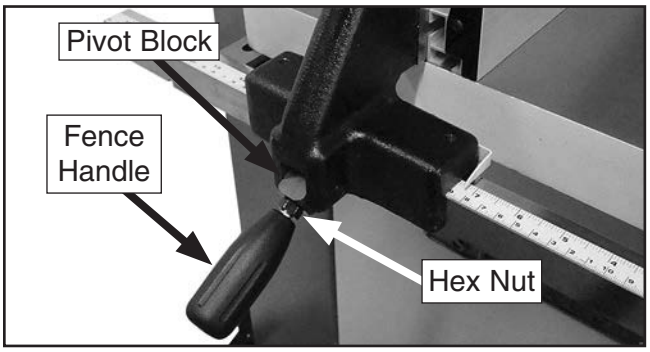


Figure 22. Fence handle components.

6. Install the resaw fence lock handle (with the 8mm fender washer and moving plate) onto the fence, then slide the resaw fence over the moving plate as shown in **Figure 23**.

   Note: *Leave the moving plate and lock handle loose enough to slide on the resaw fence.*

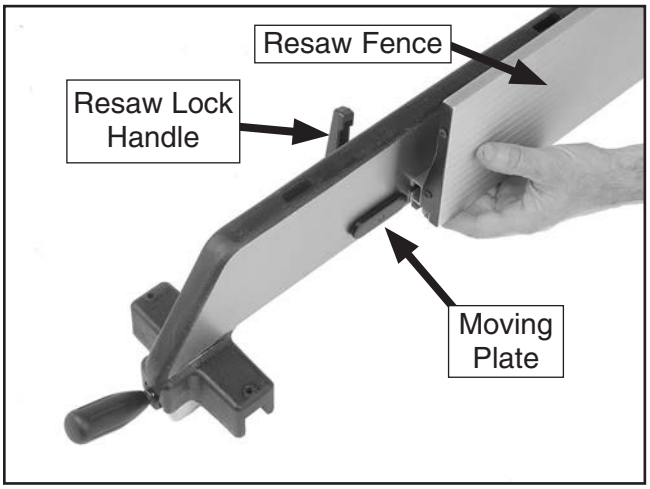


Figure 23. Example of attaching resaw fence to standard fence.

7. Tighten the resaw lock handle.

8. Pull the fence handle up and place the fence assembly on the rail.

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

Power Connection

After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine from the power

Connecting Power

1. Turn the machine power switch **OFF**.

2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

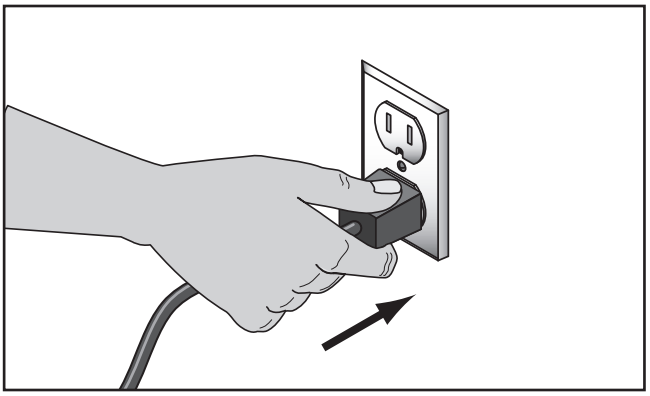


Figure 24. Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.

2. Grasp the molded plug and pull it completely out of the receptacle. DO NOT pull by the cord as this may damage the wires inside.

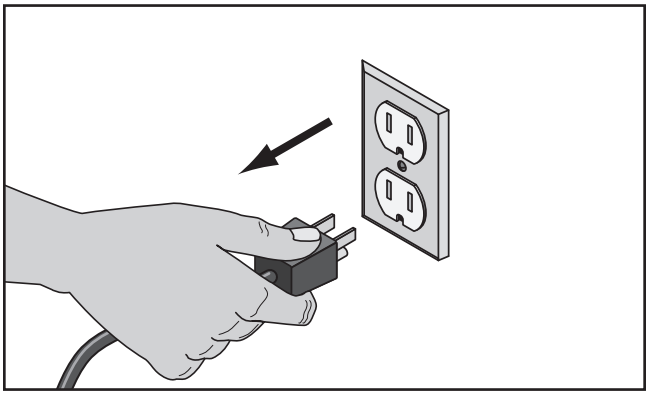


Figure 25. Disconnecting power.

Test Run

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

The test run consists of verifying the following: 1) The motor powers up and runs correctly, 2) the safety disabling mechanism on the switch works correctly, and 3) the stop button safety feature works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 48**.

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

To test run the machine:

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

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

3. Connect the machine to the power source.

4. Verify that the machine is operating correctly by turning the switch disabling key (**Figure 26**) to "1" and turning the machine ***ON***.

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

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

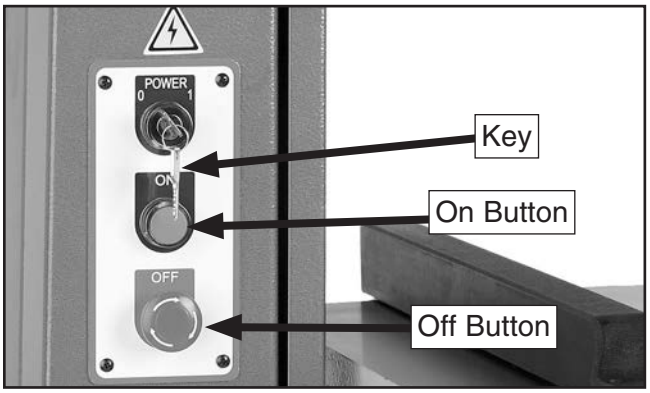


Figure 26. G0636X switch disabling key and ON/OFF switch.

5. Press the OFF button to stop the machine.

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

   —If the machine does not start, the OFF button safety feature is working correctly.

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

7. Twist the OFF button clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 27**).

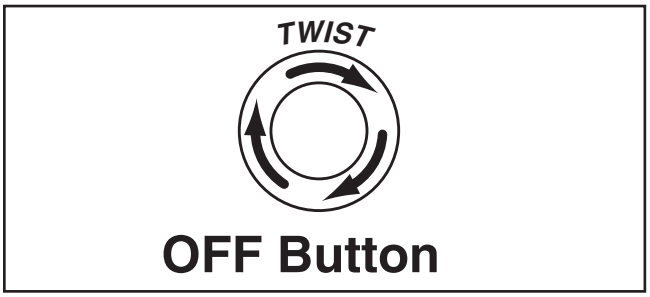


Figure 27. Resetting the switch.

8. Turn the switch disabling key to "0", as shown in **Figure 26**.

9. Try to turn the machine ***ON***.

—If the bandsaw does not start, the switch disabling feature is working as designed. The Test Run is complete.

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

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is required before making many bandsaw adjustments. (Every time you replace the blade, you should perform this procedure because all blades tension differently.)

To tension the bandsaw blade:

1. Complete the **Test Run** procedure and make sure the blade is tracking properly (see **Page 19**).

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 (see **Adjusting Blade Guide Bearings**).

Note: *This procedure will NOT work if the guide blocks have any contact with the blade.*

3. Move the quick tension lever to the tightened position and turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade thickness (See **Figure 14**, **Page 19**).

4. Turn the bandsaw ***ON***.

5. Slowly release the tension one quarter of a turn at a time. 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 blade tension scale reads and use that as a guide for tensioning that blade in the future.

Note: *Always release blade tension after use to increase blade life and reduce strain on the bandsaw components.*

8. Re-adjust the blade tracking as instructed on **Page 19**.

Adjusting Blade Guide Bearings

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

To adjust the upper blade guides:

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

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the blade guide controls shown in **Figure 28 & 29**.

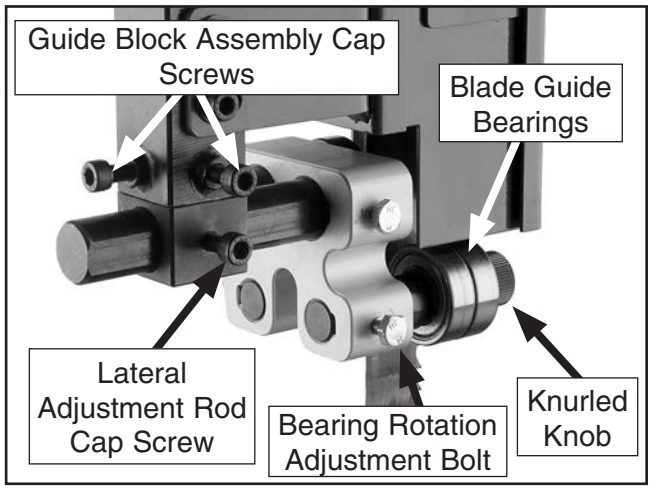


Figure 28. Upper blade guide controls (rear view).

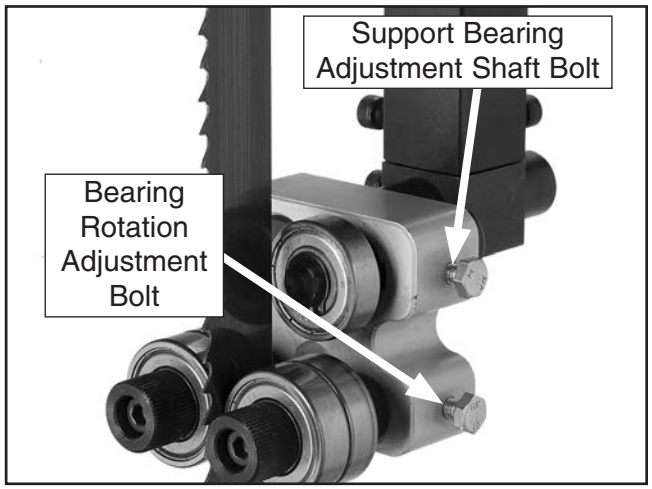


Figure 29. Upper blade guide controls (front view).

4. Loosen the lateral adjustment rod cap screw, loosen the support bearing adjustment shaft bolt, and adjust the blade guides until the edges of the bearings are 1/16" behind the blade gullets, as illustrated in **Figure 30**.

Note: *The 1/16" spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the guide bearings as far forward to the blade gullets as possible, and still maintain the proper support bearing spacing adjustment.*

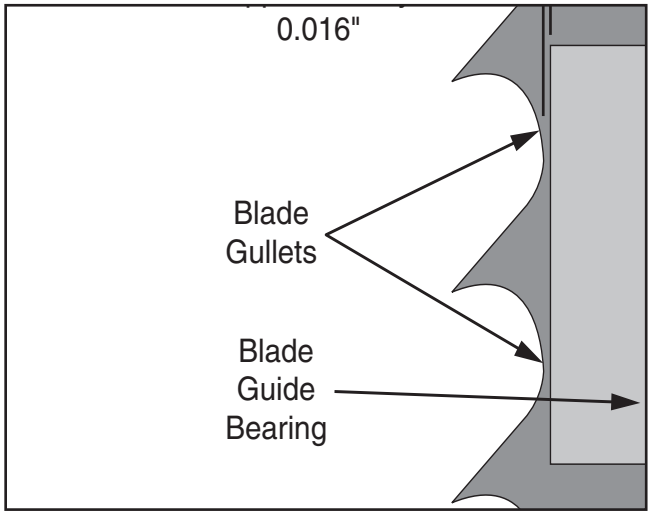


Figure 30. Lateral adjustment of blade guides.

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.

5. Tighten the lateral adjustment rod cap screw.

6. Loosen the bearing rotation adjustment bolts on both sides of the blade.

7. Rotate the knurled knobs to position the bearings 0.004" away from the blade.

   Note: *0.004" is approximately the thickness of a dollar bill.*

8. Tighten both of the bearing rotation adjustment bolts 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 and locked before cutting operations.

To adjust the lower blade guides:

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

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the blade guide controls shown in **Figure 31**.

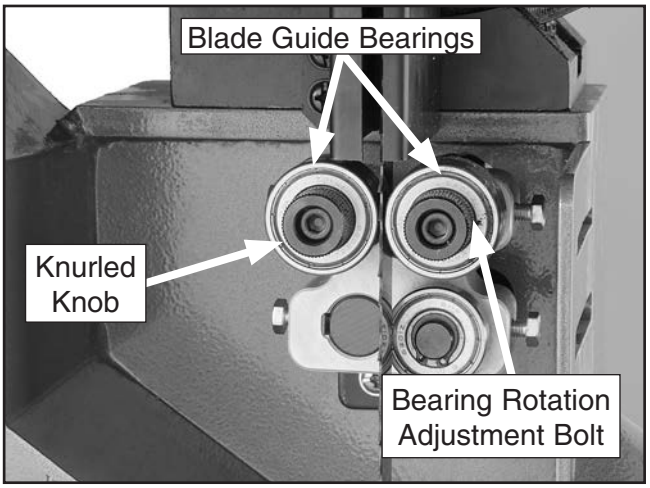


Figure 31. Lower blade guide controls (front view).

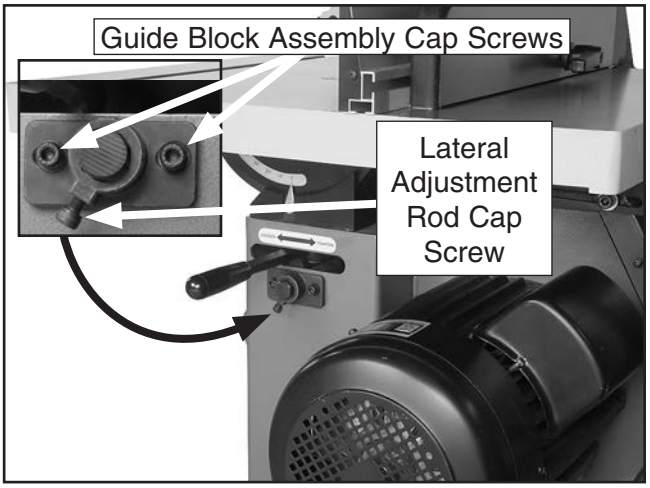


Figure 32. Lower blade guide controls (rear view).

4. Follow the procedure for adjusting the upper blade guides on **Page 25**.

   Note: *The lateral adjustment rod cap screw and guide block assembly cap screws are located below the table tilt lock lever (see **Figure 32**).*

Adjusting Support Bearings

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.

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.

To adjust the upper support bearing:

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

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the upper support bearing controls shown in **Figure 28 & 29**.

4. Loosen the guide block assembly cap screws and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing, as illustrated in **Figure 33**.

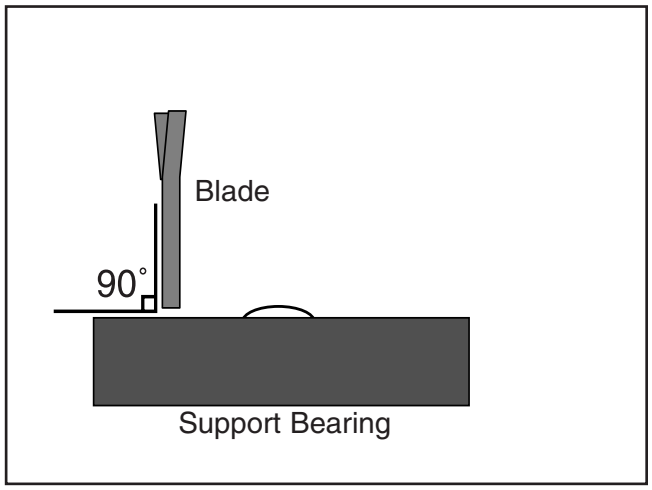


Figure 33. Illustration of blade set perpendicular (90˚) to the support bearing face.

5. Tighten the guide block assembly cap screws.

6. Loosen the bolt on the support bearing adjustment shaft—if it is not already loose.

7. Using a feeler gauge between the support bearing and the blade, position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 34**.

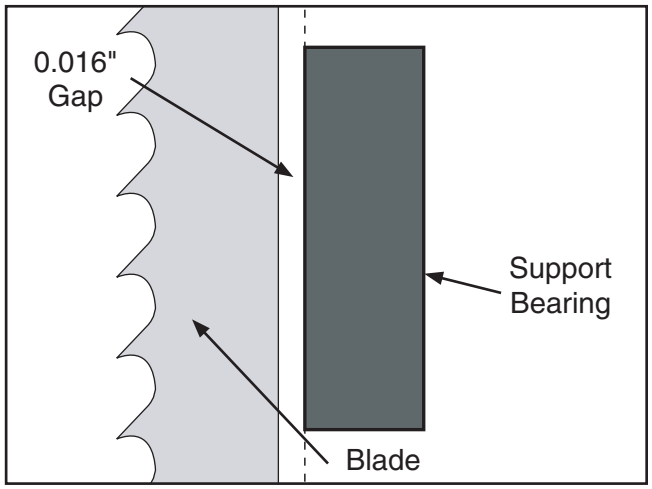


Figure 34. Blade aligned 0.016" away from the bearing edge.

Note: *For a quick gauge, fold a crisp dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016") and place it between the support bearing and the blade as shown in* ***Figure 35***.

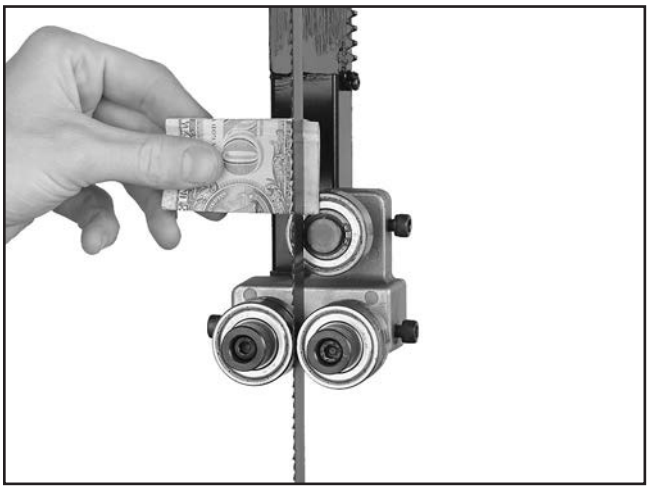


Figure 35. Example of dollar bill folded twice to make an approximate 0.016" gauge.

8. Tighten the bolt to keep the support bearing locked in place.

To adjust the lower support bearing:

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

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the lower support bearing controls shown in **Figure 36**.

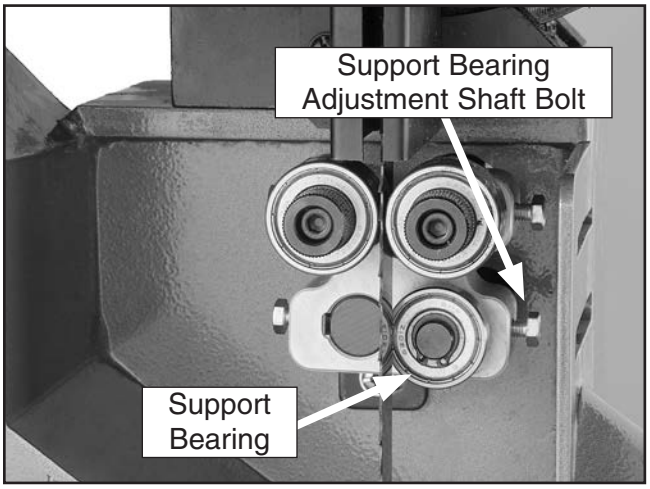


Figure 36. Lower support bearing controls.

4. Open the upper and lower wheel covers.

5. Make sure that the blade is perpendicular to the face of the support bearing, as illustrated in **Figure 33**.

   —If the blade is perpendicular to the face of the support bearing, continue on to the next step.

   —If the blade is not perpendicular to the support bearing, loosen the lateral adjustment rod cap screw and guide block assembly cap screws (**Figure 32**) and rotate the assembly side-to-side until it is perpendicular to the face of the support bearing, then re-tighten the cap screws.

6. Loosen the bolt on the support bearing adjustment shaft.

7. Using a feeler gauge, position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 34**, or use a dollar bill, as shown in **Figure 35**.

8. Tighten the bolt to keep the support bearing locked in place.

Aligning Table

To ensure cutting accuracy, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a 1⅜" blade installed.

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

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

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the four trunnion cap screws that secure the table to the trunnions (see **Figure 37**).

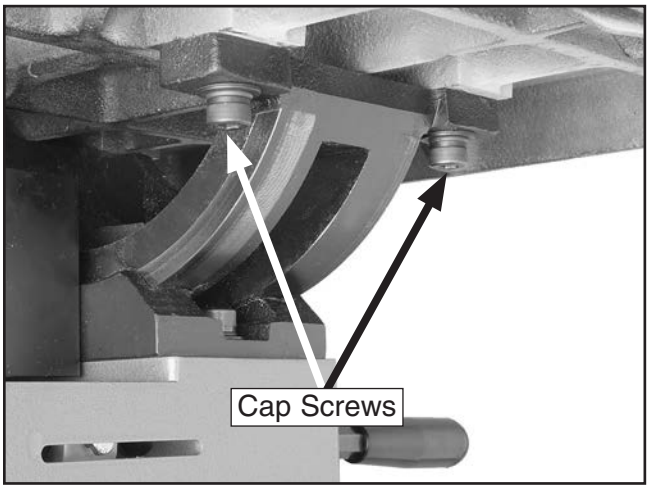


Figure 37. Cap screws securing table to trunnion.

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 accurately 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 (see **Figure 38**).

6. Adjust the table as needed for proper alignment.

7. Tighten the trunnion cap screws when the alignment is correct.

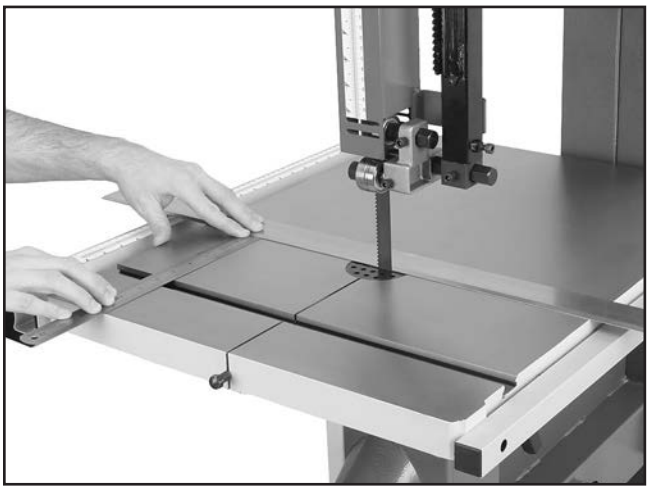


Figure 38. Example of measuring for miter slot to be parallel with blade.

Aligning Fence

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

To align the fence parallel with the miter slot:

1. DISCONNECT BANDSAW FROM POWER!

2. Make sure the miter slot is aligned with the bandsaw blade (see **Page 29**).

3. Mount the fence next to the miter slot, then loosen the knobs and cap screw that secure the fence rail to the table.

4. Adjust the fence face parallel with the edge of the miter slot, as shown in **Figure 39**.

Figure 39. Example of fence square with miter slot.

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

NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the "Aligning Table" instructions on Page 29.

Miter Gauge

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

To calibrate the miter gauge:

1. Place one edge of a machinist's square against the face of the miter gauge and the other against the blade face, as shown in **Figure 40**.

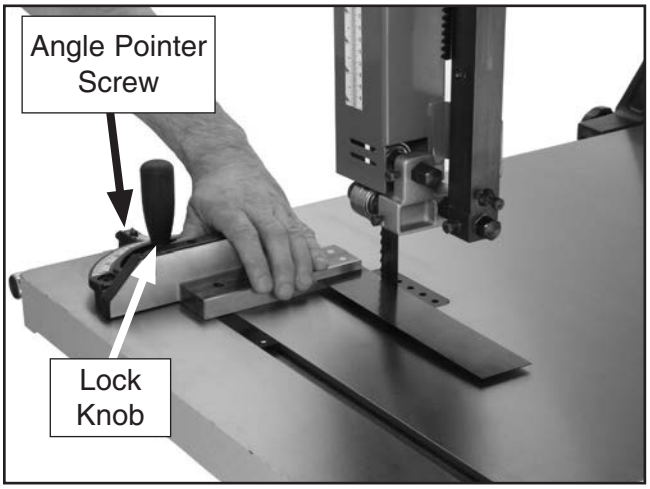


Figure 40. Example of squaring miter gauge to blade.

2. Loosen the lock knob on the miter gauge and adjust the gauge 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.

Pointer Calibration

Your new bandsaw is equipped with a fence measurement system that includes a fence pointer, which must be calibrated when the bandsaw is first set up.

To calibrate the pointer:

1. If the fence is mounted on the right-hand side of the blade, remove it and re-install it on the left-hand side of the blade.

2. Place the fence flush against the bandsaw blade (see **Figure 41**).

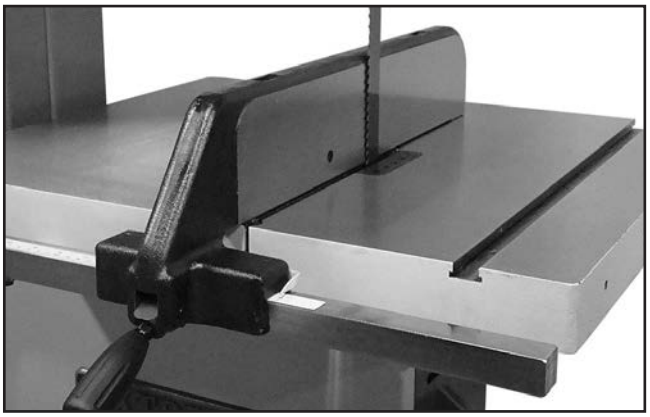


Figure 41. Example of fence flush with blade.

3. Loosen the pointer adjustment screw (**Figures 42–43**) and set the pointer in line with "0" and the measurement scale on the table.

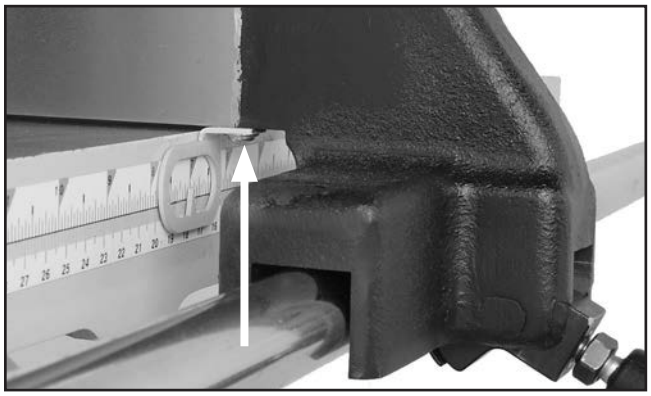


Figure 42. Model G0636X fence pointer adjustment screw.

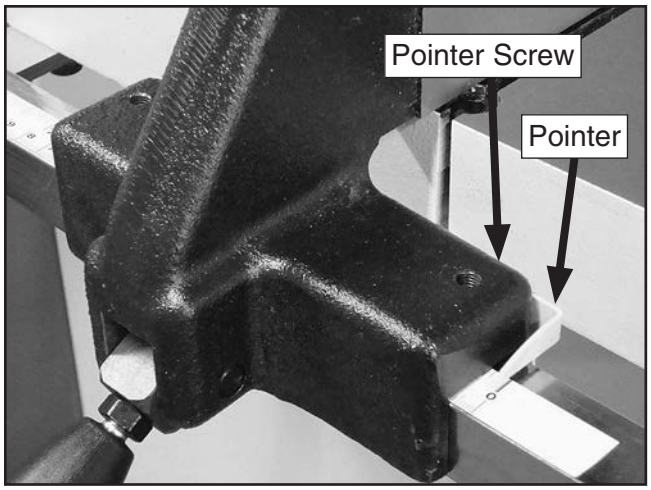


Figure 43. Model G0636XB fence pointer (screw out of view).

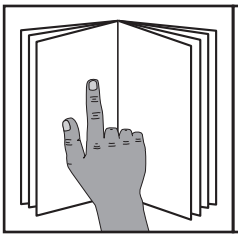
4. Tighten the pointer adjustment nut.

SECTION 4: OPERATIONS

Operation Overview

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

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

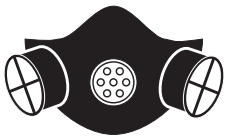


⚠WARNING

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

⚠WARNING

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



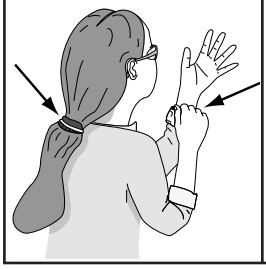
NOTICE

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

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

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the fence away from the blade the same width of the desired cut and then locks it in place.
3. Adjusts the table tilt, if necessary, to the correct angle of the desired cut.
4. Adjusts the blade guide height to approximately 1" from the top of the workpiece.
5. Checks to make sure the workpiece can safely pass all the way through the blade without interference from other objects.
6. Puts on safety glasses.
7. Starts the dust collector and bandsaw.
8. Holds the workpiece firmly and flatly against both the table and fence, and then pushes the workpiece into the blade at a steady and controlled rate until the workpiece moves completely beyond the blade.

   Note: *The operator is very careful to keep fingers away from the blade and uses a push stick to feed narrow workpieces.*
9. Stops the bandsaw and removes the workpiece when the blade is completely stopped.



⚠WARNING

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

Basic Cutting Tips

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

- Keep the upper blade guide assembly adjusted to within 1" of the workpiece.
- Replace, sharpen, and clean blades as necessary. Make adjustments periodically to keep the saw running in top condition.
- Use light and even pressure while cutting. Light contact with the blade makes it easier to follow lines and prevents extra friction, which reduces blade life.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners.
- Do not back the workpiece away from the blade while the saw is running.

Workpiece Inspection

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

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

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. Cutting drywall or cementitious backer board creates extremely fine dust, which may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.
- **Foreign Objects (Figure 44):** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, do NOT cut the workpiece.

Continued on next page ⟶

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

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

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

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side faces the table or fence, as shown in **Figure 45**. On the contrary, a workpiece supported on the bowed side will rock during a cut, leading to loss of control.

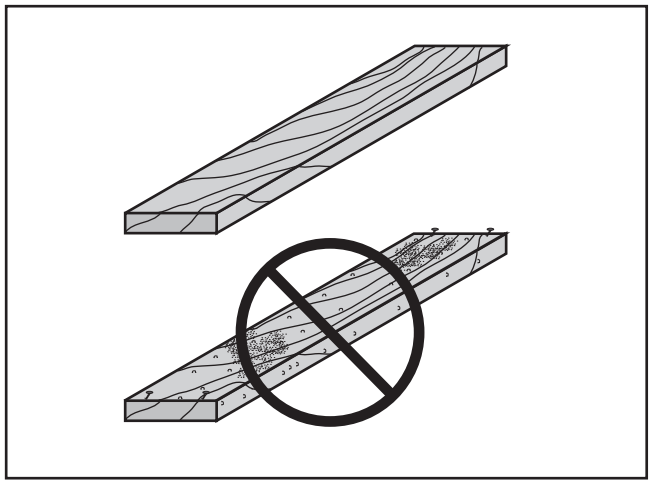


Figure 44. Choosing wood without foreign objects embedded.

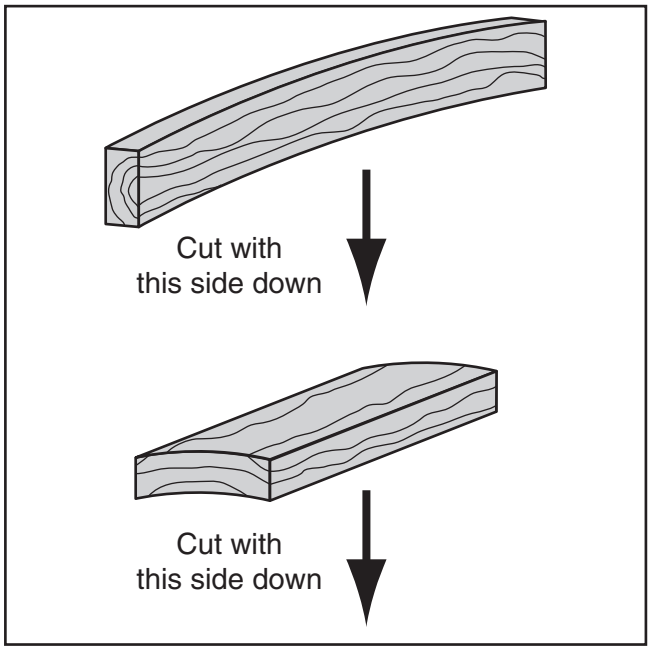


Figure 45. Cutting wood with minor warping.

⚠WARNING

Because of its unpredictable nature, use extreme caution if cutting warped stock. The difference between acceptable and unacceptable warped stock varies from machine to machine. If you are in doubt, square-up the stock first or do not cut it.

Foot Brake

The Model G0636X is equipped with a foot brake (see **Figure 46**). Use the brake only in emergency situations to stop power from going to the motor and bring the blade to a halt.

⚠CAUTION

The foot brake will not stop the bandsaw wheels and blade instantly. DO NOT become over confident and relax your safety awareness because of the foot brake feature.

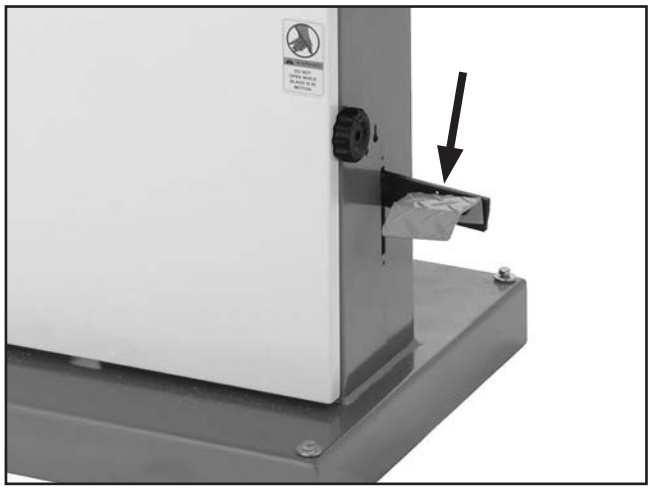
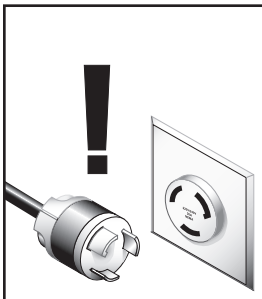


Figure 46. Foot brake location.

Table Tilt



⚠WARNING

Personal injury or death can occur if the bandsaw starts during table adjustment. Disconnect power from the bandsaw before performing table adjustments.

The bandsaw table will tilt 5˚ left and 45˚ right to provide a wide range of cutting options.

To tilt the table:

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the table tilt lock lever shown in **Figure 47**.

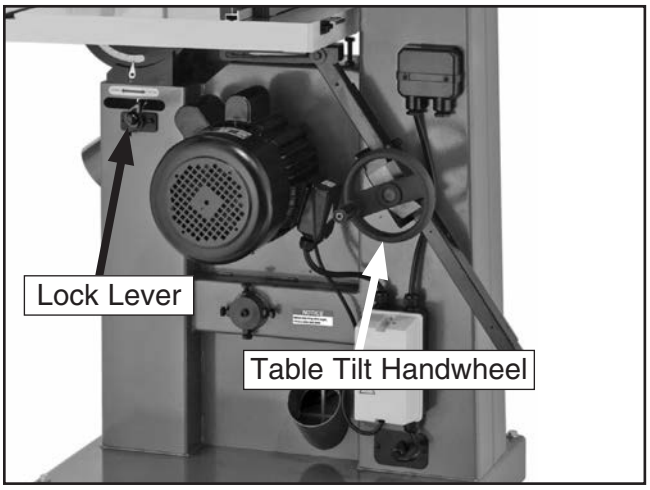


Figure 47. Table tilt controls.

3. To tilt the table to the right, turn the table tilt handwheel clockwise (see **Figure 47**).

4. To tilt the table to the left, turn the table tilt handwheel clockwise one turn, lower the positive stop bolt, then turn the handwheel counterclockwise.

5. Secure the table tilt lock lever.

6. Follow "Positive Stop" instructions on **Page 20** for resetting the stop bolt and table for horizontal (0º) operations.

Guide Post

The guide post, shown in **Figure 48**, connects the upper blade guide assembly to the bandsaw. The guide post allows the blade guide assembly to move up or down via a rack and pinion. 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 best support for the blade.

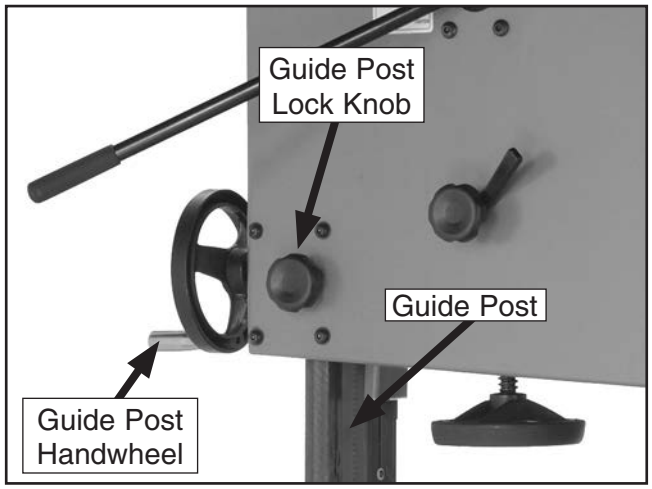


Figure 48. Guide post controls.

To adjust guide post:

1. Make sure that the blade tension, blade tracking, support bearings, and blade guides are adjusted correctly.

2. Loosen the guide post lock knob shown in **Figure 48**.

3. Turn the guide post handwheel to raise or lower the guide post until the upper blade guide assembly is within 1" from the top of the workpiece.

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

Fine Tune Tracking

NOTICE

Adjusting the final blade tracking setting requires the machine to be turned *ON*.

To fine tune the tracking:

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

2. Observe the blade tracking path through the clear window on the right edge of the bandsaw, as shown in **Figure 49**.

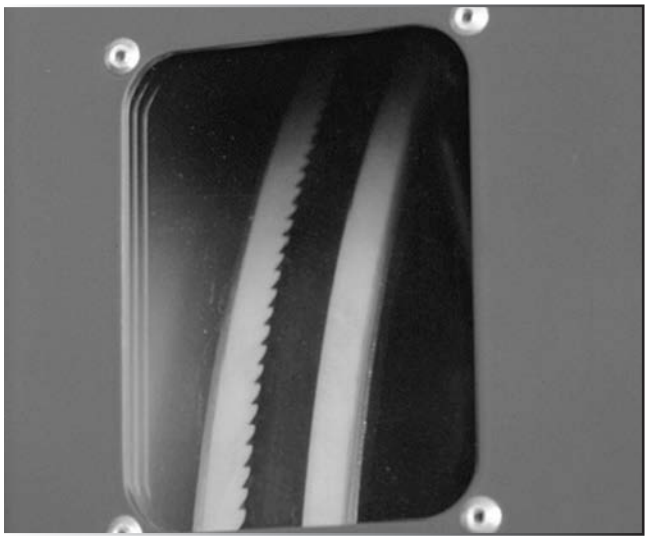


Figure 49. Blade tracking window.

3. Using the tracking controls (**Page 20**, **Figure 16**), adjust the blade so it tracks on the center of the wheel.

4. Tighten the lock lever so the tracking knob cannot move.

Blade Lead

Bandsaw blades commonly wander off the cut line when sawing, as shown in **Figure 50**. This is called blade lead. Blade lead is commonly caused by too fast of a feed rate, a dull or abused blade, or improper tension. If your blade is sharp/undamaged and you still have blade lead, perform the following instructions.

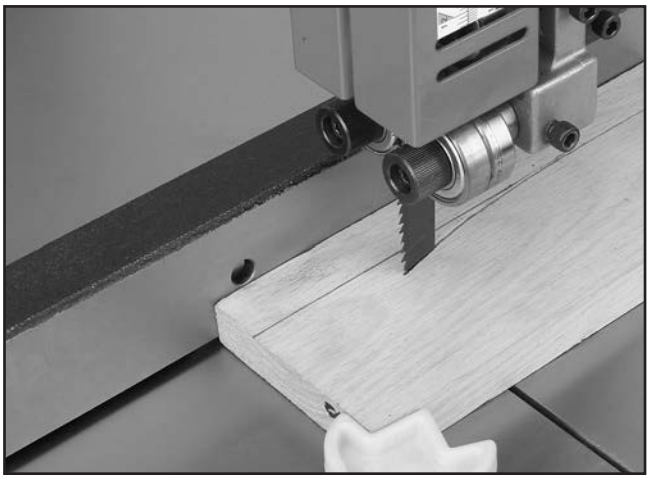


Figure 50. Example of blade leading away from line of cut.

To correct blade lead:

1. Use less pressure when feeding the workpiece through the cut.

2. Check that the miter slot or fence is parallel to the blade line, and correct if necessary (See **Aligning Table, Page 29** and **Aligning Fence, Page 30**).

3. 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 ¾" thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.

2. Slide the bandsaw fence out of the way and cut halfway through the board on the line by pushing it into the blade. 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 two cap screws that secure the fence rail to the underside of the table (see **Page 30**).

5. Skew the fence so it is parallel to the edge of the scrap piece.

6. While maintaining the skew, tighten the cap screws loosened in **Step 4**.

7. Make a few cuts using the fence. If the fence still does not seem parallel to the blade, repeat **Steps 1–6** until the blade and fence are parallel with each other.

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. Turn the bandsaw ***OFF*** and wait for the blade to stop.

4. Using an 8mm hex wrench, loosen the four cap screws that mount the table to the trunnion (**Figure 37**). Shift the table to compensate for the blade lead, then retighten the cap screws.

5. Repeat **Steps 1–4** until the blade cuts straight.

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. For ripping, a wider blade is better. In most ripping applications, a standard raker tooth style will be sufficient.

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece and lock the fence in place.

2. Adjust the blade guide assembly to the correct height.

3. After all safety precautions have been met, turn the bandsaw ***ON***. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 51** shows a typical ripping operation. **Note:** *If you are cutting narrow pieces, use a push stick to protect your fingers.*

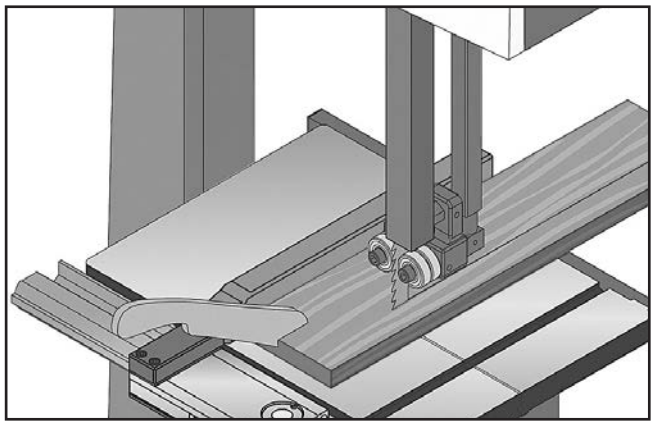


Figure 51. Example of typical ripping operation with a push stick.

⚠WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may slip 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 make a 90˚ crosscut:

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

2. Adjust the blade guide assembly to the correct height and make sure the miter gauge is set to 0°.

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

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

5. After all safety precautions have been met, turn the bandsaw ***ON***. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 52** shows a typical crosscutting operation.

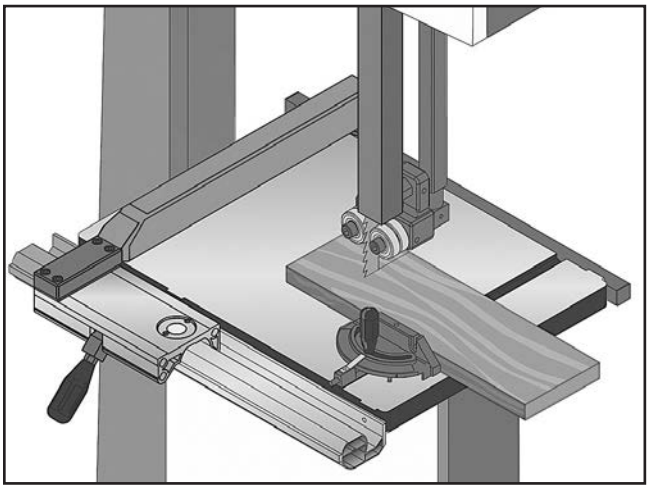


Figure 52. Example of crosscutting operation with miter gauge.

Resawing

Resawing (see **Figure 53**) 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.

One of the most important considerations when resawing is blade selection. Generally, wider blades are better. In most applications, a hook or a skip tooth style will be desirable. Choose blades with fewer teeth-per-inch (from 3 to 6), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.

⚠WARNING

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

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the fence is parallel to the blade.

2. Adjust the upper blade guide so it is about 1" above the workpiece with a minimum amount of blade exposed.

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

NOTICE

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

4. Support the ends of the board if necessary.

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

6. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece (see **Figure 53**).

Figure 53. Example of resawing lumber.

Cutting Curves

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

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

NOTICE

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

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

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together. Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90° (see **Page 20**). Otherwise, any error will be compounded.

To complete a stacked cut:

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

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

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

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

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line, as shown in **Figure 54**.

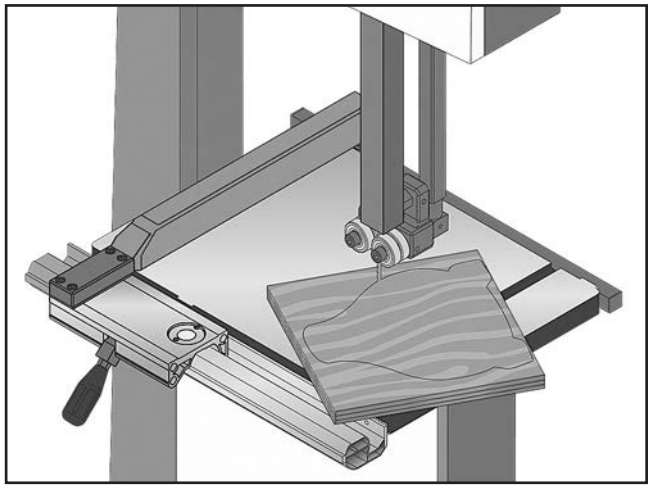


Figure 54. Typical stacked cut.

Blade Information

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0636X is designed for blades that are 160" long. Refer to **Page 43** for blade replacements.

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 G0636X can use blades from 1/8" to 1 3/8" in width. Always pick the size of blade that best suits your application.

- ***Curve Cutting:*** Use the chart in **Figure 55** 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.

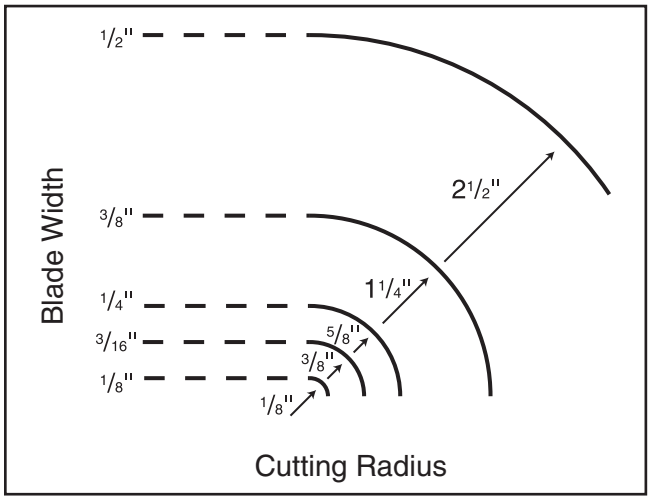


Figure 55. Blade width radii.

- ***Straight Cutting***: Use the largest width blade that you own. 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 56** shows the three main categories of tooth style:

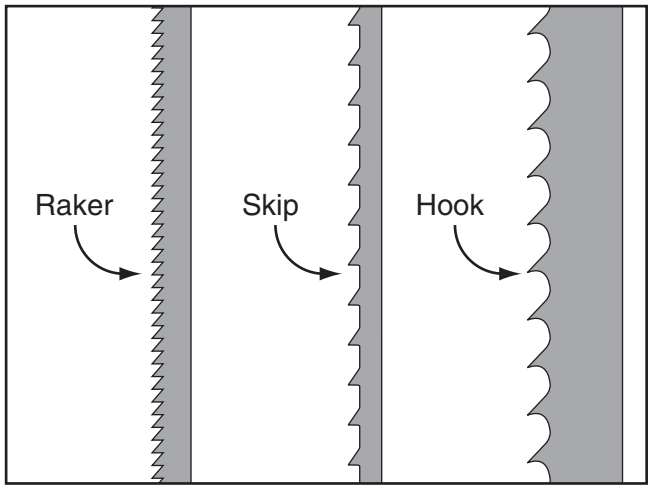


Figure 56. Raker, Skip & Hook tooth styles.

- ***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.

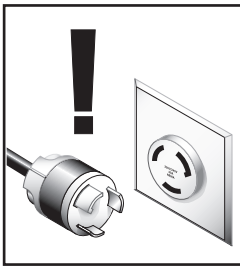
Blade Breakage

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 workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.

Blade Changes



⚠WARNING

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.

⚠CAUTION

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

To remove a blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Release the blade tension.
3. Remove the table insert and the table pin. Adjust the upper and lower guide bearings as far away as possible from the blade.
4. Open the upper and lower wheel covers, and with gloved hands, slide the blade off of both wheels.
5. Slide the blade through the slot in the table.

To replace a blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing forward and 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 (see **Figure 57**).

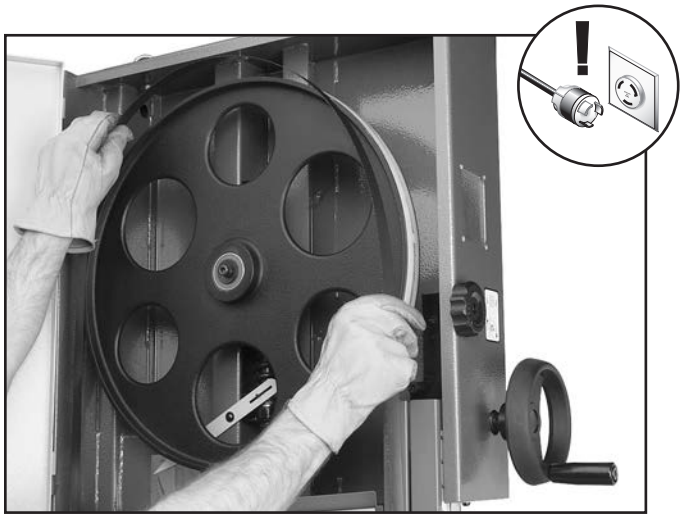


Figure 57. Typical example of placing blade on the wheels.

3. Adjust tension as described on **Page 25**.
4. Adjust tracking if needed (see **Page 19**).
5. Adjust the upper/lower guide bearings and the support bearings (see **Page 25**).
6. Replace the table insert and table pin.
7. Close the wheel covers.

SECTION 5: ACCESSORIES

⚠WARNING

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

NOTICE

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

Replacement Blades

These replacement blades are milled for exact tooth set and are made with high quality tool steel.

160" Carbon Steel Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
H8416	3/16"	4 SKIP
H8417	3/16"	10 RAKER
H8418	3/16"	14 RAKER
H8419	1/4"	4 HOOK
H8420	1/4"	6 HOOK
H8429	1/2"	4 HOOK
H8476	1"	6 HOOK

160" Timber Wolf® Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
T20201	1/4"	4 POS. CLAW
T20202	1/4"	6 POS. CLAW
T20208	3/8"	6 POS. CLAW
T20209	3/8"	10 RAKER
T20211	1/2"	3 POS. CLAW
T20212	1/2"	4 POS. CLAW
T20214	1/2"	10 RAKER
T20215	1/2"	18 RAKER

162" Carbon Steel Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
H4819	3/8"	6 HOOK
H4820	3/8"	10 RAKER
H4821	1/2"	4 HOOK
H4822	1/2"	6 HOOK
H4823	3/4"	3 HOOK
H4824	1"	6 HOOK
H4825	1"	2 HOOK

162" Timber Wolf® Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
H9567	1/2"	3 POS. CLAW
H9568	1/2"	4 POS. CLAW
H9569	1/2"	6 POS. CLAW
H9570	1/2"	10 RAKER
H9571	1"	3 POS. CLAW
H9572	1"	4 POS. CLAW
H9573	1"	10 RAKER
H9574	1 1/4"	3/4" PITCH

D2058A—Heavy-Duty Shop Fox Mobile Base

This patented base is the most stable on the market with outrigger type supports. Adjusts from 18½" x 24½" to 28½" x 33½". 1300 lb. capacity. Weighs 39 lbs.

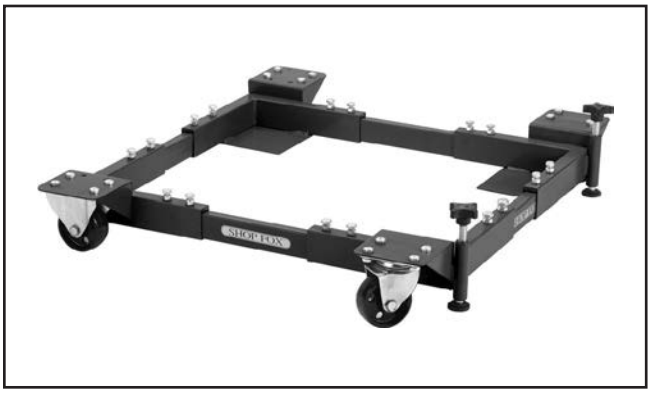


Figure 58. D2058A Shop Fox Mobile Base.

Basic Eye Protection

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20451—"Kirova" Clear Safety Glasses
T20452—"Kirova" Anti-Reflective S. Glasses
T27717—Bifocal Magnifiers 1.5
T27718—Bifocal Magnifiers 2.0
T27719—Bifocal Magnifiers 2.5

Figure 59. Eye protection assortment.

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

Figure 60. Recommended products for protecting unpainted cast iron/steel on machinery.

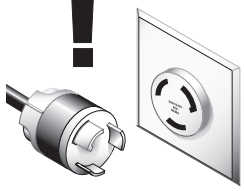
H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 61. Half-mask respirator with disposable cartridge filters.

G0862—3 HP Portable Cyclone Dust Collector
The capstone of our new line of affordable, high-quality cyclones, the G0862 features a 3 HP motor, a whopping 1941 CFM of airflow capacity, and a 55-gallon collection capacity.

Figure 62. Model G0862 3 HP Portable Cyclone Dust Collector.

SECTION 6: MAINTENANCE



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

Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing
To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

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

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

Cleaning & Protecting

Cleaning the Model G0636X/G0636XB is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 44** for more details).

Brushes

The bandsaw is equipped with three lower brushes. The brushes should be checked daily and cleaned when they become dirty. There are adjustment brackets that allow the brushes to be adjusted for bristle wear. Refer to **Adjusting Brushes** on **Page 52** for adjustment 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 a bearing supply store.

Most other moving parts need to be lubricated as needed to maintain smooth function of the bandsaw.

Blade Guide Rack & Pinion

1. DISCONNECT BANDSAW FROM POWER!

2. Lower the blade guide until it reaches the table.

3. Wipe off any existing grease and sawdust buildup on the rack (see **Figure 63**)

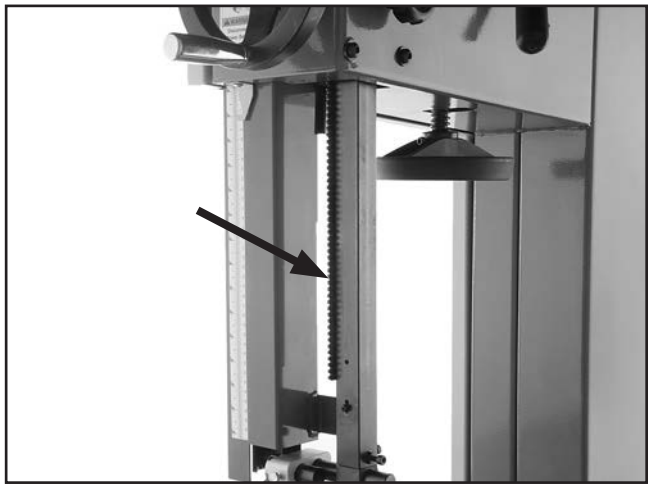


Figure 63. Rack lubrication location.

4. Apply a thin coat of light all-purpose grease to the rack.

5. Move the blade guide up and down several times and remove any excess grease to help prevent sawdust buildup.

Blade Tracking Knob

1. DISCONNECT BANDSAW FROM POWER!

2. Unscrew the blade tracking knob 5 turns.

3. Wipe off any existing grease and sawdust buildup on the threads.

4. Apply a few dabs of a light all-purpose grease to the threads.

5. Re-adjust tracking (see **Blade Tracking** on **Page 19**).

Tension Adjustment Assembly

1. DISCONNECT BANDSAW FROM POWER!

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

3. Wipe off any existing grease and sawdust buildup on the blade tension adjustment assembly and tension lever cam.

4. Apply a thin coat of grease to the tension adjustment assembly and tension lever cam (see **Figure 64**).

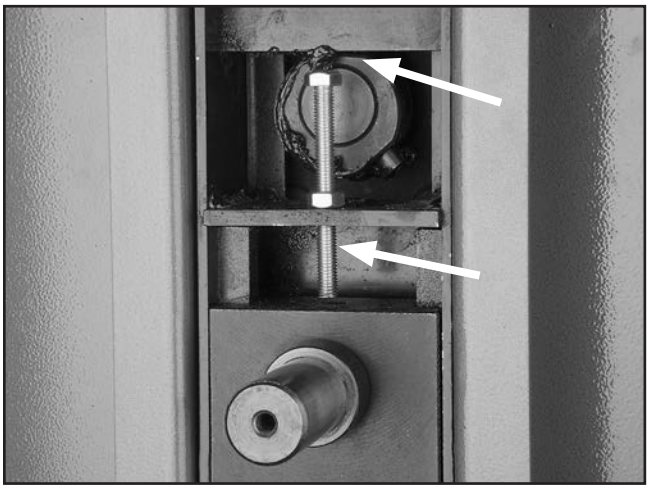


Figure 64. Tension adjustment assembly locations (top wheel removed for clarity).

Table Tilt Rack & Pinion Assembly

1. DISCONNECT BANDSAW FROM POWER!

2. With the table perpendicular to the blade, wipe off all existing grease and sawdust buildup from the rack.

3. Move the table up to its maximum 45˚ angle and wipe (see **Figure 65**) off all existing grease and sawdust buildup from the rack.

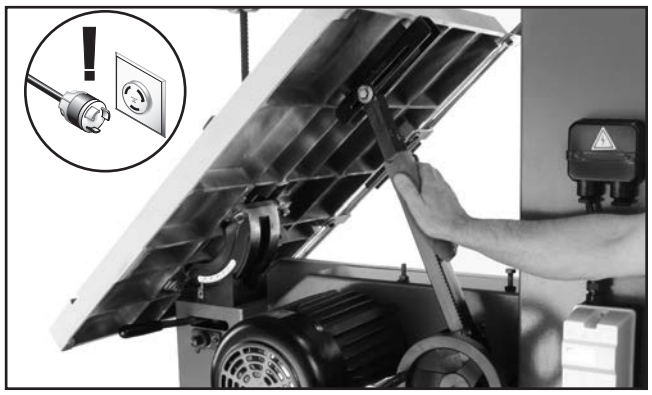


Figure 65. Table tilt rack and pinion assembly.

4. Apply a thin coat of light all-purpose grease to the rack.

5. Move the table up and down several times to distribute the grease, then wipe off any excess grease.

Trunnions

1. DISCONNECT BANDSAW FROM POWER!

2. Move the table up until it reaches its maximum 45˚ angle and wipe off all excess grease and sawdust from the trunnions.

3. Apply a thin coat of light all purpose grease to the trunnions (see **Figure 66**).

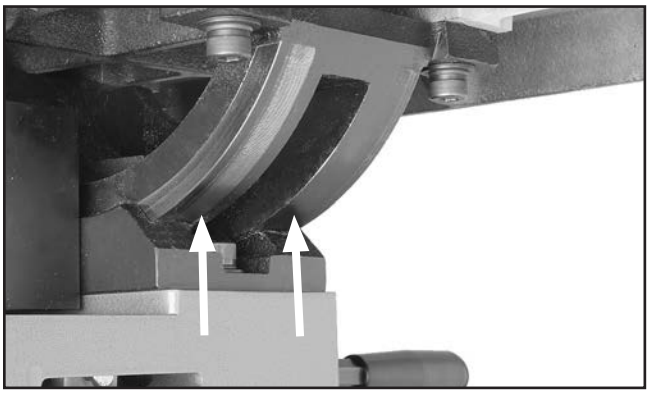


Figure 66. Trunnion lubrication location.

4. Move the table down and then back up to distribute the grease, then wipe off any excess grease from the trunnions.

SECTION 7: SERVICE

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

Troubleshooting

Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Power switch key is turned to "0".	1. Turn power switch key to "1".
	2. Stop/reset button engaged.	2. Rotate clockwise until it pops out/replace.
	3. Plug/receptacle is at fault or wired incorrectly.	3. Test for good contact or correct the wiring.
	4. Motor connection wired incorrectly.	4. Correct motor wiring connections (**Page 60**).
	5. Thermal protection circuit breaker amperage is set too low or motor is at fault.	5. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting. If switch is maxed out, replace motor.
	6. Power supply is at fault/switched OFF.	6. Ensure hot lines have correct voltage on all legs and main power supply is switched ***ON***.
	7. Motor ON/OFF switch is at fault.	7. Replace faulty ON/OFF switch.
	8. Wiring is open/has high resistance.	8. Check for broken wires or corroded/disconnected connections, and repair/replace as necessary.
	9. Start capacitor is at fault.	9. Test/replace if faulty.
	10. Motor is at fault.	10. Repair/replace.
	11. Wheel cover limit switch is not closed, wheel covers are open.	11. Close wheel covers.
	12. Foot brake limit switch is at fault or is pressed down (switch is not closed).	12. Repair/replace limit switch, or stop pressing foot brake.
Machine stalls or is underpowered.	1. Motor run capacitor at fault.	1. Replace run capacitor.
	2. Wrong workpiece material.	2. Use wood with correct moisture content, without glues, and little pitch/resins.
	3. Feed speed too fast for task.	3. Decrease feed speed. See **Basic Cutting Tips** on **Page 33**.
	4. V-belt slipping.	4. Replace bad V-belt, align pulleys, and re-tension (**Page 50 & 51**).
	5. Blade is slipping on wheels.	5. Adjust blade tracking and tension to factory specifications. See **Page 19** or **25**.
	6. Low power supply voltage.	6. Ensure all hot lines have correct voltage on all legs.
	7. Plug/receptacle is at fault.	7. Test for good contacts and correct wiring.
	8. Motor connection is wired incorrectly.	8. Correct motor wiring connections (**Page 60**).
	9. Motor bearings are at fault.	9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	10. Motor has overheated.	10. Let motor cool, clean it off, and reduce workload.
	11. Motor is at fault.	11. Repair/replace.

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation when running.	1. Blade weld hits guides or teeth are broken. 2. Bent or worn out blade. 3. Motor or component is loose. 4. V-belt worn or loose. 5. Motor fan is rubbing on fan cover. 6. Pulley is loose. 7. Machine is incorrectly mounted or sits unevenly on floor. 8. Motor bearings are at fault. 9. Worn arbor bearings. 10. Wheels not coplanar/aligned correctly. 11. Wheels out of balance.	1. Replace blade (**Page 42**). 2. Replace blade (**Page 42**). 3. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 4. Inspect/replace belts with matched set (**Page 51**). 5. Replace dented fan cover and loose/damaged fan. 6. Realign/replace shaft, pulley, setscrew, and key as required. 7. Adjust the feet on the bottom of the stand; relocate machine. 8. Test by rotating shaft—rotational grinding/loose shaft requires bearing replacement. 9. Check/replace arbor bearings. 10. Adjust wheel alignment to coplaner (**Page 52**). 11. Replace wheels.
Machine takes more than five seconds to stop.	1. Space between magnetic brake and motor too large.	1. Adjust space between the magnetic brake and brake shoe (**Page 57**).

Cutting Operations

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	1. Feeding workpiece too fast. 2. Blade is dull.	1. Reduce feed rate. See **Basic Cutting Tips** on **Page 33**. 2. Replace blade (**Page 42**).
Ticking sound when the saw is running.	1. Blade weld contacting support bearing. 2. Blade weld may be failing.	1. Use file or stone to smooth and round the back of the blade. 2. Inspect and replace blade if necessary (**Page 42**).
Blade contacting table insert.	1. Excessive side pressure when cutting. 2. Table improperly adjusted.	1. Reduce side pressure. 2. Adjust table (**Page 29**).
Vibration when cutting.	1. Loose or damaged blade. 2. Blade is tracking incorrectly. 3. Blade tension is loose.	1. Tighten or replace blade. See **Page 42 or 25.** 2. Fix blade tracking (**Page 19**). 3. Fix blade tension (**Page 25**).
Burn marks on the edge of the cut.	1. Too much side pressure when feeding workpiece. 2. Blade too wide for size of radius being cut.	1. Feed workpiece straight into the blade. See **Basic Cutting Tips** on **Page 33**. 2. Install a smaller width blade/increase blade tension. See **Page 25 or 42**.
Rough or poor quality cuts.	1. Feeding workpiece too fast. 2. Tracking and tension incorrect.	1. Reduce feed rate. See **Basic Cutting Tips** on **Page 33**. 2. Fix tracking and tension (see **Page 19** and **25**).
Sawdust buildup inside cabinet.	1. Clogged dust port. 2. Low CFM (airflow) from dust collection system.	1. Clean out dust port. 2. Three options: —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a stronger dust collector.
Blade wanders or won't follow line of cut.	1. Blade lead.	1. Refer to Blade Lead on **Page 37**.

Checking and Tensioning V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition and operate under proper tension. The belts 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.

Tools Needed:	**Qty**
Ruler	1
Hex Wrench 6mm	1
Wrench 17mm	1

To check the V-belts:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Note the condition of the V-belts. If the V-belts are cracked, frayed, or glazed; they should be replaced.
4. Push the center of the V-belts. Note the amount of deflection (see **Figure 67**). If deflection is more than ¾", tension the V-belt.

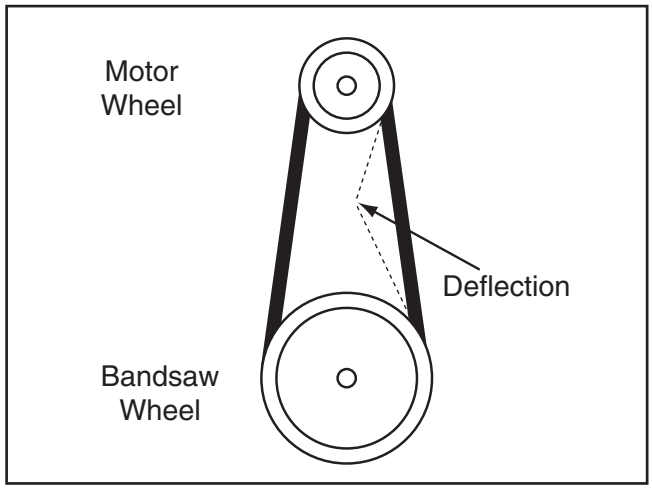


Figure 67. V-belt deflection.

To tension the V-belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Loosen the motor adjustment bolts shown in **Figure 68**.

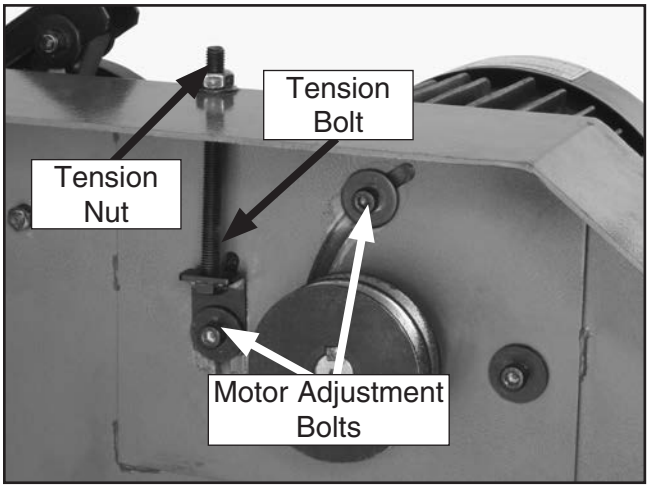


Figure 68. Motor mount bolts and tension bolt.

4. Adjust the belt tension:

   —If the belt is too loose, turn the tension nut clockwise to tighten the belts.

   —If the belt is too tight, turn the tension nut counterclockwise to loosen the belts

5. Push the center of the V-belt. If deflection is approximately ¾" with moderate pressure, then the tension is correct. If the deflection is more than ¾", repeat **Step 4**.
6. When the V-belt tension is correct, tighten the motor adjustment bolts, and close the wheel covers.

Replacing V-Belts

Tools Needed: **Qty**
Hex Wrench 6mm 1
Wrench 13mm 1

To replace the V-belts:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the wheel covers and remove the bandsaw blade (see **Page 42**).

3. Loosen the motor adjustment bolts and tension nut shown in **Figure 68**, then turn the tension bolt counterclockwise.

4. Unthread the wheel cap screw shown in **Figure 69** and slide the lower wheel off of the bearing shaft.

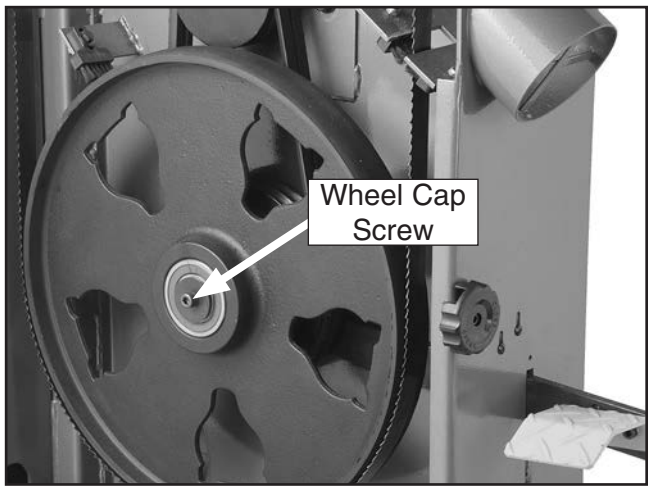


Figure 69. Wheel cap screw for removing the wheel.

5. Slip the old V-belts off of the pulleys and install the new V-belt set in their place.

6. Install the lower wheel back onto the bearing shaft, tighten the wheel mount cap screw, and tension the V-belt (see **Page 50**).

7. Close the lower wheel cover.

Adjusting Tension Lever

The tension lever has an adjustment screw that allows you to adjust how much tension is released when the lever is used.

Tools Needed: **Qty**
Wrench 13mm 1

To adjust the tension lever:

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the adjustment screw 5–10 turns.

3. Move the tension lever to the tightened position and tension the blade.

4. Turn the adjustment screw shown in **Figure 70** until the gap between the screw and the wheel shaft hinge is 1/16"– 3/16".

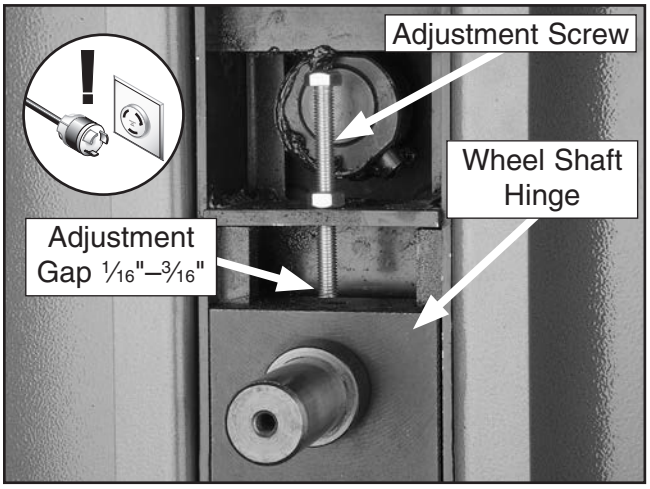


Figure 70. Tension lever adjustment components (top wheel removed for clarity).

5. Engage the tension lever and test the blade tension.

6. Repeat **Steps 1–5** until the tension lever adds the right amount of tension to the blade when it is engaged.

Adjusting Wheel and Blade Brushes

The lower wheel compartment contains the brushes shown in **Figure 71**. These brushes are designed to sweep sawdust off the wheel tire and blade as the bandsaw is operating. In order to work properly, the brushes must be making contact with the wheel and blade.

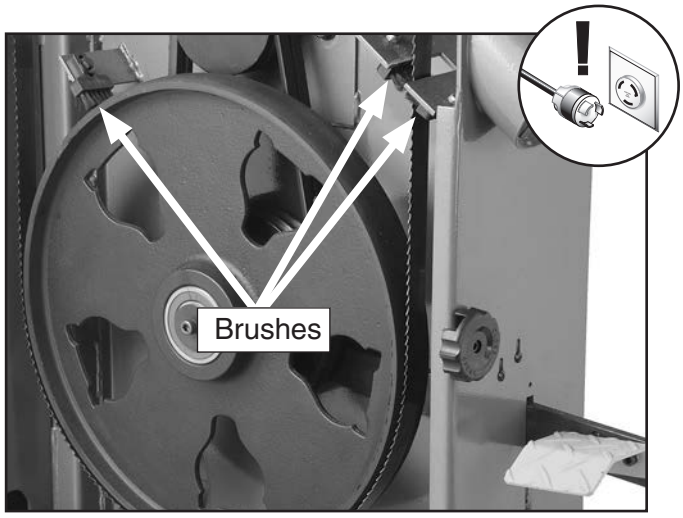


Figure 71. The wheel brush.

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

To adjust the brushes:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Loosen the bolt/nut that secures each brush in place.
4. Adjust each brush so it makes good contact with the wheel or blade—without bendng the bristles.
5. Tighten the bolt/nuts to secure each brush in place.

Wheel Alignment

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

Tools Needed:
Wrench 17mm..... 1
Tape Measure..... 1
Coplanarity Gauge (see **Figure 72**) 1

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

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

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

To check if your wheels are coplanar (Checking coplanarity):

1. Make the "Coplanarity Gauge" shown in **Figure 72** on **Page 53**.

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

2. Remove the fence and open both wheel covers.
3. Adjust the blade guides away from the blade, loosen blade tension, remove the table insert and pin, and remove the blade.
4. Remove the four trunnion cap screws and the table.
5. Reinstall the blade (**Page 42**), making sure the guide bearings and support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.

6. Place your coplanarity gauge up against both wheels in the positions shown in **Figure 73**.

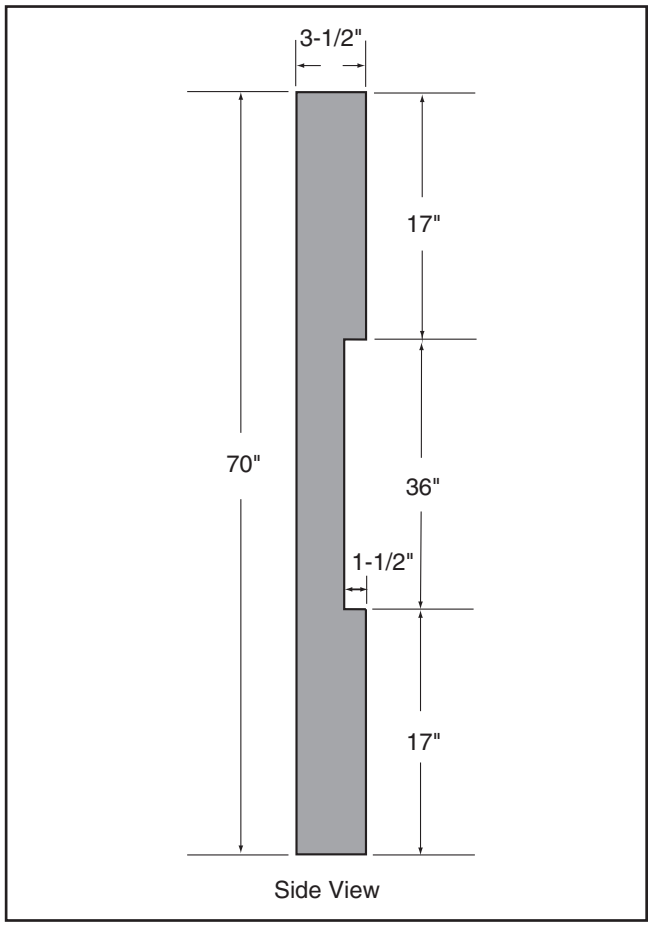


Figure 72. Dimensions of coplanarity gauge.

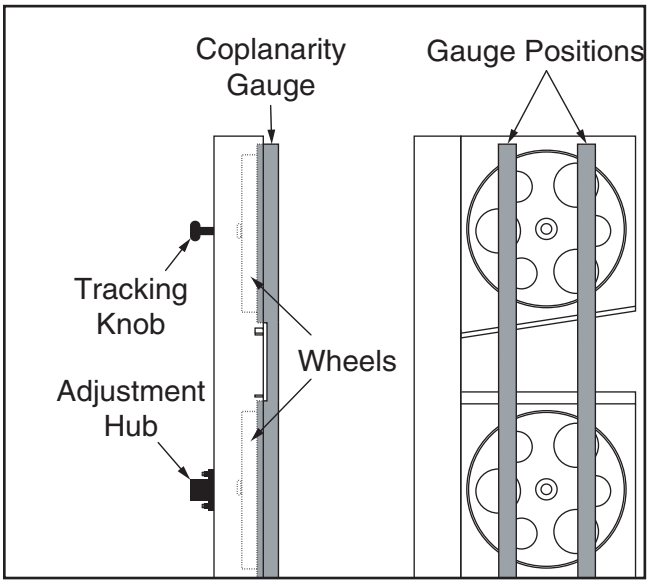


Figure 73. Checking for coplanarity.

7. 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 (see **Figure 74**) so they line up.

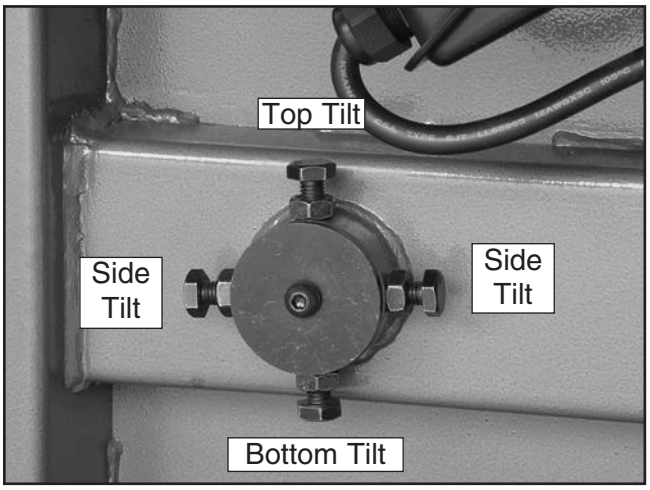


Figure 74. Lower wheel adjustment control.

8. If the wheels will go parallel but not coplanar, shim the upper wheel out as needed using thin ¾" washers on the shaft behind the wheel.

9. **Figure 75** shows the positions of the wheels when coplanar. When your wheels are coplanar, reinstall the table, table insert, and pin, readjust the guide blocks and rear support bearings, and close the wheel covers.

10. Finally, check table and fence alignment (see **Pages 29 & 30**).

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.*

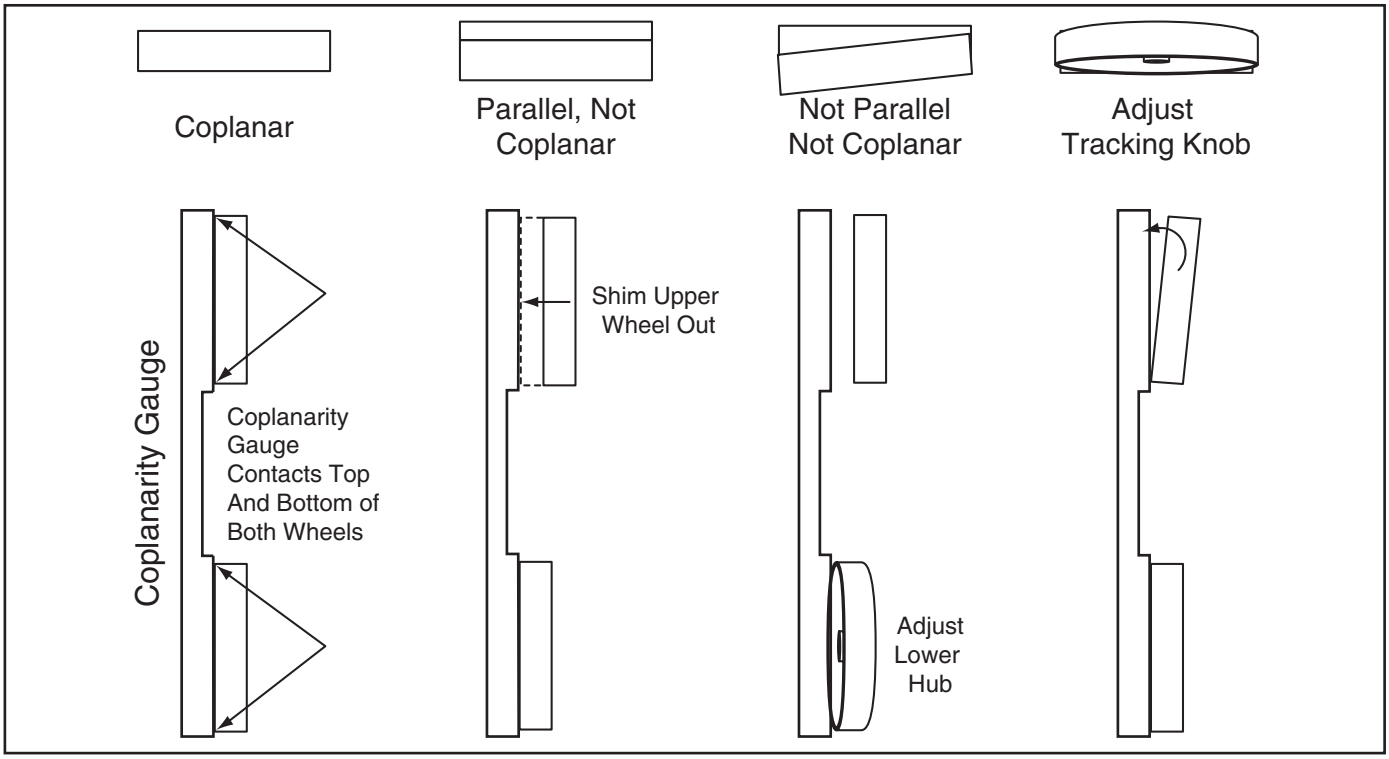


Figure 75. Coplanarity diagram.

Adjusting Guide Post Travel

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

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

To check if the guide post is parallel side-to-side with the blade:

1. DISCONNECT BANDSAW FROM POWER!

2. Tighten the blade to the tension that will be used during operation.

3. Loosen the guide post lock knob, raise the guide post, then place a machinist's square on the table next to the side of the blade as illustrated in **Figure 76**.

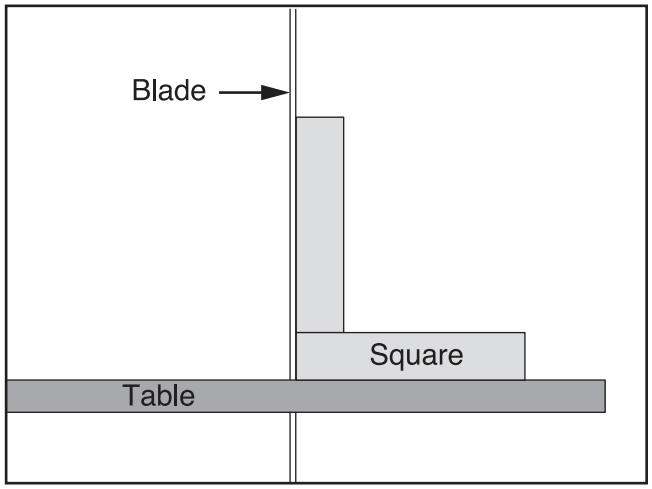


Figure 76. Squaring table to blade.

4. Adjust the table square with the blade using the table tilt handwheel, then secure it with the table tilt lock lever.

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

6. Place a machinist's square on the table next to the right hand side of the guide post, as shown in **Figure 77**.

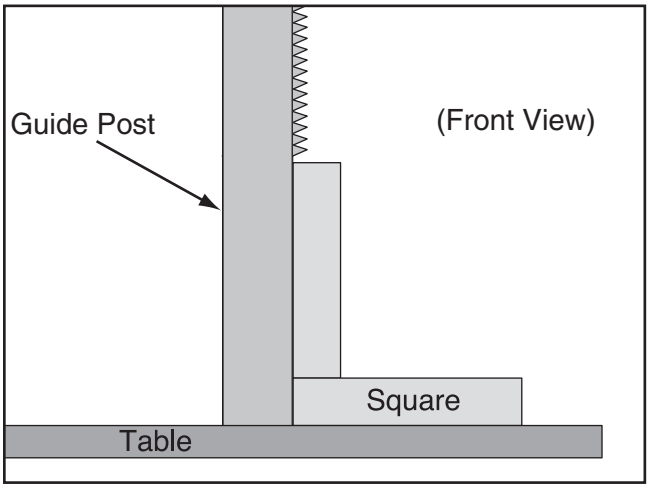


Figure 77. Example of checking guide post squareness.

—If there is no gap between the square and the guide post along its full length, no adjustments need to be made. Proceed to "To check if the guide post is parallel with the blade front-to-back."

—If there is a gap between the square and the guide post, the guide post is not parallel to the blade. Go to **Step 7**.

7. Loosen each of the four screws shown in **Figure 78** ¼ turn**.**

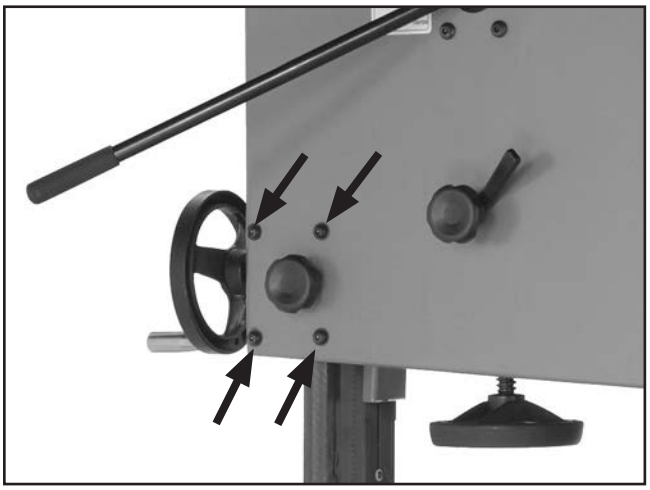


Figure 78. Guide post adjustment screws.

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

9. Tighten the screws shown in **Figure 78**.

To check if the guide post is parallel with the blade front-to-back:

1. DISCONNECT BANDSAW FROM POWER!

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

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

4. Measure the distance "A" between the top front face of the guide post rack and the back of the blade (see **Figure 79**).

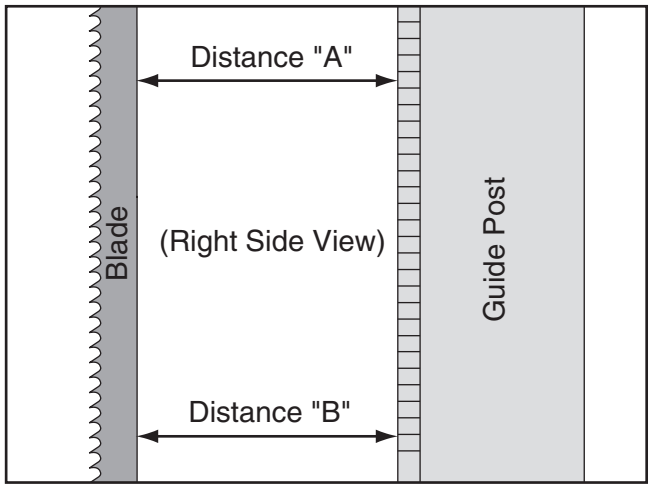


Figure 79. Example of measuring distance between rack and blade at top of guide post.

5. Measure the distance "B" between the bottom front face of the guide post rack and the back of the blade (see **Figure 79**).

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

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

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

7. Loosen the four screws shown in **Figure 78** enough to fit metal shims between the frame and the guide post bracket (see **Figure 80**).

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

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

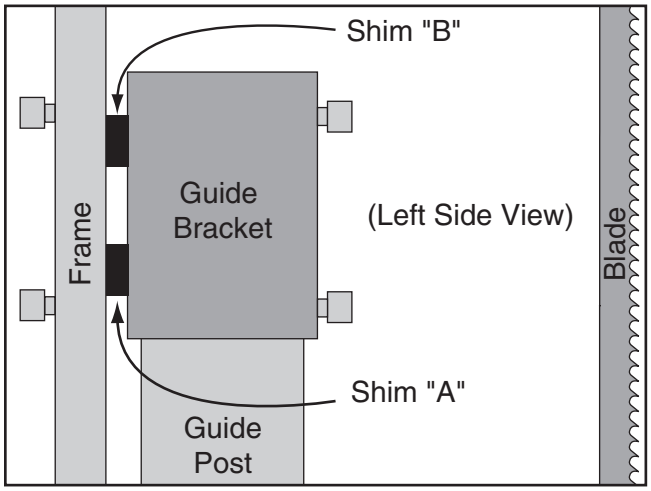


Figure 80. Location for placing shims.

8. Tighten the four screws shown in **Figure 78**, then repeat **Steps 4**–**5**.

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

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

9. Reinstall the guide post guard with the screws removed in **Step 3**.

Magnetic Brake Adjustment (G0636XB)

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

Tools Needed

Phillips Head Screwdriver..... 1
US Dollar Bills or 0.008" Feeler Gauges..... 2
Hex Wrench 3mm..... 1
Hex Wrench 4mm..... 1

To adjust the space between the magnetic brake and brake shoe:

1. DISCONNECT BANDSAW FROM POWER!

2. Remove the motor fan cover, then loosen the cap screws securing the motor fan and brake shoe (see **Figure 81**).

3. Fold two dollar bills in half and slide them (or feeler gauges) between the brake shoe and magnetic brake on both sides (see **Figure 81**).

4. Slide the fan toward the brake until you feel a slight resistance when moving the bill, then tighten the cap screws on the brake shoe and motor fan, and reinstall the motor fan cover.

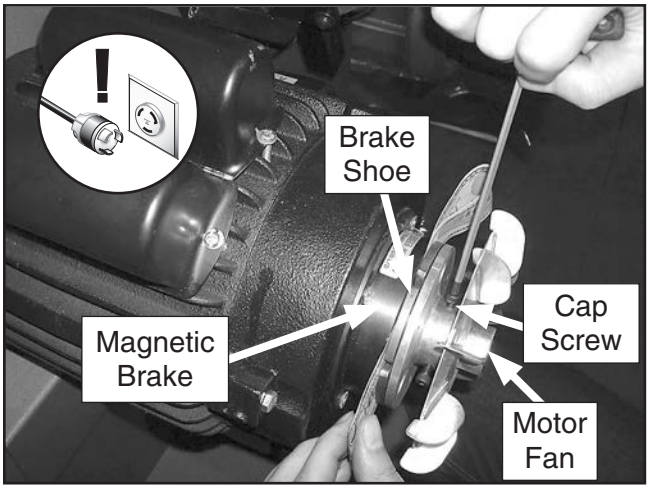


Figure 81. Adjusting distance between magnetic brake and brake shoe.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

COLOR KEY

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

G0636X Electrical Components

Figure 82. Power supply wiring.

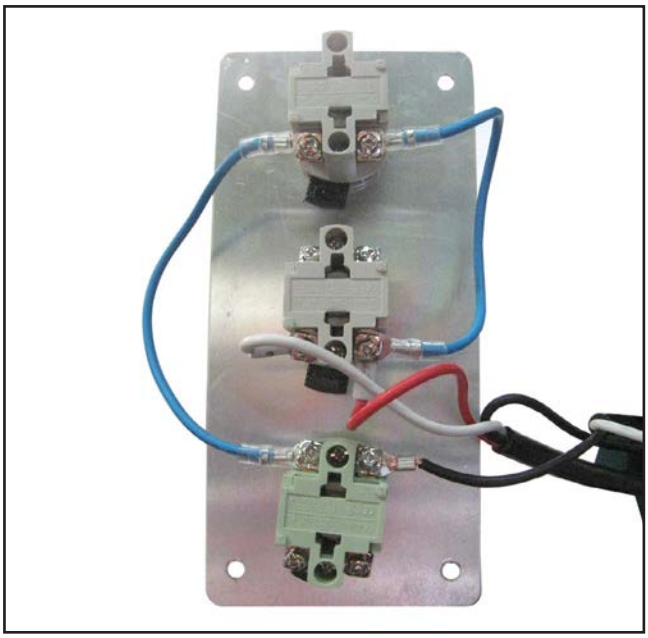


Figure 83. G0636X control panel wiring.

Figure 84. Wheel cover limit switch (left) and foot brake switch (right).

Figure 85. G0636X motor wiring.

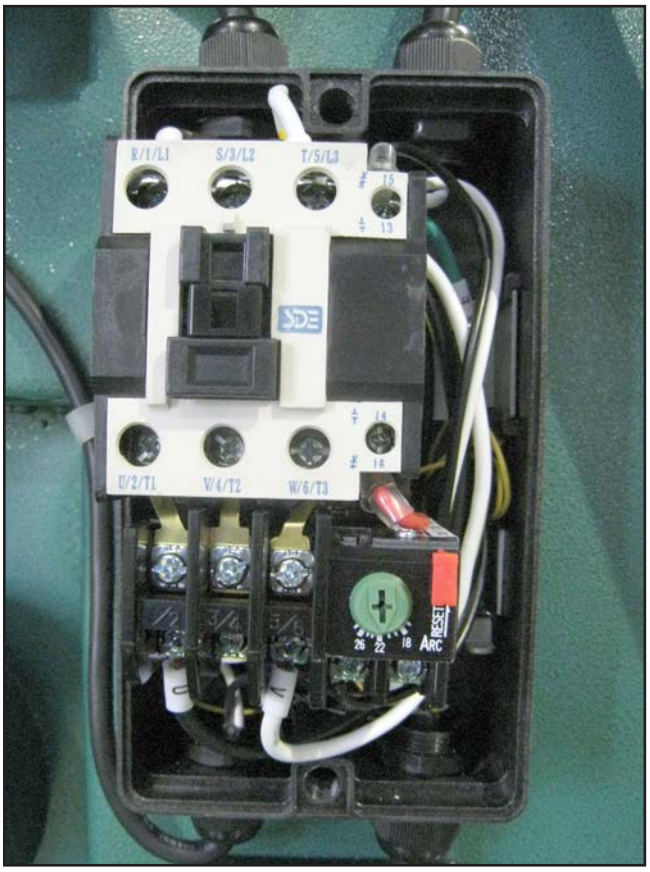
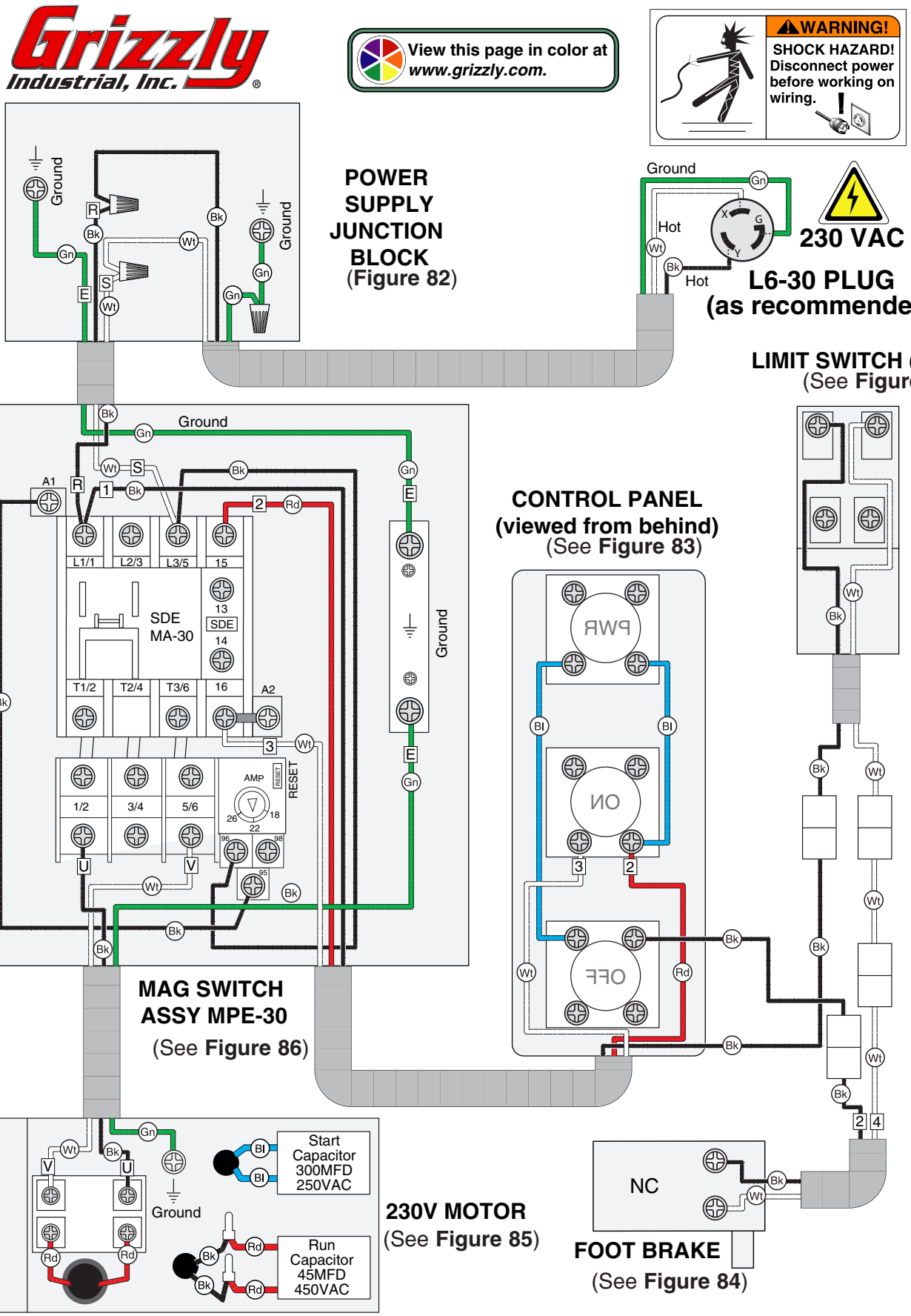


Figure 86. G0636X magnetic switch.

STOP *READ ELECTRICAL SAFETY ON PAGE 58!*

G0636X Wiring Diagram



READ ELECTRICAL SAFETY ON PAGE 58!

G0636XB Electrical Components

Figure 87. Power supply wiring.

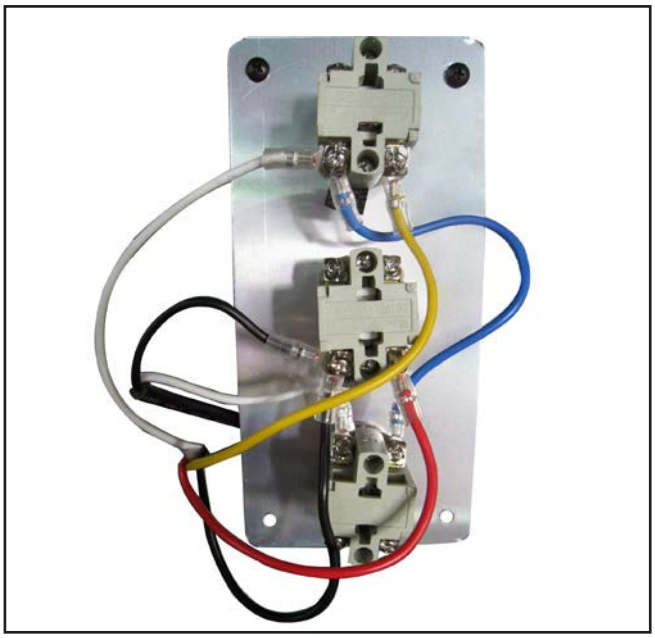


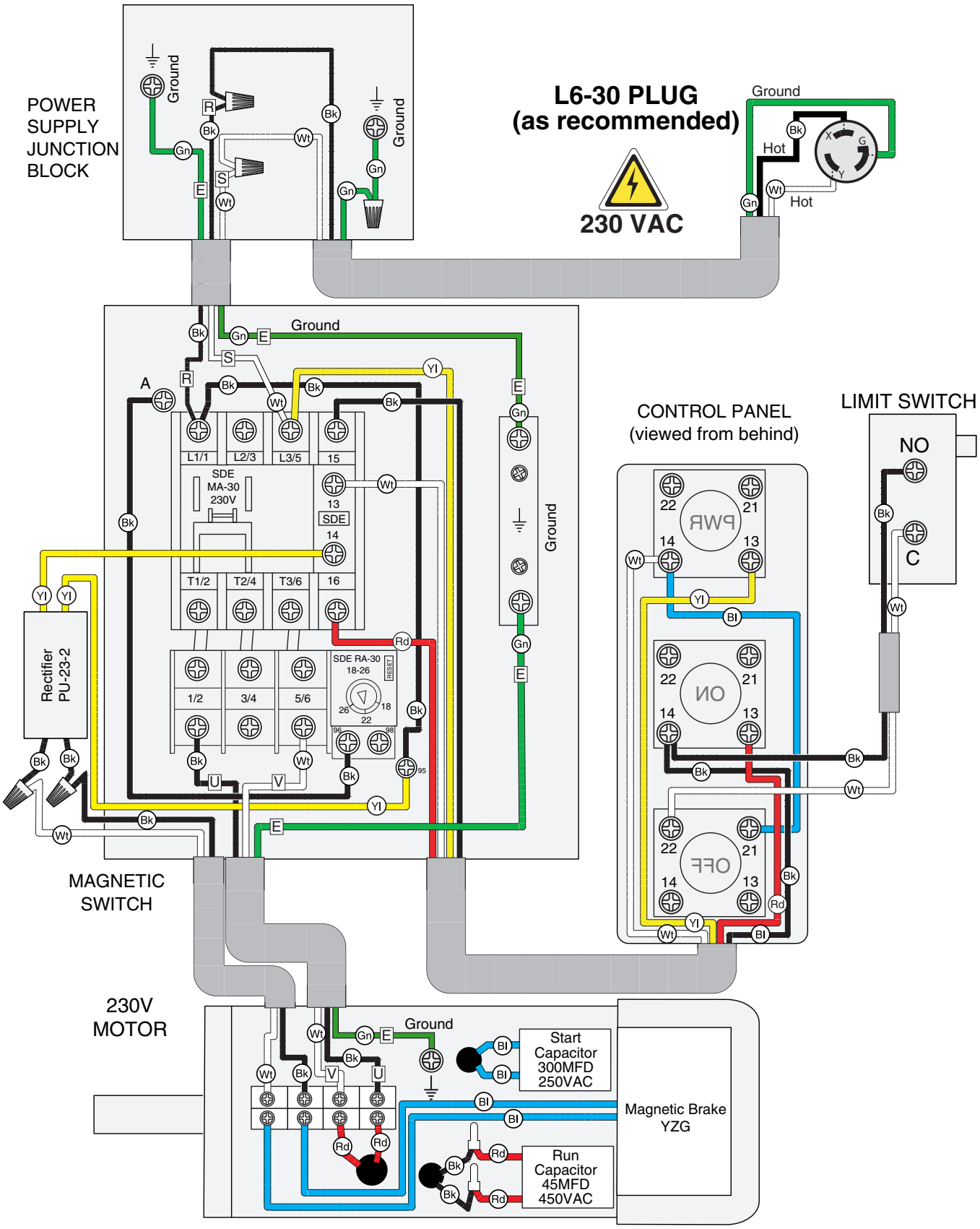
Figure 88. Control panel wiring.

Figure 89. Wheel cover limit switch.

Figure 90. Motor wiring.

Figure 91. Magnetic switch.

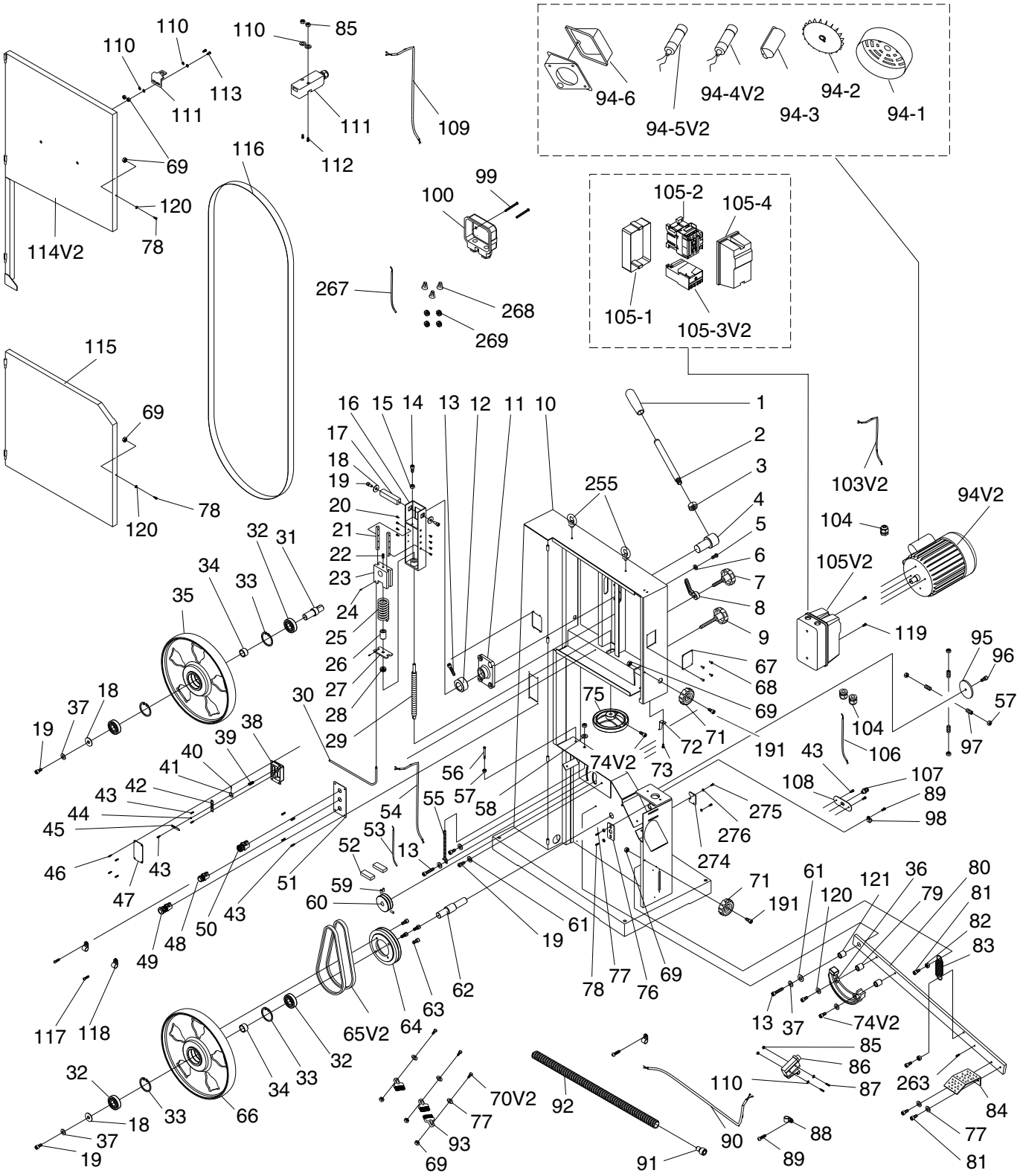
G0636XB Wiring Diagram



READ ELECTRICAL SAFETY ON PAGE 58!

SECTION 9: PARTS

G0636X Main



G0636X Main Parts List

REF	PART #	DESCRIPTION
1	P0636X001	HANDLE
2	P0636X002	LEVER ROD M16-2
3	P0636X003	HEX NUT M16-2
4	P0636X004	ROTATE SHAFT
5	P0636X005	BUTTON HD CAP SCR M10-1.5 X 20
6	P0636X006	LOCK WASHER 10MM
7	P0636X007	BLADE TRACKING KNOB M10-1.5 x 25
8	P0636X008	BLADE TRACKING LOCK LEVER 10MM
9	P0636X009	GUIDE POST LOCK KNOB M10-1.5 X 25
10	P0636X010	MACHINE BODY
11	P0636X011	PILLOW BLOCK
12	P0636X012	CAM
13	P0636X013	CAP SCREW M8-1.25 X 25
14	P0636X014	HEX BOLT M8-1.25 X 80
15	P0636X015	HEX NUT M8-1.25
16	P0636X016	UPPER WHEEL HINGE
17	P0636X017	SQUARE SHAFT
18	P0636X018	SQUARE SHAFT WASHER 8MM
19	P0636X019	CAP SCREW M8-1.25 X 20
20	P0636X020	FLAT HD SCR M5-.8 X 16
21	P0636X021	LOCATE PLATE
22	P0636X022	SET SCREW M10-1.5 X 16
23	P0636X023	GUIDE BLOCK
24	P0636X024	SET SCREW M5-.8 X 5
25	P0636X025	COMPRESSION SPRING
26	P0636X026	BUSHING
27	P0636X027	PRESS BLOCK
28	P0636X028	THRUST BEARING 51201
29	P0636X029	BLADE TENSION SHAFT
30	P0636X030	TENSION LINE
31	P0636X031	UPPER WHEEL SHAFT
32	P0636X032	BALL BEARING 6306ZZ
33	P0636X033	INT RETAINING RING 72MM
34	P0636X034	BUSHING
35	P0636X035	UPPER WHEEL
36	P0636X036	BRAKE PAD
37	P0636X037	LOCK WASHER 8MM
38	P0636X038	UPPER WHEEL SLIDING BRACKET
39	P0636X039	COMPRESSION SPRING
40	P0636X040	GUIDE PIN 3 X 12
41	P0636X041	MOVING PLATE
42	P0636X042	FIXED PLATE
43	P0636X043	TAP SCREW M4 X 10
44	P0636X044	FLAT WASHER 4MM
45	P0636X045	TENSION POINTER
46	P0636X046	TAP SCREW M4 X 16
47	P0636X047	TENSION SCALE
48	P0636X048	START SWITCH
49	P0636X049	STOP SWITCH
50	P0636X050	KEY SWITCH
51	P0636X051	SWITCH PLATE
52	P0636X052	CONNECTING BLOCK
53	P0636X053	CONNECTING CORD
54	P0636X054	SWITCH CORD
55	P0636X055	ADJUST BOLT
56	P0636X056	HEX BOLT M10-1.5 X 50
57	P0636X057	HEX NUT M10-1.5

REF	PART #	DESCRIPTION
58	P0636X058	FLAT WASHER 10MM
59	P0636X059	SET SCREW M6-1 X 12
60	P0636X060	MOTOR PULLEY
61	P0636X061	FLAT WASHER 8MM
62	P0636X062	LOWER WHEEL SHAFT
63	P0636X063	BUTTON HD CAP SCR M8-1.25 X 20
64	P0636X064	WHEEL PULLEY
65V2	P0636X065V2	V-BELT 17-380
66	P0636X066	LOWER WHEEL
67	P0636X067	TRACKING WINDOW
68	P0636X068	RIVET 3.2 X 10
69	P0636X069	LOCK NUT M6-1
70V2	P0636X070	HEX BOLT M6-1 X 25
71	P0636X071	KNOB
72	P0636X072	HEIGHT POINTER
73	P0636X073	FLANGE SCREW M5-.8 X 10
74V2	P0636X074V2	CAP SCREW M6-1 X 30
75	P0636X075	BLADE TENSION HANDWHEEL
76	P0636X076	LOWER WHEEL SUPPORT
77	P0636X077	FLAT WASHER 6MM
78	P0636X078	FLANGE SCREW M6-1 X 10
79	P0636X079	BUSHING
80	P0636X080	BRAKE LEVER
81	P0636X081	CAP SCREW M6-1 X 16
82	P0636X082	HEX NUT M6-1
83	P0636X083	EXTENSION SPRING
84	P0636X084	BRAKE STEP PLATE
85	P0636X085	HEX NUT M4-.7
86	P0636X086	LIMIT SWITCH KL7141
87	P0636X087	PHLP HD SCR M4-.7 X 30
88	P0636X088	CORD CLAMP 5/8"
89	P0636X089	TAP SCREW M4 X 8
90	P0636X090	BRAKE LEVER CORD
91	P0636X091	CORD BUSHING
92	P0636X092	PROTECT TUBE 1/2" X 43-5/16"
93	P0636X093	BRUSH
94V2	P0636X094V2	MOTOR 5HP V2.06.08
94-1	P0636X094-1	MOTOR COVER
94-2	P0636X094-2	MOTOR FAN
94-3	P0636X094-3	CAPACITOR COVER
94-4V2	P0636X094-4V2	S CAPACITOR 300M 250V 1-3/4 x 4 V2.06.08
94-5V2	P0636X094-5V2	R CAPACITOR 45M 450V 2 x 3-1/2 V2.06.08
94-6	P0636X094-6	JUNCTION BOX
95	P0636X095	ADJUSTMENT HUB COVER
96	P0636X096	BUTTON HD CAP SCR M8-1.25 X 20
97	P0636X097	SET BOLT M10-1.5 X 30
98	P0636X098	CORD CLAMP 1/2"
99	P0636X099	FLANGE SCREW M5-.8 X 50
100	P0636X100	TERMINAL BOX
103V2	P0636X103V2	POWER CORD 12G 3W V2.11.10
104	P0636X104	STRAIN RELIEF M20
105V2	P0636X105V2	MAGNETIC SWITCH MPE-30 V2.11.10
105-1	P0636X105-1	MAG SWITCH BACK COVER
105-2	P0636X105-2	CONTACTOR SDE MA-30
105-3V2	P0636X105-3V2	OL RELAY SDE RA-30 18-26A V2.11.10
105-4	P0636X105-4	MAG SWITCH FRONT COVER

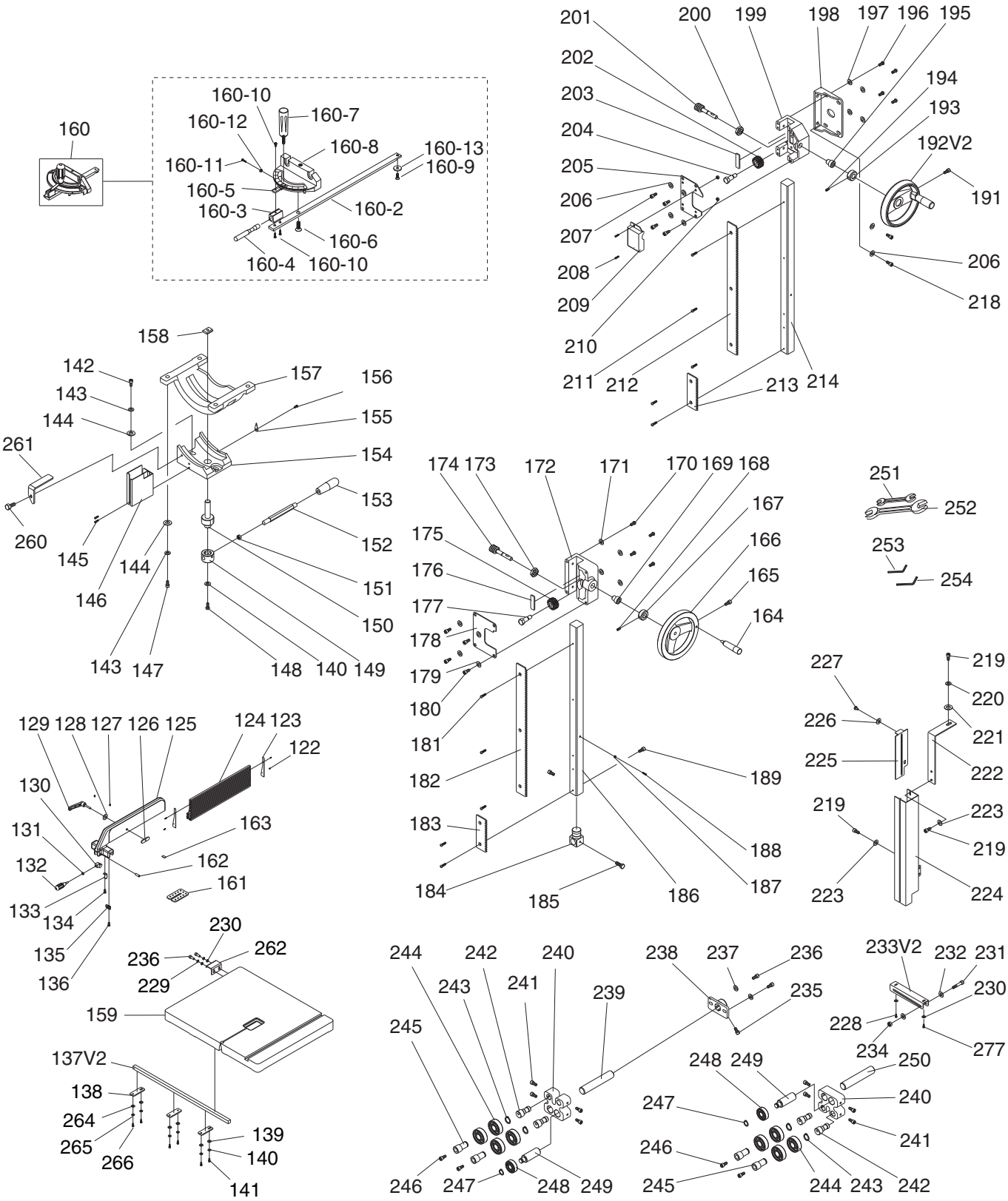
G0636X Main Parts List

REF	PART #	DESCRIPTION
106	P0636X106	MOTOR CORD
107	P0636X107	STRAIN RELIEF M20
108	P0636X108	PLATE
109	P0636X109	SWITCH CORD 18G 2W
110	P0636X110	FLAT WASHER 4MM
111	P0636X111	DOOR LATCH SWITCH ASM ADZ-S11
112	P0636X112	FLANGE SCREW M4-.7 X 35
113	P0636X113	PHLP HD SCR M4-.7 X 10
114V2	P0636X114V2	UPPER WHEEL COVER V2.06.08
115	P0636X115	LOWER WHEEL COVER
116	P0636X116	SAW BLADE 3TPI 162" X 1" X 0.035
117	P0636X117	TAP SCREW M4 X 10
118	P0636X118	CORD CLAMP 5/16"

REF	PART #	DESCRIPTION
119	P0636X119	FLANGE SCREW M5-.8 X 10
120	P0636X120	LOCK WASHER 6MM
121	P0636X121	BUSHING
191	P0636X191	CAP SCREW M6-1 X 25
255	P0636X255	EYE BOLT M10-1.5- X 15
263	P0636X263	NYLON SET SCREW M7 X 10
267	P0636X267	CONNECTING CORD 12G 3C
268	P0636X268	WIRE NUT P3
269	P0636X269	EXT TOOTH WASHER 5MM
274	P0636X274	STOP PLATE
275	P0636X275	CAP SCREW M5-.8 X 12
276	P0636X276	FLAT WASHER 5MM

Please Note: *We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call* ***(800) 523-4777*** *or visit our online parts store at* ***www.grizzly.com*** *to check for availability.*

G0636X Fence/Guides/Trunnion



G0636X Fence/Guides/Trunnion Parts List

REF	PART #	DESCRIPTION
122	P0636X122	TAP SCREW 3.5 X 8
123	P0636X123	FENCE PIECE 148 X 22 X 1
124V2	P0636X124V2	RESAW FENCE AL 590MM V2.04.17
125	P0636X125	FENCE
126	P0636X126	MOVING PLATE
127	P0636X127	PLASTIC SET SCREW
128	P0636X128	FLAT WASHER 8MM
129	P0636X129	LOCK KNOB M8-1.25 X 44
130	P0636X130	PIVOT BLOCK
131	P0636X131	HEX NUT M8-1.25
132	P0636X132	FENCE HANDLE M8-1.25 X 20
133	P0636X133	SPRING PIECE
134	P0636X134	FLANGE SCREW M4-.7 X 8
135	P0636X135	POINTER
136	P0636X136	FLANGE SCREW M5-.8 X 8
137V2	P0636X137V2	GUARD RAIL SQUARE V2.09.11
138	P0636X138	GUARD RAIL PLATE
139	P0636X139	FLAT WASHER 8MM
140	P0636X140	LOCK WASHER 8MM
141	P0636X141	CAP SCREW M8-1.25 X 20
142	P0636X142	CAP SCREW M10-1.5 X 30
143	P0636X143	LOCK WASHER 10MM
144	P0636X144	FLAT WASHER 10MM
145	P0636X145	FLANGE SCREW M6-1 X 10
146	P0636X146	BLADE GUARD
147	P0636X147	CAP SCREW M10-1.5 X 35
148	P0636X148	HEX BOLT M8-1.25 X 20
149	P0636X149	MICRO ADJUSTING RING
150	P0636X150	PRESS SHAFT
151	P0636X151	HEX NUT M12-1.75
152	P0636X152	HANDLE SHAFT
153	P0636X153	HANDLE KNOB M12-1.75 FEMALE
154	P0636X154	TRUNNION HOUSING
155	P0636X155	POINTER
156	P0636X156	PHLP HD SCR M4-.7 X 10
157	P0636X157	TRUNNION BLOCK
158	P0636X158	PRESS BLOCK
159	P0636X159	TABLE
160	P0636X160	MITER GAUGE ASSEMBLY
160-2	P0636X160-2	GUIDE BAR
160-3	P0636X160-3	LOCKING BRACKET
160-4	P0636X160-4	LOCKING SHAFT
160-5	P0636X160-5	POINTER
160-6	P0636X160-6	STEP SCREW
160-7	P0636X160-7	HANDLE 5/16-18 X 1-1/2
160-8	P0636X160-8	MITER GAUGE BODY
160-9	P0636X160-9	FLAT HD SCR M6-1 X 6
160-10	P0636X160-10	PHLP HD SCR 10-24 X 3/8
160-11	P0636X160-11	PHLP HD SCR M4-.7 X 16
160-12	P0636X160-12	HEX NUT M4-.7
160-13	P0636X160-13	FLAT WASHER 8MM
161	P0636X161	TABLE INSERT
162	P0636X162	SHAFT
163	P0636X163	NYLON PIECE
164	P0636X164	HANDLE 3/8-16 X 1/2
165	P0636X165	CAP SCREW M6-1 X 25

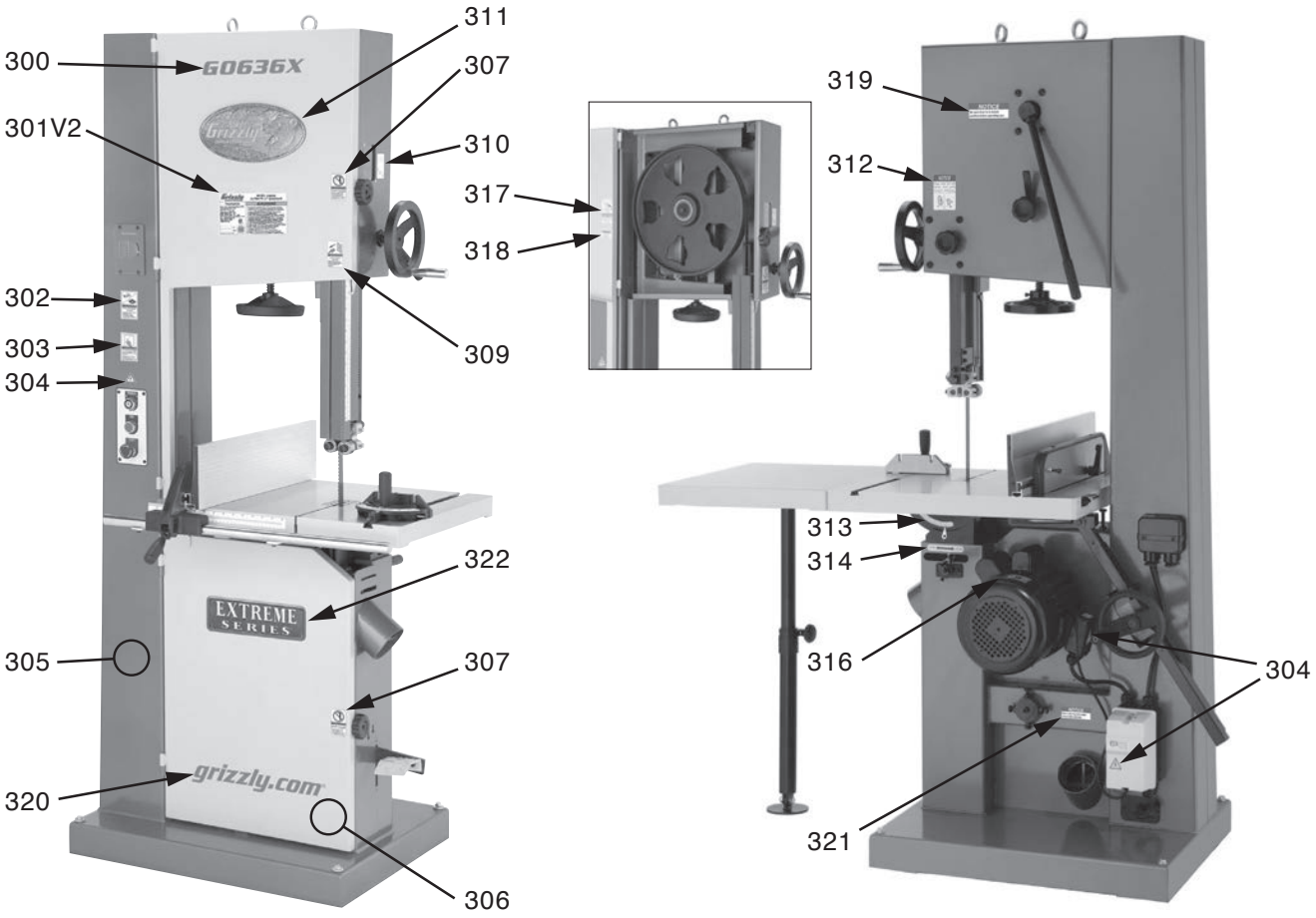
REF	PART #	DESCRIPTION
167	P0636X167	LOCK COLLAR
166	P0636X166	HANDWHEEL
168	P0636X168	SET SCREW M5-.8 X 5
169	P0636X169	BUSHING
170	P0636X170	BUTTON HD CAP SCR M8-1.25 X 35
171	P0636X171	FLAT WASHER 8MM
172	P0636X172	UPPER GUIDE BRACKET
173	P0636X173	HEX NUT M16-1.5
174	P0636X174	WORM SHAFT
175	P0636X175	WORM GEAR
176	P0636X176	FIXED PLATE
177	P0636X177	FIXED BOLT
178	P0636X178	UPPER GUIDE BRACKET COVER
179	P0636X179	LOCK WASHER 8MM
180	P0636X180	CAP SCREW M8-1.25 X 16
181	P0636X181	FLAT HD SCR M4-.7 X 10
182	P0636X182	RACK
183	P0636X183	EXTENSION RACK
184	P0636X184	UPPER GUIDE SUPPORT BLOCK
185	P0636X185	HEX BOLT M6-1 X 10
186	P0636X186	UPPER GUIDE BAR
187	P0636X187	HEX NUT M4-.7
188	P0636X188	PHLP HD SCR M4-.7 X 10
189	P0636X189	CAP SCREW M6-1 X 16
191	P0636X191	CAP SCREW M6-1 X 25
192V2	P0636X192V2	HANDWHEEL W/HANDLE V2.06.08
193	P0636X193	LOCK COLLAR
194	P0636X194	SET SCREW M5-.8 X 5
195	P0636X195	BUSHING
196	P0636X196	BUTTON HD CAP SCR M8-1.25 X 20
197	P0636X197	FLAT WASHER 8MM
198	P0636X198	TRUNNION PLATE
199	P0636X199	TABLE TILT GUIDE BRACKET
200	P0636X200	HEX NUT M16-1.5
201	P0636X201	WORM CYLINDER
202	P0636X202	WORM GEAR
203	P0636X203	FIXED PLATE
204	P0636X204	FIXED BOLT
205	P0636X205	TABLE TILT GUIDE BRACKET COVER
206	P0636X206	LOCK WASHER 8MM
207	P0636X207	CAP SCREW M8-1.25 X 16
208	P0636X208	FLANGE SCREW M5-.8 X 10
209	P0636X209	COVER
210	P0636X210	HEX NUT M5-.8
211	P0636X211	FLAT HD SCR M4-.7 X 10
212	P0636X212	RACK
213	P0636X213	EXTENSION RACK
214	P0636X214	SQUARE TUBE
218	P0636X218	CAP SCREW M8-1.25 X 20
219	P0636X219	CAP SCREW M6-1 X 10
220	P0636X220	LOCK WASHER 6MM
221	P0636X221	FLAT WASHER 6MM
222	P0636X222	SUPPORT PLATE
224	P0636X224	PROTECT COVER ASM
225	P0636X225	SLIDING PLATE
226	P0636X226	FIBER WASHER 13MM

G0636X Fence/Guides/Trunnion Parts List

REF	PART #	DESCRIPTION
227	P0636X227	SHOULDER SCREW
228	P0636X228	CAP SCREW M6-1 X 10
229	P0636X229	LOCK WASHER 6MM
230	P0636X230	FLAT WASHER 6MM
231	P0636X231	CAP SCREW M8-1.25 X 55
232	P0636X232	FLAT WASHER 8MM
233V2	P0636X233V2	SLIDING PLATE V2.11.11
234	P0636X234	LOCK NUT M8-1.25
235	P0636X235	HEX BOLT M6-1 X 16
236	P0636X236	CAP SCREW M6-1 X 16
237	P0636X237	FLAT WASHER 6MM
238	P0636X238	LOWER SUPPORT BRACKET
239	P0636X239	SHAFT
240	P0636X240	BLADE GUIDE SUPPORT
241	P0636X241	HEX BOLT M6-1 X 16
242	P0636X242	ECCENTRIC SHAFT
243	P0636X243	EXT RETAINING RING 15MM
244	P0636X244	BALL BEARING 6202ZZ

REF	PART #	DESCRIPTION
245	P0636X245	HANDLE BUSHING
246	P0636X246	CAP SCREW M6-1 X 40
247	P0636X247	EXT RETAINING RING 12MM
248	P0636X248	BALL BEARING 6201ZZ
249	P0636X249	SPACING SLEEVE
250	P0636X250	SHAFT
251	P0636X251	WRENCH 10 X 13
252	P0636X252	WRENCH 17 X 19
253	P0636X253	HEX WRENCH 5MM
254	P0636X254	HEX WRENCH 6MM
260	P0636X260	FLANGE SCREW M6-1 X 12
261	P0636X261	L-HOLDER PLATE
262	P0636X262	STOP BRACKET
264	P0636X264	FLAT WASHER 6MM
265	P0636X265	LOCK WASHER 6MM
266	P0636X266	CAP SCREW M6-1 X 20
277	P0636X277	CAP SCREW M6-1 X 12

G0636X Labels



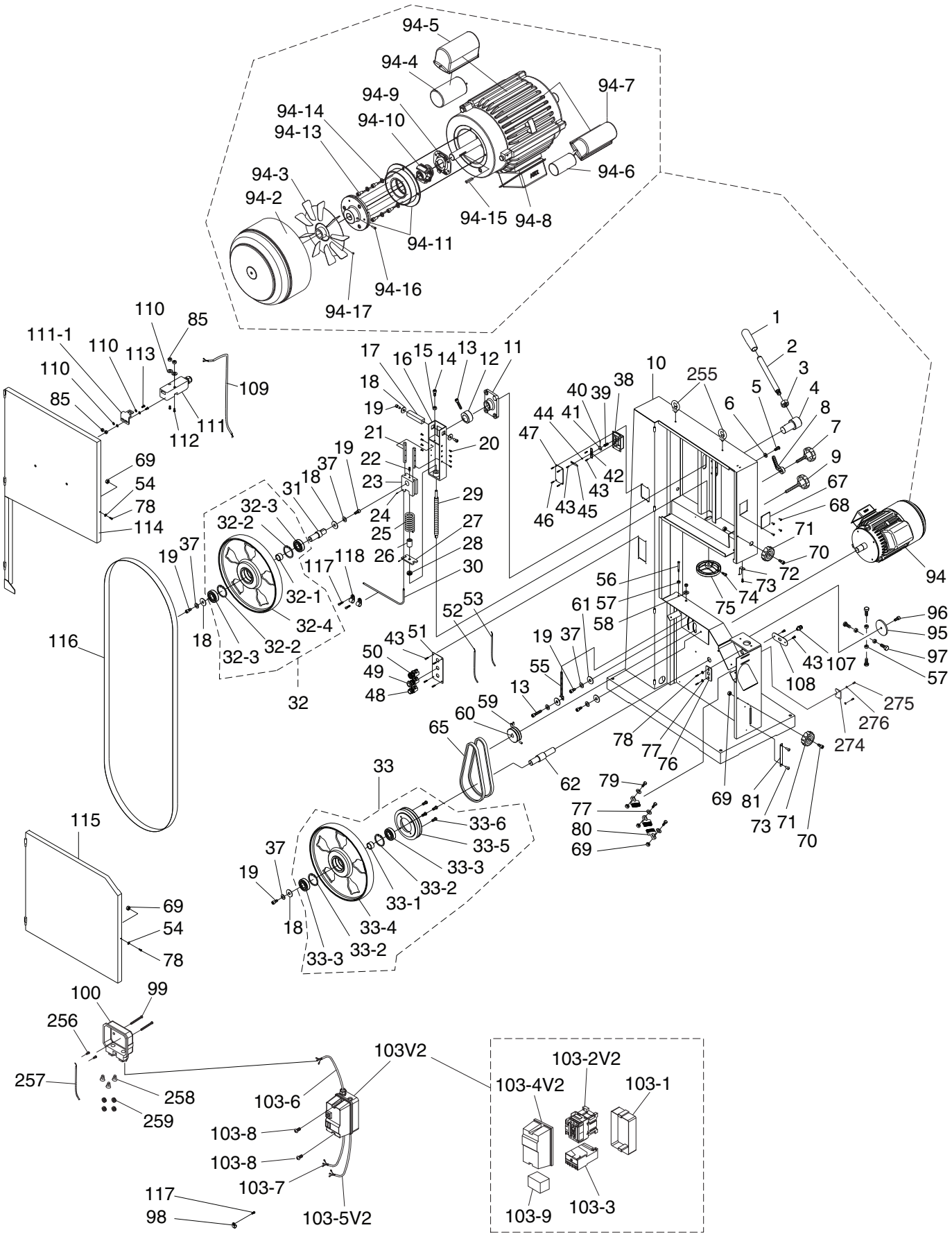
REF	PART #	DESCRIPTION
300	P0636X300	MODEL NUMBER LABEL
301V2	P0636X301V2	MACHINE ID LABEL V2.07.19
302	P0636X302	SAFETY GLASSES LABEL
303	P0636X303	READ MANUAL LABEL
304	P0636X304	ELECTRICITY LABEL
305	P0636X305	TOUCH UP PAINT, GRIZZLY GREEN
306	P0636X306	TOUCH UP PAINT, GREY PUTTY
307	P0636X307	DONT OPEN LABEL
309	P0636X309	UNPLUG BANDSAW LABEL
310	P0636X310	BLADE ASSEMBLY DIRECTION LABEL
311	P0636X311	GRIZZLY NAMEPLATE-LARGE

REF	PART #	DESCRIPTION
312	P0636X312	TENSION ADJ LABEL
313	P0636X313	TABLE ANGLE SCALE
314	P0636X314	TABLE LOCK LEVER LABEL
316	P0636X316	MOTOR LABEL
317	P0636X317	UPPER WHEEL HINGE/STOP LABEL
318	P0636X318	PATENT LABEL
319	P0636X319	LOCK LEVER LABEL
320	P0636X320	GRIZZLY.COM
321	P0636X321	HANDWHEEL LOCK LEVER LABEL
322	P0636X322	EXTREME SERIES PLATE

⚠WARNING

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

G0636XB Main



G0636XB Main Parts List

REF	PART #	DESCRIPTION
1	P0636XB001	HANDLE
2	P0636XB002	LEVER ROD M16-2
3	P0636XB003	HEX NUT M16-2
4	P0636XB004	ROTATE SHAFT
5	P0636XB005	BUTTON HD CAP SCR M10-1.5 X 20
6	P0636XB006	LOCK WASHER 10MM
7	P0636XB007	BLD TRACKING KNOB M10-1.5 x 25
8	P0636XB008	BLD TRACKING LOCK LEVER 10MM
9	P0636XB009	GD POST LOCK KNOB M10-1.5 X 25
10	P0636XB010	MACHINE BODY
11	P0636XB011	PILLOW BLOCK
12	P0636XB012	CAM
13	P0636XB013	CAP SCREW M8-1.25 X 25
14	P0636XB014	HEX BOLT M8-1.25 X 60
15	P0636XB015	HEX NUT M8-1.25
16	P0636XB016	UPPER WHEEL HINGE
17	P0636XB017	SQUARE SHAFT
18	P0636XB018	SQUARE SHAFT WASHER 8MM
19	P0636XB019	CAP SCREW M8-1.25 X 25
20	P0636XB020	FLAT HD SCR M5-.8 X 16
21	P0636XB021	LOCATE PLATE
22	P0636XB022	SET SCREW M10-1.5 X 16
23	P0636XB023	GUIDE BLOCK
24	P0636XB024	SET SCREW M5-.8 X 5
25	P0636XB025	COMPRESSION SPRING
26	P0636XB026	BUSHING
27	P0636XB027	PRESS BLOCK
28	P0636XB028	THRUST BEARING 51201
29	P0636XB029	BLADE TENSION SHAFT
30	P0636XB030	TENSION LINE
31	P0636XB031	UPPER WHEEL SHAFT
32	P0636XB032	UPPER WHEEL ASSEMBLY
32-1	P0636XB032-1	BUSHING
32-2	P0636XB032-2	INT RETAINING RING 72MM
32-3	P0636XB032-3	BALL BEARING 6306ZZ
32-4	P0636XB032-4	LOWER WHEEL
33	P0636XB033	LOWER WHEEL ASSEMBLY
33-1	P0636XB033-1	BUSHING
33-2	P0636XB033-2	INT RETAINING RING 72MM
33-3	P0636XB033-3	BALL BEARING 6306ZZ
33-4	P0636XB033-4	LOWER WHEEL
33-5	P0636XB033-5	WHEEL PULLEY
33-6	P0636XB033-6	BUTTON HD CAP SCR M8-1.25 X 20
37	P0636XB037	LOCK WASHER 8MM
38	P0636XB038	UPPER WHEEL SLIDING BRACKET
39	P0636XB039	COMPRESSION SPRING
40	P0636XB040	GUIDE PIN 3 X 12
41	P0636XB041	MOVING PLATE
42	P0636XB042	FIXED PLATE
43	P0636XB043	TAP SCREW M4 X 10
44	P0636XB044	FLAT WASHER 4MM
45	P0636XB045	TENSION POINTER
46	P0636XB046	TAP SCREW M4 X 16
47	P0636XB047	TENSION SCALE

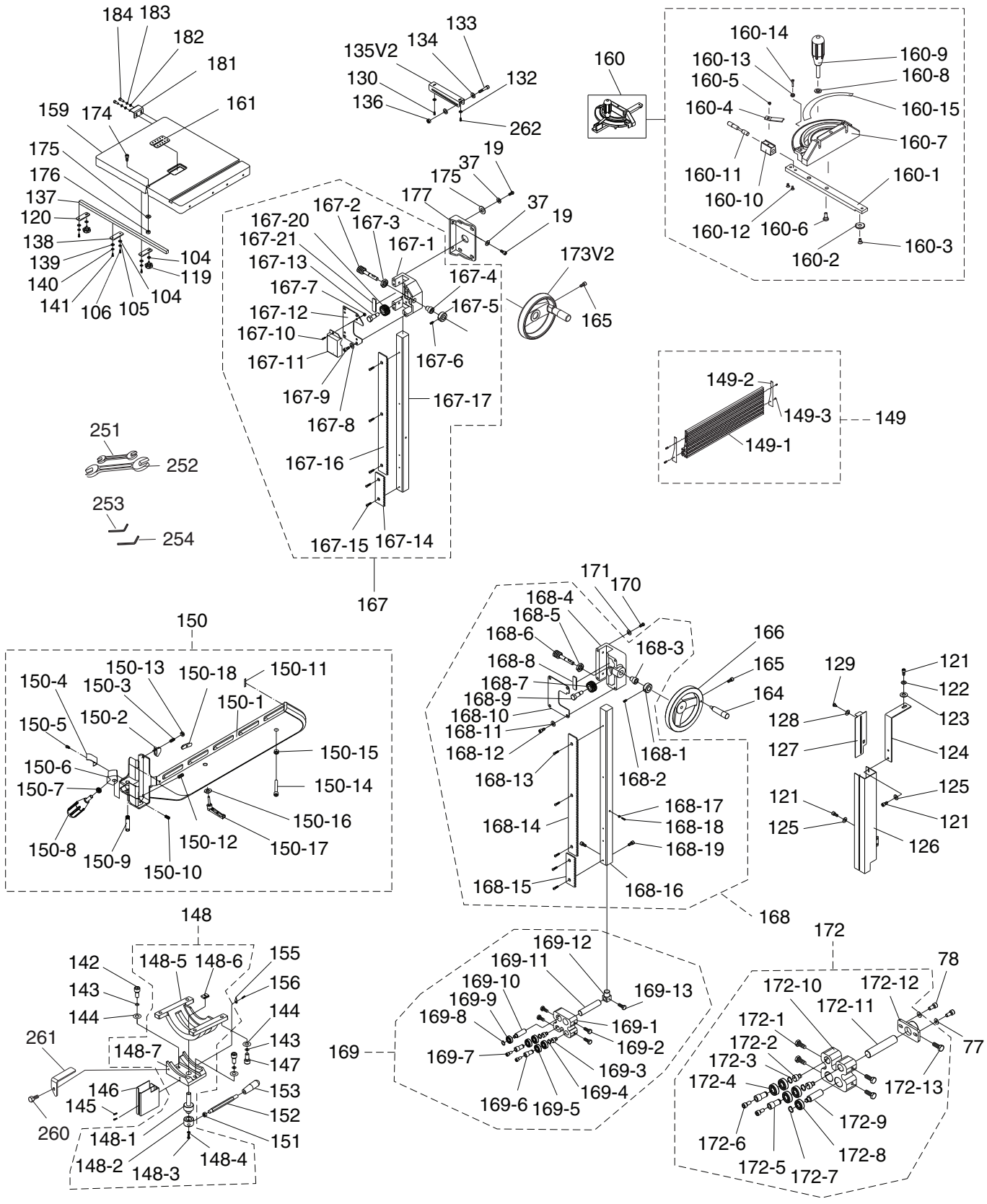
REF	PART #	DESCRIPTION
48	P0636XB048	START SWITCH
49	P0636XB049	STOP SWITCH
50	P0636XB050	KEY SWITCH
51	P0636XB051	SWITCH PLATE
52	P0636XB052	CONNECTING CORD
53	P0636XB053	CONNECTING CORD
54	P0636XB054	LOCK WASHER 6MM
55	P0636XB055	ADJUST BOLT
56	P0636XB056	HEX BOLT M10-1.5 X 70
57	P0636XB057	HEX NUT M10-1.5
58	P0636XB058	FLAT WASHER 10MM
59	P0636XB059	SET SCREW M6-1 X 12
60	P0636XB060	MOTOR PULLEY
61	P0636XB061	FLAT WASHER 8MM
62	P0636XB062	LOWER SHAFT
65	P0636XB065	V-BELT 17-380
67	P0636XB067	TRACKING WINDOW
68	P0636XB068	RIVET 3.2 X 10
69	P0636XB069	LOCK NUT M6-1
70	P0636XB070	CAP SCREW M6-1 X 20
71	P0636XB071	KNOB
72	P0636XB072	HEIGHT POINTER
73	P0636XB073	FLANGE SCREW M5-.8 X 10
74	P0636XB074	CAP SCREW M6-1 X 25
75	P0636XB075	BLADE TENSION HANDLEWHEEL
76	P0636XB076	LOWER WHEEL SUPPORT
77	P0636XB077	FLAT WASHER 6MM
78	P0636XB078	FLANGE SCREW M6-1 X 10
79	P0636XB079	HEX BOLT M6-1 X 25
80	P0636XB080	BRUSH
81	P0636XB081	FOOT PEDAL COVER
85	P0636XB085	HEX NUT M4-.7
94	P0636XB094	MOTOR W/BRAKE 5HP 1PH 230V
94-2	P0636XB094-2	MOTOR FAN COVER
94-3	P0636XB094-3	MOTOR FAN
94-4	P0636XB094-4	S CAPACITOR 300M 250V 1-3/4 x 4
94-5	P0636XB094-5	S CAPACITOR COVER
94-6	P0636XB094-6	R CAPACITOR 45M 450V 2 x 3-1/2
94-7	P0636XB094-7	R CAPACITOR COVER
94-8	P0636XB094-8	JUNCTION BOX
94-8	P0636XB094-8	JUNCTION BOX
94-9	P0636XB094-9	CENTRIFUGAL SWITCH PLATE
94-10	P0636XB094-10	CENTRIFUGAL SWITCH
94-11	P0636XB094-11	MAGNETIC BRAKE W/SHOE
94-13	P0636XB094-13	CAP SCREW M6-1 X 12
94-14	P0636XB094-14	LOCK WASHER 6MM
94-15	P0636XB094-15	KEY 5 X 5 X 25
94-16	P0636XB094-16	CAP SCREW M5-.8 X 16
94-17	P0636XB094-17	SET SCREW M6-1 X 6
95	P0636XB095	ADJUSTMENT HUB COVER
96	P0636XB096	BUTTON HD CAP SCR M8-1.25 X 20
97	P0636XB097	HEX BOLT M10-1.5 X 35
98	P0636XB098	CORD CLAMP 1/2"
99	P0636XB099	FLANGE SCREW M5-.8 X 50

G0636XB Main Parts List

REF	PART #	DESCRIPTION
100	P0636XB100	TERMINAL BOX
103V2	P0636XB103V2	MAG SWITCH ASSY SDE MPE-30 22A V2.11.10
103-1	P0636XB103-1	MAG SWITCH BACK COVER
103-2V2	P0636XB103-2V2	CONTACTOR SDE MA-30 230V V2.11.10
103-3	P0636XB103-3	OL RELAY SDE RA-30 18-26A
103-4V2	P0636XB103-4V2	MAG SWITCH FRONT COVER V2.11.10
103-5V2	P0636XB103-5V2	CONNECTING CORD 16G 5W V2.11.10
103-6	P0636XB103-6	POWER CORD 12G 3W
103-7	P0636XB103-7	MOTOR CORD 12G 5W
103-8	P0636XB103-8	FLANGE SCREW M5-.8 X 10
103-9	P0636XB103-9	RECTIFIER PU-23-2
107	P0636XB107	STRAIN RELIEF M13.5
108	P0636XB108	PLATE
109	P0636XB109	SWITCH CORD 18G 2W
110	P0636XB110	FLAT WASHER 4MM
111	P0636XB111	DOOR LATCH SWITCH ADZ-S11

REF	PART #	DESCRIPTION
111-1	P0636XB111-1	DOOR LATCH
112	P0636XB112	FLANGE SCREW M4-.7 X 35
113	P0636XB113	PHLP HD SCR M4-.7 X 10
114	P0636XB114	UPPER WHEEL COVER
115	P0636XB115	LOWER WHEEL COVER
116	P0636XB116	SAW BLADE 3TPI 162" X 1" X 0.035
117	P0636XB117	TAP SCREW M4 X 10
118	P0636XB118	CORD CLAMP 5/16"
255	P0636XB255	EYE BOLT M10-1.5- X 15
256	P0636XB256	PHLP HD SCR M4-.7 X 10
257	P0636XB257	CONNECTING CORD 12G 1W
258	P0636XB258	WIRE NUT P3
259	P0636XB259	EXT TOOTH WASHER 5MM
274	P0636XB274	STOP PLATE
275	P0636XB275	CAP SCREW M5-.8 X 12
276	P0636XB276	FLAT WASHER 5MM

G0636XB Fence/Guides/Trunnion



G0636XB Fence/Guides/Trunnion Parts List

REF	PART #	DESCRIPTION
19	P0636XB019	CAP SCREW M8-1.25 X 25
37	P0636XB037	LOCK WASHER 8MM
77	P0636XB077	FLAT WASHER 6MM
78	P0636XB078	FLANGE SCREW M6-1 X 10
104	P0636XB104	FLAT WASHER 8MM
105	P0636XB105	LOCK WASHER 8MM
106	P0636XB106	CAP SCREW M8-1.25 X 20
119	P0636XB119	KNOB BOLT M8-1.25 X 20
120	P0636XB120	OUTER RAIL PLATE
121	P0636XB121	CAP SCREW M6-1 X 10
122	P0636XB122	LOCK WASHER 6MM
123	P0636XB123	FLAT WASHER 6MM
124	P0636XB124	SUPPORT PLATE
125	P0636XB125	FLAT WASHER 6MM
126	P0636XB126	PROTECT COVER (ASM)
127	P0636XB127	SLIDING PLATE
128	P0636XB128	FIBER WASHER 13MM
129	P0636XB129	SHOULDER SCREW
130	P0636XB130	CAP SCREW M6-1 X 10
132	P0636XB132	FLAT WASHER 6MM
133	P0636XB133	HEX BOLT M8-1.25 X 55
134	P0636XB134	FLAT WASHER 8MM
135V2	P0636XB135	SLIDING PLATE V2.11.11
136	P0636XB136	LOCK NUT M8-1.25
137	P0636XB137	GUARD RAIL
138	P0636XB138	GUARD RAIL PLATE
139	P0636XB139	FLAT WASHER 6MM
140	P0636XB140	LOCK WASHER 6MM
141	P0636XB141	CAP SCREW M6-1 X 20
142	P0636XB142	CAP SCREW M10-1.5 X 30
143	P0636XB143	LOCK WASHER 10MM
144	P0636XB144	FLAT WASHER 10MM
145	P0636XB145	FLANGE SCREW M6-1 X 10
146	P0636XB146	BLADE GUARD
147	P0636XB147	CAP SCREW M10-1.5 X 35
148	P0636XB148	TRUNNION BRACKET ASSEMBLY
148-1	P0636XB148-1	PRESS SHAFT
148-2	P0636XB148-2	MICRO ADJUSTING RING
148-3	P0636XB148-3	CAP SCREW M8-1.25 X 20
148-4	P0636XB148-4	LOCK WASHER 8MM
148-5	P0636XB148-5	TRUNNION BLOCK
148-6	P0636XB148-6	PRESS BLOCK
148-7	P0636XB148-7	TRUNNION HOUSING
149	P0636XB149	RESAW FENCE ASSEMBLY
149-1	P0636XB149-1	RESAW FENCE(AL) 590MM
149-2	P0636XB149-2	TAP SCREW M3.5 X 8
149-3	P0636XB149-3	FENCE PIECE 148 X 22 X 1
150	P0636XB150	FENCE ASSSMBLY
150-1	P0636XB150-1	FENCE
150-2	P0636XB150-2	POINTER
150-3	P0636XB150-3	SET SCREW M8-1.25 X 20
150-4	P0636XB150-4	SPRING PIECE

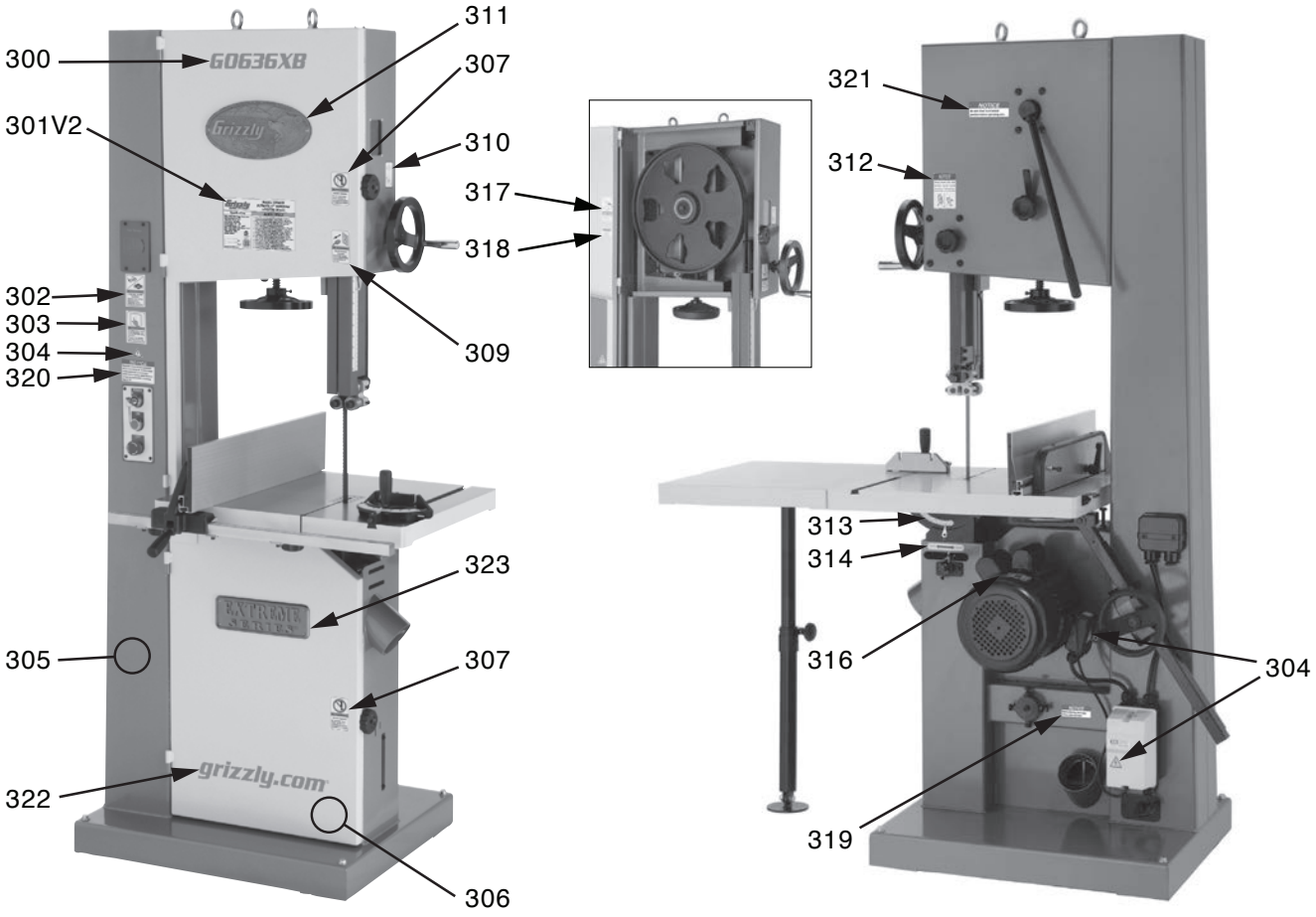
REF	PART #	DESCRIPTION
150-5	P0636XB150-5	FLANGE SCREW M4-.7 X 8
150-6	P0636XB150-6	PIVOT BLOCK
150-7	P0636XB150-7	HEX NUT M8-1.25
150-8	P0636XB150-8	HANDLE
150-9	P0636XB150-9	SHAFT
150-10	P0636XB150-10	SET SCREW PLASTIC
150-11	P0636XB150-11	NYLON PAD
150-12	P0636XB150-12	SET SCREW M8-1.25 X 12
150-13	P0636XB150-13	HEX NUT M8-1.25
150-14	P0636XB150-14	CAP SCREW M8-1.25 X 15
150-15	P0636XB150-15	HEX NUT M8-1.25
150-16	P0636XB150-16	FLAT WASHER 8MM
150-17	P0636XB150-17	LOCK HANDLE M8-1.25 X 44
150-18	P0636XB150-18	MOVING PLATE
151	P0636XB151	HEX NUT M12-1.75
152	P0636XB152	HANDLE SHAFT
153	P0636XB153	HANDLE KNOB M12-1.75 (FEMALE)
155	P0636XB155	POINTER
156	P0636XB156	PHLP HD SCR M4-.7 X 10
159	P0636XB159	TABLE
160	P0636XB160	MITER GAUGE ASSEMBLY
160-1	P0636XB160-1	GUIDE BAR
160-2	P0636XB160-2	GUIDE PIECE
160-3	P0636XB160-3	FLAT HD SCR M6-1 X 8
160-4	P0636XB160-4	POINTER
160-5	P0636XB160-5	PHLP HD SCR 10-24 X 3/8
160-6	P0636XB160-6	SHOULDER SCREW
160-7	P0636XB160-7	MITER GAUGE BODY
160-8	P0636XB160-8	FLAT WASHER 8MM
160-9	P0636XB160-9	HANDLE
160-10	P0636XB160-10	FIXED BLOCK
160-11	P0636XB160-11	LOCKING SHAFT
160-12	P0636XB160-12	PHLP HD SCR 10-24 X 3/8
160-13	P0636XB160-13	HEX NUT M4-.7
160-14	P0636XB160-14	PHLP HD SCR M4-.7 X 16
160-15	P0636XB160-15	SCALE
161	P0636XB161	TABLE INSERT
164	P0636XB164	HANDLE 3/8-16 X 1/2
165	P0636XB165	CAP SCREW M6-1 X 25
166	P0636XB166	HANDWHEEL 7" (STEEL)
167	P0636XB167	TABLE TILT ASSEMBLY
167-1	P0636XB167-1	GUIDE BRACKET
167-2	P0636XB167-2	WORM SHAFT
167-3	P0636XB167-3	HEX NUT M16-1.5
167-4	P0636XB167-4	BUSHING
167-5	P0636XB167-5	LOCK COLLAR
167-6	P0636XB167-6	SET SCREW M5-.8 X 5
167-7	P0636XB167-7	HEX NUT M5-.8
167-8	P0636XB167-8	LOCK WASHER 8MM
167-9	P0636XB167-9	CAP SCREW M8-1.25 X 16
167-10	P0636XB167-10	FLANGE SCREW M5-.8 X 10
167-11	P0636XB167-11	COVER

G0636XB Fence/Guides/Trunnion Parts List

REF	PART #	DESCRIPTION
167-12	P0636XB167-12	COVER
167-13	P0636XB167-13	FIXED BOLT 12 X 43 X 10M 1.5P
167-14	P0636XB167-14	EXTENSION RACK
167-15	P0636XB167-15	FLAT HD SCR M4-.7 X 10
167-16	P0636XB167-16	RACK
167-17	P0636XB167-17	UPPER GUIDE BAR
167-20	P0636XB167-20	PINION GEAR
167-21	P0636XB167-21	FIXED PLATE
168	P0636XB168	UPPER GUIDE ASSEMBLY
168-1	P0636XB168-1	LOCK COLLAR
168-2	P0636XB168-2	SET SCREW M5-.8 X 5
168-3	P0636XB168-3	BUSHING
168-4	P0636XB168-4	UPPER GUIDE BRACKET
168-5	P0636XB168-5	HEX NUT M16-1.5
168-6	P0636XB168-6	WORM SHAFT
168-7	P0636XB168-7	WORM GEAR
168-8	P0636XB168-8	FIXED PLATE
168-9	P0636XB168-9	FIXED BOLT
168-10	P0636XB168-10	COVER
168-11	P0636XB168-11	LOCK WASHER 8MM
168-12	P0636XB168-12	HEX BOLT M8-1.25 X 12
168-13	P0636XB168-13	FLAT HD SCR M4-.7 X 10
168-14	P0636XB168-14	RACK
168-15	P0636XB168-15	EXTENSION RACK
168-16	P0636XB168-16	UPPER GUIDE BAR
168-17	P0636XB168-17	HEX NUT M4-.7
168-18	P0636XB168-18	PHLP HD SCR M4-.7 X 10
168-19	P0636XB168-19	CAP SCREW M6-1 X 16
169	P0636XB169	UPPER BLADE GUIDE ASSEMBLY
169-1	P0636XB169-1	UPPER BLADE GUIDE SUPPORT
169-2	P0636XB169-2	HEX BOLT M6-1 X 16
169-3	P0636XB169-3	ECCENTRIC SHAFT
169-4	P0636XB169-4	EXT RETAINING RING 15MM
169-5	P0636XB169-5	BALL BEARING 6202ZZ
169-6	P0636XB169-6	HANDLE BEARING
169-7	P0636XB169-7	CAP SCREW M6-1 X 40
169-8	P0636XB169-8	EXT RETAINING RING 12MM

REF	PART #	DESCRIPTION
169-9	P0636XB169-9	BALL BEARING 6201ZZ
169-10	P0636XB169-10	UPPER SPACING SLEEVE
169-11	P0636XB169-11	SHAFT
169-12	P0636XB169-12	UPPER GUIDE SUPPORT BLOCK
169-13	P0636XB169-13	HEX BOLT M6-1 X 10
170	P0636XB170	BUTTON HD CAP SCR M8-1.25 X 35
171	P0636XB171	FLAT WASHER 8MM
172	P0636XB172	LOWER BLADE GUIDE ASSEMBLY
172-1	P0636XB172-1	HEX BOLT M6-1 X 16
172-2	P0636XB172-2	ECCENTRIC SHAFT
172-3	P0636XB172-3	EXT RETAINING RING 15MM
172-4	P0636XB172-4	BALL BEARING 6202ZZ
172-5	P0636XB172-5	HANDLE BUSHING
172-6	P0636XB172-6	CAP SCREW M6-1 X 40
172-7	P0636XB172-7	EXT RETAINING RING 12MM
172-8	P0636XB172-8	BALL BEARING 6201ZZ
172-9	P0636XB172-9	SPACING SLEEVE
172-10	P0636XB172-10	BLADE GUIDE SUPPORT
172-11	P0636XB172-11	SHAFT
172-12	P0636XB172-12	LOWER SUPPORT BRACKET
172-13	P0636XB172-13	HEX BOLT M6-1 X 16
173V2	P0636XB173V2	HANDWHEEL V2.06.08
174	P0636XB174	HEX BOLT M8-1.25 X 50
175	P0636XB175	FLAT WASHER 8MM
176	P0636XB176	HEX NUT M8-1.25
177	P0636XB177	SUPPORT PLATE
181	P0636XB181	STOP BRACKET
182	P0636XB182	LOCK WASHER 6MM
183	P0636XB183	FLAT WASHER 6MM
184	P0636XB184	HEX BOLT M6-1 X 16
251	P0636XB251	WRENCH 10/13
252	P0636XB252	WRENCH 17/19
253	P0636XB253	HEX WRENCH 5MM
254	P0636XB254	HEX WRENCH 6MM
260	P0636XB260	FLANGE SCREW M6-1 X 12
261	P0636XB261	L-HOLDER PLATE
262	P0636XB262	CAP SCREW M6-1 X 12

G0636XB Labels



REF	PART #	DESCRIPTION
300	P0636XB300	MODEL NUMBER LABEL
301V2	P0636XB301V2	MACHINE ID LABEL V2.07.19
302	P0636XB302	SAFETY GLASSES LABEL
303	P0636XB303	READ MANUAL LABEL
304	P0636XB304	ELECTRICITY LABEL
305	P0636XB305	TOUCH UP PAINT, GRIZZLY GREEN
306	P0636XB306	TOUCH UP PAINT, GREY PUTTY
307	P0636XB307	DONT OPEN LABEL
309	P0636XB309	UNPLUG BANDSAW LABEL
310	P0636XB310	BLADE ASSEMBLY DIRECTION LABEL
311	P0636XB311	GRIZZLY NAMEPLATE-LARGE

REF	PART #	DESCRIPTION
312	P0636XB312	TENSION ADJ LABEL
313	P0636XB313	TABLE ANGLE SCALE
314	P0636XB314	TABLE LOCK LEVER LABEL
316	P0636XB316	MOTOR LABEL
317	P0636XB317	UPPER WHEEL HINGE/STOP BOLT LABEL
318	P0636XB318	PATENT LABEL
319	P0636XB319	HANDWHEEL LOCK LEVER LABLE
320	P0636XB320	MAGNETIC BRAKE NOTICE
321	P0636XB321	LOCK LEVER LABLE
322	P0636XB322	GRIZZLY.COM LABLE
323	P0636XB323	EXTREME SERIES PLATE

⚠WARNING

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

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.

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.

In the event you need to use 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.

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.

To take advantage of this warranty, you must register it at **https://www.grizzly.com/secureforms/warranty-card**, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.