MODEL G0692
14" DRY CUT METAL SAW
OWNER'S MANUAL
(FOR MACHINES MANUFACTURED FROM 11/08 AND LATER)

#JBCR11500 PRINTED IN TAIWAN

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

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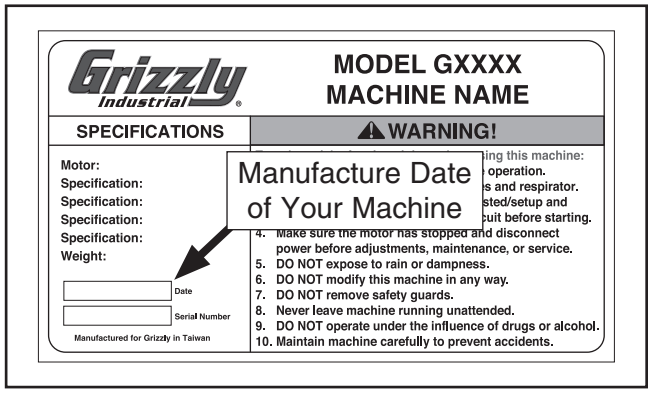
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

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

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



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

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, 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

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

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

This 14" Dry Cut Metal Saw is used to cut thin-walled metal workpieces accurately, efficiently, and safely. This saw is advantageous over a typical metal-cutting bandsaw in that the cuts produced are cleaner, more accurate, and can be made much faster.

An adjustable vise holds the workpiece securely and ensures proper positioning of the workpiece relative to the blade.

The cutting angle is adjustable from 0° to 45° and is measured by a scale located on the saw base.

Identification

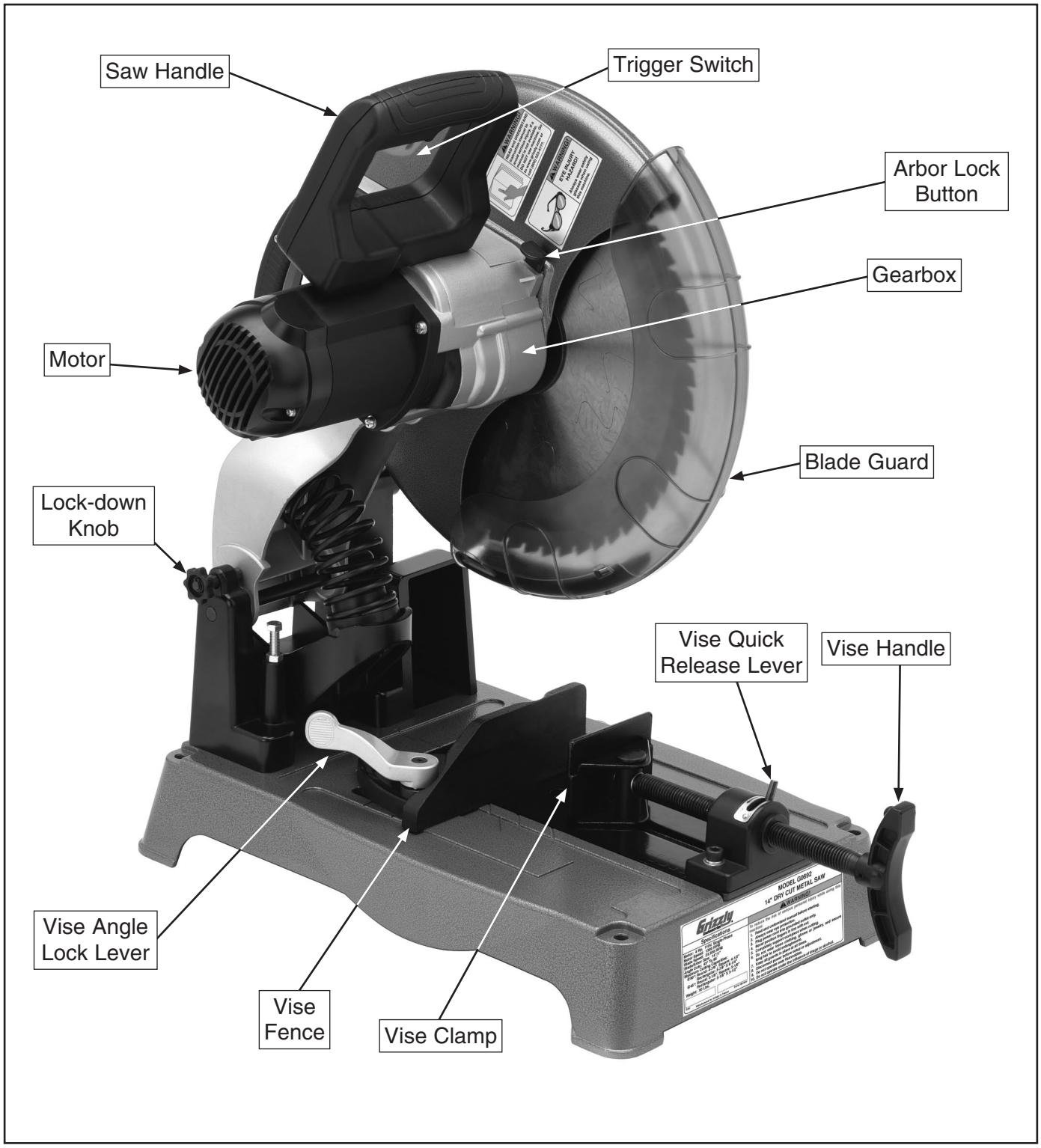


Figure 1. Identification.

MACHINE DATA SHEET

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

MODEL G0692
14" DRY CUT METAL SAW

Product Dimensions:

Weight	50 lbs.
Length/Width/Height	24¾" x 16¾" x 19⅝"
Foot Print (Length/Width)	19⅛" x 12½"

Shipping Dimensions:

Type	Cardboard Box
Content	Machine
Weight	58 lbs.
Length/Width/Height	22" x 18" x 21"

Electrical:

Switch	Trigger Switch on Handle
Switch Voltage	110V
Cord Length	8 ft.
Cord Gauge	14 AWG
Minimum Circuit Size	20A
Plug Type Included	NEMA 1-15

Motor:

Type	Universal DC
Horsepower	4 HP
Voltage	110V
Phase	Single-Phase
Amps	15A
Speed	23,500 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Gearbox
Bearings	Shielded and Permanently Sealed

Main Specifications:

Operation Information

Blade Speed	1300 RPM
Blade Size	14"
Arbor Size	1"

Cutting Capacities

Angle Cuts	45° – 90°
Vise Jaw Depth	8⅛"
Vise Jaw Height	2¾"
Maximum Capacity Square @ 90°	4½"
Maximum Capacity Rectangular @ 90°	3⅞"W x 6¼"H
Maximum Capacity Round @ 90°	4⅞"
Maximum Capacity Square @45°	3⅛"
Maximum Capacity Rectangular @ 45°	3⅛"W x 3½"H
Maximum Capacity Round @ 45°	3⅛"

Construction

Table Construction	Aluminum
Saw Wheel Cover	Steel
Saw Wheel Guard	Plastic
Body Construction	Aluminum
Paint	Urethane

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine ID Label on Body Frame

Features:

Spring Assisted Return
Adjustable Angle from 45° to 90°

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

⚠WARNING

Safety Instructions for Metal Cutting Saws

1. **BLADE CONDITION.** Do not operate with a dull, cracked or badly worn blade. A damaged blade could break apart during use, resulting in serious personal injury. Inspect blades for cracks and missing teeth before each use.

2. **HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Hands could be crushed in vise or from falling machine components.

3. **ENTANGLEMENT HAZARDS.** Do not operate this saw without blade guard in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.

4. **BLADE REPLACEMENT.** When replacing blades, disconnect the machine from power to reduce the risk of injury from accidental startup.

5. **LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall which could cause serious injury.

6. **FIRE HAZARD.** If cutting magnesium, DO NOT allow magnesium chips to build up. Magnesium chips are extremely flammable and can catch fire and burn at very high temperatures

7. **ATTENTION TO WORK AREA.** Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.

8. **MAINTENANCE/SERVICE.** To reduce the risk of injury from accidental startup, all inspections, adjustments, and maintenance are to be done with the power ***OFF*** and the machine disconnected from power. Wait for all moving parts to come to a complete stop.

9. **HEARING PROTECTION & HAZARDS.** Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals.

10. **HOT SURFACES.** Contact with hot surfaces from machine components, ejections of hot chips, and the workpiece itself can cause burns.

11. **WORKPIECE HANDLING.** Always support the workpiece with table, vise, or some type of support fixture to maintain control over the workpiece during the cut. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.

⚠WARNING

No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G0692. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

SECTION 2: CIRCUIT REQUIREMENTS

110V Operation

⚠WARNING

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

⚠WARNING

Electrocution or fire could result if machine is not installed in compliance with electrical codes. Compliance MUST be verified by a qualified electrician!

Full Load Amperage Draw

This machine draws the following amps under maximum load:

Amp Draw..... 15 Amps

Power Supply Circuit Requirements

The power supply circuit for your machine MUST be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

Minimum Circuit Size.....20 Amps

Power Connection Device

The Model G0692 comes with a NEMA 1-15 plug, similar to **Figure 2**, to connect the machine to power.

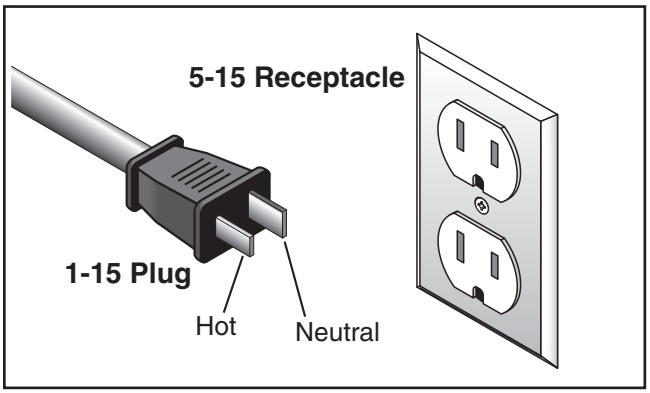


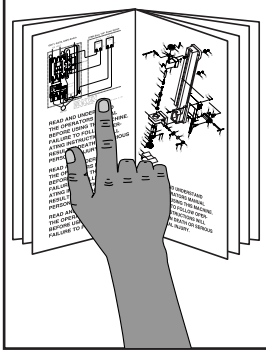
Figure 2. Typical 1-15 plug and 5-15 receptacle.

Extension Cords

We do not recommend using extension cords, but if you find it absolutely necessary:

- Use at least a 14 gauge cord that does not exceed 50 feet in length!
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

SECTION 3: SETUP



⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!

Needed for Setup

Description	Qty
• 14" Saw Blade (Model T20920)	1
• Safety Glasses	1 Pr.
• Shop Rags & Solvent Cleaner	As needed

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *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, inventory the contents.

Inventory

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

Container 1: (Figure 3)	Qty
A. Saw Unit	1
B. Hex Wrench 8mm	1

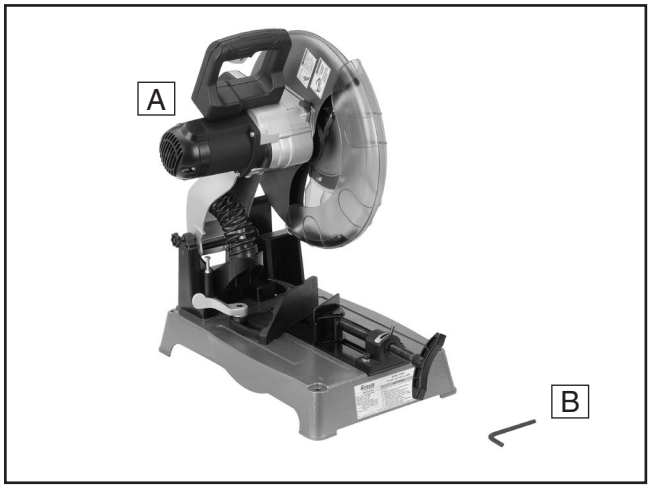


Figure 3. Machine inventory.

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

Site Considerations

Workbench Load

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

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

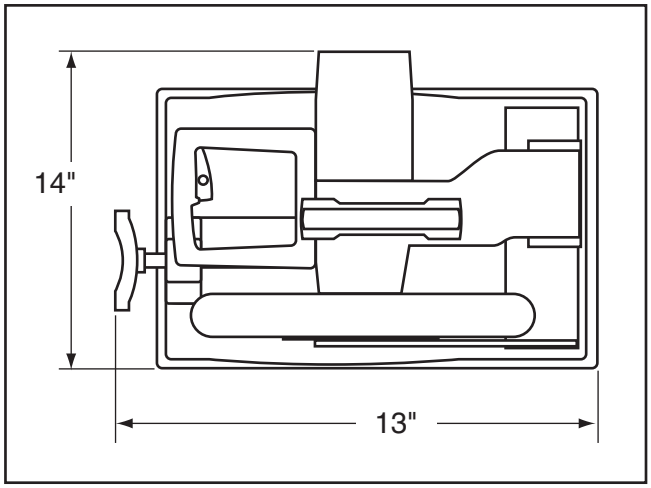
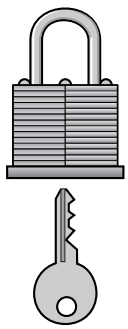


Figure 4. Minimum working clearances.



⚠CAUTION

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

Blade Installation

To install the blade on your new machine, perform the procedures for **Changing Blade** on **Page 17**, omitting the removal of the old blade, then return to **Test Run**, below.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 23**.

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

To test run the machine:

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

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

3. Connect the machine to the power source.

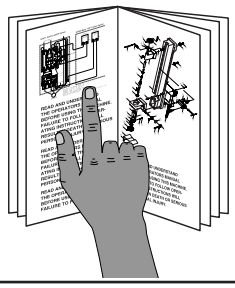
4. Pull the trigger switch to turn the saw ***ON***.

5. Listen and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

   —Strange or unusual noises must be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting problems.

6. Release the trigger switch to turn the machine ***OFF***.

SECTION 4: OPERATIONS

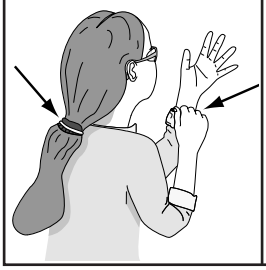


⚠WARNING

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

⚠WARNING

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



⚠WARNING

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

NOTICE

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

Basic Controls

Use the descriptions and figures below to become familiar with the basic controls of your machine.

Trigger Switch: Turns the motor ***ON***, spinning the blade.

Saw Handle: Lowers the saw into the workpiece.

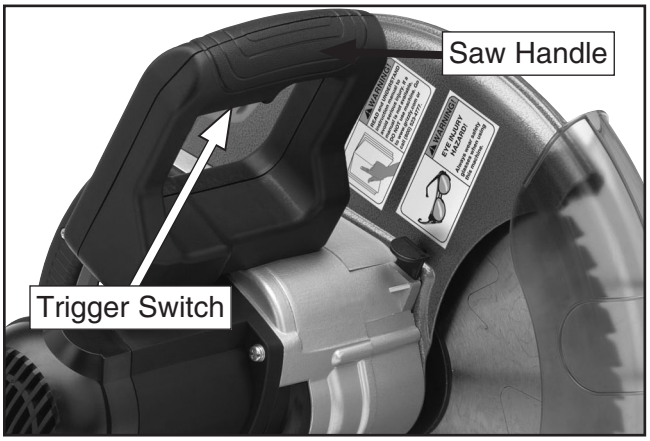


Figure 5. Control box.

Vise Handle: Opens and closes the vise jaws to clamp the workpiece.

Vise Angle Lock Lever: Locks the angle of the vise fence.

Vise Location Lock Lever: Locks the position of the vise fence for proper workpiece alignment.

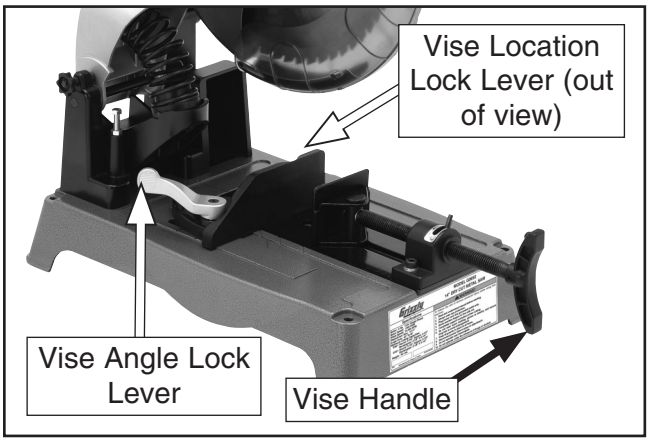


Figure 6. Vise controls.

Vise Fence

For optimal cutting results, the center-line of the blade must be as close as possible to the center-line of the workpiece. The workpiece alignment is determined by both the *position* and the *angle* of the vise fence. Since the position and the angle of the fence are related, both must be adjusted at the same time.

To adjust the vise fence:

1. DISCONNECT SAW FROM POWER!

2. Loosen the vise angle lock lever and the vise location lock lever (**Figure 7**).

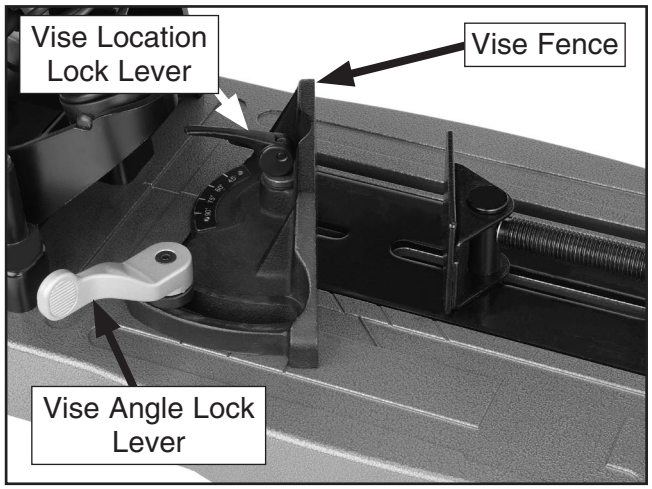


Figure 7. Vise fence.

3. Place the workpiece against the vise fence, then, using the scale as a guide, set the approximate desired angle of cut.

4. While maintaining the angle of the vise fence, slide the fence along the base until the center-line of the workpiece approximately matches the center-line of the saw (**Figure 8**).

   Note: *Because the center-line of the saw changes as the saw arm moves, it is necessary to lower the saw for proper alignment. Check for proper alignment periodically as you adjust the fence position.*

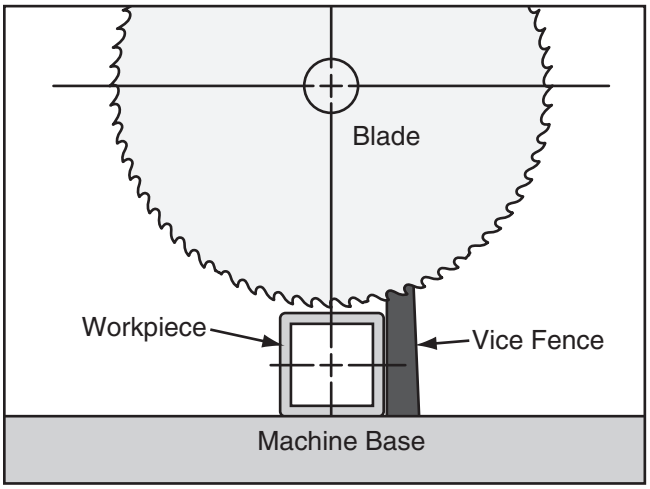


Figure 8. Blade/workpiece alignment.

5. Double check that the vise fence is still set for the desired angle of cut, then tighten both lock levers.

⚠CAUTION

Always turn the saw *OFF* and allow the blade to come to a complete stop before using the vise! Failure to follow this caution may lead to injury.

Use the chart shown in **Figure 9** as a guide to quickly position the workpiece between the vise jaws correctly and to avoid slipping during a cut. DO NOT CUT STEEL THAT IS STACKED OR BUNDLED. One or more workpieces will slip and damage the saw blade.

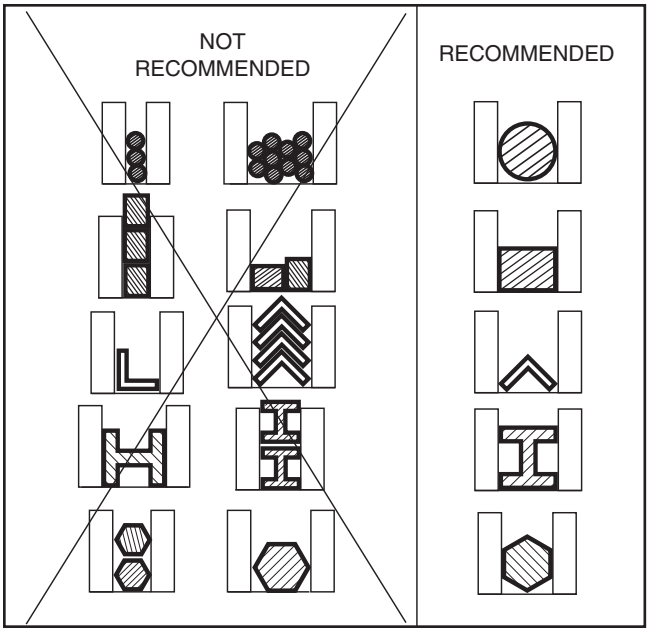


Figure 9. Vise holding chart.

Vise Quick Release

The Model G0692 is equipped with a quick release on the vise leadscrew. This allows for rapid adjustments for a variety of workpiece dimensions.

To use the vise quick release:

1. Move the vise quick release lever to the left ("loose") position. This releases the leadscrew and allows the vise clamp to slide as needed (**Figure 10**).

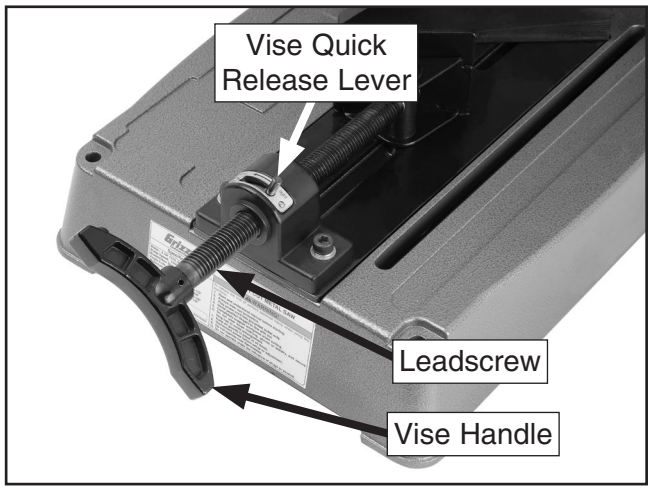


Figure 10. Vise quick release lever.

2. Slide the vise clamp to the approximate location needed, then move the vise quick release lever to the right ("tight") position. This engages the leadscrew.

3. Use the vise handle to tighten and loosen the vise clamp as needed to secure the workpiece.

Chip Collection Tray

The Model G0692 has a chip collection tray to catch most of the chips produced during cutting. Periodically slide it out the back and dispose of the chips (**Figure 11**).

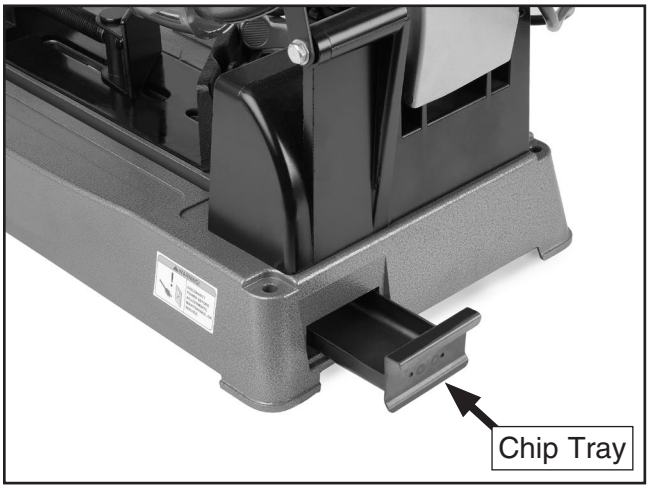


Figure 11. Chip collection tray.

Switch Lock-out

To prevent unauthorized use of the saw, it can be locked in the off position by placing a padlock through the hole in the trigger switch (**Figure 12**).

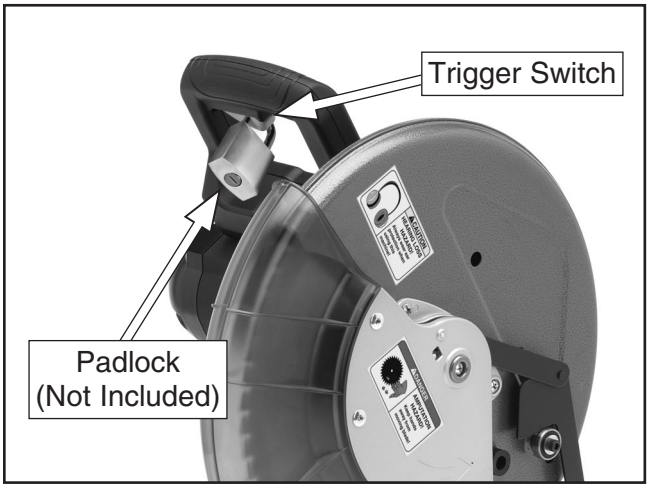


Figure 12. Switch lockout.

Blade Terminology

Selecting the right blade for the cut requires an understanding of various blade characteristics.

Blade Terminology

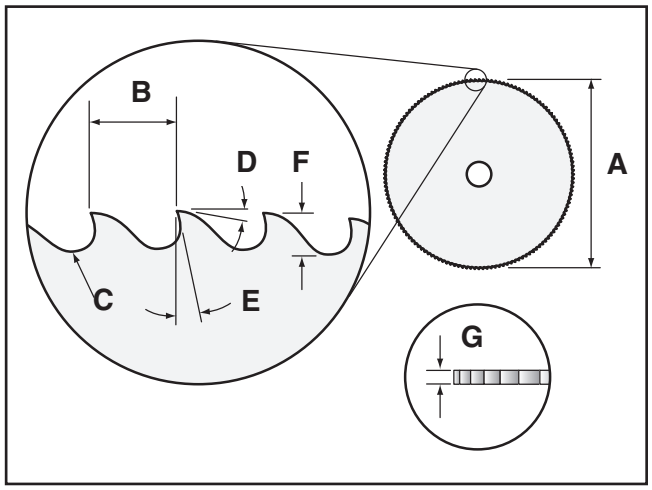


Figure 13. Blade terminology.

A. Blade Size (Diameter): The overall diameter of the blade. The Model G0692 uses 14" blades.

B. Pitch: The distance from the tip of one tooth to the tip of the next. Typically given in Teeth Per Inch (TPI).

C. Gullet: The shallow area between the tips of the teeth.

D. Front Rake Angle: The measurement of the angle formed between the tip of the blade tooth and a line tangent to the perimeter of the blade.

E. Rear Rake Angle: The measurement of the angle formed between the face of the tooth and the diameter.

F. Tooth Depth: The distance from the tip of the tooth to the bottom of the corresponding gullet.

G. Kerf: The width of the cut created by the blade.

Blade Pitch

The most important consideration when selecting a blade is blade pitch, which is typically measured in "teeth per inch" (TPI). Proper TPI for any cut depends on the cross-section size and wall thickness of the workpiece.

If the blade pitch is too coarse for the cut, there will be too few teeth making the cut at any given time. This results in broken blade teeth and rough cuts due to excessive strain applied to both the blade and the workpiece (**Figure 14**). Use a blade pitch that keeps at least three teeth in the workpiece at any time.

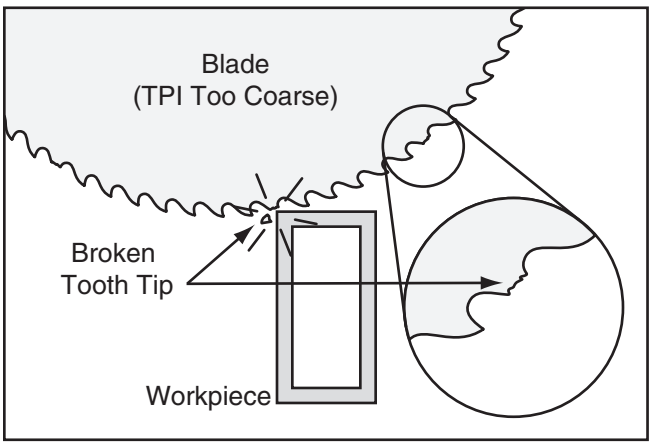


Figure 14. TPI too coarse for workpiece.

Conversely, if the blade pitch is too fine for the cut, teeth will remain in the workpiece and remove more material than the blade gullet can hold. This buildup of chips prevents the teeth from cutting effectively and results in poor cutting efficiency, overheating, and rapid rounding-off of teeth (**FIgure 15**).

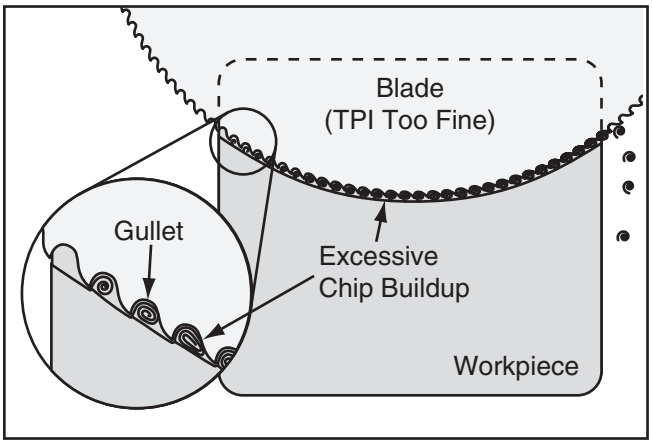


Figure 15. TPI too fine for workpiece.

Similarly, if the workpiece is a soft metal such as aluminum, each tooth will remove more material and rapidly fill the blade gullet. For this reason, use a blade with fewer TPI on soft metals.

An additional problem with an overly fine-pitched blade is that the pressure each tooth exerts on the workpiece is reduced. This limits the cutting ability of the teeth and also results in a buildup of heat and inefficient cuts.

The ideal blade pitch is one that doesn't overload individual teeth (too coarse) and avoids excessive chip buildup in the gullet (too fine) (**Figure 16**).

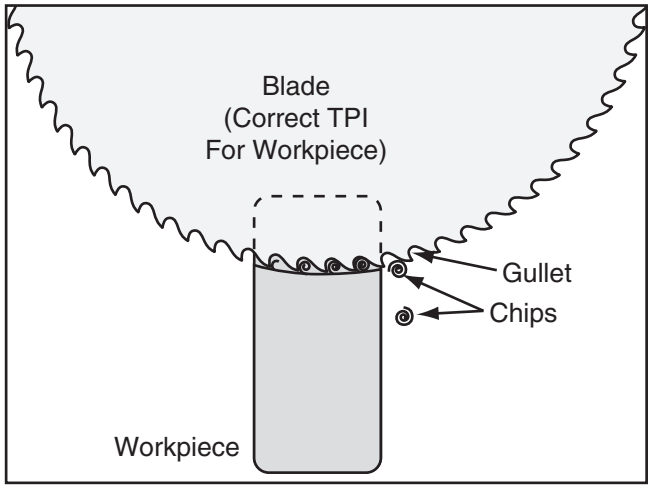


Figure 16. Correct TPI.

Damage to the blade, rough cuts, poor cutting performance, and overheating are all possible signs of improper blade pitch.

If you feel your machine is not functioning properly or performing to your standards, check that the blade pitch is correct for the cut.

Blade Feed Rate

Blade feed rate refers to the speed at which the blade cuts through a workpiece. On the Model G0692, feed rate is controlled by the amount of pressure exerted on the handle by the user. Pulling hard on the lever will result in a greater feed rate, whereas only pulling lightly will result in a very slow feed rate.

Cutting with a feed rate that is too slow can result in lengthy, inefficient cuts and in some cases, tooth dulling and overheating. The chips produced by the cut will generally be thin or powdery.

Cutting with a feed rate that is too fast may cause the blade to wander, resulting in cuts that are not straight, and will generate excess heat and dull the blade. When cutting small or thin-walled workpieces, the edges of the cut may become rough or torn.

The best method for evaluating the feed rate is through trial and error.

Blade Break-in

Proper break-in is important for the cutting performance and longevity of the blade. During the break-in period, only mild pressure should be exerted on the blade (about half of the normal feed pressure for a properly broken-in blade). The duration of the break-in period is determined by the hardness of the material cut. The break-in period is defined in terms of square inches of material cut.

—For hard materials, such as steel, the break-in period is the first 50 square inches of material cut.

—For soft materials, such as aluminum, the break-in period is the first 150 square inches of material cut.

To determine the square inches of a cut, calculate the area of the cross-section of the workpiece. Keep in mind when cutting hollow-section pieces that the area only includes the solid walls of the workpiece. Refer to **Figure 17** to calculate approximate square inches for many typical cuts.

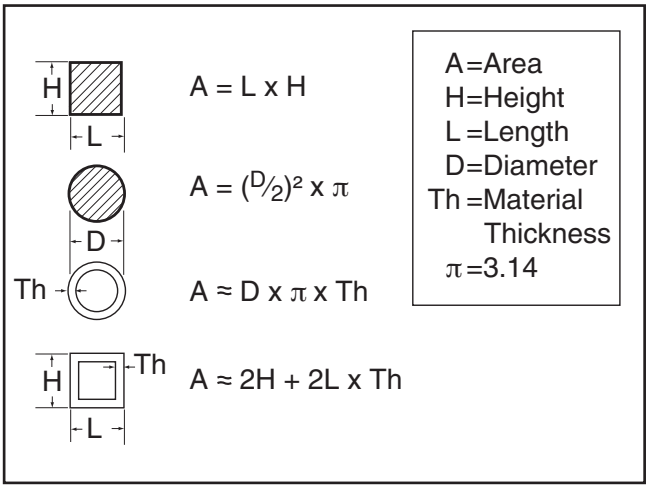
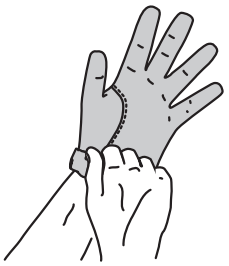


Figure 17. Calculating cut area for break-in.

Changing Blade



⚠CAUTION

The teeth of saw blades are sharp and can easily cut fingers and hands. Always wear heavy leather gloves when handling saw blades.

Tools Needed: **Qty**
Phillips Screwdriver #2 1
Hex Wrench 8mm..... 1

To replace the blade:

1. DISCONNECT SAW FROM POWER!

2. Loosen the two Phillips head screws shown in **Figure 18**.

Note: *The upper screw must be loosened approximately ¼" for **Step 3** to work properly.*

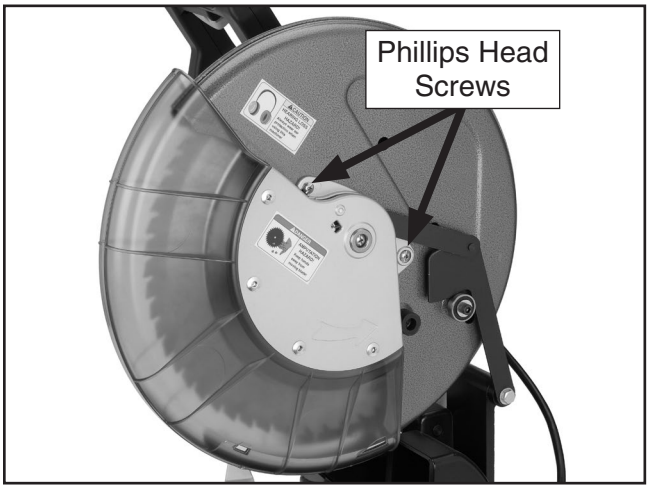


Figure 18. Guard bracket screw locations.

3. Retract the blade guard. As it rotates, the mounting bracket should also rotate, exposing the arbor screw, as shown in **Figure 19**.

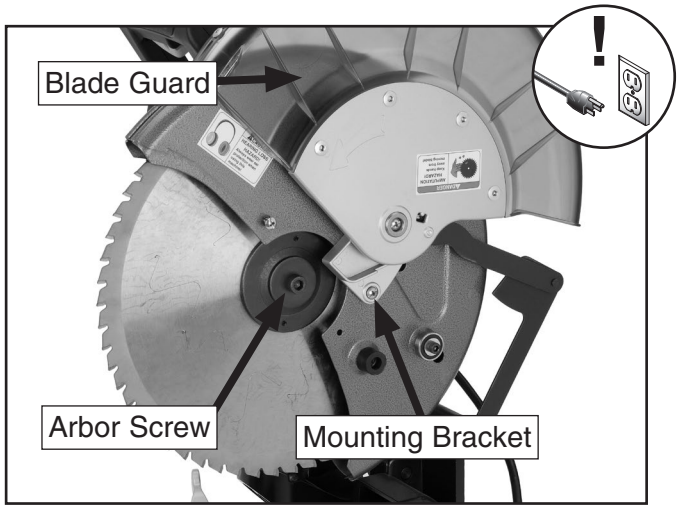


Figure 19. Blade guard retracted.

4. Lightly press down on the arbor lock button and rotate the blade until the button moves inward and locks the arbor. While holding the button, loosen the arbor screw (**Figure 20**).

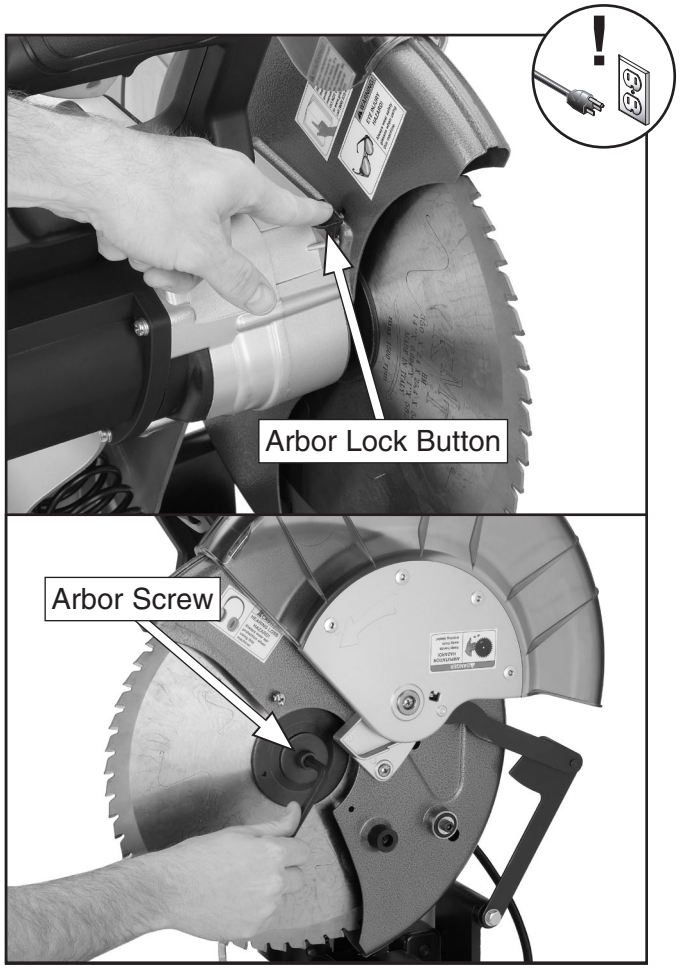


Figure 20. Arbor screw removal.

5. Remove the arbor screw, arbor washer, arbor flange, and the old blade (**Figure 21**).

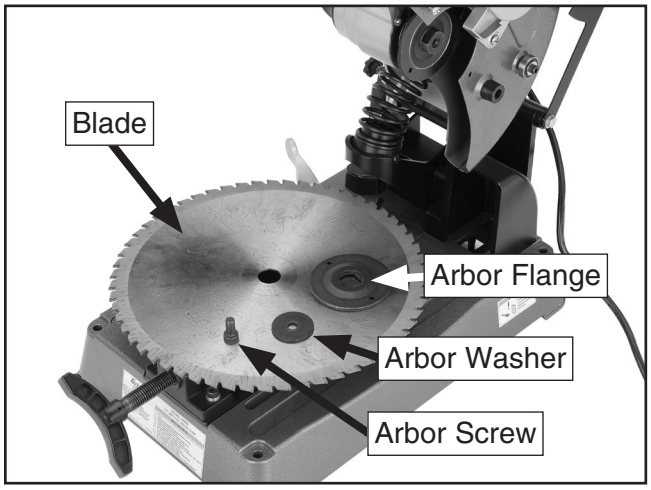


Figure 21. Blade components.

6. Install the new blade, arbor flange, arbor washer, and arbor screw in the reverse order from which they were removed. Use the arbor lock button to secure the arbor while tightening the arbor screw (**Figure 22**).

   Note: When installing the new blade, make sure the teeth point downward at the front of the blade, as shown in **Figures 13** & **22**

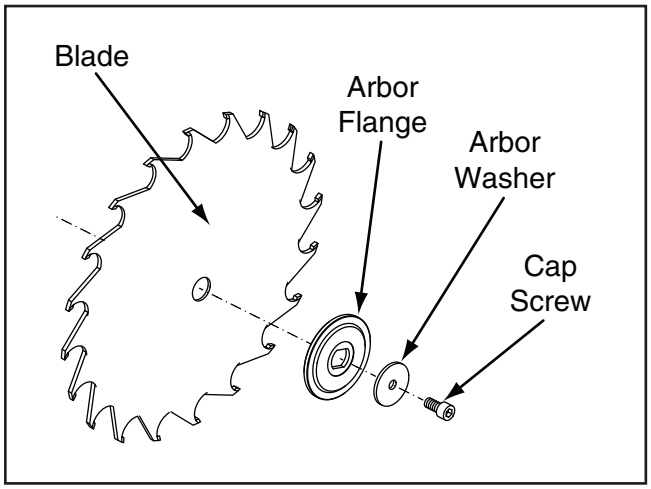


Figure 22. Blade installation sequence.

7. Return the blade guard to its normal position and tighten both Phillips head screws shown in **Figure 18**.

Cutting Procedures

After familiarizing yourself with the controls of the Model G0692, follow the basic outline below to perform safe and efficient cuts.

To make a cut:

1. DISCONNECT SAW FROM POWER!
2. Set the vise fence position and angle (**Page 13**).
3. Clamp the workpiece in the vise.
4. Connect the saw to power.
5. Press the trigger switch to start the blade and use a controlled, steady force to complete the cut. When the cut is completed, raise the saw, release the trigger, and allow the blade to come to a complete stop before proceeding.

Cutting Tips

- Replace, sharpen, and clean blades as necessary to maintain optimum cutting performance.
- Use even pressure while cutting. Heavy or irregular pressure can lead to poor cuts and damage the blade.
- Misusing the saw or using incorrect techniques is unsafe and results in poor cuts. Remember—the blade does the cutting with the operator's guidance.
- Use a roller stand to support long workpieces. See **Accessories** on **Page 20**.

General Machine Tips

- When the machine is not in use, raise the saw to reduce strain on the return spring.
- Inspect the machine regularly to keep it running in top condition.
- Clean, lubricate, and cover the machine before putting it into storage for extended periods of time.

SECTION 5: ACCESSORIES

T20920—Replacement blade for G0692 58T
H8724—14" x 1" Carbide Tipped Blade 72T
H5109—14" x 1" Metal Cutting Blade 90T
H5110—14" x 1" Stainless Steel Cutting Blade 90T

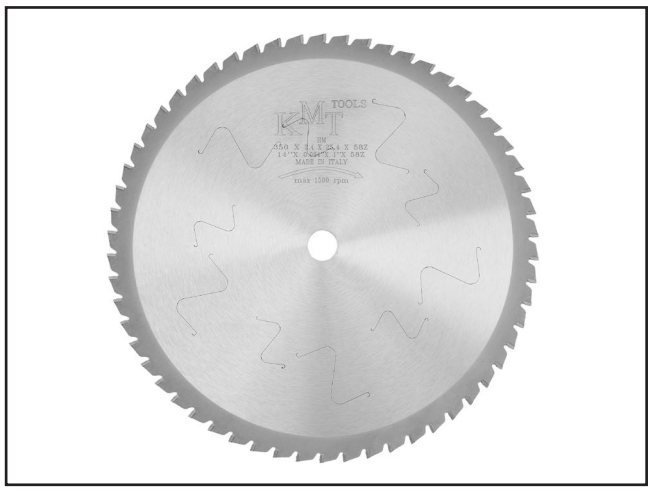


Figure 23. Replacement blade.

G8983—Tilting Roller Stand
Adjusts from 26" to 44", 0°-45°. 150 lb. capacity.
G8984—Single Roller Stand
Adjusts from 26⅝" to 45". 250 lb. capacity.
G8985—5 Roller Stand
Adjusts from 26" to 44⅝". 250 lb. capacity.
These super heavy-duty roller stands feature convenient hand knobs for fast height adjustment.

Figure 24. SHOP FOX® Roller Stands.

Basic Eye Protection

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

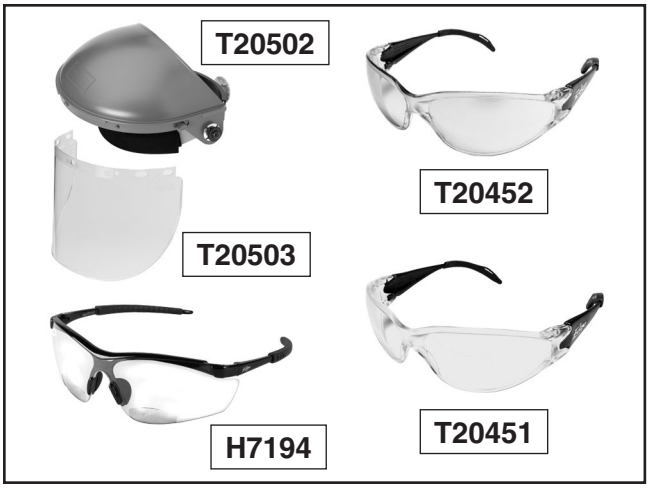


Figure 25. Our most popular eye protection.

G7313—700 lb Capacity SHOP FOX® Stand
A perfect stand for mounting your smaller machines on. Sturdy and rugged for everyday shop use.

Figure 26. G7313 **SHOP FOX®** Stand.

G5618—Deburring Tool w/2 Blades
G5619—Extra Aluminum Blades
G5620—Extra Brass and Cast Iron Blade
The quickest tool for smoothing freshly machined metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.

Figure 27. G5618 Deburring tool.

H3153—Pigskin Palm Gloves
H3154—Lined Pigskin Palm Gloves
Durable pigskin leather is combined with cloth backs for true comfort. One size fits many.

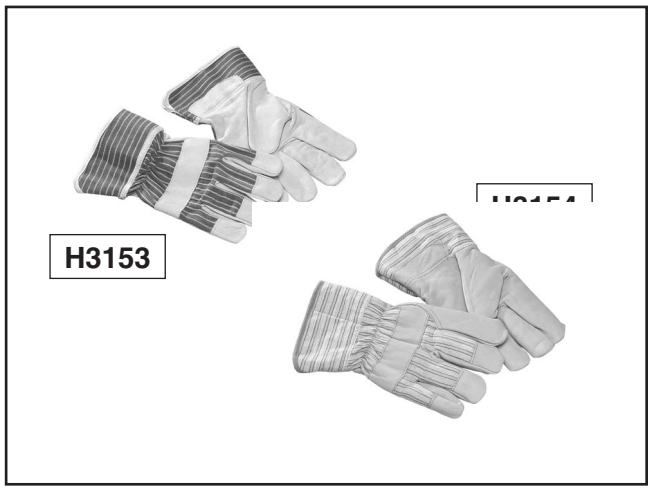


Figure 28. Work gloves.

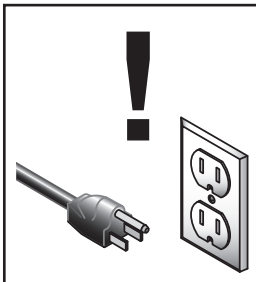
H8003—Hydraulic Lifting Table - 450 lbs.
This rugged and affordable lifting table allows you to lift stacks of sheet goods right up to the saw with minimal effort. Features 39⅜" x 19¾" table, 39½" maximum table height, 8" fixed and swivel casters with brakes.

Figure 29. Model H8003 Hydraulic Lifting Table.

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

Figure 30. Recommended products for protecting unpainted cast iron/steel part on machinery.

SECTION 6: MAINTENANCE



⚠WARNING

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

Schedule

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

Daily Check:
- Loose mounting bolts/screws/nuts.
- Damaged or worn saw blade.
- Proper function of blade guard.
- Any other unsafe condition.
- General cleanup to prevent buildup of metal shavings.

Weekly Maintenance:
- Clean the machine thoroughly.
- Clean/grease the vise leadscrew.

Monthly Check:
- Check/tighten all machine bolts.

Cleaning

Cleaning the Model G0692 is relatively easy. Vacuum excess metal chips and wipe off the remaining debris and residue with a dry cloth.

Unpainted Cast Iron

Keep unpainted cast iron surfaces rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9, all available through the Grizzly catalog or website.

Lubrication

Vise Leadscrew

1. DISCONNECT SAW FROM POWER!

2. Use a rag to clean any debris from the vise leadscrew.

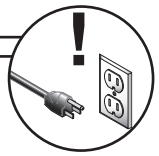
3. Apply multipurpose grease to the leadscrew and completely open and close the vise several times to distribute the grease.

   Note: *Periodically clean the leadscrew thoroughly with mineral spirits or other degreaser and relubricate with multipurpose grease.*

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

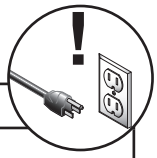
Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Corrective Action
Machine does not start/indicator light does not come on or a breaker trips.	1. Plug/receptacle is at fault or wired incorrectly. 2. Wall fuse/circuit breaker is blown/tripped. 3. Power supply switched ***OFF*** or is at fault. 4. Wiring is open/has high resistance. 5. Motor ON/OFF switch is at fault. 6. Motor is at fault.	1. Test for good contacts; correct the wiring. 2. Ensure circuit size is suitable for this machine; replace weak breaker. 3. Ensure power supply is switched ***ON***; ensure power supply has the correct voltage. 4. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 5. Replace faulty ON/OFF switch. 6. Test/repair/replace.
Machine stalls or is overloaded.	1. Motor connection is wired incorrectly. 2. Plug/receptacle is at fault. 3. Motor is at fault.	1. Correct motor wiring connections (**Page 27**). 2. Test for good contacts; correct the wiring. 3. Test/repair/replace.
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. Motor mount loose/broken. 3. Machine sits unevenly. 4 Motor fan is rubbing on fan cover. 5. Motor bearings are at fault.	1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Tighten/replace. 3. Relocate/shim machine. 4. Replace dented fan cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Indicator light is on and trigger switch fails to activate motor.	1. Plug connecting trigger switch to control box is unplugged. 2. Trigger switch at fault. 3. Motor is at fault.	1. Correctly insert plug. 2. Test/repair/replace. 3. Test/repair/replace.

Blade Troubleshooting



Symptom	Possible Cause	Corrective Action
Blade teeth dull prematurely.	1. Feed speed/pressure too low. 2. Blade pitch too fine for cut. 3. Impurities in workpiece. 4. Blade not broken-in properly.	1. Increase feed speed/pressure. 2. Check blade pitch, use a coarser-pitch blade. 3. Inspect/clean/discard workpiece. 4. Replace blade and follow **Blade Break-in** on **Page 17**.
Blade teeth are broken/ missing.	1. Feed speed/pressure too high. 2. Blade allowed to hop during cut. 3. Blade was in contact with the workpiece when machine was turned ***ON***. 4. Blade tooth pitch incorrect for cut. 5. Blade not broken-in correctly.	1. Reduce feed pressure by relieving pressure on the feed lever during operation. 2. Allow blade to enter workpiece in a slow and controlled manner, follow through with a smooth and even pressure. 3. Never start the blade in contact with the workpiece. 4. Check blade tooth pitch. 5. Replace blade and follow **Blade Break-in** on **Page 17**.

Motor Brushes

During the life of your machine, you may find it necessary to replace the motor brushes. If the motor loses power or becomes noisy, check the brushes and replace them if they are worn down to ¼" or less.

Tools Needed	Qty
Phillips Screwdriver #2	1
Acetone and Cotton Rag	1
Crocus Cloth (From Local Auto Parts Store)	1
Brush Set	1

To replace the brushes:

1. DISCONNECT SAW FROM POWER!

2. Remove the two motor cover screws and the motor cover (**Figure 31**).

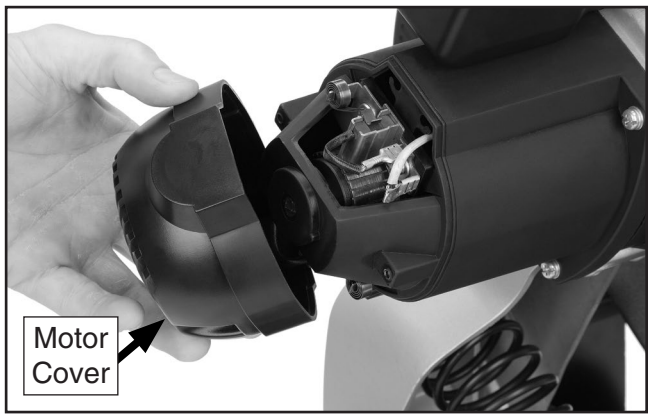


Figure 31. Motor cover.

3. Pull back the brush springs and remove both brush assemblies (**Figure 32**).

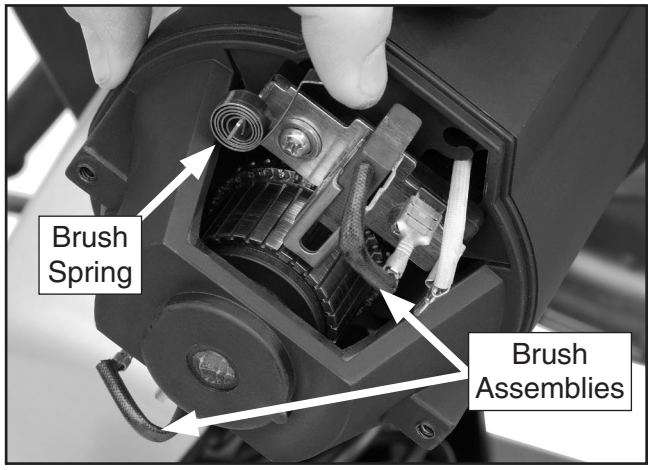


Figure 32. Brush removal.

4. Inspect the commutator surface (**Figure 33**).

   —If the brushes have worn deep grooves in the commutator, we recommend replacing the motor. Typically the labor involved with re-turning the commutator on a lathe and then undercutting the insulator segments exceeds the price of a new motor.

   —If the commutator only has minor wear and black-colored carbon tracking (**Figure 33**), use a fine crocus cloth to polish the commutator where the brushes ride.

   Finish the cleaning process by using acetone and a cotton rag to wipe off any oils or contaminants from the commutator. DO NOT use emery cloth or sandpaper to clean the commutator or you will make it out-of-round, which will cause the new brushes to arc, overheat, and wear out quickly.

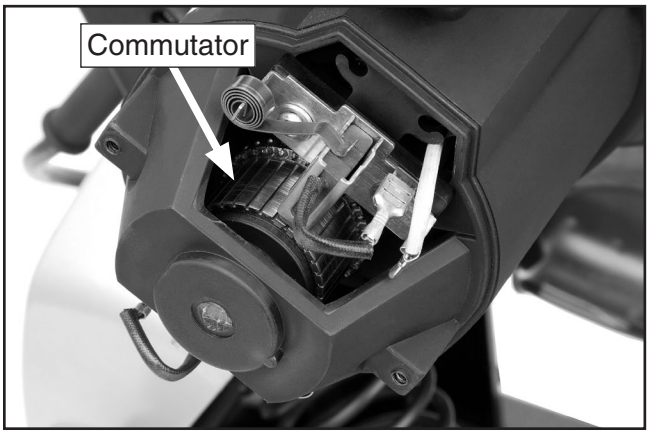


Figure 33. Commutator.

5. Replace both brush assemblies, making sure they are held in place with the spring and that the wire is connected.

6. Reinstall the motor cover.

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠WARNING
Wiring Safety Instructions

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

2. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

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

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

5. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

7. **CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.

8. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements on **Page 9** when connecting your machine to a power source.

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

NOTICE

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

COLOR KEY

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

Wiring Diagram

View this page in color at *www.grizzly.com.*

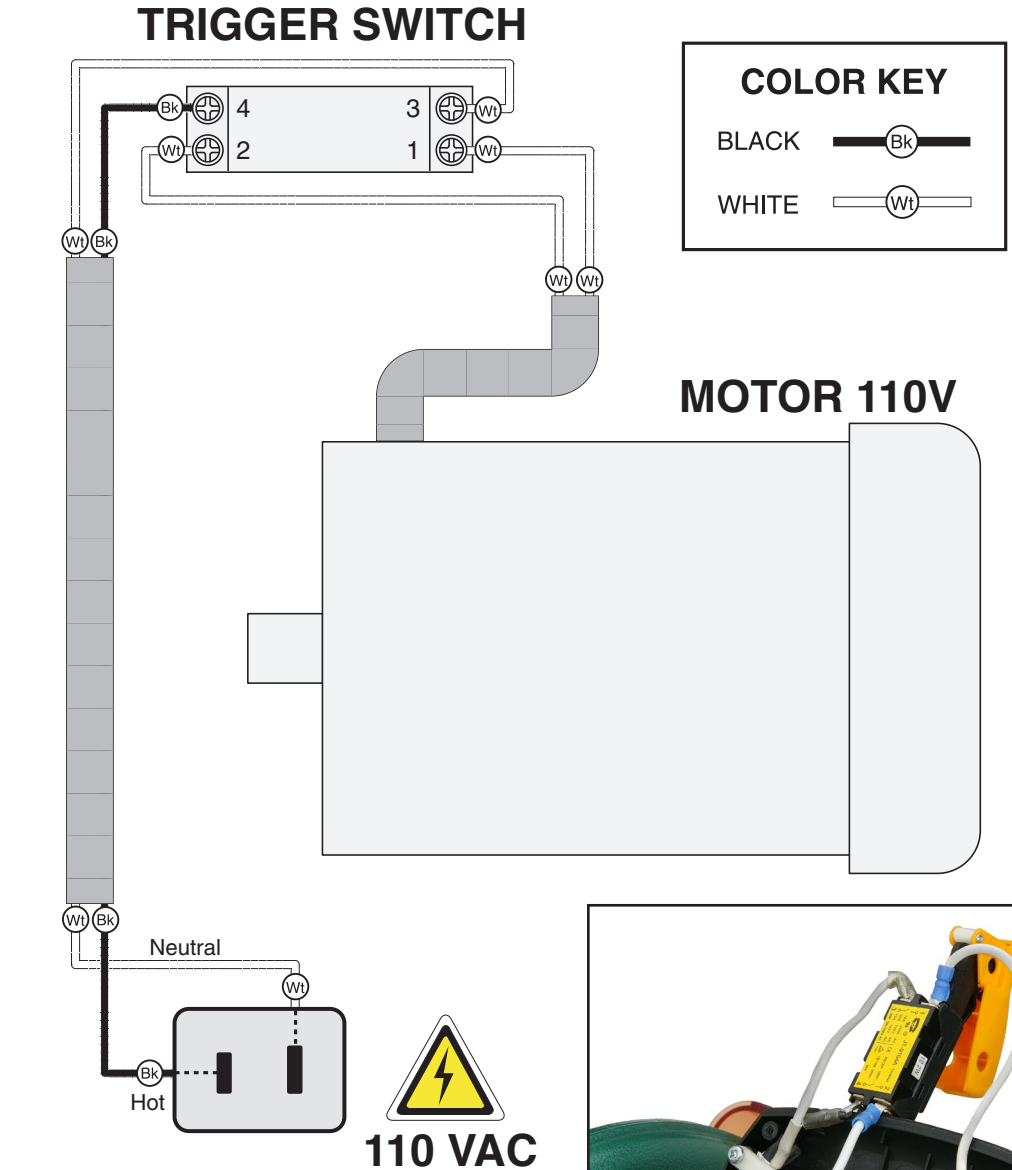
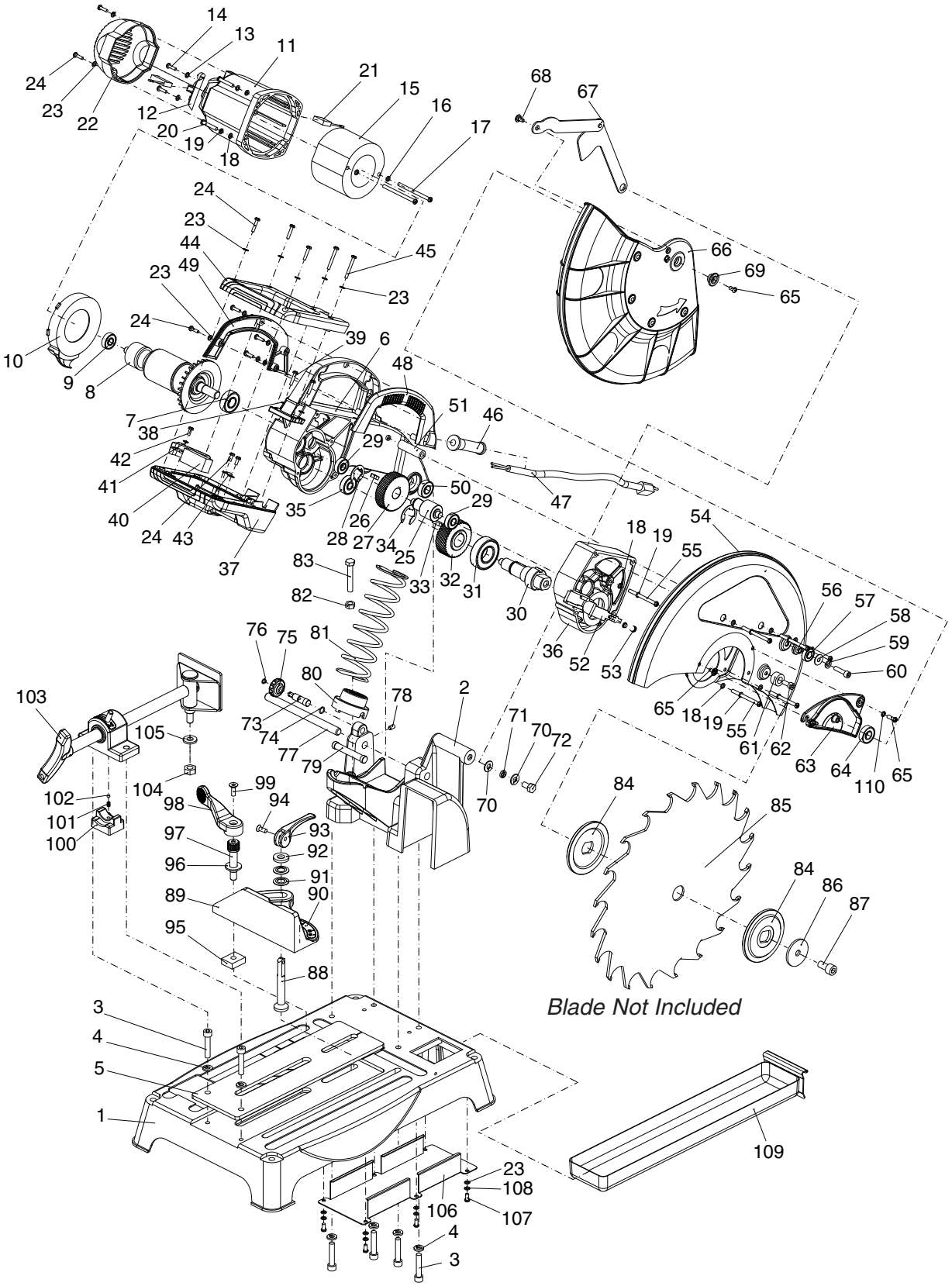


Figure 34. Wiring.

SECTION 9: PARTS

Parts Breakdown

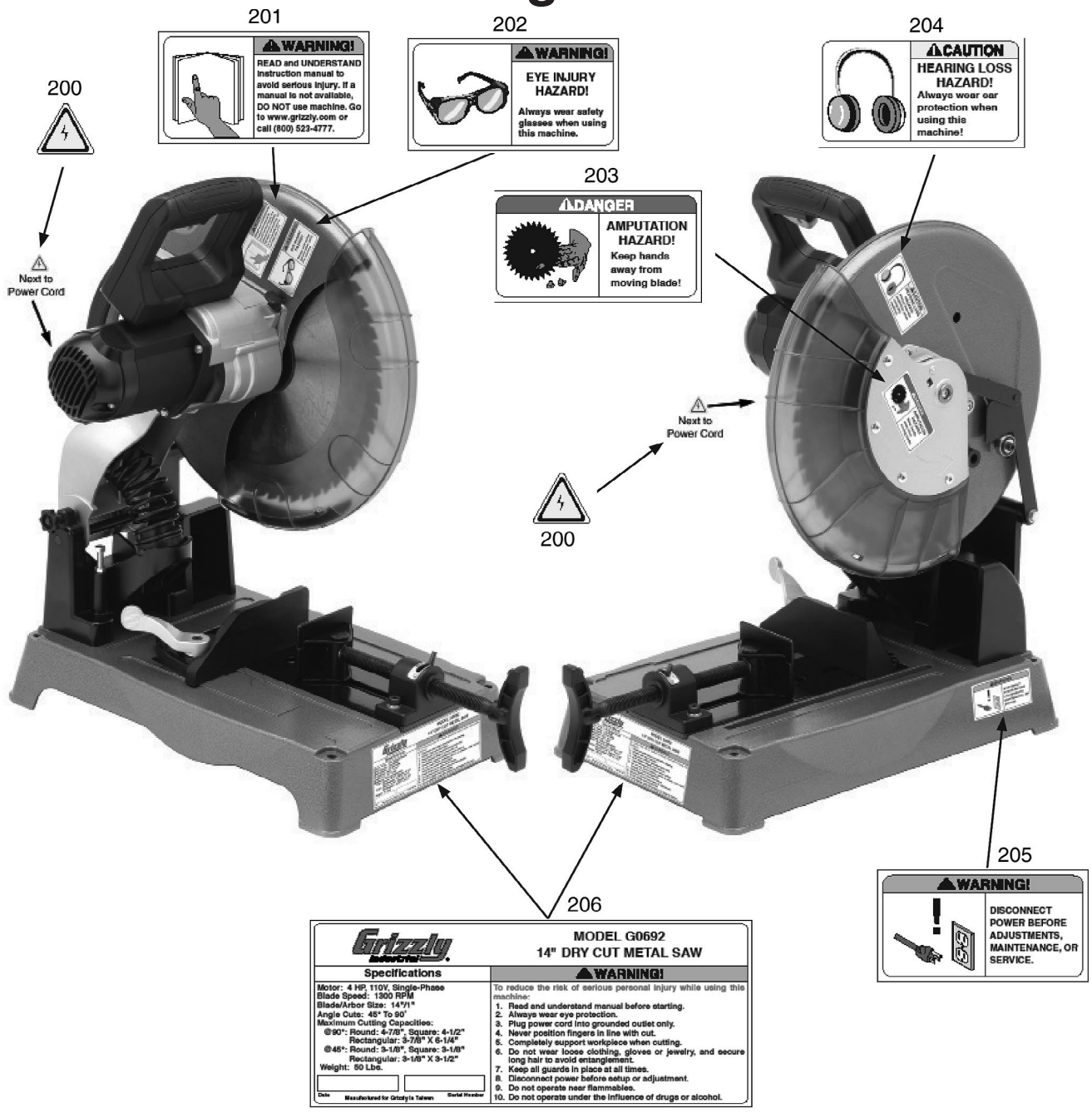


Parts List

REF	PART #	DESCRIPTION
1	P0692001	BASE
2	P0692002	ANCHOR HOUSING
3	PSB40M	CAP SCREW M8-1.25 X 35
4	PLW04M	LOCK WASHER 8MM
5	P0692005	VISE SLIDE PLATE
6	P0692006	MOTOR TILT BASE
7	P6202LLB	BALL BEARING 6202LLB
8	P0692008	ROTOR
9	P6000LLB	BALL BEARING 6000LLB
10	P0692010	AIR FLOW COVER
11	P0692011	MOTOR FRAME
12	P0692012	BRUSH HOLDER
13	PW05M	FLAT WASHER 4MM
14	PHTEK31M	TAP SCREW M4 X 14
15	P0692015	STATOR
16	PTLW02M	EXT TOOTH WASHER 5MM
17	PHTEK43M	TAP SCREW M5 X 70
18	PW02M	FLAT WASHER 5MM
19	PLW01M	LOCK WASHER 5MM
20	P0692020	CAP SCREW M5-.8 X 28
21	P0692021	CARBON BRUSH SET
22	P0692022	COVER
23	PW05M	FLAT WASHER 4MM
24	PHTEK6M	TAP SCREW M4 X 16
25	P0692025	GEAR SHAFT
26	PK19M	KEY 5 X 5 X 14
27	P0692027	PINION M1.25 X 43T
28	PEC03M	E-CLIP 10MM
29	P6000LLB	BALL BEARING 6000LLB
30	P0692030	ARBOR
31	P6205LLB	BALL BEARING 6205LLB
32	P0692032	GEAR M1.5 X 40T
33	PK14M	KEY 5 X 5 X 18
34	PEC03M	E-CLIP 25MM
35	P6200LLB	BALL BEARING 6200LLB
36	P0692036	GEAR BOX
37	P0692037	LOWER SWITCH HANDLE
38	PW05M	FLAT WASHER 4MM
39	PHTEK28M	TAP SCREW M4 X 25
40	P0692040	TRIGGER SWITCH
41	PW05M	FLAT WASHER 4MM
42	PHTEK39M	TAP SCREW M4 X 12
43	P0692043	WIRE RETAINER
44	P0692044	UPPER SWITCH HANDLE
45	PHTEK42M	TAP SCREW M4 X 35
46	P0692046	WIRE GUARD
47	P0692047	POWER CORD 110V 8'
48	P0692048	RIGHT SIDE HANDLE
49	P0692049	LEFT SIDE HANDLE
50	P6000LLB	BALL BEARING 6000LLB
51	P0692051	GUARD TUBE
52	P0692052	FRONT SHAFT BRAKE LEVER
53	P0692053	COMPRESSION SPRING
54	P0692054	SAWBLADE GUARD
55	PSB137M	CAP SCREW M5-.8 X 55

REF	PART #	DESCRIPTION
56	P0692056	BEARING BUSHING
57	P6000LLB	BALL BEARING 6000LLB
58	PW03M	FLAT WASHER 6MM
59	PLW03M	LOCK WASHER 6MM
60	PSB02M	CAP SCREW M6-1 X 20
61	P0692061	RUBBER SEAT
62	PSB26M	CAP SCREW M6-1 X 12
63	P0692063	CENTER COVER
64	P6000LLB	BALL BEARING 6000LLB
65	PSB33M	CAP SCREW M5-.8 X 12
66	P0692066	SLIDING GUARD ASSEMBLY
67	P0692067	CONNECTION ROD ASSEMBLY
68	P0692068	SPECIAL CAP SCREW M5-.8 X 12
69	P0692069	GUARD BUSHING
70	PW01M	FLAT WASHER 8MM
71	P0692071	CONNECTION ROD BUSHING
72	PB84M	HEX BOLT M8-1.25 X 14
73	P0692073	LOCK LEVER
74	P0692074	RUBBER RING
75	P0692075	KNOB HANDLE
76	PR04M	EXT RETAINING RING 6MM
77	P0692077	SHAFT
78	PSB04M	CAP SCREW M6-1 X 10
79	P0692079	SPRING SEAT SHAFT
80	P0692080	SPRING RUBBER SEAT
81	P0692081	COMPRESSION SPRING
82	PN03M	HEX NUT M8-1.25
83	PB126M	HEX BOLT M8-1.25 X 40
84	P0692084	ARBOR FLANGE
85	T20920	BLADE 58-T 350 X 2.4 X 25.4MM
86	P0692086	CLAMP WASHER
87	PB56M	CAP SCREW M10-1.5 X 20
88	P0692088	PIVOT SHAFT
89	P0692089	FIXED VISE JAW
90	P0692090	ANGLE SCALE
91	P0692091	DISC SPRING
92	P0692092	BUSHING
93	P0692093	PULL BAR
94	PSB26M	CAP SCREW M6-1 X 12
95	P0692095	T-NUT M8-1.25
96	P0692096	SPACER RING
97	P0692097	STUD
98	P0692098	LEVER
99	PFH02M	FLAT HD SCR M6-1 X 12
100	P0692100	SADDLE
101	P0692101	COMPRESSION SPRING
102	P0692102	STEEL BALL
103	P0692103	LEADSCREW ASSEMBLY
104	PN02M	HEX NUT M10-1.5
105	PW04M	FLAT WASHER 10MM
106	P0692106	SLAG TRAY SLIDE
107	PSB23M	CAP SCREW M4-.7 X 12
108	PLW02M	LOCK WASHER 4MM
109	P0692109	SLAG TRAY
110	PW02M	FLAT WASHER 5MM

Warning Labels



REF	PART #	DESCRIPTION
200	PLABEL-14B	ELECTRICTY LABEL
201	P0692201	READ MANUAL LABEL
202	P0692202	WEAR SAFETY GLASSES LABEL
203	P0692203	AMPUTATION WARNING LABEL

REF	PART #	DESCRIPTION
204	P0692204	HEARING WARNINING LABEL
205	P0692205	DISCONNECT POWER LABEL
206	P0692206	MACHINE ID LABEL

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____

Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

____ Advertisement	____ Friend	____ Catalog
____ Card Deck	____ Website	____ Other:

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

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

3. What is your annual household income?

____ $20,000-$29,000	____ $30,000-$39,000	____ $40,000-$49,000
____ $50,000-$59,000	____ $60,000-$69,000	____ $70,000+

4. What is your age group?

____ 20-29	____ 30-39	____ 40-49
____ 50-59	____ 60-69	____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____Yes _____No

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

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

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

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

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

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

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