

Grizzly *Industrial, Inc.*®

Industrial Bandsaw MODEL G0566/G0568/G0569 INSTRUCTION MANUAL



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WARNING

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

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

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

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INTRODUCTION

Foreword

We are proud to offer the Model G0566/G0568/G0569 Industrial Bandsaw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0566/G0568/G0569. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0566/G0568/G0569 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!



Contact Info

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

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

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

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





MACHINE DATA SHEET

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

MODEL G0566 21" HEAVY-DUTY BANDSAW

Design Type Floor Model

Overall Dimensions:

Table Size 29½" x 20¾" x 1⅞"
 Height From Floor To Table 35½"
 Overall Height 78"
 Overall Width 39½"
 Overall Depth (Including Fence) 28⅝"
 Shipping Weight 678 lbs.
 Machine Weight 581 lbs.
 Crate Size 26½" L x 39" W x 87" H
 Footprint 33½" W x 21⅝" L

Capacities:

Throat Capacity (Left of Blade) 20"
 Max Cutting Width w/Fence 18½"
 Height Capacity 14"
 Table Tilt 45°R
 Blade Size Range ¼"—1⅜"
 Standard Blade Length 165"
 Blade Speeds 4600 FPM

Construction:

Table Precision Ground Cast Iron
 Wheels Fully Balanced Cast Iron w/Polyurethane Tires
 Rip Fence Precision Ground Cast Iron
 Wheel Covers Pre-Formed Steel
 Guides Ball Bearing

Main Motor:

Type TEFC Capacitor-Start Induction
 Horsepower 3 HP
 Phase / Voltage Single-Phase / 220V
 Amps 15A
 Cycle / RPM 60 Hertz / 1725 RPM
 Switch Magnetic w/Thermal Overload Protection
 Bearings Shielded & Permanently Lubricated Ball Bearings

Features:

..... 4" Dust Port x 2
 Quick Change Blade Release/Tensioner
 Blade Tension Indicator
 Micro-Adjusting Rack & Pinion Table Tilt
 Height Scale Measurement
 Foot Brake Stop
 Included Miter Gauge
 Rack & Pinion Upper Guide Adjustment
 Magnifying Window Over Fence Scale
 Hinged Wheel Covers w/Safety Lock

Specifications, while deemed accurate, are not guaranteed.



MACHINE DATA SHEET

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

MODEL G0568 24" HEAVY-DUTY BANDSAW

Design Type Floor Model

Overall Dimensions:

Table Size 33½" x 23⅝" x 2"
 Height From Floor To Table 34½"
 Overall Height 83½"
 Overall Width 47⅝"
 Overall Depth (Including Fence) 31¼"
 Shipping Weight 957 lbs.
 Machine Weight 836 lbs.
 Crate Size 29" L x 45¼" W x 88" H
 Footprint 41⅜" W x 23½" L

Capacities:

Throat Capacity (Left of Blade) 24½"
 Height Capacity 16"
 Table Tilt 45°R
 Blade Size Range ¼"-1½"
 Standard Blade Length 181"
 Blade Speeds 5300 FPM

Construction:

Table Precision Ground Cast Iron
 Wheels Fully Balanced Cast Iron w/Rubber Tires
 Rip Fence Precision Ground Cast Iron
 Wheel Covers Pre-Formed Steel
 Guides Ball Bearing

Main Motor:

Type TEFC Capacitor-Start Induction
 Horsepower 5 HP
 Phase / Voltage Single-Phase / 220V
 Amps 30A
 Cycle / RPM 60 Hertz / 1725 RPM
 Switch Magnetic w/Thermal Overload Protection

Bearings Shielded & Permanently Lubricated Ball Bearings

Features:

..... 4" Dust Port x 2
 Quick Change Blade Release/Tensioner
 Blade Tension Indicator
 Micro-Adjusting Rack & Pinion Table Tilt
 Height Scale Measurement
 Foot Brake Stop
 Included Miter Gauge
 Rack & Pinion Upper Guide Adjustment
 Magnifying Window Over Fence Scale
 Hinged Wheel Covers w/Safety Lock

Specifications, while deemed accurate, are not guaranteed.



MACHINE DATA SHEET

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

MODEL G0569 24" HEAVY-DUTY BANDSAW

Design Type Floor Model

Overall Dimensions:

Table Size 33½" x 23⅝" x 2"
 Height From Floor To Table 34½"
 Overall Height 83½"
 Overall Width 47⅝"
 Overall Depth (Including Fence) 31¼"
 Shipping Weight 957 lbs.
 Machine Weight 836 lbs.
 Crate Size 29" L x 45¼" W x 88" H
 Footprint 41⅜" W x 23½" L

Capacities:

Throat Capacity (Left of Blade) 24½"
 Height Capacity 16"
 Table Tilt 45° R
 Blade Size Range ¼"–1½"
 Standard Blade Length 181"
 Blade Speeds 5300 FPM

Construction:

Table Precision Ground Cast Iron
 Wheels Fully Balanced Cast Iron w/Rubber Tires
 Rip Fence Precision Ground Cast Iron
 Wheel Covers Pre-Formed Steel
 Guides Ball Bearing

Main Motor:

Type TEFC Induction
 Horsepower 7½ HP
 Phase / Voltage 3-Phase / 220V/440V
 Amps 20A/10A
 Cycle / RPM 60 Hertz / 1725 RPM
 Switch Magnetic w/Thermal Overload Protection

Bearings Shielded & Permanently Lubricated Ball Bearings

Features:

..... 4" Dust Port x 2
 Quick Change Blade Release/Tensioner
 Blade Tension Indicator
 Micro-Adjusting Rack & Pinion Table Tilt
 Height Scale Measurement
 Foot Brake Stop
 Included Miter Gauge
 Rack & Pinion Upper Guide Adjustment
 Magnifying Window Over Fence Scale
 Hinged Wheel Covers w/Safety Lock

Specifications, while deemed accurate, are not guaranteed.

Machine Features

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

Match up the feature list below with the letters in **Figures 1, 2, and 3** to identify the external bandsaw feature locations.

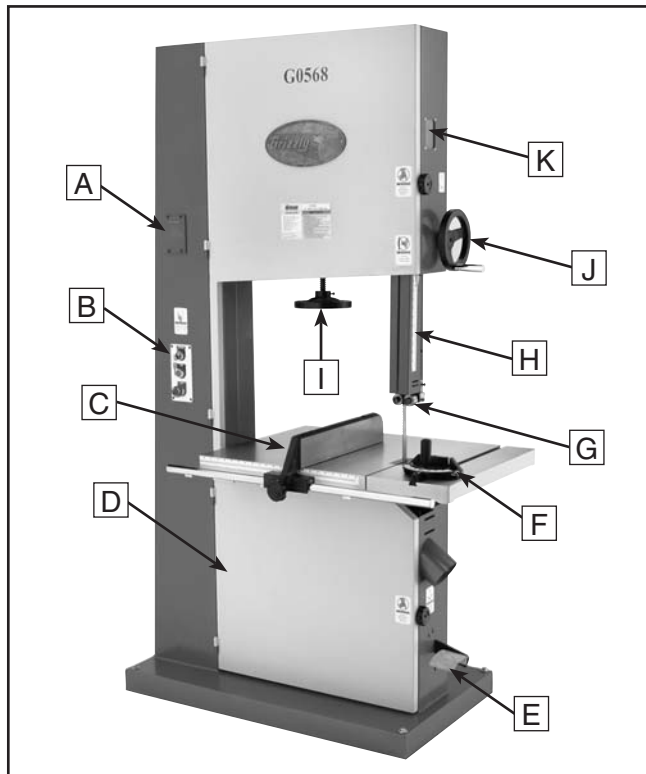


Figure 1. Front of the bandsaw.

- A. Tension Indicator Window
- B. Key Switch, Start & Stop Buttons
- C. Rip Fence
- D. Hinged Wheel Cover
- E. Foot Brake
- F. Miter Gauge
- G. Ball Bearing Blade Guides
- H. Cutting Height Scale
- I. Blade Tension Handwheel
- J. Guide Post Handwheel
- K. Blade Tracking Window

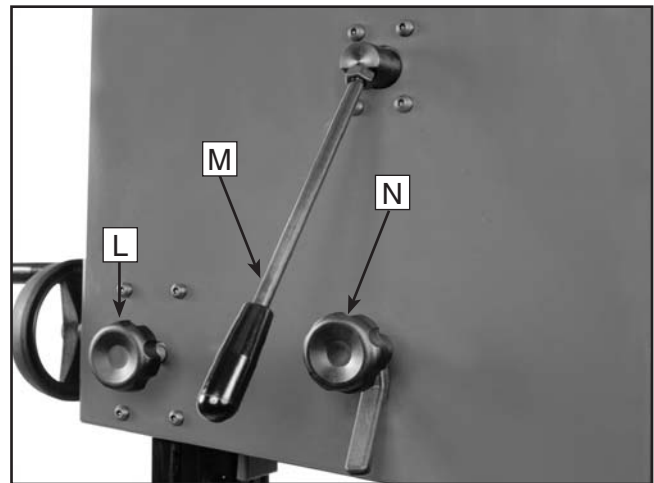


Figure 2. Rear, top-side of the bandsaw.

- L. Guide Post Lock Knob
- M. Blade Tension Lever
- N. Blade Tracking Knob

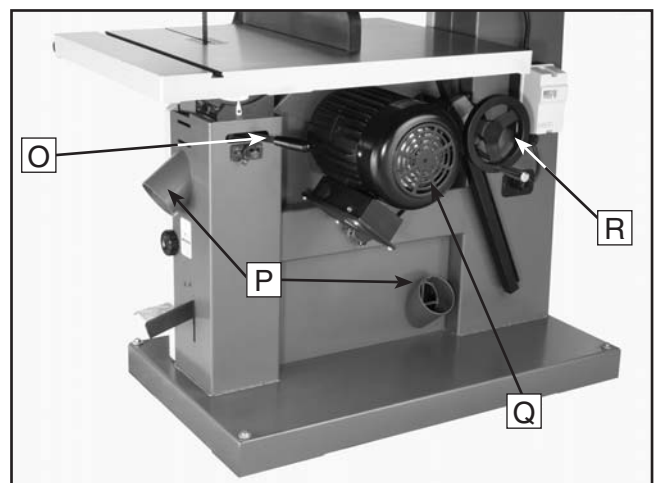


Figure 3. Rear, lower-side of the bandsaw.

- O. Table Lock Lever
- P. (2) 4" Dust Ports
- Q. Motor
- R. Table Tilt Handwheel



SECTION 1: SAFETY


WARNING

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

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

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

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

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

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

WARNING

Safety Instructions for Machinery

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

WARNING

Safety Instructions for Machinery

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

WARNING

Additional Safety Instructions for Bandsaws

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

WARNING

Like all machines there is danger associated with the Model G0566/G0568/G0569. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with caution to reduce the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

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

SECTION 2: CIRCUIT REQUIREMENTS

G0566/G0568

WARNING

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

The Model G0566/G0568 requires a 220V, single-phase power circuit for safe operation. A cord is not provided because the style of cord used will vary depending upon the type electrical service of each particular shop.

Amperage Draw

G0566 3HP Motor 15 Amps
 G0568 5HP Motor 30 Amps

Circuit Breaker Requirements

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

G0566.....20 Amp
 G0568.....35 Amp

Minimum Cord Requirements

For 220V single-phase operation, use the following type of cord:

Cord.....3 Wire, Copper
 G0566 Gauge..... 14 AWG
 G0568 Gauge.....8 AWG


Plug Type

We recommend using the following plug and receptacle to connect your machine to power.

G0566..... L6-20
 G0568..... L6-35

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded as well. All electrical connections must be made in accordance with local codes and ordinances.



WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!

Your Shop Circuit Capacity

Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.



G0569

!WARNING

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

The Model G0569 is prewired for 220V 3-phase power, but can be rewired for 440V 3-Phase power operation. A cord is not provided because the style of cord used will vary depending upon the type of electrical service in each particular shop.

Amperage Draw

The Model G0569 has a 7 $\frac{1}{2}$ HP motor that will draw the following amps:

| | |
|-----------------------|---------|
| 220 Volt 3-Phase..... | 20 Amps |
| 440 Volt 3-Phase..... | 10 Amps |

Circuit Breaker Requirements

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

| | |
|-----------------------|--------|
| 220 Volt 3-Phase..... | 25 Amp |
| 440 Volt 3-Phase..... | 15 Amp |

Minimum Cord Requirements

220V 3-phase:

| | |
|------------|--------|
| Cord..... | Copper |
| Gauge..... | 12 AWG |

440V 3-phase:

| | |
|------------|--------|
| Cord..... | Copper |
| Gauge..... | 12 AWG |

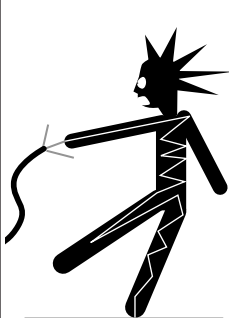
Plug Type

The plug you install on your cord will depend upon the type of service you currently have or plan to install. We recommend using the following plug and receptacle for your machine on a dedicated circuit only:

| | |
|----------------------------------|--------|
| 220 Volt Plug & Receptacle | L15-30 |
| 440 Volt Plug & Receptacle | L16-20 |

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded as well. All electrical connections must be made in accordance with local codes and ordinances.

| | |
|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | !WARNING Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician! |
|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

Your Shop Circuit Capacity

Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

| |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| !CAUTION A fire may occur if your particular electrical configuration does not comply with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician. |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|



Rewiring G0569 to 440V

The Model G0569 can be rewired for 440V operation. This rewiring job consists of disconnecting the saw from the power source, changing the magnetic switch, and rewiring the cutting motor.

The Model G0569082A 440V Conversion Kit needed for this procedure can be purchased from Grizzly Industrial by calling our customer service number at (800) 523-4777.

This procedure takes moderate electrical skill and the rewiring job must be inspected by a qualified electrician before the saw is connected to the power source.

To rewire the Model G0569 for 440V operation:

1. **Unplug the Bandsaw!**
2. Open the electrical panel (**Figure 4**), disconnect and remove the magnetic switch.
3. Install the 440V magnetic switch and wire



Figure 4. 220V Magnetic Switch

it according to the **G0569 Wiring Diagram** on **page 51**. Note—Consult the wiring diagram on the inside of the switch cover. If that diagram differs from the manual, use the diagram in the switch cover.

4. Raise the table, open the motor wiring cover and remove the motor wiring caps from the motor.
5. Rewire the motor as shown in **Figure 5**. Note—Consult the wiring diagram on the inside of the motor cover. If that diagram differs from the manual, use the diagram in the motor cover.
6. Install the switch cover and lower the table.

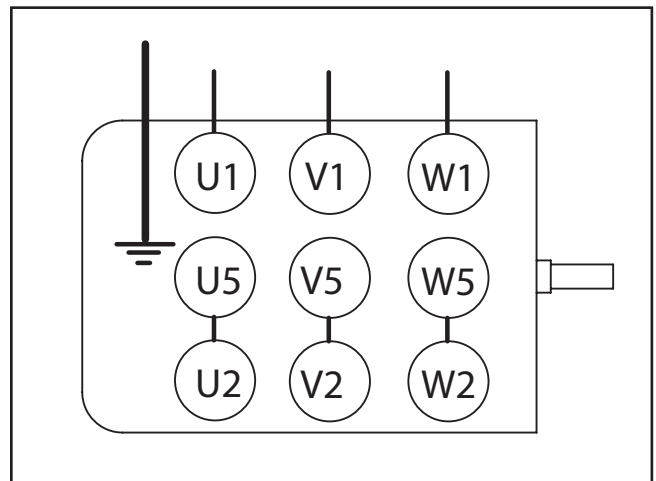
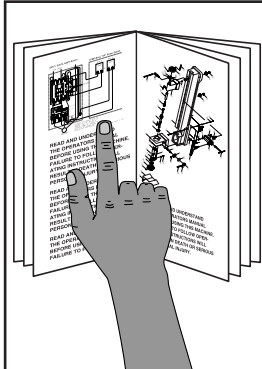


Figure 5. 440V motor wiring.



SECTION 3: SET UP

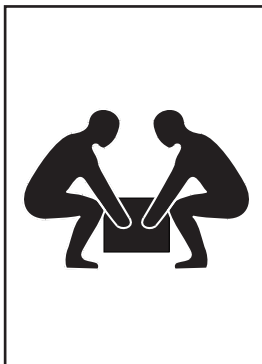
Set Up Safety



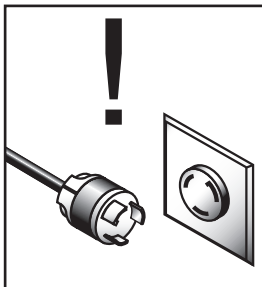
! WARNING
 This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



! WARNING
 Wear safety glasses during the entire set up process!



! WARNING
 The Model G0566/G0568/G0569 is a heavy machine (581/863 lbs. shipping weight). DO NOT over-exert yourself while unpacking or moving your machine—get assistance.



! WARNING
 Perform all set up procedures with the machine disconnected from its power source. Failure to do so may result in serious personal injury.



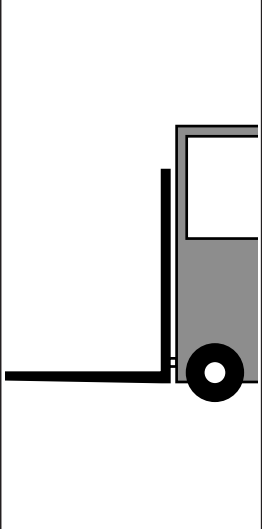
Items Needed for Set Up

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

| DESCRIPTION | QTY |
|------------------------------------------|-----|
| • Safety Glasses (for each person) | 1 |
| • Phillips Screwdriver | 1 |
| • Straight Slot Screwdriver..... | 1 |
| • Feeler Gauge .016", .004"..... | 1 |
| • Machinists Square..... | 1 |
| • Straightedge (approximately 24")..... | 1 |
| • Fine Ruler..... | 1 |
| • Dust Collection System | 1 |
| • 4" Dust Hose (length as needed) | 2 |
| • 4" Hose Clamp | 4 |



Unpacking

| | |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>⚠️ WARNING</p> <p>The Model G0566/G0568/G0569 is a heavy machine that weighs approximately 581/836 lbs. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.</p> |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

The Model G0566/G0568/G0569 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

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

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



Inventory

After everything has been removed from the crate, you should have the following items:

Inventory (Figure 6):

- A. Bandsaw (not shown)..... 1
- B. Fence 1
- C. Hand Knob 1
- D. Miter Gauge..... 1
- E. Handwheel 1
- F. Handle (G0568/G0569)..... 1
- G. Hex Wrench 5mm..... 1
- H. Hex Wrench 6mm..... 1
- I. Open End Wrench 10mm x 13mm..... 1
- J. Open End Wrench 17mm x 19mm 1
- K. Lifting Rings 2

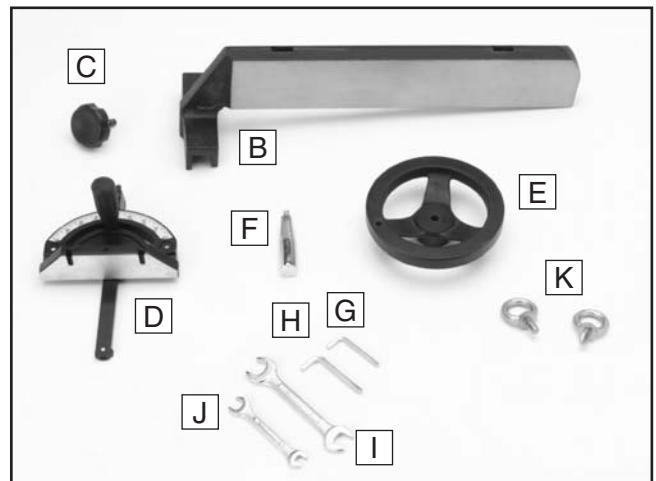


Figure 6. Inventory

Inventory G0568 / G0569 only (not shown):

- L. Riser Blocks 2
- N. Hardware Bag 1
 - Hex Bolt M12-1.75 x 110..... 4
 - Flat Washers 12mm 4
 - Lock Washers 12mm..... 4

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

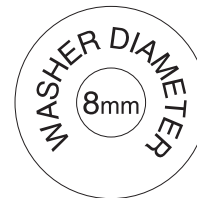
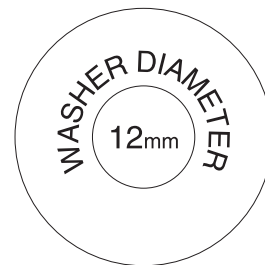
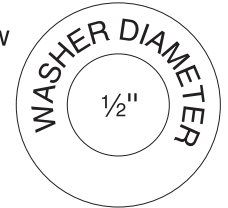
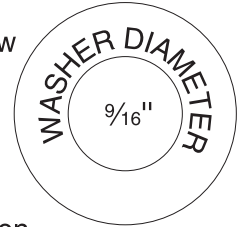
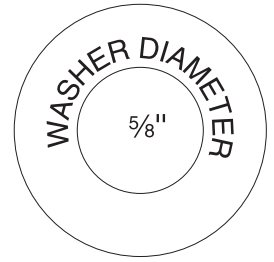
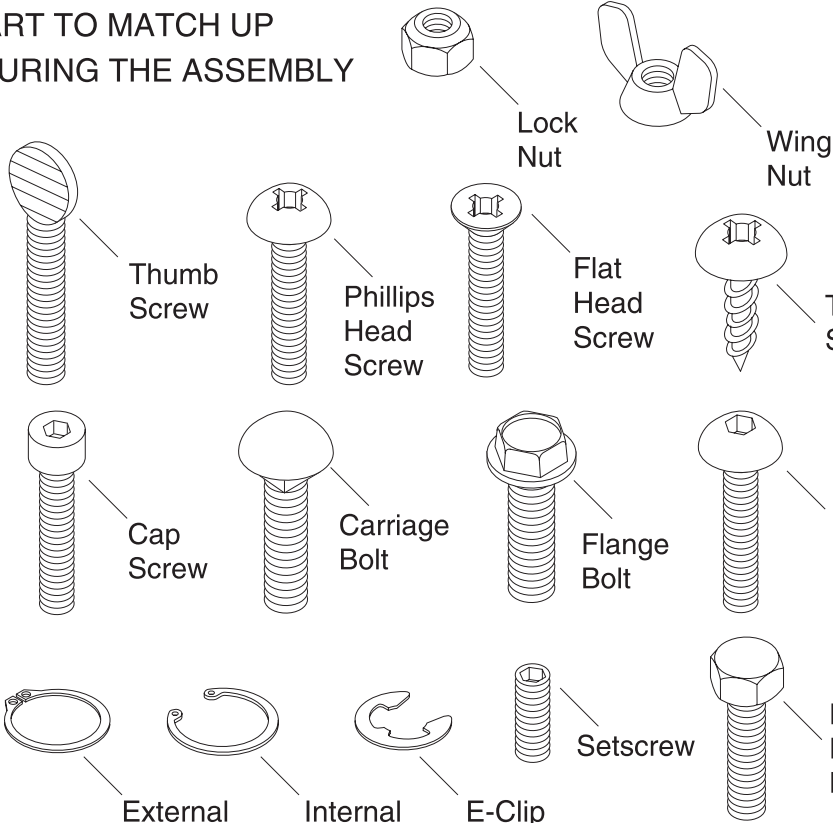


Hardware Recognition Chart

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

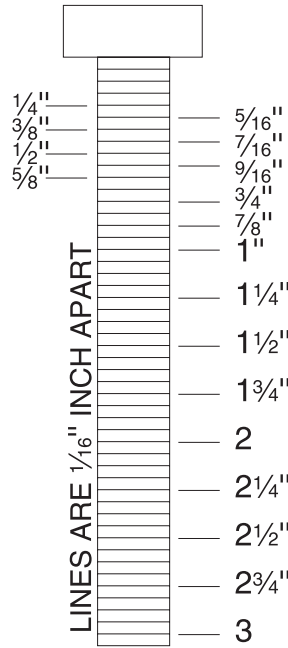
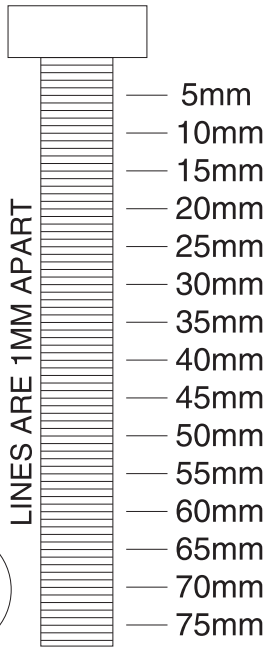
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"



#10

- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



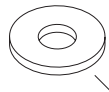
WASHERS ARE MEASURED BY THE INSIDE DIAMETER

LINES ARE 1MM APART

LINES ARE 1/16" INCH APART



Key



Flat Washer



Lock Washer



Hex Nut

Clean Up

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



Site Considerations

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

G0566 Floor Load

The Model G0566 weighs 581 lbs. and has a base footprint of 33 $\frac{1}{2}$ " W x 21 $\frac{5}{8}$ " D. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

G0566 Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 7** for the minimum working clearances of the Model G0566.

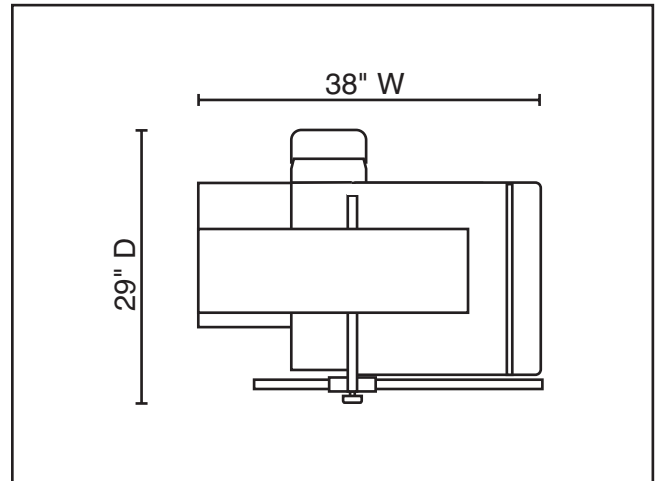


Figure 7. G0566 working clearances.

G0568/G0569 Floor Load

The Model G0568/G0569 weighs 836 lbs. and has a base footprint of 41 $\frac{3}{8}$ " W x 23 $\frac{1}{2}$ " L. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

G0568/G0569 Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 8** for the minimum working clearances of the Model G0568/G0569.

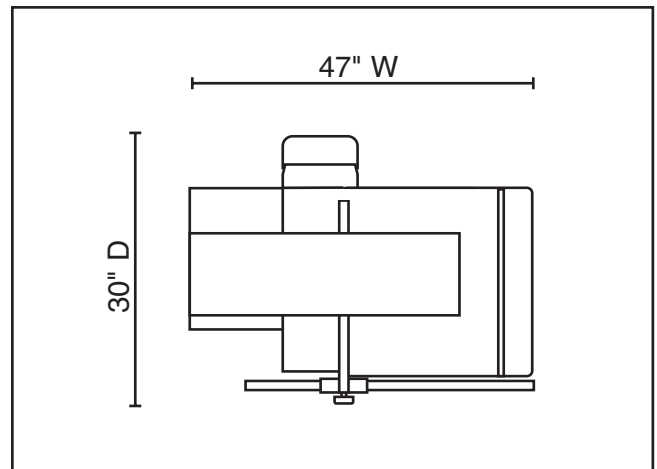


Figure 8. G0568/G0569 working clearances.



Riser Blocks

Riser blocks, shown in **Figure 9**, are included with the Model G0568/G0569 to match the height of the table to your personal preference or needs. This added feature, when installed, lifts the working table height from 32¹/₂" to 34¹/₂".

| Components and Hardware Needed: | Qty |
|----------------------------------------|------------|
| Hex Bolts M12-1.75 x 110..... | 4 |
| Flat Washers 12mm | 4 |
| Lock Washers 12mm..... | 4 |
| Riser Bars..... | 2 |

Tools Needed:

| | |
|-----------------------------|---|
| Hex Wrench/Socket 19mm..... | 1 |
|-----------------------------|---|



Figure 9. Optional riser blocks and hardware.

To install the riser blocks:

1. Lift the Model G0568/G0569 with a forklift or other power equipment.
2. Place the four hex bolts, lock washers, and flat washers, down through the holes in the base.
3. Locate and align the threaded holes in the riser bars, then securely tighten the bolts.

Note—The riser bars have tabs with holes for mounting the bandsaw unit to the floor to maximize stability. We highly recommend utilizing them and securing the bandsaw to the floor.



Fence

| Components and Hardware Needed: | Qty |
|----------------------------------------|------------|
| Fence..... | 1 |
| Hand Knob | 1 |

Tools Needed:

| | |
|----------------------------|---|
| Hex Wrench 6mm..... | 1 |
| Phillips Screwdriver | 1 |

To install the fence:

1. Remove the cap screws holding the rail onto the table, and remove the rail.
2. Flip the rail over and reinstall with the cap screws removed in **step 1 (Figure 10)**.

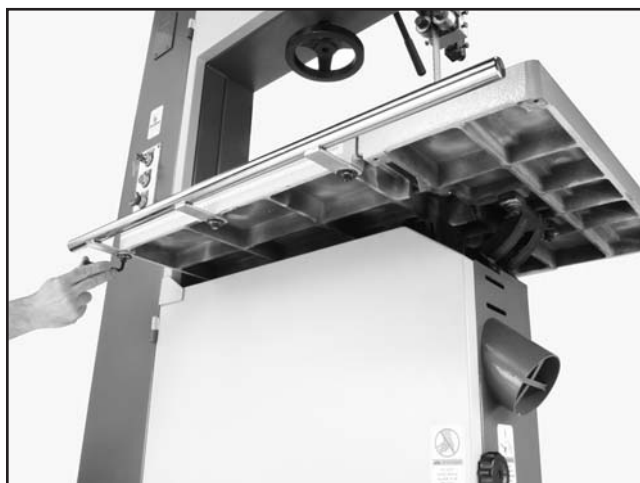


Figure 10. Tightening guard rail cap screws.

3. Place the fence on the rail (**Figure 11**) and tighten securely with the hand knob. See **page 23** to calibrate the pointer.



Figure 11. Installing fence onto rail.



Handwheel

| Components and Hardware Needed: | Qty |
|---------------------------------|-----|
| Handwheel..... | 1 |
| Handle (G0568/G0569 only) | 1 |

Tools Needed:

| | |
|--------------------------------------|---|
| Hex Wrench 5mm..... | 1 |
| Wrench 14mm (G0568/G0569 only) | 1 |

To install the handwheel (Figure 12):

1. Slide the handwheel on to the shaft.
2. Tighten the cap screw in the handwheel securely.
3. Thread the handle in to the handwheel (G0568/G0569 only) and tighten with the 14mm wrench.

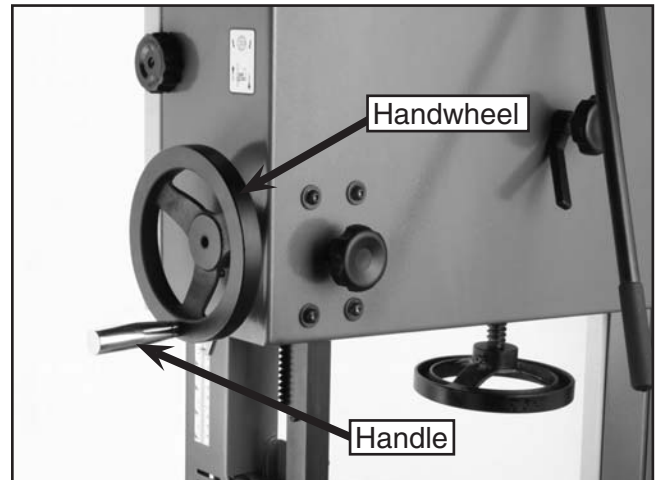


Figure 12. Handwheel correctly installed.



Adjusting Positive Stop

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

| | |
|--------------------------|------------|
| Tools Needed: | QTY |
| Wrenches 17mm | 2 |
| Machinist's Square | 1 |

To set the positive stop:

1. Tension the tension to the appropriate level for the blade size by referencing the tension gauge.
2. **Unplug the bandsaw!**
3. Loosen the check-nut that locks the positive stop adjusting bolt in place.
4. Raise the guide post and place a 6" machinist's square on the table next to the side of the blade as illustrated in **Figure 13**. Tilt the table until the table rests at 90° to the blade, then secure with the table tilt lock lever.

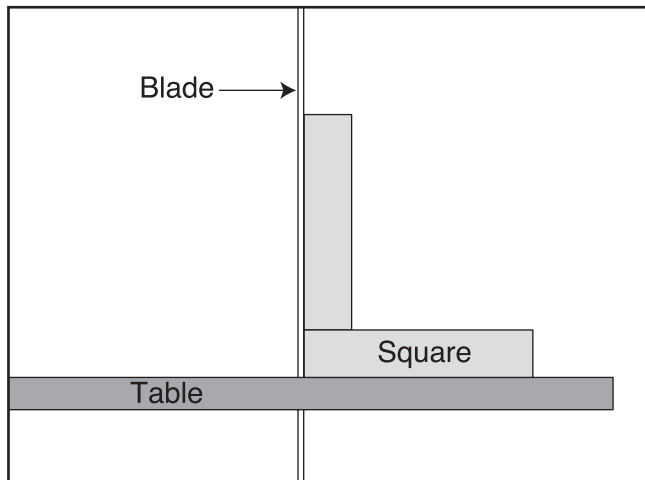


Figure 13. Squaring table to blade.

5. Adjust the positive stop bolt to the adjusted height of the table.
6. Secure the positive stop bolt by tightening the check-nut with another wrench.



Table Tilt

The table can be tilted 5° to the left and 45° to the right for performing angled cuts. Study **Figure 14** to become familiar with the table tilt controls.

| | |
|----------------------|------------|
| Tools Needed: | QTY |
| Wrenches 17mm | 2 |

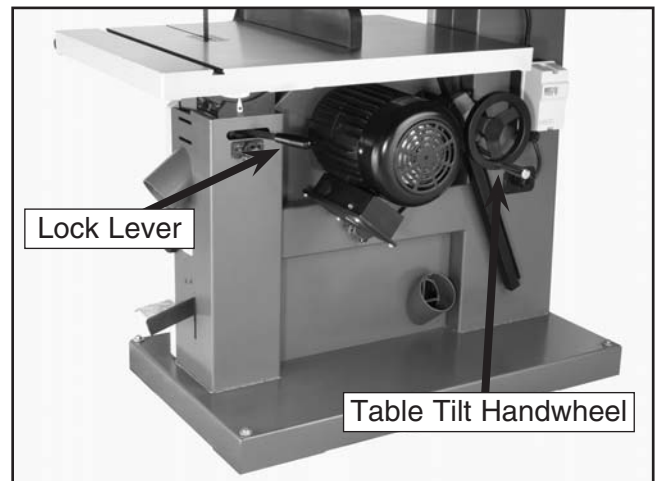


Figure 14. Table tilt controls.

To adjust the table tilt:

1. Loosen the table tilt lock lever.
2. To tilt the table to the right, turn the table tilt handwheel clockwise.
3. 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.
4. Secure the table tilt lock lever.



Blade Tracking

The blade tracking is primarily affected by the tilt of the upper wheel, also known as **Center Tracking**; and the alignment of both wheels, also known as **Coplanar Tracking** (see “Wheel Alignment” on page 46)

The wheels were aligned at the factory, so center tracking is the only adjustment that needs to be performed during set up.

To center track the blade:

1. Adjust the upper and lower guide bearings and support bearings away from the blade.
2. Open the upper wheel cover.
3. Adjust blade tension to match the size of the installed blade with the mark on the blade tension scale. Note—Changes in blade tension may change the blade tracking.

CAUTION

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

4. 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 tracked properly and no further adjustments are needed at this time.

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

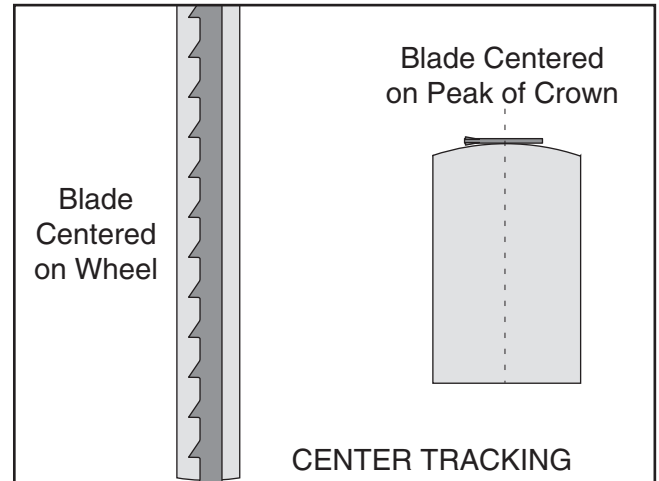


Figure 15. Center tracking profiles.

5. Loosen the lock lever (**Figure 16**) on the blade tracking knob.

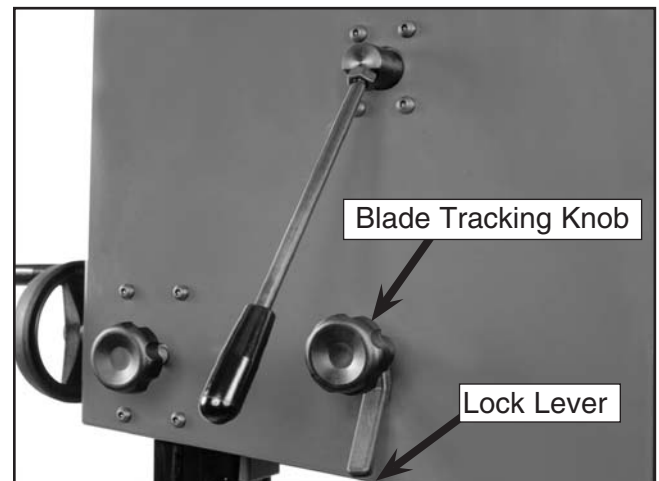


Figure 16. Blade lock lever and tracking knob.

6. 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 tire, while observing the tracking path through the blade tracking window.
7. When the blade is tracking correctly, tighten the tracking control lock handle and close the upper wheel cover.

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



Table Alignment

To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade.

| Tools Needed: | QTY |
|----------------------|------------|
| Hex Wrench 8mm..... | 1 |
| Straightedge | 1 |
| Fine Ruler..... | 1 |

To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and is correctly tensioned.
2. Loosen the trunnion cap screws that secure the table to the trunnions.
3. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.
4. Use a fine ruler to gauge the distance between the blade and the miter slot. The distance you measure should be the same at both the front and the back of the table.
5. Rotate the table in the direction needed to correctly align the table.
6. Tighten the trunnion cap screws when the alignment is correct.



Miter Gauge

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

To calibrate the miter gauge:

1. Use a machinist square with one edge against the face of the miter gauge and the other against the belt face as shown in **Figure 17**.



Figure 17. Squaring miter gauge to blade.

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



Fence Alignment

Fence alignment is critical for optimum performance from your new bandsaw. Follow these steps to properly align the fence with the miter slot.

Tools Needed: **QTY**
Hex Wrench 8mm..... 1

To align the fence parallel to the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and re-install it on the right-hand side of the blade.
2. Loosen the three cap screws that secure the rail to the table.
3. Adjust the fence face parallel with the edge of the miter slot as shown in **Figure 18**.



Figure 18. Fence square with miter slot.

4. Tighten the three cap screws that secure the rail to the table.



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.

Tools Needed: **QTY**
Phillips Screwdriver 1

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 (**Figure 19**).



Figure 19. Fence flush with blade.

3. Loosen the pointer adjustment screw and set the pointer in line with "0" and the measurement scale on the table.
4. Tighten the pointer adjustment screw.



Dust Collection

⚠ CAUTION

DO NOT operate the Model G0566/G0568/G0569 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

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

| Tools Needed: | |
|----------------------------|---|
| Phillips Screwdriver | 1 |

To connect a dust collection hose:

1. Place the hose clamps over the end of the 4" flexible hoses.
2. Fit the 4" flexible hoses over the dust ports, as shown in **Figure 20**, and tighten.



Figure 20. Dust hose attached to dust port.


3. Tug the hoses to make sure that they do not come off. A tight fit is necessary for best performance!
4. Connect the hoses to a dust collection system with the remaining hose clamps.



Test Run

Once the assembly is complete and you have performed all the procedures in this manual up to this step, a test run of the machine is necessary to continue with the remainder of the Set Up procedures.

If, during the test run, there is a source of unusual noise or vibration that you can not easily locate, feel free to contact our service department for help.

| | |
|------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <h2>⚠ WARNING</h2> <p>Wear safety glasses during the entire test run process. Failure to comply may result in serious personal injury.</p> |
|------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|

To test run the machine:

1. Make sure that you have performed all procedures in this manual up to this step before continuing with these instructions.
2. Make sure that the blade guides are moved away from the blade and that the blade is not touching the table or table insert.
3. Plug the machine into the power source.
4. Turn the key ON, rotate the OFF button to the right, then press the ON button. Keep your hand poised over the switch in case you need to quickly turn the machine OFF.
5. Watch and listen to the bandsaw for abnormal noises or actions. The bandsaw should run smoothly with little or no vibration or rubbing noises. Note—Strange or unnatural noises should be investigated and corrected before further operation of the machine; always unplug the machine when investigating or correcting any situation with the machine. Refer to Troubleshooting on **page 68**.



Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is a prerequisite before making many bandsaw adjustments. Release the blade tension when not in use to minimize undue strain on the blade.

To tension the bandsaw blade:

1. Make sure you have performed all procedures in this manual up to this point, and the blade guides are adjusted as far away as possible from the blade path.
2. With the blade tension lever in the down (engaged) position (**Figure 21**), adjust the blade tension handwheel (**Figure 22**) until the blade tension scale matches the size of blade that is installed on the bandsaw.

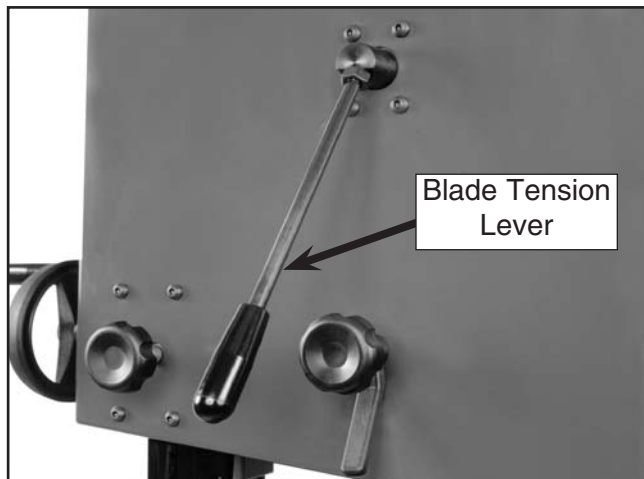


Figure 21. Blade tension lever engaged.

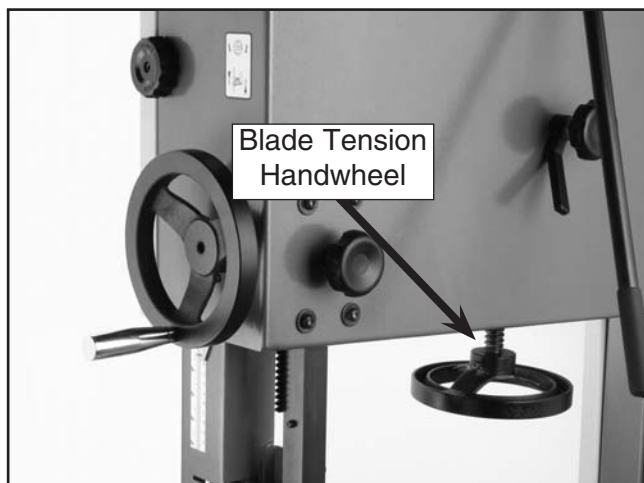


Figure 22. Blade tension handwheel.

3. Turn the bandsaw ON.
4. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.
5. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension one more quarter of a turn.
6. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future.

NOTICE

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



Blade Guides

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

| Tools Needed: | QTY |
|---------------------|-----|
| Wrench 10mm | 1 |
| Hex Wrench 5mm..... | 1 |

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Familiarize yourself with the blade guide controls shown in **Figure 23**.

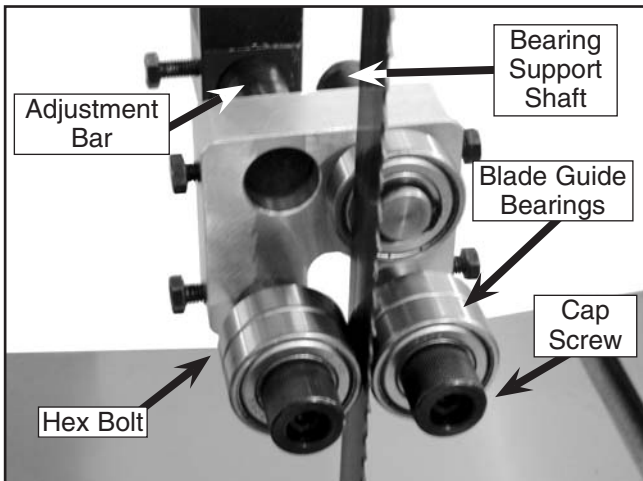


Figure 23. Blade guide controls.

4. Loosen the hex bolt on the bearing support shaft, and slide the blade support bearing all the way back.
5. Loosen the hex bolt on the adjustment bar and slide the bar forward or backward until the bearings rest $\frac{1}{16}$ " back from the blade gullets as shown in **Figure 24**.

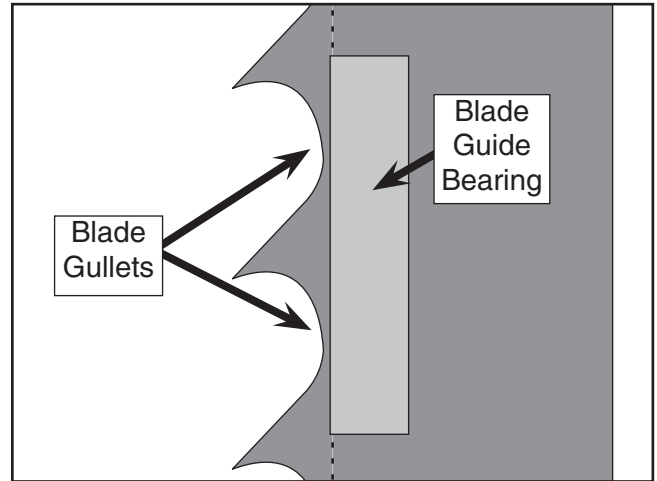


Figure 24. Proper position of blade guides.

6. Tighten the hex bolt on the adjustment bar to secure the guide bearings position.
7. Loosen the lower two hex bolts on the blade guide support bracket.
8. Rotate the bearings with the hex wrench until the bearings almost touch the blade as illustrated in **Figure 25**. Note—Fold a dollar bill in half, place it over the blade. Slide the dollar bill and bearing through the blade guides. If the dollar bill and blade do not fit through the guides, they are too tight.

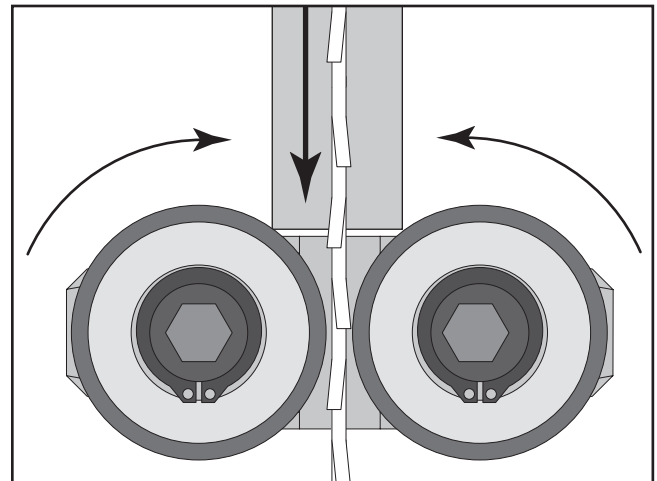


Figure 25. Blade guides bearings properly adjusted.

9. Tighten the hex bolts to lock the blade guides in position. Note—after the blade guides are tightened, the bearings should still spin.



Support Bearings

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

| Tools Needed: | QTY |
|--------------------------|-----|
| Wrench 10mm | 1 |
| Feeler Gauge .016" | 1 |

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Familiarize yourself with the support bearing detail shown in **Figure 26**.

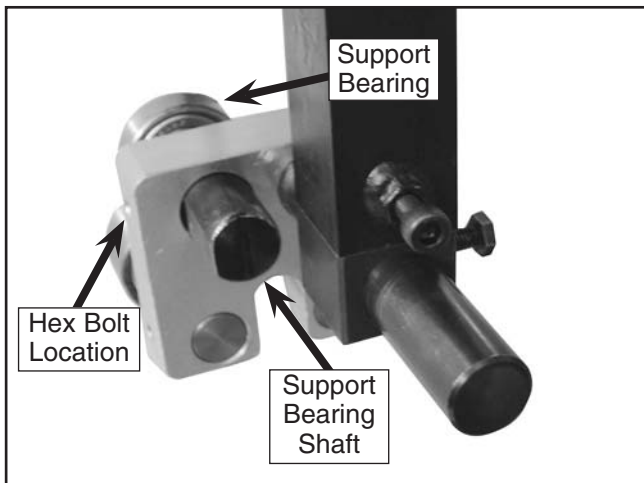


Figure 26. Support bearing detail.

7. Loosen the hex bolt on the support bearing shaft.
8. Using the feeler gauge, position the support bearing approximately .016" away from the back of the blade as illustrated in **Figure 27**.

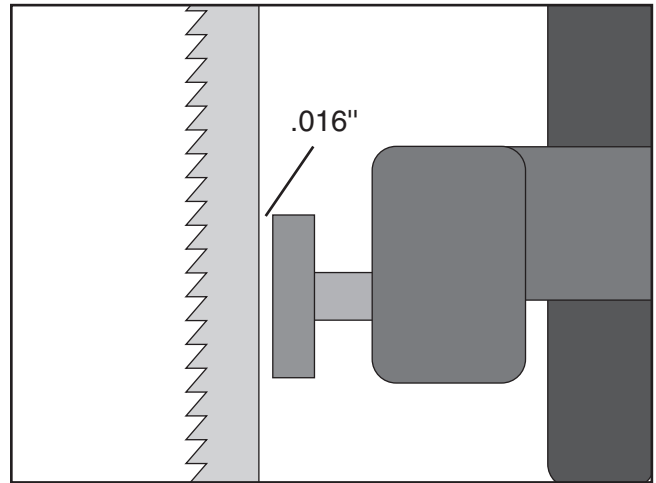


Figure 27. Support bearing spacing.

10. Tighten the hex bolt on the support bearing shaft to keep the support bearing locked in place.

NOTICE

When changing a blade or adjusting tension and tracking, all blade support bearings and guide-blocks must be properly adjusted before cutting operations.

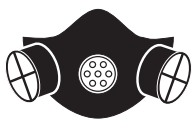


SECTION 4: OPERATIONS

Operation Safety

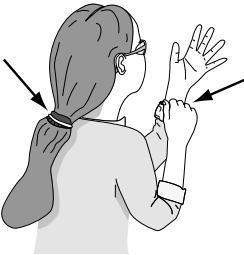
⚠️ WARNING

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



⚠️ WARNING

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



NOTICE

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



Foot Brake

The Model G0566/G0568/G0569 is equipped with a foot brake (**Figure 28**). Use the brake only in emergency situations to disconnect power 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.

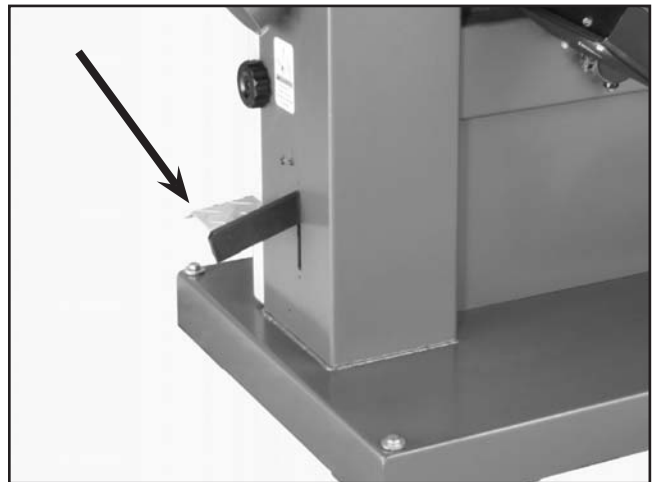


Figure 28. The foot brake is located below the dust collection port.



Key Switch

One of the most useful safety features of the Model G0566/G0568/G0569 is the key switch (**Figure 29**). To disable the ON and OFF controls turn the key to "0" and remove the key if desired. To enable the ON and OFF controls, turn the key to "1". The OFF button functions also as an emergency stop switch. If at any time during operation of the bandsaw a safety hazard present itself, immediately press the OFF button, or use the foot brake to bring the blade to a halt.



Figure 29. G0566/G0568/G0569 control panel.

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



Guide Post

The guide post moves up and down on a rack-and-pinion system that is adjusted by turning the guide post handwheel shown in **Figure 30**. The upper blade guide assembly is attached to the bottom end of the guide post. The guide post/upper blade guide assembly is set correctly when the bottom edge of the guide bearings are approximately $\frac{1}{4}$ " above the top surface of the workpiece.

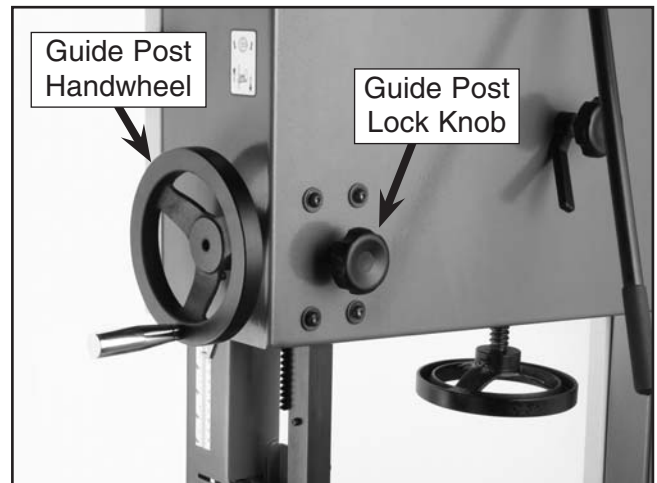


Figure 30. Guide post handwheel and lock knob.

To adjust the guide post:

1. Loosen the guide post lock knob.
2. Turn the guide post handwheel to raise or lower the guide post/upper blade guide assembly $\frac{1}{4}$ " above the workpiece.
3. Tighten the guide post lock knob.



Ripping

Ripping is cutting with the grain direction of the workpiece. Ripping man-made wood products like plywood is cutting parallel with the longest side.

To make a rip cut:

1. Set the fence to the desired width of cut on the fence rail scale.
2. Adjust the guide post/blade guide assembly to the correct height.
3. Square one long edge of the workpiece on a jointer.
4. Place jointed edge of the workpiece against the fence, and feed the workpiece into the saw blade with a push stick as shown in **Figure 31**. Refer to "Blade Lead" on **page 32** for further instruction.



Figure 31. Ripping with a push stick.



Crosscutting

Crosscutting is cutting across the grain direction of the workpiece. Crosscutting man-made wood products like plywood is cutting parallel with the shortest side.

To make a 90° crosscut:

1. Adjust the miter gauge to the 90° position.
2. Adjust the guide post to the correct height.
3. Position the workpiece against the miter gauge and line up the cut with the blade.
4. While holding the workpiece against the miter gauge, feed the workpiece through the saw blade as shown in **Figure 32**. Refer to "Blade Lead" on **page 32** for further instruction.



Figure 32. Crosscutting with the miter gauge.



Resawing

Resawing is cutting a board into two thinner pieces. The width and length dimensions remain the same. The maximum workpiece height that can be resawn is 20" on the Model G0566 and 24¹/₂" G0568 & G0569.

To make a resaw cut:

1. For the most accurate and straight cut, install the widest blade available for your bandsaw when performing resaw operations. The best tooth style is a hook tooth between 3 and 6 teeth-per-inch.
2. Joint one face of the workpiece on a jointer.
3. Adjust the guide post/blade guide assembly to the correct height for the workpiece.
4. Adjust the fence to the desired location for the planned cut.
5. The jointed face of the workpiece must be against the fence during the operation. Use a push paddle, and slowly feed the workpiece into the blade (**Figure 33**). Refer to "Blade Lead" on **page 32** for further instruction.



Figure 33. Resawing lumber.



Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without being twisted. 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 teeth-per-inch (TPI), or make relief cuts into the tight corners. A blade with more TPI can cut relatively tighter curves, though the cut is usually rougher than cuts produced by a blade with a medium amount of TPI.

Always make short cuts first, then proceed to the longer cuts. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the cut line. Make relief cuts from the workpiece edge to points along the cut line where there are sharp changes in direction. Relief cuts will reduce the chance that the blade will be pinched or twisted. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. (**Figure 34**).

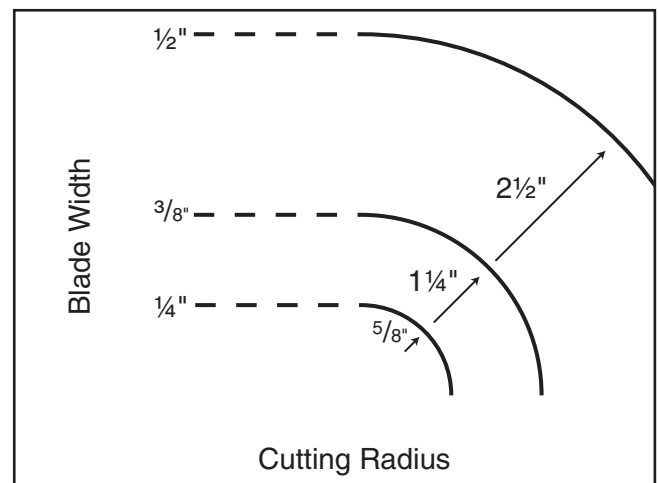


Figure 34. Blade width to cutting radius chart.



Blade Lead

It is common for a bandsaw blade to wander off the cut line when sawing as shown in **Figure 35**. This is called blade lead.



Figure 35. Blade leading away from line of cut.

To correct blade lead:

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

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut the board on the line by pushing it into the blade with the miter gauge.
3. **Unplug the bandsaw!**
4. Loosen the table mounting bolts. Shift the table to compensate for the blade lead.
5. Repeat **Steps 1-4** until the blade cuts straight.
6. Tighten the table bolts.



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°. Any misalignment will be magnified with each piece.

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!)

CAUTION

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

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 wood grain 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 36**.



Figure 36. Cutting multiple pieces at once.



Blade Information

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

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. Refer to the current Grizzly catalog for prices and ordering information.

G0566 Blade Length 163"-166"
 G0568/G0569 Blade Length..... 179"-182"

Blade Width

Measured from the back of the blade to the tip of the blade tooth, blade width is often the first consideration. 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 G0566 can use blades from 1/4" to 1-3/8" in width. The Models G0568 & G0569 can use blades that range from 1/4" to 1-1/2". Always pick the blade size to best suit your application.

- **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.
- **Curve Cutting**—Use the chart in **Figure 37** 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.

Blade Tooth Type

Carbon Steel—The less expensive carbon steel blades are adequate for most cutting applications; however, they dull quickly and for economical reasons they are usually replaced rather than resharpened.

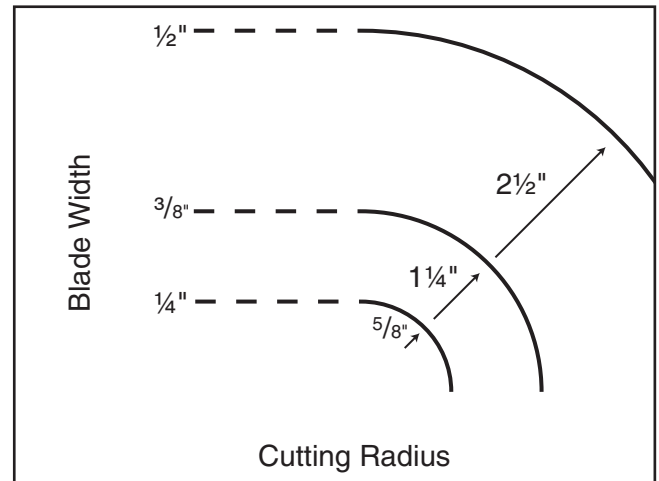


Figure 37. Ideal cutting radius/blade sizes.

Carbide Tipped—The more expensive carbide-tipped blades are designed for continuous use in production shop situations. They hold an edge longer than carbon steel and they can be resharpened many times before needing to be replaced.

Figure 38 shows the two of blades available for this saw:

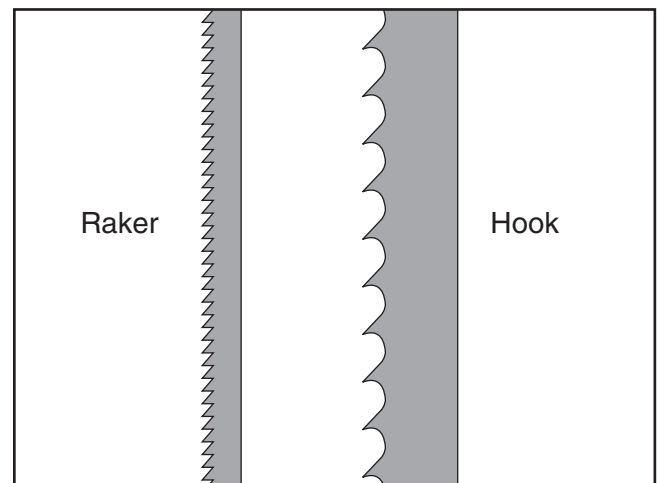


Figure 38. Raker, & Hook tooth styles.

- **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 at the same time do not cut fast and generate more heat while cutting.

- **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 T.P.I. (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 optimize the longest use from a bandsaw blade if you give it fair treatment. 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:

- improperly aligned and adjusted 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.
- Excessive/insufficient tension.
- Top blade guide assembly set too high above the work piece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.



Saw Blade Removal



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

To remove the blade:

1. **Unplug the bandsaw!**
2. Release tension on the blade by rotating the quick release tension lever clockwise as shown in **Figure 39**.

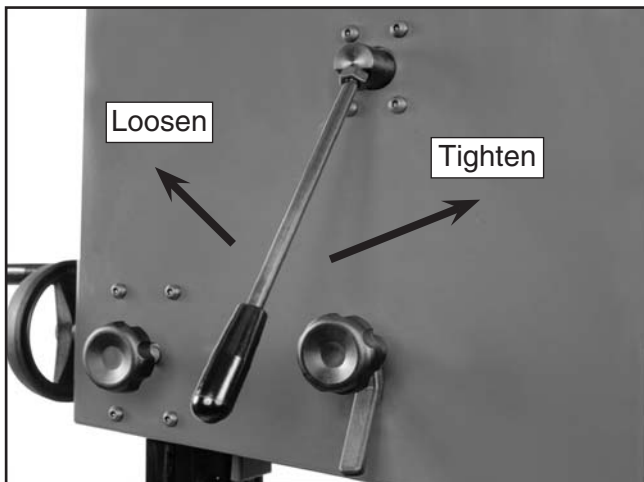



Figure 39. Quick release tension lever.

3. Open the upper and lower wheel covers and slide the blade off both wheels. Note—If the blade does not slide off easily, loosen the blade tension handwheel.
4. Feed the blade through the blade guards, table slot and fence rail, and remove from the saw.



Installing Saw Blade



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

Components and Hardware Needed: Qty
Saw Blade 1

To install the blade:

1. **Unplug the bandsaw!**
2. Make sure the quick release tension lever shown in **Figure 39** is released.
3. With the blade teeth pointing downward, slide the blade around the fence rail and through the table slot. Note—If the blade cannot be positioned with the teeth pointing downward, it may be inside out. While wearing leather gloves, flip the blade right-side out.
4. Slide the blade through the upper and lower blade guides, and blade guard, then place and center it on the upper and lower wheels.
5. Tighten the quick release tension lever.
6. Close the wheel covers.
7. Check tracking and tensioning.

!CAUTION

Operating the bandsaw before the blade tracking and tension have been adjusted could cause the blade to fall off the wheels resulting in operator injury.



SECTION 5: ACCESSORIES

Replacement Blades

Replacement blades for the Model G0566 Industrial Bandsaw. Hook blades are signified by the H after the TPI, and raker blades are signified by the R after TPI.

| MODEL | TYPE | WIDTH | GAUGE | TPI |
|-------|--------|--------|--------|------|
| H6978 | Carbon | 1/2" | 0.025" | 3H |
| H6979 | Carbon | 1/2" | 0.025" | 4H |
| H6980 | Carbon | 1/2" | 0.025" | 6H |
| H6981 | Carbon | 1/2" | 0.025" | 10R |
| H6982 | Carbon | 1/2" | 0.025" | 14R |
| H6983 | Carbon | 1" | 0.035" | 2H |
| H6984 | Carbon | 1" | 0.035" | 6H |
| H6985 | Carbon | 1" | 0.035" | 10R |
| H6986 | Carbon | 1 1/4" | 0.035" | 1.3H |
| H6987 | Carbon | 1" | 0.035" | 3H |

Replacement blades for the Model G0568/G0569 Industrial Bandsaw.

| MODEL | TYPE | WIDTH | GAUGE | TPI |
|-------|--------|--------|--------|------|
| H6988 | Carbon | 1/2" | 0.025" | 3H |
| H6989 | Carbon | 1/2" | 0.025" | 4H |
| H6990 | Carbon | 1/2" | 0.025" | 6H |
| H6991 | Carbon | 1/2" | 0.025" | 10R |
| H6992 | Carbon | 1/2" | 0.025" | 14R |
| H6993 | Carbon | 1" | 0.035" | 2H |
| H6994 | Carbon | 1" | 0.035" | 6H |
| H6995 | Carbon | 1" | 0.035" | 10R |
| H6996 | Carbon | 1 1/4" | 0.035" | 1.3H |
| H6997 | Carbon | 1" | 0.035" | 3H |

Call 1-800-523-4777 To Order

G7984—Face Shield

H1298—Dust Sealed Safety Glasses

H1300—UV Blocking, Clear Safety Glasses

H2347—Uvex® Spitfire Safety Glasses

H0736—Shop Fox® Safety Glasses

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



Figure 40. Our most popular safety glasses.

H1302—Standard Earmuffs

H4979—Deluxe Twin Cup Hearing Protector

H4977—Work-Tunes Radio Headset Earmuffs

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



Figure 41. Our most popular earmuffs.

H5408—Blade Tensioning Gauge

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

The Blade Tensioning Gauge is made of lightweight, cast aluminum for optimum accuracy. Bright color coding makes it easy to use and easy to read. The Blade Tensioning Gauge comes in a handy metal box with instructions on the lid.



Figure 42. H5408 Blade Tensioning Gauge.

H3788—G96® Gun Treatment 12 oz Spray

H3789—G96® Gun Treatment 4.5 oz Spray

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



Figure 43. G96® Gun Treatment spray.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

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



Figure 44. SLIPIT® gel and spray.

G1955—OxiSolv® Blade & Bit Cleaner

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

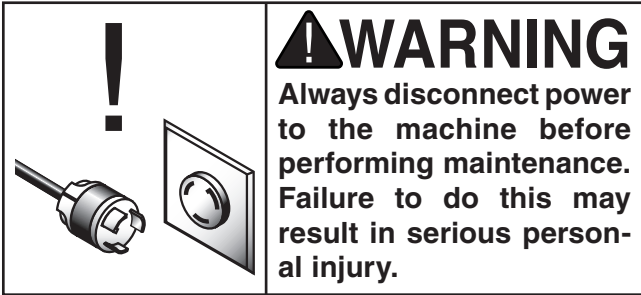


Figure 45. G1955 OxiSolv® spray.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

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

Daily Maintenance:

- Check for loose mounting bolts.
- Check for damaged saw blade.
- Check for worn or damaged wires.
- Check for worn or damaged guide bearings.
- Check for any other unsafe condition.
- Check guide bearing for sawdust build-up, clean when necessary.
- Check wheel brushes for sawdust build-up, clean/adjust when necessary.
- Wipe sawdust buildup from table surface.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Wipe a lubricant such as SLIPIT® onto the cast iron table.

Monthly Maintenance:

- Check V-belt tension, damage, and wear; replace as necessary.
- Lubrication as shown on the next page.



Cleaning

Cleaning the Model G0566/G0568/G0569 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.



Unpainted Cast Iron

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

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Section 5: Accessories on **page 37** for more details).



Lubrication

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

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

To lubricate the blade guide rack and pinion:

1. **Unplug the bandsaw!**
2. Lower the blade guide until it reaches the table.
3. Wipe off any existing grease and sawdust buildup on the rack.
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.

To lubricate the blade tracking knob:

1. **Unplug the bandsaw!**
2. Unscrew the blade tracking knob 5-6 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 Section 3: Set Up on **page 14**).

To lubricate the tension adjustment assembly (Figure 46):

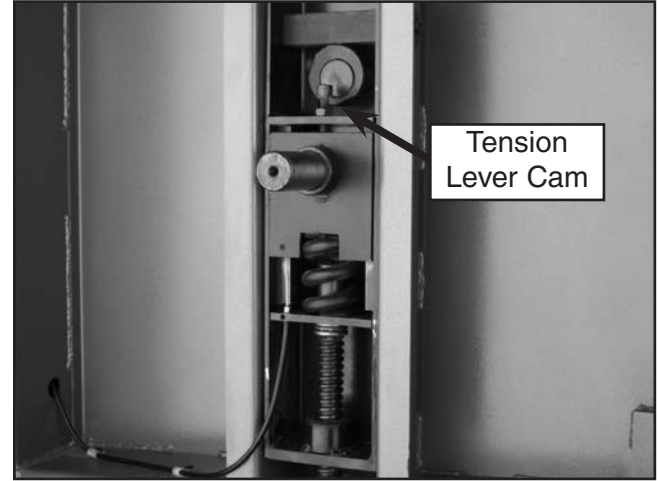


Figure 46. Tension adjustment assembly.

1. **Unplug the bandsaw!**
2. Wipe off any existing grease and sawdust buildup on the blade tension adjustment assembly and tension lever cam.
3. Apply a thin coat of grease to the tension adjustment assembly and tension lever cam.

To lubricate the table tilt rack and pinion assembly:

1. **Unplug the bandsaw!**
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 (**Figure 47**) off all existing grease and sawdust buildup from the rack.

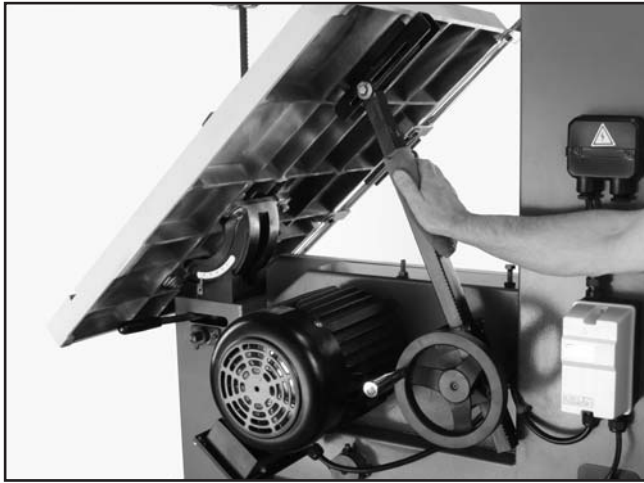


Figure 47. Table tilt rack and pinion assembly.

4. Apply a thin coat of light all-purpose grease to the rack.
5. Move the table up and down several times and wipe off any excess grease.

To lubricate the trunnions:

1. **Unplug the bandsaw!**
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.
4. Move the table down and then back up. Wipe off any excess grease from the trunnions.



Brushes

The bandsaw is equipped with three brushes. The brushes should be checked daily and cleaned when they become dirty. Adjust the brushes to keep them in contact with the wheel and blade.

| | |
|----------------------|------------|
| Tools Needed: | QTY |
| Wrenches 10mm | 2 |

To adjust the wheel brushes:

1. **Unplug the bandsaw!**
2. Open the wheel covers, and locate the brushes (**Figure 48**).
3. Loosen the hex bolts holding the brushes in place.
4. Adjust the brushes so light contact with the wheel/blade is made.
5. Tighten the hex bolts.

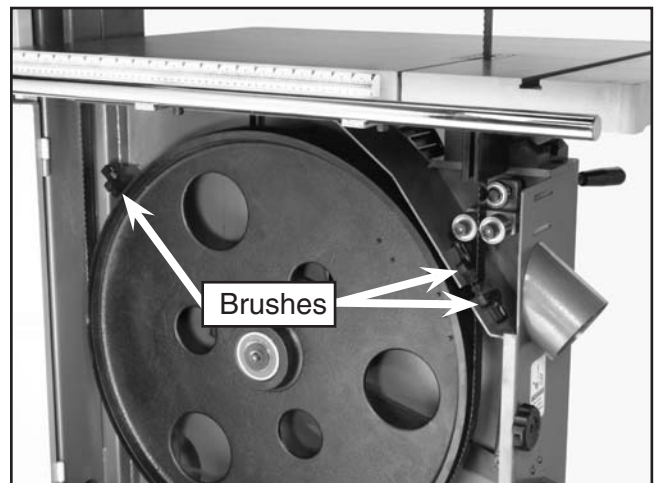
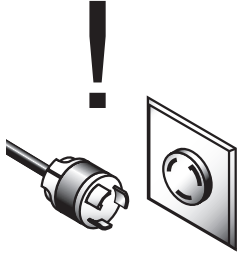


Figure 48. Brush locations.



SECTION 7: SERVICE

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

About Service

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

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

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



Items Needed for Service

The following items are needed, but not included, to complete the service process:

| DESCRIPTION | QTY |
|----------------------------------------------------------|-----|
| • Safety Glasses (for each person) | 1 |
| • Board 2" x 4" x 70 ¹ / ₄ " | 1 |
| • Tape Measure | 1 |
| • Circular Saw | 1 |
| • Jointer | 1 |
| • Calipers | 1 |
| • Hex Wrench 5mm | 1 |
| • Hex Wrench 6mm | 1 |
| • Wrench 13mm | 1 |
| • Wrench 12mm | 1 |



Checking V-Belts

For optimal power transmission from the motor to the blade, the V-belts must be in good condition and properly tensioned. 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.

To check the V-belts:

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



Tensioning V-Belts

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

To tension the V-belt:

1. **Unplug the bandsaw!**
2. Open the wheel covers.
3. Loosen the motor adjustment and hinge bolts shown in **Figure 49**.

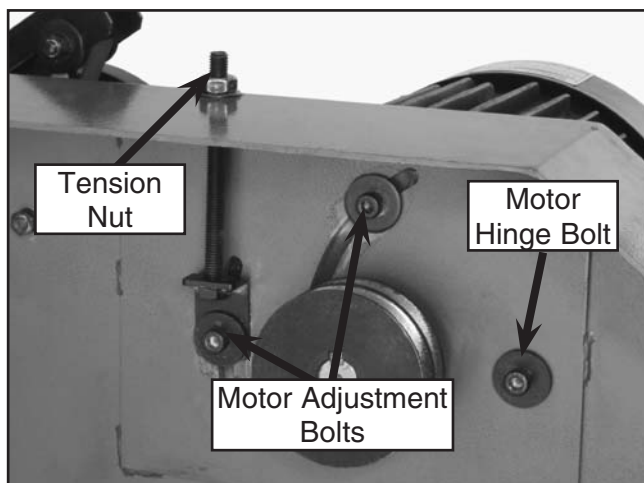


Figure 49. Motor mount bolts and tension bolt.

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 $\frac{3}{4}$ " with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more/less than $\frac{3}{4}$ ", repeat **step 4**.
7. When the V-belt tension is correct, tighten the motor adjustment and hinge bolts, and close the wheel covers.



Replacing V-Belt

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

To replace the V-belt:

1. **Unplug the bandsaw!**
2. Open the wheel covers and remove the bandsaw blade.
3. Loosen the motor mount bolts shown in **Figure 49**, then turn the tension bolt counterclockwise, and pull the V-belts off.
5. Unthread the wheel cap screw shown in **Figure 50** and slide the lower wheel off of the bearing shaft.

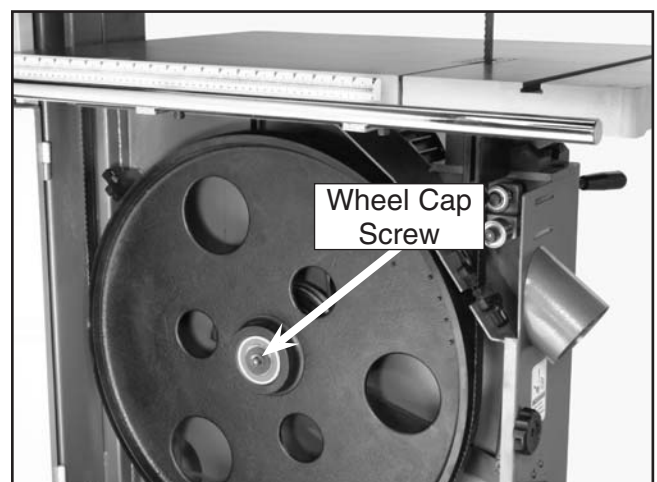


Figure 50. Wheel cap screw for removing the wheel.

6. Slip the old V-belts off of the wheel pulley and install the new V-belts in their place.
7. Install the lower wheel back onto the bearing shaft, tighten the wheel mount bolt, place the V-belts over the motor pulley, and turn the tension bolt clockwise to tighten the V-Belt tension.
8. When the tension is correct, tighten the motor hinge bolt and close the lower wheel cover.



Wheel Height Limiting Screw

The wheel height limiting screw, when set properly, prevents the wheel from making contact with the top of the bandsaw body. The screw must be set $\frac{3}{16}$ "– $\frac{1}{4}$ " below the plate and secured with the check nut to be effective.

| Tools Needed: | QTY |
|---------------------|-----|
| Hex Wrench 5mm..... | 1 |
| Hex Wrench 6mm..... | 1 |
| Wrench 12mm..... | 1 |
| Calipers | 1 |

1. **Unplug the bandsaw!**
2. Remove the blade.
3. Remove the upper wheel.
4. Measure how far the screw is threaded through the plate (**Figure 51**):
 - If it measures $\frac{3}{16}$ "– $\frac{1}{4}$ " beneath the plate, the limiting screw is set correctly.
 - If it measures more or less than $\frac{3}{16}$ "– $\frac{1}{4}$ " beneath the plate continue to **step 4**.

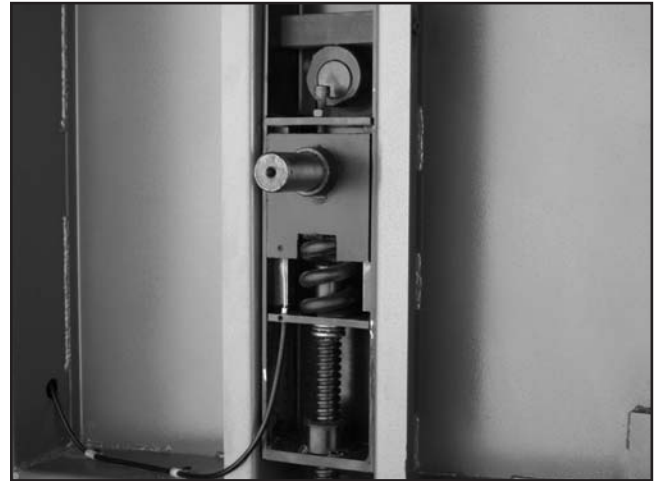


Figure 51. Wheel height limiting screw.

4. Adjust the screw in or out until the screw sticks out $\frac{3}{16}$ "– $\frac{1}{4}$ " beneath the plate, and secure it with the check nut.
5. Install the upper wheel and blade.
6. After this procedure you will need to track and tension the blade (**page 21 & page 25**).



Wheel Alignment

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

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

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

| Components and Hardware Needed: | Qty |
|--------------------------------------------------------|-----|
| Board 2" x 4" x 70 ¹ / ₄ " | 1 |

Tools Needed:

| | |
|--------------------|---|
| Wrench 17mm | 1 |
| Tape Measure | 1 |
| Circular Saw | 1 |
| Jointer..... | 1 |

To check if your wheels are coplanar:

1. The body of the bandsaw does not allow you to place a regular straightedge across both wheels at the same time. We’ve found a simple way to overcome this situation. All you need is a 70¹/₄ x 2" x 4" board, a jointer and a circular saw. Run the 2" x 4" across a jointer on the side to be placed against the wheels, then cut a 1¹/₂ x 28¹/₄" notch out of the center. Refer to **Figure 52** for more details on how to make this gauge.
2. After you’ve made your coplanarity gauge, remove the fence and table, then open both wheel covers.
3. Make sure the guide blocks and rear support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.
4. Place your gauge up against both wheels in the positions shown in **Figure 53**.

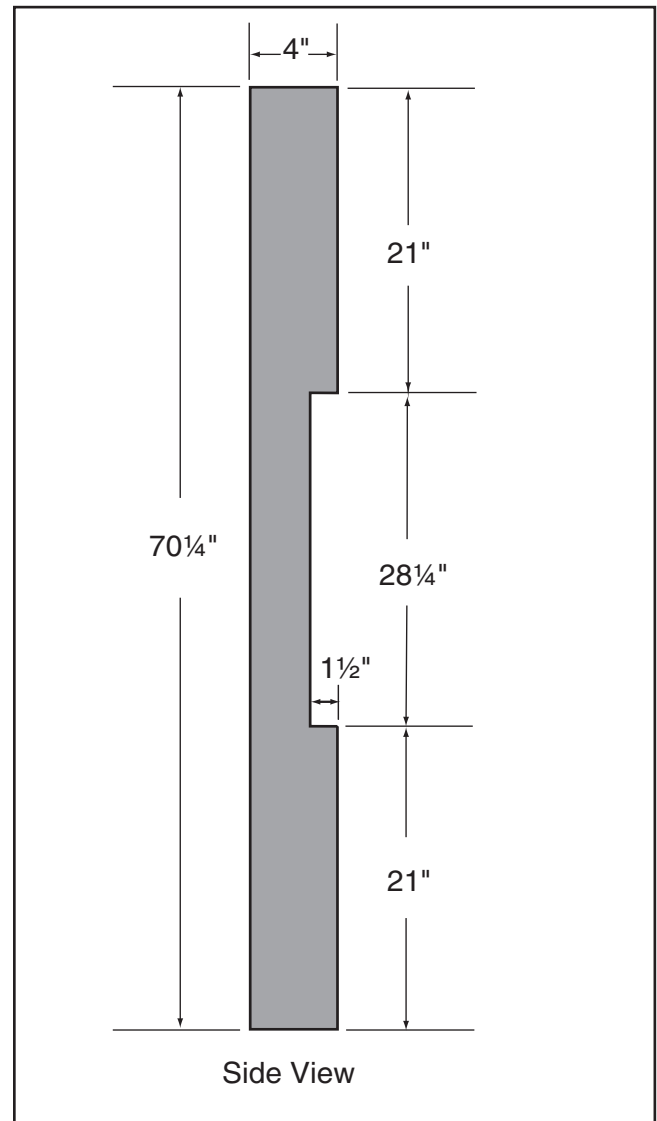


Figure 52. Dimensions of coplanarity gauge.

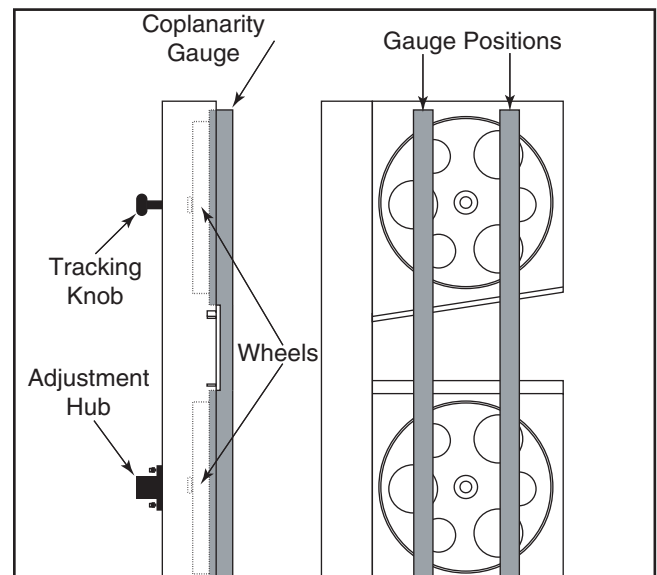


Figure 53. Checking for coplanarity.

5. The adjustment hub allows you to move the lower wheel in the desired direction. Turning all the bolts clockwise in equal amounts pushes the wheel forward. Turning all the bolts counterclockwise brings the wheel backward, closer to the adjustment hub. Used individually, each bolt can control the direction that the wheel tilts.
6. Adjust the tracking knob to get both wheels parallel. If the wheels won't go parallel to each other, then move the lower wheel at the adjustment hub so they line up.
7. If the wheels will go parallel but not coplanar, then move the lower wheel at the adjustment hub (**Figure 54**) as necessary.
8. **Figure 55** shows the positions of the wheels when coplanar. When your wheels are coplanar, readjust the guide blocks and rear support bearings, and replace the wheel covers.

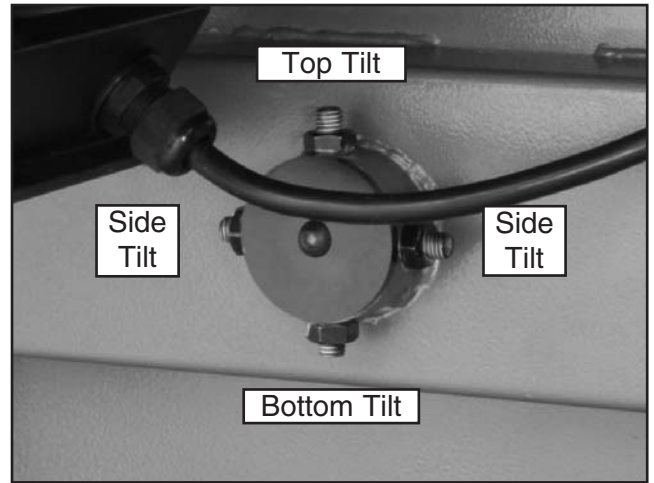


Figure 54. Lower wheel adjustment control.



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

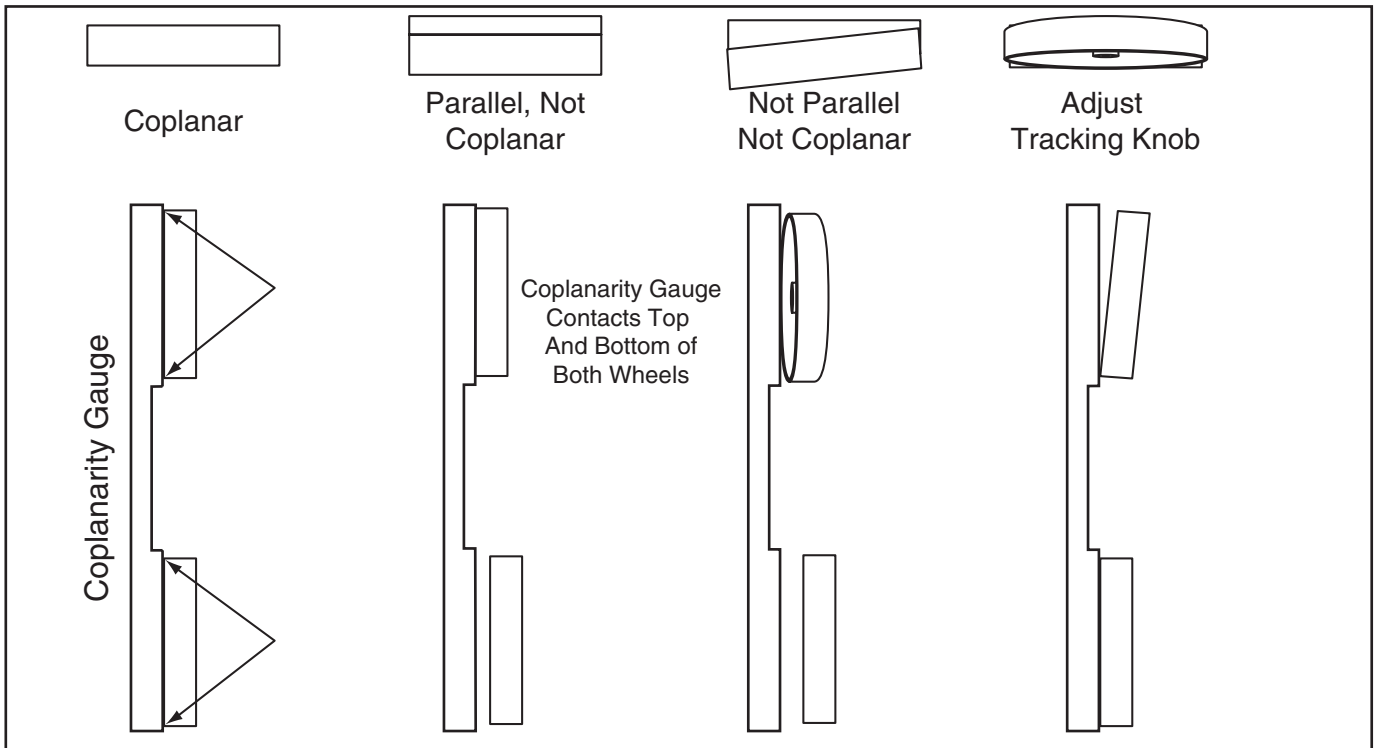
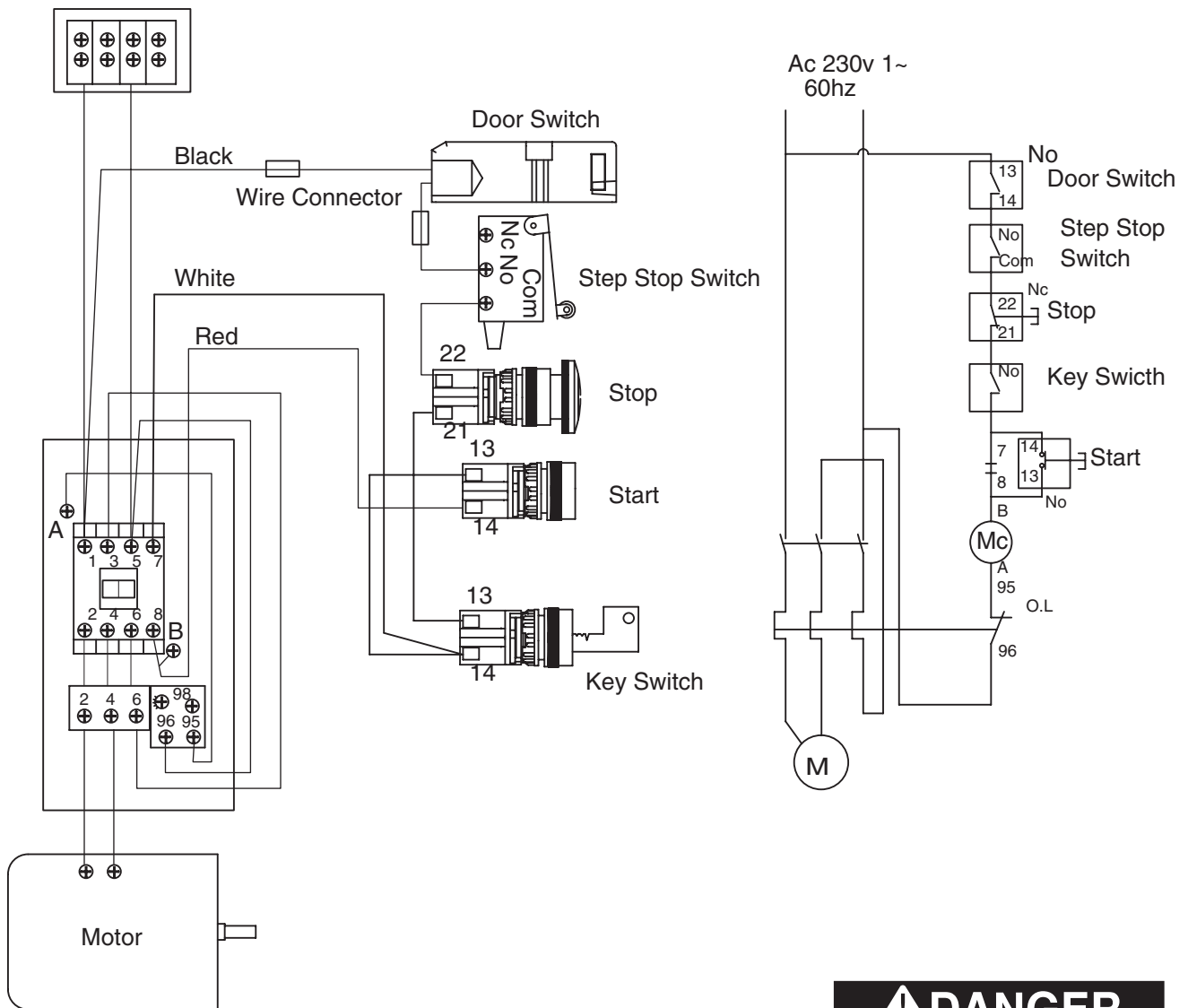


Figure 55. Coplanarity diagram.



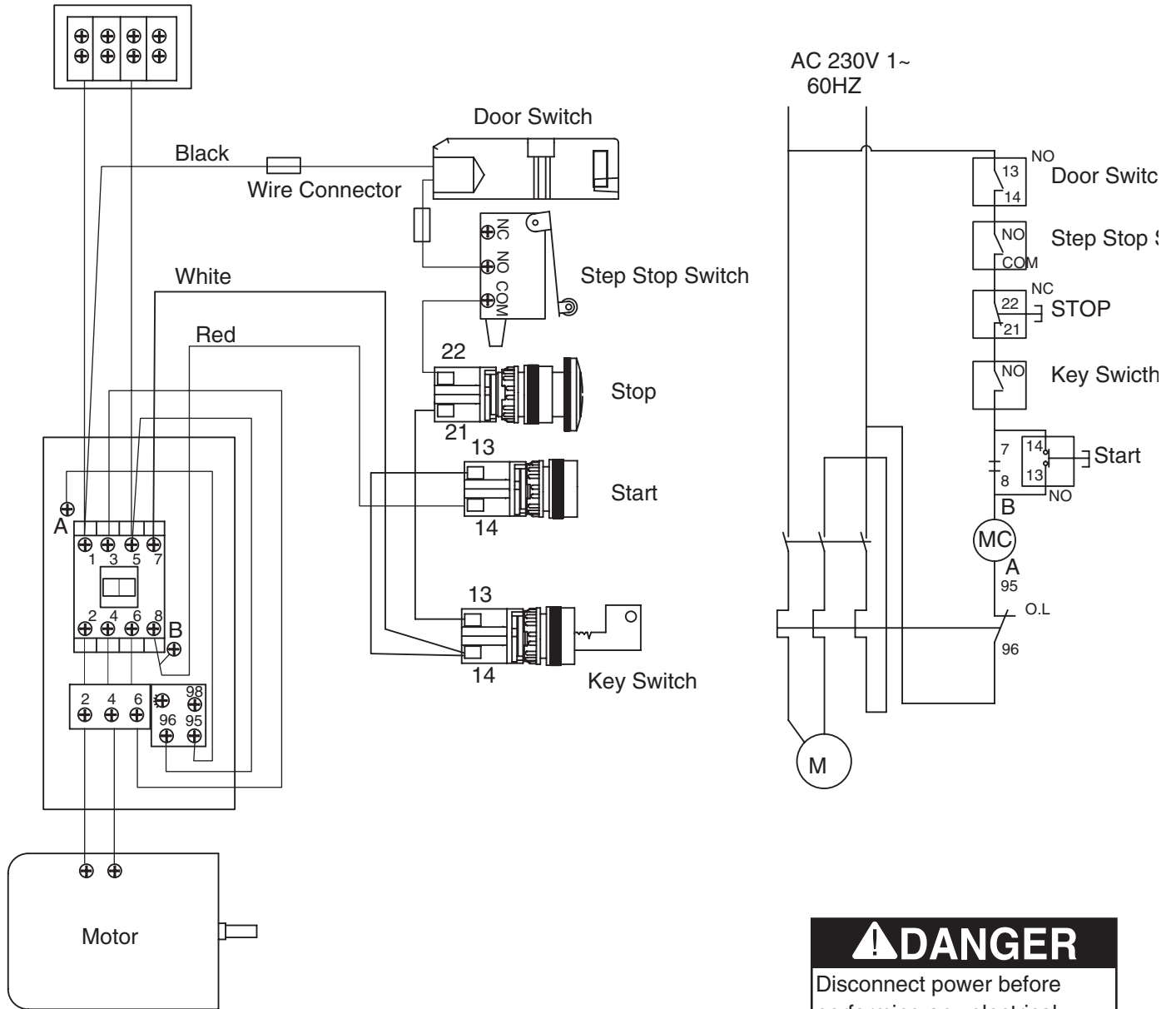
G0566
220v Single-Phase



⚠ DANGER
Disconnect Power Before
Performing Any Electrical
Service. Electricity Presents
Serious Shock Hazards That
Will Result In Severe



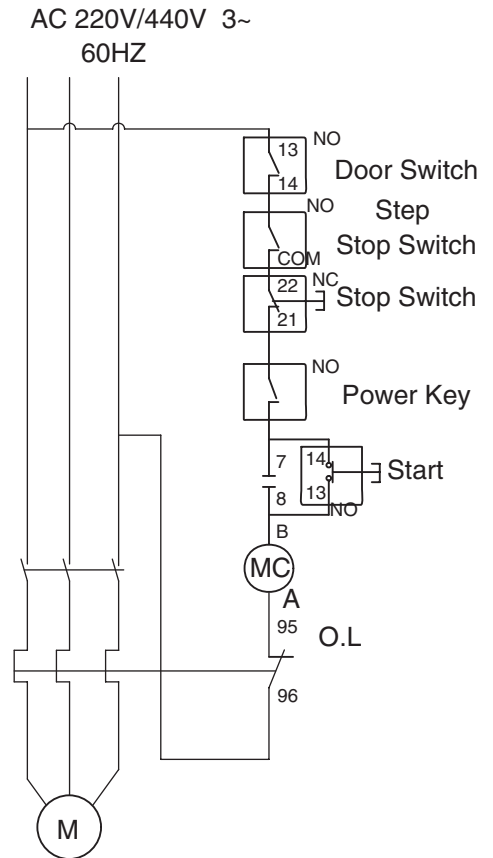
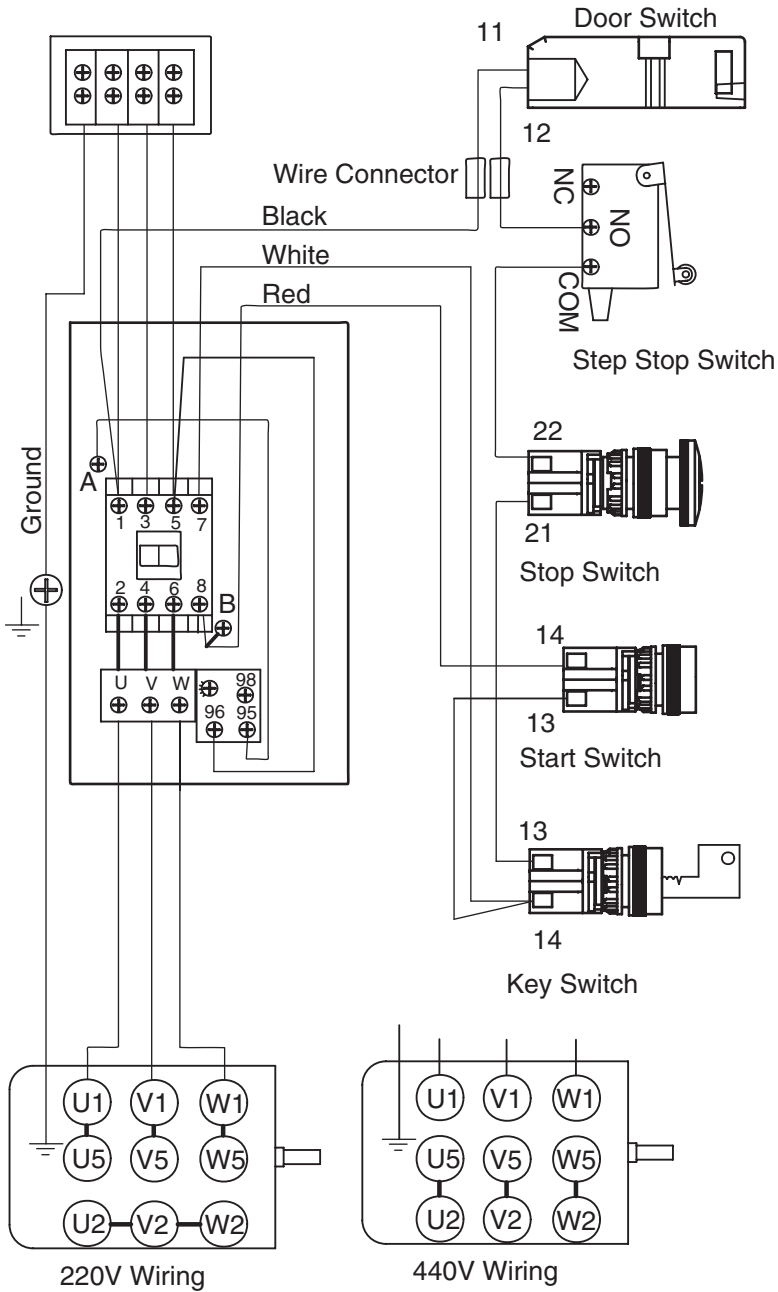
G0568
220V Single-Phase



⚠ DANGER
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal



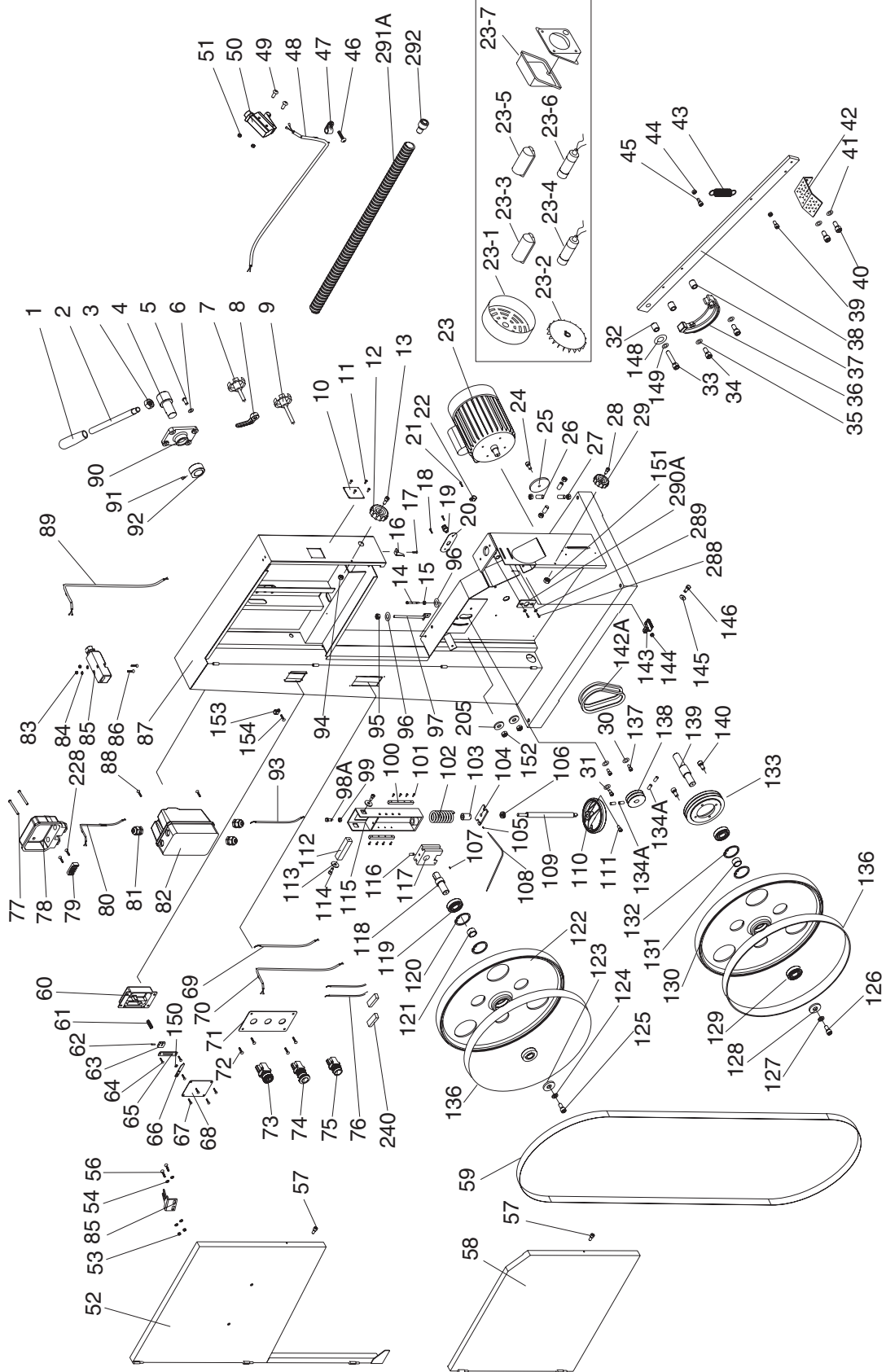
G0569
220/440v 3-Phase



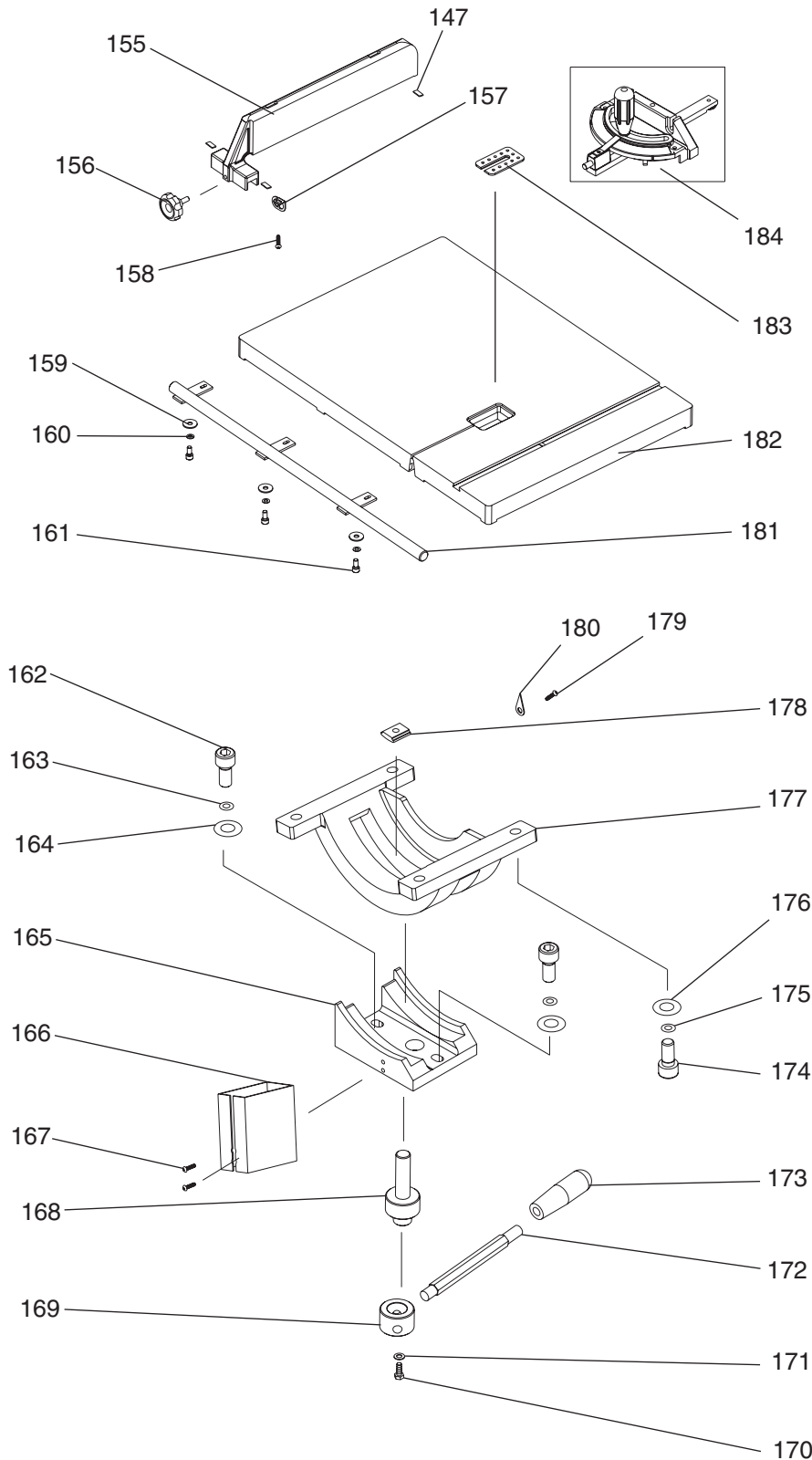
⚠ DANGER

Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal

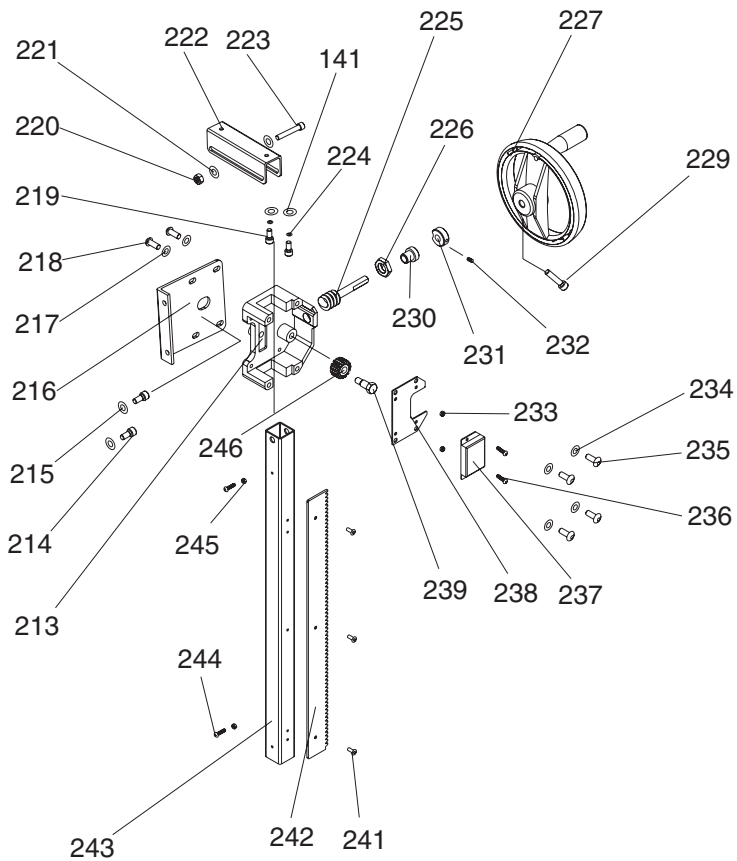
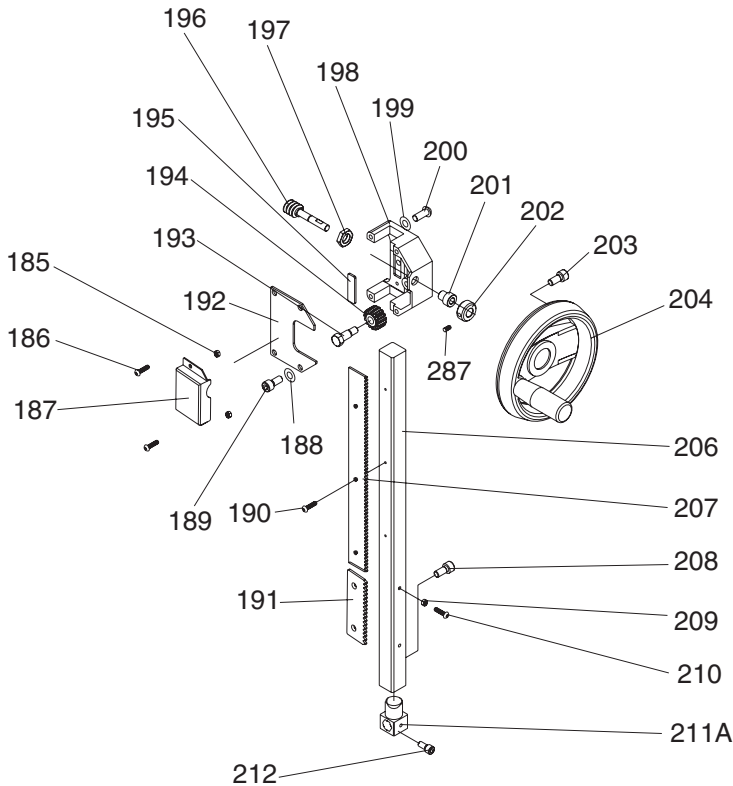
G0566 Parts Breakdown



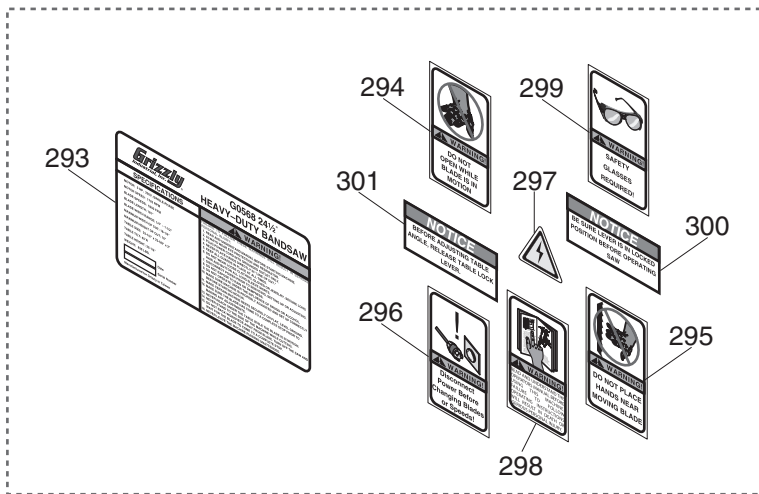
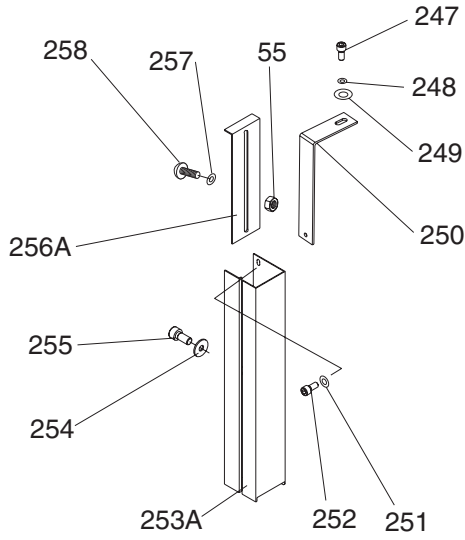
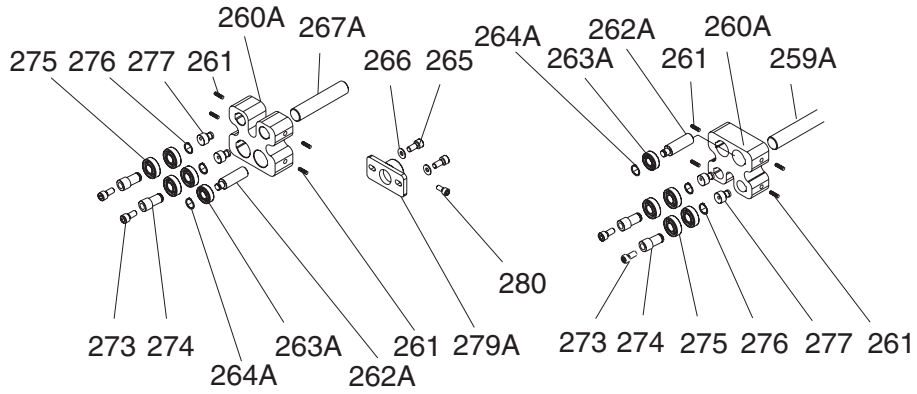
G0566 Parts Breakdown



G0566 Parts Breakdown



G0566 Parts Breakdown



G0566 Parts List

| REF | PART # | DESCRIPTION |
|------|------------|--------------------------------|
| 1 | P0566001 | HANDLE KNOB M16-1.5 |
| 2 | P0566002 | HANDLE SHAFT |
| 3 | PN05M | NUT M16-1.5 |
| 4 | P0566004 | ECCENTRIC SHAFT |
| 5 | PSBS03M | BUTTON HD CAP SCR M10-1.5 X 20 |
| 6 | PLW06M | LOCK WASHER 10MM |
| 7 | P0566007 | KNOB SCREW M10-1.5 X 25 |
| 8 | P0566008 | LOCK HANDLE M10-1.5 |
| 9 | P0566009 | KNOB SCREW M10-1.5 X 25 |
| 10 | P0566010 | TRANSLUCENT PIECE |
| 11 | P0566011 | RIVET 3.2 X 10 |
| 12 | P0566012 | LATCHING KNOB 6MM |
| 13 | PSB02M | CAP SCREW M6-1 X 20 |
| 14 | PB73M | HEX BOLT M10-1.5 X 50 |
| 15 | PN02M | HEX NUT M10-1.5 |
| 16 | P0566016 | HEIGHT POINTER |
| 17 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 18 | PHTEK4M | TAP SCREW M4 X 8 |
| 19 | P0566019 | STRAIN RELIEF M20 |
| 20 | P0566020 | PLATE |
| 21 | PHTEK4M | TAP SCREW M4 X 8 |
| 22 | P0566022 | CORD CLAMP 1/2" |
| 23 | P0566023 | MOTOR 3HP 220V 1PHASE |
| 23-1 | P0566023-1 | FAN COVER |
| 23-2 | P0566023-2 | FAN |
| 23-3 | P0566023-3 | CAPACITOR COVER |
| 23-4 | P0566023-4 | START CAPACITOR 250MFD/250V |
| 23-5 | P0566023-5 | CAPACITOR COVER |
| 23-6 | PC20A | CAPACITOR 20MFD/400V |
| 23-7 | P0566023-7 | WIRING BOX |
| 24 | PSBS01M | BUTTON HD CAP SCR M8-1.25 X 20 |
| 25 | P0566025 | COVER |
| 26 | PB01M | HEX BOLT M10-1.5 X 30 |
| 27 | PN02M | HEX NUT M10-1.5 |
| 28 | PSB02M | CAP SCREW M6-1 X 20 |
| 29 | P0566029 | LATCHING KNOB 6MM |
| 30 | PW01M | FLAT WASHER 8MM |
| 31 | PSB31M | CAP SCREW M8-1.25 X 25 |
| 32 | P0566032 | BUSHING |

| REF | PART # | DESCRIPTION |
|-----|----------|-----------------------------|
| 33 | PSB31M | CAP SCREW M8-1.25 X 25 |
| 34 | PSB06M | CAP SCREW M6-1 X 25 |
| 35 | PLW03M | LOCK WASHER 6MM |
| 36 | P0566036 | BRAKE PAD |
| 37 | P0566037 | BUSHING |
| 38 | P0566038 | BRAKE LEVER |
| 39 | PSB01M | CAP SCREW M6-1 X 16 |
| 40 | PSB01M | CAP SCREW M6-1 X 16 |
| 41 | PLW03M | LOCK WASHER 6MM |
| 42 | P0566042 | BRAKE STEP PLATE |
| 43 | P0566043 | SPRING |
| 44 | PN01M | HEX NUT M6-1 |
| 45 | PSB01M | CAP SCREW M6-1 X 16 |
| 46 | PHTEK4M | TAP SCREW M4 X 8 |
| 47 | P0566047 | CORD CLAMP 5/8" |
| 48 | P0566048 | STEP CORD |
| 49 | PB41M | HEX BOLT M4-.7 X 30 |
| 50 | P0566050 | LIMIT SWITCH KL7141 |
| 51 | PN04M | HEX NUT M4-.7 |
| 52 | P0566052 | UPPER WHEEL COVER |
| 53 | PN04M | HEX NUT M4-.7 |
| 54 | PW05M | FLAT WASHER 4MM |
| 55 | PLN03M | LOCK NUT M6-1 |
| 56 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 57 | PSB04M | CAP SCREW M6-1 X 10 |
| 58 | P0566058 | LOWER WHEEL COVER |
| 59 | P0566059 | SAW BLADE 4190X25.4X0.9mm |
| 60 | P0566060 | UPPER WHEEL SLIDING BRACKET |
| 61 | P0566061 | SPRING |
| 62 | PRP61M | PIN 3 X 12 |
| 63 | P0566063 | MOVING PLATE |
| 64 | PHTEK15M | TAP SCREW M4 X 10 |
| 65 | P0566065 | FIX PLATE |
| 66 | P0566066 | TENSION POINTER |
| 67 | PHTEK6M | TAP SCREW M4 X 16 |
| 68 | P0566068 | TENSION SCALE |
| 69 | P0566069 | CONNECTING CORD |
| 70 | P0566070 | SWITCH CORD |
| 71 | P0566071 | SWITCH PLATE |

G0566 Parts List

| REF | PART # | DESCRIPTION |
|-----|----------|----------------------------|
| 72 | PHTEK15M | TAP SCREW M4 X 10 |
| 73 | P0566073 | KEY SWITCH Ø22 |
| 74 | P0566074 | STOP SWITCH Ø22 |
| 75 | P0566075 | START SWITCH Ø22 |
| 76 | P0566076 | CONNECTING CORD |
| 77 | PFS09M | FLANGE SCREW M5-.8 X 50 |
| 78 | P0566078 | TERMINAL BOX |
| 79 | P0566079 | TERMINAL HOUSE |
| 80 | P0566080 | POWER CORD |
| 81 | P0566081 | STRAIN RELIEF M20 |
| 82 | P0566082 | MAGNETIC SWITCH MPE-18 22A |
| 83 | PN04M | HEX NUT M4-.7 |
| 84 | PW05M | FLAT WASHER 4MM |
| 85 | P0566085 | DOOR LATCH SWITCH ADZ-S11 |
| 86 | PFS10M | FLANGE SCREW M4-.7 X 35 |
| 87 | P0566087 | MACHINE BODY |
| 88 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 89 | P0566089 | SWITCH CORD |
| 90 | P0566090 | HOUSING PLATE |
| 91 | PSB31M | CAP SCREW M8-1.25 X 25 |
| 92 | P0566092 | CAM |
| 93 | P0566093 | MOTOR CORD |
| 94 | PLN03M | LOCK NUT M6-1 |
| 95 | PN02M | HEX NUT M10-1.5 |
| 96 | PW04M | FLAT WASHER 10MM |
| 97 | P0566097 | ADJUST BOLT |
| 98A | PSB60M | CAP SCREW M8-1.25 X 55 |
| 99 | PN03M | HEX NUT M8-1.25 |
| 100 | P0566100 | LOCATE PLATE |
| 101 | PFH39M | FLAT HD SCR M5-.8 X 16 |
| 102 | P0566102 | SPRING |
| 103 | P0566103 | BUSHING |
| 104 | P0566104 | PRESS BLOCK |
| 105 | PSS07M | SET SCREW M5-.8 X 5 |
| 106 | P0566106 | BEARING 51201 |
| 107 | PSS07M | SET SCREW M5-.8 X 5 |
| 108 | P0566108 | TENSION LINE |
| 109 | P0566109 | SHAFT |

| REF | PART # | DESCRIPTION |
|------|----------|-------------------------------|
| 110 | P0566110 | HANDWHEEL |
| 111 | PSB06M | CAP SCREW M6-1 X 25 |
| 112 | P0566112 | SQUARE SHAFT |
| 113 | PW01M | FLAT WASHER 8MM |
| 114 | PSB14M | CAP SCREW M8-1 X 20 |
| 115 | P0566115 | UPPER WHEEL HINGE ASSY |
| 116 | PSS75M | SET SCREW M10-1.5 X 16 |
| 117 | P0566117 | GUIDE BLOCK |
| 118 | P0566118 | UPPER WHEEL SHAFT |
| 119 | P6205 | BALL BEARING 6205LLU |
| 120 | PR26M | INT RETAINING RING 52MM |
| 121 | P0566121 | BUSHING |
| 122 | P0566122 | UPPER WHEEL Ø21" |
| 123 | PW01M | FLAT WASHER 8MM |
| 124 | PLW04M | LOCK WASHER 8MM |
| 125 | PSB14M | CAP SCREW M8-1 X 20 |
| 126 | PSB14M | CAP SCREW M8-1 X 20 |
| 127 | PLW04M | LOCK WASHER 8MM |
| 128 | PW01M | FLAT WASHER 8MM |
| 129 | P6205 | BALL BEARING 6205LLU |
| 130 | P0566130 | LOWER WHEEL Ø21" |
| 131 | P0566131 | BUSHING |
| 132 | PR26M | INT RETAINING RING 52MM |
| 133 | P0566133 | PULLEY |
| 134A | PSS04M | SET SCREW M6-1 X 12 |
| 136 | P0566136 | TIRE |
| 137 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 138 | P0566138 | PULLEY |
| 139 | P0566139 | LOWER SHAFT |
| 140 | PSBS01M | BUTTN HD CAP SCR M8-1.25 X 20 |
| 141 | PW03M | FLAT WASHER 6MM |
| 142A | PVA30 | V-BELT A-30 4L300 |
| 143 | P0566143 | BRUSH |
| 144 | PLN03M | LOCK NUT M6-1 |
| 145 | PW03M | FLAT WASHER 6MM |
| 146 | PSB02M | CAP SCREW M6-1 X 20 |
| 147 | P0566147 | NYLON PIECE |
| 148 | PW01M | FLAT WASHER 8MM |

G0566 Parts List

| REF PART # | DESCRIPTION |
|------------|----------------------------------------|
| 149 | PLW04M LOCK WASHER 8MM |
| 150 | PW05M FLAT WASHER 4MM |
| 151 | PLN03M LOCK NUT M6-1 |
| 152 | PN03M HEX NUT M8-1.25 |
| 153 | P0566153 CORD CLAMP 5/16" |
| 154 | PHTEK15M TAP SCREW M4 X 10 |
| 155 | P0566155 FENCE |
| 156 | P0566156 KNOB SCREW M10-1.5 X 25 |
| 157 | P0566157 POINTER |
| 158 | PFS01M FLANGE SCREW M5-.8 X 8 |
| 159 | PW01M FLAT WASHER 8MM |
| 160 | PLW04M LOCK WASHER 8MM |
| 161 | PB09M HEX BOLT M8-1.25 X 20 |
| 162 | PSB72M CAP SCREW M10-1.5 X 30 |
| 163 | PLW06M LOCK WASHER 10MM |
| 164 | PW04M FLAT WASHER 10MM |
| 165 | P0566165 TRUNNION HOUSING |
| 166 | P0566166 BLADE GUARD |
| 167 | PFS11M FLANGE SCREW M6 X 10 |
| 168 | P0566168 PRESS SHAFT |
| 169 | P0566169 MICRO ADJUSTING RING |
| 170 | PSB14M CAP SCREW M8-1.25 X 20 |
| 171 | PLW04M LOCK WASHER 8MM |
| 172 | P0566172 HANDLE SHAFT |
| 173 | P0566173 HANDLE KNOB M12-1.75 (FEMALE) |
| 174 | PSB84M CAP SCREW M10-1.5 X 35 |
| 175 | PLW06M LOCK WASHER 10MM |
| 176 | PW04M FLAT WASHER 10MM |
| 177 | P0566177 TRUNNION BLOCK |
| 178 | P0566178 PRESS BLOCK |
| 179 | PS38M PHLP HD SCR M4-.7 X 10 |
| 180 | P0566180 POINTER |
| 181 | P0566181 GUARD RAIL |
| 182 | P0566182 TABLE |
| 183 | P0566183 TABLE INSERT |
| 184 | P0566184 MITER GAUGE ASSY |
| 184-1 | P0566184-1 GUIDE |
| 184-2 | P0566184-2 GUIDE BAR |
| 184-3 | P0566184-3 LOCATE BRACKET |

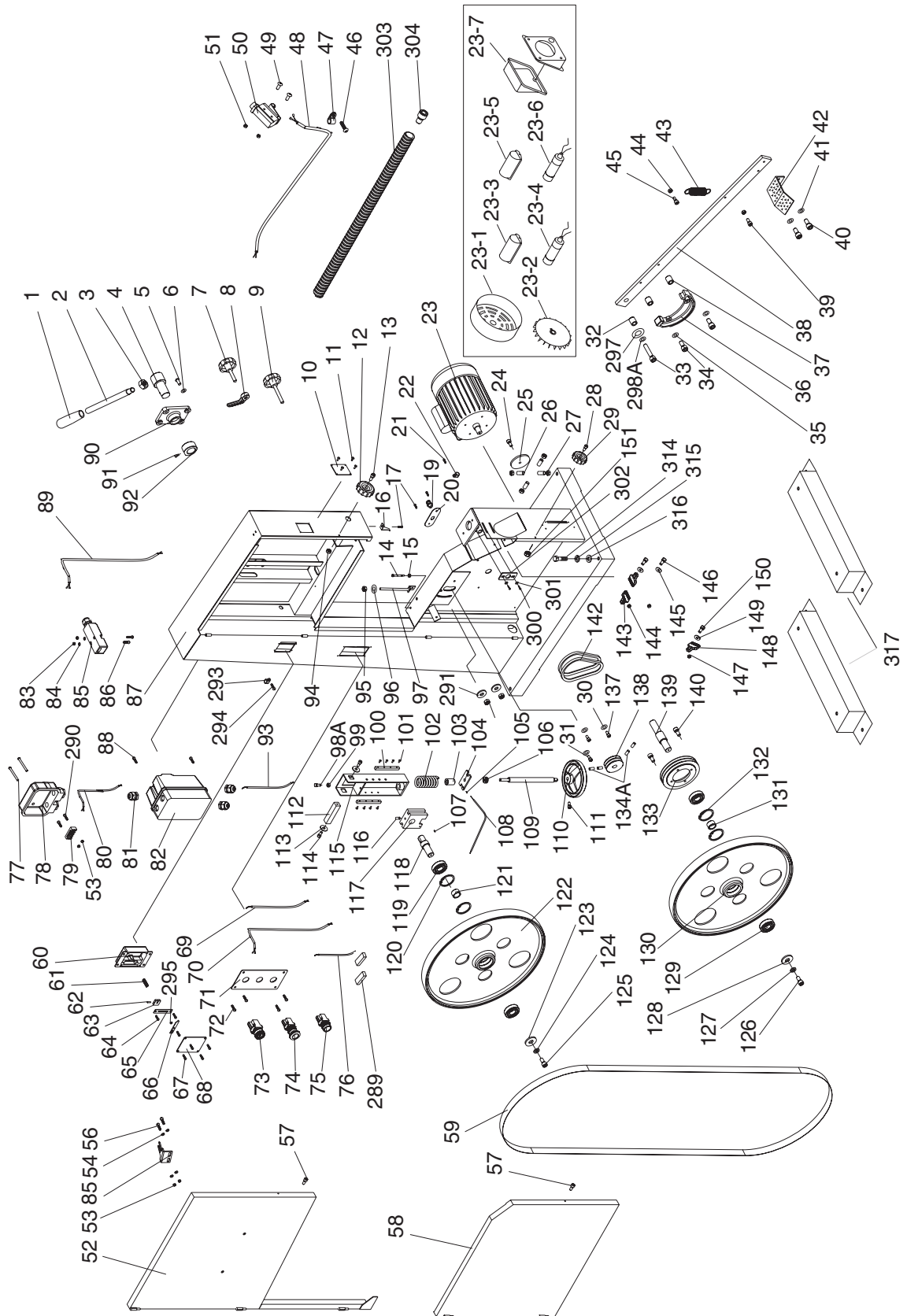
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| 184-4 | P0566184-4 LOCATE SHAFT |
| 184-5 | P0566184-5 POINTER |
| 184-6 | P0566184-6 STEP SCREW |
| 184-7 | P0566184-7 HANDLE |
| 184-8 | P0566184-8 MITER GAUGE BODY |
| 184-9 | PFH9M FLAT HEAD SCR M6-1 X 8 |
| 184-10 | PS06 PHLP HD SCR 10-24 X 3/8 |
| 184-11 | PS56M PHLP HD SCR M4-.7 X 16 |
| 184-12 | PN04M HEX NUT M4-.7 |
| 184-13 | PW01M FLAT WASHER 8MM |
| 185 | PN06M HEX NUT M5-.8 |
| 186 | PFS07M FLANGE SCREW M5-.8 X 10 |
| 187 | P0566187 COVER |
| 188 | PLW04M LOCK WASHER 8MM |
| 189 | PSB11M CAP SCREW M8-1.25 X 16 |
| 190 | PFH19M FLAT HD SCR M4-.7 X 10 |
| 191 | P0566191 EXTENSION RACK |
| 192 | P0566192 COVER |
| 193 | P0566193 FIXED BOLT |
| 194 | P0566194 PINION GEAR |
| 195 | P0566195 FIXED PLATE |
| 196 | P0566196 WORM CYLINDER |
| 197 | PN05M HEX NUT M16-1.5 |
| 198 | P0566198 GUIDE BRACKET |
| 199 | PW01M FLAT WASHER 8MM |
| 200 | PSBS04M BUTTON HD CAP SCR M8-1.25 X 35 |
| 201 | P0566201 BUSHING |
| 202 | P0566202 SWITCH BUSHING |
| 203 | PSB06M CAP SCREW M6-1 X 25 |
| 204 | P0566204 HANDWHEEL |
| 205 | PW01M FLAT WASHER 8MM |
| 206 | P0566206 UPPER GUIDE BAR |
| 207 | P0566207 RACK |
| 208 | PSB01M CAP SCREW M6-1 X 16 |
| 209 | PN04M HEX NUT M4-.7 |
| 210 | PS38M PHLP HD SCR M4-.7 X 10 |
| 211A | P0566211A UPPER GUIDE SUPPORT BLOCK |
| 212 | PB83M HEX BOLT M6-1 X 16 |
| 213 | P0566213 GUIDE BRACKET |

G0566 Parts List

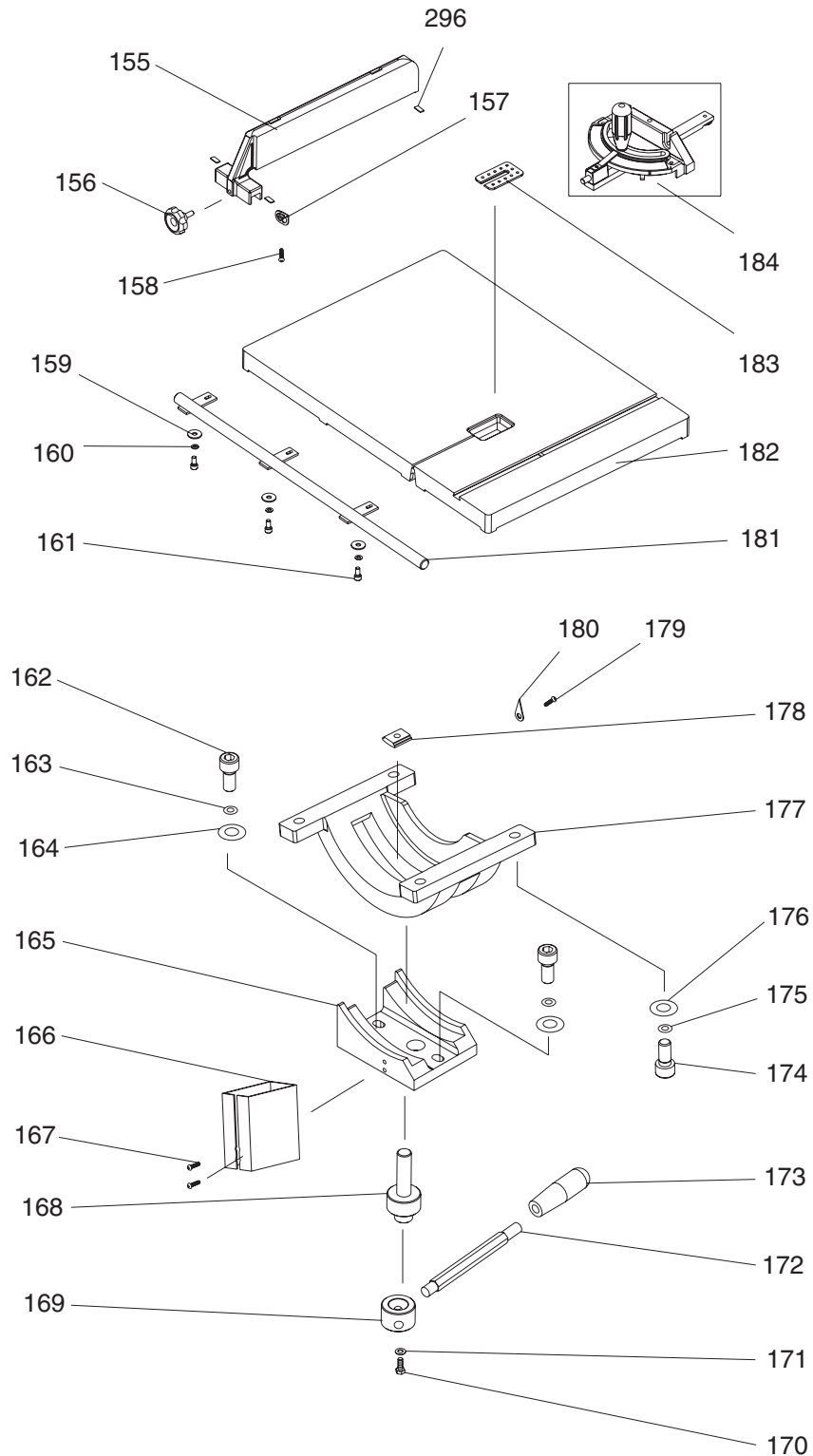
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|-----|----------|--------------------------------|
| 214 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 215 | PLW04M | LOCK WASHER 8MM |
| 216 | P0566216 | SUPPORT PLATE |
| 217 | PW01M | FLAT WASHER 8MM |
| 218 | PSBS01M | BUTTON HD CAP SCR M8-1.25 X 20 |
| 219 | PSB04M | CAP SCREW M6-1 X 10 |
| 220 | PLN04M | LOCK NUT M8-1.25 |
| 221 | PW01M | FLAT WASHER 8MM |
| 222 | P0566222 | SLIDING PLATE |
| 223 | PB30M | HEX BOLT M8-1.25 X 55 |
| 224 | PLW03M | LOCK WASHER 6MM |
| 225 | P0566225 | WORM CYLINDER |
| 226 | PN05M | HEX NUT M16-1.5 |
| 227 | P0566227 | HANDWHEEL |
| 228 | PS52M | PHLP HD SCR M4-.7 X 20 |
| 229 | PSB06M | CAP SCREW M6-1 X 25 |
| 230 | P0566230 | BUSHING |
| 231 | P0566231 | SWITCH BUSHING |
| 232 | PSS07M | SET SCREW M5-.8 X 5 |
| 233 | PN06M | HEX NUT M5-.8 |
| 234 | PLW04M | LOCK WASHER 8MM |
| 235 | PSB11M | CAP SCREW M8-1.25 X 16 |
| 236 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 237 | P0566237 | COVER |
| 238 | P0566238 | COVER |
| 239 | P0566239 | SPECIAL BOLT |
| 240 | P0566240 | CORD CONNECTOR 224-201 |
| 241 | PFH19M | FLAT HD SCR M4-.7 X 10 |
| 242 | P0566242 | RACK |
| 243 | P0566243 | SQUARE TUBE |
| 244 | PFS05M | FLANGE SCREW M4-.7 X 10 |
| 245 | PN04M | HEX NUT M4-.7 |
| 246 | P0566246 | PINION GEAR |
| 247 | PSB04M | CAP SCREW M6-1 X 10 |
| 248 | PLW03M | LOCK WASHER 6MM |
| 249 | PW03M | FLAT WASHER 6MM |
| 250 | P0566250 | SUPPORT PLATE |
| 251 | PW03M | FLAT WASHER 6MM |
| 252 | PSB04M | CAP SCREW M6-1 X 10 |

| REF | PART # | DESCRIPTION |
|------|-----------|-----------------------------|
| 253A | P0566253A | PROTECT COVER ASSY |
| 254 | PW03M | FLAT WASHER 6MM |
| 255 | PSB04M | CAP SCREW M6-.1 X 10 |
| 256A | P0566256A | SLIDING PLATE |
| 257 | P0566257 | PLASTIC WASHER 6MM |
| 258 | PFS11M | FLANGE SCREW M6-1 X 10 |
| 259A | P0566259A | ADJUST BAR |
| 260A | P0566260A | BLADE GUIDE SUPPORT |
| 261 | PB83M | HEX BOLT M6-1 X 16 |
| 262A | P0566262A | UPPER SPACING SLEEVE |
| 263A | P6201 | BALL BEARING 6201ZZ |
| 264A | PR03M | EXT RETAINING RING 12MM |
| 265 | PSB01M | CAP SCREW M6-1 X 16 |
| 266 | PW03M | FLAT WASHER 6MM |
| 267A | P0566267A | ADJUSTING SHAFT |
| 273 | PCAP29M | CAP SCREW M6-1 X 40 |
| 274 | P0566274 | HANDLE BUSHING |
| 275 | P6202 | BALL BEARING 6202ZZ |
| 276 | PR05M | EXT RETAINING RING 15MM |
| 277A | P0566277A | ECCENTRIC SHAFT |
| 279A | P0566279A | SUPPORT BRACKET |
| 280 | PB83M | HEX BOLT M6-1 X 16 |
| 287 | PSS07M | SET SCREW M5-.8 X 5 |
| 288 | PSB04M | CAP SCREW M6-1 X 10 |
| 289 | PW03M | FLAT WASHER 6MM |
| 290A | P0566290A | SUPPORT |
| 291A | P0566291A | PROTECT TUBE 1/2"X1100mm(L) |
| 292 | P0566292 | CORD BUSHING |
| 293 | P0566293 | MACHINE ID LABEL |
| 294 | PLABEL-20 | DON'T OPEN LABEL |
| 295 | PLABEL-19 | HANDS/BS BLADE 2"X3 5/16"H. |
| 296 | PLABEL-18 | UNPLUG BANDSAW LABEL |
| 297 | PLABEL-14 | ELECTRICITY LABEL |
| 298 | PLABEL-12 | READ MANUAL 2"W X 3 5/16" |
| 299 | PLABEL-11 | SAFETY GLASSES 2" X 3 5/16" |
| 300 | P0566300 | TENSION LEVER LABEL |
| 301 | P0566301 | TABLE LOCK LABEL |

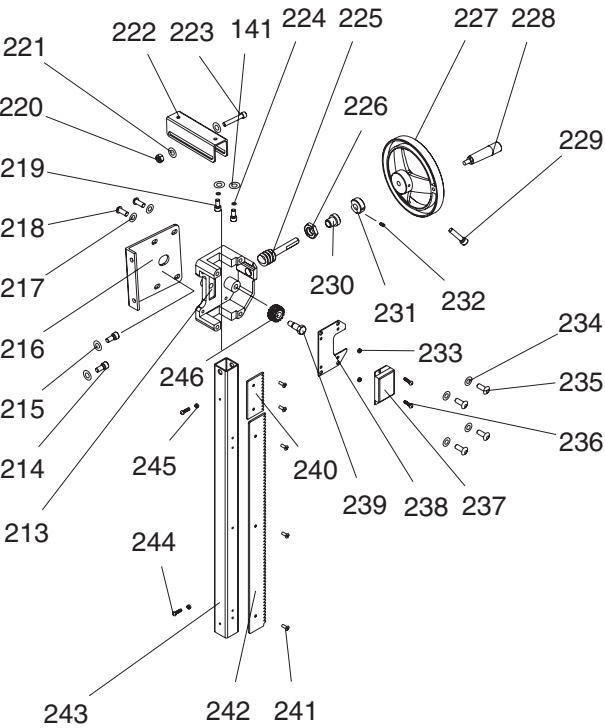
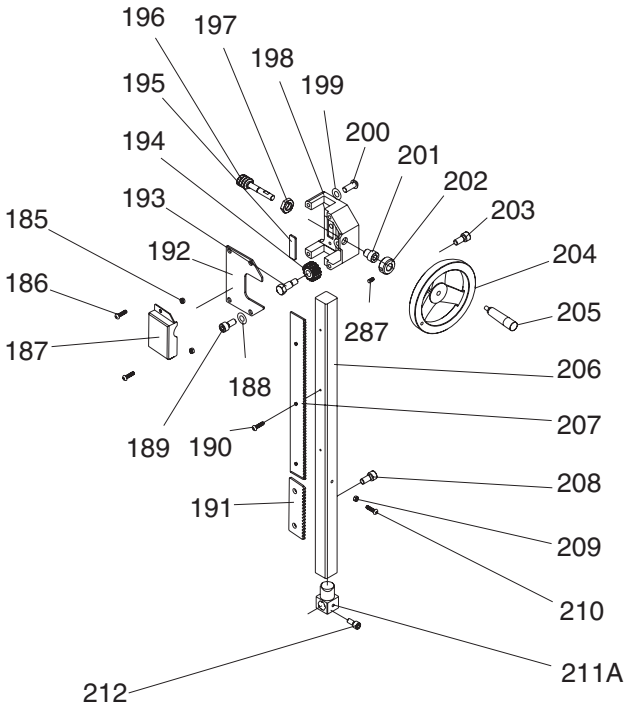
G0568/G0569 Parts Breakdown



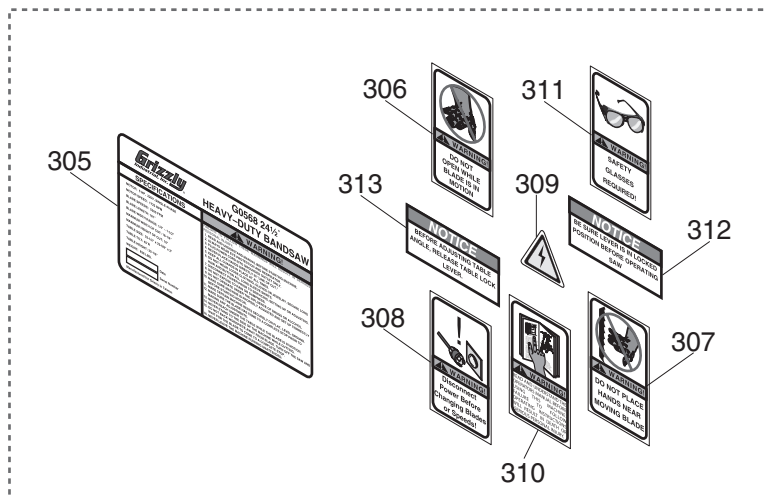
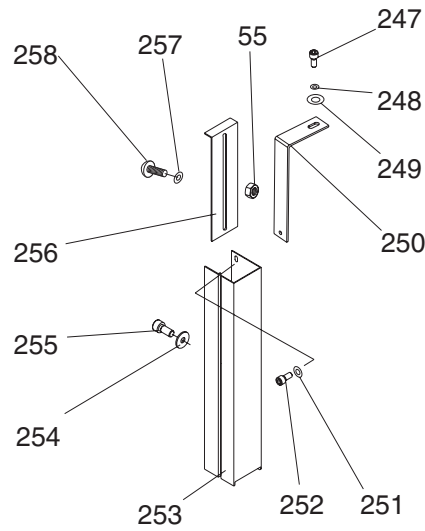
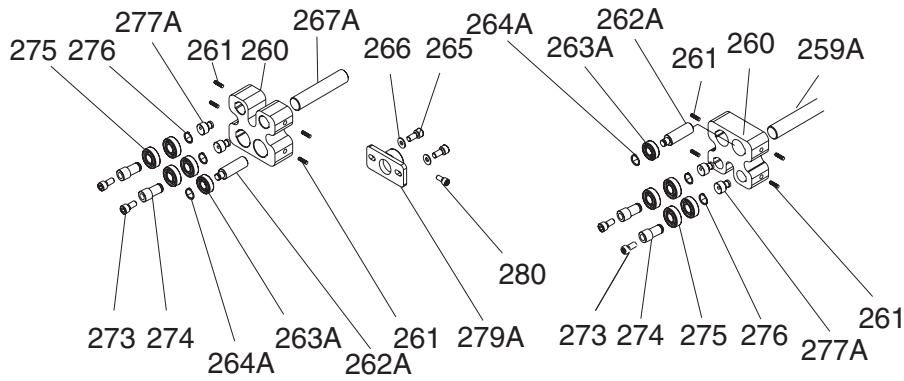
G0568/G0569 Parts Breakdown



G0568/G0569 Parts Breakdown



G0568/G0569 Parts Breakdown



G0568/G0569 Parts List

| REF | PART # | DESCRIPTION |
|------|------------|--------------------------------|
| 1 | P0566001 | HANDLE KNOB |
| 2 | P0566002 | HANDLE SHAFT |
| 3 | PN05M | HEX NUT M16-1.5 |
| 4 | P0566004 | ROTATE SHAFT |
| 5 | PSBS03M | BUTTON HD CAP SCR M10-1.5 X 20 |
| 6 | PLW06M | LOCK WASHER 10MM |
| 7 | P0566007 | KNOB SCREW M10-1.5 X 25 |
| 8 | P0566008 | LOCATE HANDLE M10-1.5 |
| 9 | P0566009 | KNOB SCREW M10-1.5 X 25 |
| 10 | P0566010 | TRANSLUCENT PIECE |
| 11 | P0566011 | RIVET 3.2 X 10 |
| 12 | P0566012 | LATCHING KNOB 6MM |
| 13 | PSB02M | CAP SCREW M6-1 X 20 |
| 14 | PB73M | HEX BOLT M10-1.5 X 50 |
| 15 | PN02M | NUT M10-1.5 |
| 16 | P0566016 | HEIGHT POINTER |
| 17 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 18 | PHTEK15M | TAP SCREW M4 X 10 |
| 19 | P0566019 | STRAIN RELIEF M20 |
| 20 | P0566020 | PLATE |
| 21 | PHTEK4M | TAP SCREW M4 X 8 |
| 22 | P0566022 | CORD CLAMP 1/2" |
| 23 | P0568023 | MOTOR 5HP G0568 |
| 23 | P0569023 | MOTOR 7-1/2HP G0569 |
| 23-1 | P0568023-1 | FAN COVER G0568 |
| 23-1 | P0569023-1 | FAN COVER G0569 |
| 23-2 | P0568023-2 | FAN G0568 |
| 23-2 | P0569023-2 | FAN G0569 |
| 23-3 | P0568023-3 | CAPACITOR COVER G0568 |
| 23-4 | PC200A | CAPACITOR 200MFD 250V. G0568 |
| 23-5 | P0568023-5 | CAPACITOR COVER G0568 |
| 23-6 | PC20A | CAPACITOR 20MFD/400V G0568 |
| 23-7 | P0568023-7 | ELECTRICAL BOX G0568 |
| 23-7 | P0569023-7 | WIRING BOX G0569 |
| 24 | PSBS01M | BUTTON HD CAP SCR M8-1.25 X 20 |
| 25 | P0566025 | PIECE |
| 26 | PB01M | HEX BOLT M10-1.5 X 30 |
| 27 | PN02M | HEX NUT M10-1.5 |
| 28 | PSB02M | CAP SCREW M6-1 X 20 |
| 29 | P0566029 | LATCHING KNOB 6MM |
| 30 | PW01M | FLAT WASHER 8MM |
| 31 | PSB31M | CAP SCREW M8-1.25 X 25 |

| REF | PART # | DESCRIPTION |
|-----|----------|--------------------------|
| 32 | P0566032 | BUSHING |
| 33 | PSB31M | CAP SCREW M8-1.25 X 25 |
| 34 | PSB06M | CAP SCREW M6-1 X 25 |
| 35 | PLW02M | LOCK WASHER 6MM |
| 36 | P0566036 | BRAKE PAD |
| 37 | P0566037 | BUSHING |
| 38 | P0568038 | BRAKE LEVER |
| 39 | PSB01M | CAP SCREW M6-1 X 16 |
| 40 | PSB01M | CAP SCREW M6-1 X 16 |
| 41 | PLW03M | LOCK WASHER 6MM |
| 42 | P0566042 | BRAKE STEP PLATE |
| 43 | P0566043 | SPRING |
| 44 | PN01M | HEX NUT M6-1 |
| 45 | PSB01M | CAP SCREW M6-1 X 16 |
| 46 | PHTEK4M | TAP SCREW M4 X 8 |
| 47 | P0566047 | CORD CLAMP 5/8" |
| 48 | P0566048 | STEP CORD |
| 49 | PB41M | HEX BOLT M4-.7 X 30 |
| 50 | P0566050 | LIMIT SWITCH KL7141 |
| 51 | PN04M | HEX NUT M4-.7 |
| 52 | P0568052 | UPPER WHEEL COVER |
| 53 | PN04M | HEX NUT M4-.7 |
| 54 | PW05M | FLAT WASHER 4MM |
| 56 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 57 | PS68M | PHLP HD SCR M6-1 X 10 |
| 58 | P0568058 | LOWER WHEEL COVER |
| 59 | P0568059 | SAW BLADE 4600X25.4X.9MM |
| 60 | P0566060 | TENSION GAUGE HOUSING |
| 61 | P0566061 | SPRING |
| 62 | PRP61M | PIN 3 X 12 |
| 63 | P0566063 | MOVING PLATE |
| 64 | PHTEK15M | TAP SCREW M4 X 10 |
| 65 | P0566065 | FIX PLATE |
| 66 | P0566066 | TENSION POINTER |
| 67 | PHTEK6M | TAP SCREW M4 X 16 |
| 68 | P0568068 | TENSION SCALE |
| 69 | P0566069 | CONNECTING CORD |
| 70 | P0566070 | SWITCH CORD |
| 71 | P0566071 | SWITCH PLATE |
| 72 | PHTEK15M | TAP SCREW M4 X 10 |
| 73 | P0566073 | KEY SWITCH |
| 74 | P0566074 | STOP SWITCH |

G0568/G0569 Parts List

| REF | PART # | DESCRIPTION |
|-----|-----------|----------------------------|
| 75 | P0566075 | START SWITCH |
| 76 | P0566076 | CONNECTING CORD |
| 77 | PFS09M | FLANGE SCREW M5-.8 X 50 |
| 78 | P0566078 | TERMINAL BOX |
| 79 | P0566079 | TERMINAL HOUSE |
| 80 | P0568080 | POWER CORD |
| 81 | P0566081 | STRAIN RELIEF M20 |
| 82 | P0568082 | MAGNETIC SWITCH 220V G0568 |
| 82 | P0569082 | MAGNETIC SWITCH 220V G0569 |
| 82A | P0569082A | MAGNETIC SWITCH 440V G0569 |
| 83 | PN04M | HEX NUT M4-.7 |
| 84 | PW05M | FLAT WASHER 4MM |
| 85 | P0566085 | DOOR LATCH SWITCH ADZ-S11 |
| 86 | PFS10M | FLANGE SCREW M4-.7 X 35 |
| 87 | P0568087 | MACHINE BODY |
| 88 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 89 | P0566089 | SWITCH CORD |
| 90 | P0566090 | PLATE |
| 91 | PSB31M | CAP SCREW M8-1.25 X 25 |
| 92 | P0566092 | CAM |
| 93 | P0566093 | MOTOR CORD |
| 94 | PLN03M | LOCK NUT M6-1 |
| 95 | PN02M | HEX NUT M10-1.5 |
| 96 | PW04M | FLAT WASHER 10MM |
| 97 | PSB14M | CAP SCREW M8-1.25 X 30 |
| 98A | PSB60M | CAP SCREW M8-1.25 X 55 |
| 99 | PN03M | HEX NUT M8-1.25 |
| 100 | P0566100 | LOCATE PLATE |
| 101 | PFH39M | FLAT HD SCR M5-.8 X 16 |
| 102 | P0568102 | SPRING |
| 103 | P0566103 | BUSHING |
| 104 | P0566104 | PRESS BLOCK |
| 105 | PSS07M | SET SCREW M5-.8 X 5 |
| 106 | P51201 | BEARING 51201 |
| 107 | PSS07M | SET SCREW M5-.8 X 5 |
| 108 | P0566108 | TENSION LINE |
| 109 | P0568109 | SHAFT |
| 110 | P0566110 | HANDWHEEL |
| 111 | PSB06M | CAP SCREW M6-1 X 25 |
| 112 | P0566112 | SQUARE SHAFT |
| 113 | PW01M | FLAT WASHER 8MM |

| REF | PART # | DESCRIPTION |
|-----|----------|--------------------------------|
| 114 | PSB31M | CAP SCREW M8-1.25 X 25 |
| 115 | P0566115 | UPPER WHEEL HINGE (ASM.) |
| 116 | PSS75M | SET SCREW M10-1.5 X 16 |
| 117 | P0566117 | GUIDE BLOCK |
| 118 | P0568118 | UPPER WHEEL SHAFT |
| 119 | P6306 | BALL BEARING 6306LLU |
| 120 | PR64M | INT RETAINING RING 72MM |
| 121 | P0568121 | BUSHING |
| 122 | P0568122 | UPPER WHEEL 25" |
| 123 | PW01M | FLAT WASHER 8MM |
| 124 | PLW04M | LOCK WASHER 8MM |
| 125 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 126 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 127 | PLW04M | LOCK WASHER 8MM |
| 128 | PW01M | FLAT WASHER 8MM |
| 129 | P6306 | BALL BEARING 6306LLU |
| 130 | P0568130 | LOWER WHEEL 25" |
| 131 | P0568131 | BUSHING |
| 132 | PR64M | INT RETAINING RING 72MM |
| 133 | P0566133 | PULLEY |
| 134 | PSS04M | SET SCREW M6-1 X 12 |
| 137 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 138 | P0566138 | PULLEY |
| 139 | P0568139 | LOWER SHAFT |
| 140 | PSBS01M | BUTTON HD CAP SCR M8-1.25 X 20 |
| 141 | PW03M | FLAT WASHER 6MM |
| 142 | PVA33 | V-BELT A-33 4L330 |
| 143 | P0566143 | BRUSH |
| 144 | PLN03M | LOCK NUT M6-1 |
| 145 | PW03M | FLAT WASHER 6MM |
| 146 | PSB02M | CAP SCREW M6-1 X 20 |
| 147 | PLN03M | LOCK NUT M6-1 |
| 148 | P0566148 | BRUSH |
| 149 | PW03M | FLAT WASHER 6MM |
| 150 | PSB02M | CAP SCREW M6-1 X 20 |
| 151 | PLN03M | LOCK NUT M6-1 |
| 155 | P0566155 | FENCE |
| 156 | P0566156 | KNOB SCREW M10-1.5 X 25 |
| 157 | P0566157 | POINTER |
| 158 | PFS01M | FLANGE SCREW M5-.8 X 8 |
| 159 | PW03M | FLAT WASHER 6MM |

G0568/G0569 Parts List

| REF | PART # | DESCRIPTION |
|--------|------------|-------------------------|
| 160 | PLW02M | LOCK WASHER 6MM |
| 161 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 162 | PSB72M | CAP SCREW M10-1.5 X 30 |
| 163 | PLW06M | LOCK WASHER 10MM |
| 164 | PW04M | FLAT WASHER 10MM |
| 165 | P0566165 | TRUNNION HOUSING |
| 166 | P0566166 | BLADE GUARD |
| 167 | PFS11M | FLANGE SCREW M6 X 10 |
| 168 | P0566168 | PRESS SHAFT |
| 169 | P0566169 | MICRO ADJUSTING RING |
| 170 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 171 | PLW04M | LOCK WASHER 8MM |
| 172 | P0566172 | HANDLE SHAFT |
| 173 | P0566173 | HANDLE KNOB M12-1.75 |
| 174 | PSB84M | CAP SCREW M10-1.5 X 35 |
| 175 | PLW04M | LOCK WASHER 8MM |
| 176 | PW04M | FLAT WASHER 10MM |
| 177 | P0566177 | TRUNNION BLOCK |
| 178 | P0566178 | PRESS BLOCK |
| 179 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 180 | P0566180 | POINTER |
| 181 | P0568181 | GUARD RAIL |
| 182 | P0568182 | TABLE |
| 183 | P0566183 | TABLE INSERT |
| 184 | P0566184 | MITER GAUGE ASSY |
| 184-1 | P0566184-1 | GUIDE |
| 184-2 | P0566184-2 | GUIDE BAR |
| 184-3 | P0566184-3 | LOCATE BRACKET |
| 184-4 | P0566184-4 | LOCATE SHAFT |
| 184-5 | P0566184-5 | POINTER |
| 184-6 | P0566184-6 | STEP SCREW |
| 184-7 | P0566184-7 | HANDLE |
| 184-8 | P0566184-8 | MITER GAUGE BODY |
| 184-9 | PFH9M | FLAT HD SCR M6-1 X 6 |
| 184-10 | PS06 | PHLP HD SCR 10-24 X 3/8 |
| 184-11 | PS56M | PHLP HD SCR M4-.7 X 16 |
| 184-12 | PN04M | HEX NUT M4-.7 |
| 184-13 | PW01M | FLAT WASHER 8MM |
| 185 | PLW04M | LOCK WASHER 8MM |
| 186 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 187 | P0566187 | COVER |

| REF | PART # | DESCRIPTION |
|------|-----------|--------------------------------|
| 189 | PSB11M | CAP SCREW M8-1.25 X 16 |
| 190 | PFH19M | FLAT HD SCR M4-.7 X 10 |
| 191 | P0566191 | EXTENSION RACK |
| 192 | P0566192 | COVER |
| 193 | P0566193 | FIXED BOLT |
| 194 | P0566194 | PINION GEAR |
| 195 | P0566195 | FIXED PLATE |
| 196 | P0566196 | WORM CYLINER |
| 197 | PN05M | HEX NUT M16-1.5 |
| 198 | P0566198 | GUIDE BRACKET |
| 199 | PW01M | FLAT WASHER 8MM |
| 200 | PSBS04M | BUTTON HD CAP SCR M8-1.25 X 35 |
| 201 | P0566201 | BUSHING |
| 202 | P0566202 | SWITCH BUSHING |
| 203 | PSB06M | CAP SCREW M6-1 X 25 |
| 204 | P0568204 | HANDWHEEL |
| 205 | P0568205 | HANDLE |
| 206 | P0568206 | UPPER GUIDE SUPPORT BLOCK |
| 207 | P0566207 | RACK |
| 208 | PSB01M | CAP SCREW M6-1 X 16 |
| 209 | PN04M | HEX NUT M4-.7 |
| 210 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 211A | P0566211A | UPPER GUIDE SUPPORT BLOCK |
| 212 | PB83M | HEX BOLT M6-1 X 16 |
| 213 | P0566213 | GUIDE BRACKET |
| 214 | PSB14M | CAP SCREW M8-1.25 X 20 |
| 215 | PLW04M | LOCK WASHER 8MM |
| 216 | P0566216 | SUPPORT PLATE |
| 217 | PW01M | FLAT WASHER 8MM |
| 218 | PSBS01M | BUTTON HD CAP SCR M8-1.25 X 20 |
| 219 | PB04M | HEX BOLT M6-1 X 10 |
| 220 | PLN04M | LOCK NUT M8-1.25 |
| 221 | PLW04M | FLAT WASHER 8MM |
| 222 | P0566222 | SLIDING PLATE |
| 223 | PB30M | HEX BOLT M8-1.25 X 55 |
| 224 | PLW03M | LOCK WASHER 6MM |
| 225 | P0566225 | WORM CYLINDER |
| 226 | PN05M | HEX NUT M16-1.5 |
| 227 | P0566227 | HANDWHEEL |
| 228 | P0566228 | KNOB M10-1.5 X 12 |
| 229 | PSB06M | CAP SCREW M6-1 X 25 |

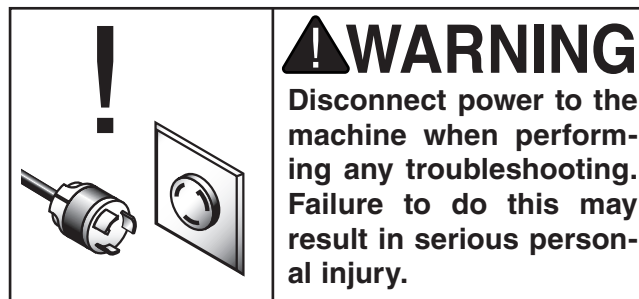
G0568/G0569 Parts List

| REF | PART # | DESCRIPTION |
|------|-----------|-------------------------|
| 230 | P0566230 | BUSHING |
| 231 | P0566231 | SWITCH BUSHING |
| 232 | PSS07M | SET SCREW M5-.8 X 5 |
| 233 | PN03M | HEX NUT M5-.8 |
| 234 | PLW04M | LOCK WASHER 8MM |
| 235 | PSB11M | CAP SCREW M8-1.25 X 16 |
| 236 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 237 | P0566237 | COVER |
| 238 | P0566238 | COVER |
| 239 | P0566239 | SPECIAL BOLT |
| 240 | P0568240 | STRETCH RACK |
| 241 | PFH19M | FLAT HD SCR M4-.7 X 10 |
| 242 | P0566242 | RACK |
| 243 | P0568243 | SQUARE TUBE |
| 244 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 245 | PN04M | HEX NUT M4-.7 |
| 246 | P0568246 | PINION GEAR |
| 247 | PSB04M | CAP SCREW M6-.1 X 10 |
| 248 | PLW03M | LOCK WASHER 6MM |
| 249 | PW03M | FLAT WASHER 6MM |
| 250 | P0566250 | SUPPORT PLATE |
| 251 | PW03M | FLAT WASHER 6MM |
| 252 | PSB04M | CAP SCREW M6-1 X 10 |
| 253 | P0568253 | PROTECT COVER ASSY |
| 254 | PW03M | FLAT WASHER 6MM |
| 255 | PSB04M | CAP SCREW M6-.1 X 10 |
| 256 | P0568256 | SLIDING PLATE |
| 257 | P0566257 | PLASTIC WASHER 6MM |
| 258 | PS68M | PHLP HD SCR M6-1 X 10 |
| 259A | P0566259A | ADJUST BAR |
| 260A | P0566260A | BLADE GUIDE SUPPORT |
| 261 | PSS01M | SET SCREW M6-1 X 10 |
| 262A | P0566262A | UPPER SPACING SLEEVE |
| 263A | P6201 | BALL BEARING 6201ZZ |
| 264A | PR03M | EXT RETAINING RING 12MM |
| 265 | PSB01M | CAP SCREW M6-1 X 16 |
| 266 | PW03M | FLAT WASHER 6MM |
| 267A | P0566267A | ADJUSTING SHAFT |

| REF | PART # | DESCRIPTION |
|------|-----------|-------------------------------|
| 273 | PB47M | HEX BOLT M6-1 X 40 |
| 274 | P0566274 | HANDLE BUSHING |
| 275 | P6202 | BALL BEARING 6202ZZ |
| 276 | PR05M | EXT RETAINING RING 15MM |
| 277A | P0566277A | ECCENTRIC SHAFT |
| 279A | P0566279A | LOWER SUPPORT BRACKET |
| 280 | PS83M | HEX BOLT M6-1 X 16 |
| 287 | PSS07M | SET SCREW M5-.8 X 5 |
| 289 | P0568289 | CORD CONNECTOR 224-201 |
| 290 | PS52M | PHLP HD SCR M4-.7 X 20 |
| 291 | PW01M | FLAT WASHER 8MM |
| 292 | PN03M | HEX NUT M8-1.25 |
| 293 | P0568293 | CORD CLAMP 5/16" |
| 294 | PHTEK15M | TAP SCREW M4 X 10 |
| 295 | PW01M | FLAT WASHER 8MM |
| 296 | P0568296 | NYLON PIECE |
| 297 | PW01M | FLAT WASHER 8MM |
| 298 | PLW04M | LOCK WASHER 8MM |
| 299 | P0568299 | PIN 6 X 15 |
| 300 | PFS11M | FLANGE SCREW M6-1 X 10 |
| 301 | PW03M | FLAT WASHER 6MM |
| 302 | P0568302 | SUPPORT |
| 303 | P0568303 | PROTECT TUBE 1/2" X 1100MM(L) |
| 304 | P0568304 | CORD BUSHING |
| 305 | P0568305 | MACHINE ID LABEL G0568 |
| 305 | P0569305 | MACHINE ID LABEL G0569 |
| 306 | PLABEL-20 | DON'T OPEN LABEL |
| 307 | PLABEL-19 | HANDS/BS BLADE 2"X3 5/16"H. |
| 308 | PLABEL-18 | UNPLUG BANDSAW LABEL |
| 309 | PLABEL-14 | ELECTRICITY LABEL |
| 310 | PLABEL-12 | READ MANUAL 2"W X 3 5/16" |
| 311 | PLABEL-11 | SAFETY GLASSES 2" X 3 5/16" |
| 312 | P0566312 | TESNSION LEVER LABEL |
| 313 | P0566313 | TABLE LOCK LABEL |
| 314 | PB76M | HEX BOLT M12-1.75 X 110 |
| 315 | PLW05M | LOCK WASHER 12MM |
| 316 | PW06M | FLAT WASHER 12MM |
| 317 | P0568317 | RISER BAR |

Troubleshooting

| Symptom | Possible Cause | Possible Solution |
|--------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Motor will not start. | <ol style="list-style-type: none"> 1. Low voltage. 2. Open circuit in motor or loose connections. | <ol style="list-style-type: none"> 1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections. |
| Motor will not start; fuses or circuit breakers blow. | <ol style="list-style-type: none"> 1. Short circuit in line cord or plug. | <ol style="list-style-type: none"> 1. Repair or replace cord or plug for damaged insulation and shorted wires. |
| Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals). | <ol style="list-style-type: none"> 1. Power line overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long. 3. General overloading of power company facilities. | <ol style="list-style-type: none"> 1. Reduce load on power line. 2. Increase wire sizes or reduce length of the circuit. 3. Request a power check from the power company. |
| Motor overheats. | <ol style="list-style-type: none"> 1. Motor overloaded. 2. Air circulation through the motor restricted. | <ol style="list-style-type: none"> 1. Reduce load on motor. 2. Clean out motor to provide normal air circulation. |
| Motor stalls (resulting in blown fuses or tripped circuit). | <ol style="list-style-type: none"> 1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded. | <ol style="list-style-type: none"> 1. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor. |
| Main blade runs backwards. | <ol style="list-style-type: none"> 1. Two of the power wires are reversed. | <ol style="list-style-type: none"> 1. Switch two of the current carrying wires at the terminal strip. |
| Blade slows when cutting. Blade makes a squealing noise, especially on start-up. | <ol style="list-style-type: none"> 1. V-belts loose. 2. V-belts worn out. | <ol style="list-style-type: none"> 1. Tighten V-belts (page 44). 2. Replace V-belts (page 44). |
| Loud repetitious noise coming from machine. | <ol style="list-style-type: none"> 1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective. | <ol style="list-style-type: none"> 1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belts (page 44). |



Troubleshooting

| Symptom | Possible Cause | Possible Solution |
|--------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Wood cuts slow or smokes during cut. | <ol style="list-style-type: none"> 1. Worn or dull blade. 2. Blade installed backwards. 3. Blade spinning backwards due to reversed wires at terminal strip. | <ol style="list-style-type: none"> 1. Replace blade (see page 36). 2. Check blade rotation as described in "Test Run" on page 24 and reverse blade if necessary. 3. Switch two of the current carrying wires at the terminal strip. |
| Rough or poor quality cuts. | <ol style="list-style-type: none"> 1. Feeding workpiece too fast. | <ol style="list-style-type: none"> 1. Reduce feed rate. |
| Sawdust buildup inside cabinet. | <ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. | <ol style="list-style-type: none"> 1. Clean out dust port. 2. Three options: <ul style="list-style-type: none"> —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a stronger dust collector. |



| | |
|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------|
| | <p>⚠ WARNING</p> <p>Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury.</p> |
|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------|

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.

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

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

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