

Grizzly *Industrial, Inc.*®

MODEL G7152 4 TON NOTCHER OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#JB10872 PRINTED IN CHINA

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

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

The owner of this machine/equipment 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, blade/cutter 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

Foreword

We are proud to offer the Model G7152 4 Ton Notcher. This machine is part of a growing Grizzly family of fine metalworking 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.

The specifications, drawings, and photographs illustrated in this manual represent the Model G7152 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

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

Functional Overview

A notcher is used to remove portions (notches) from the edges of sheet-metal workpieces. Because the notcher blades form a 90° angle, all notches are made at right angles.

To use the Model G7152, the operator places the sheet metal workpiece on the work table, aligning the workpiece with the notching blades. If repetitive cuts will be made, the operator can place the work stops against the workpiece so that later cuts can be quickly aligned. Once the workpiece is aligned, the operator pulls the handle to lower the blades into and through the workpiece.



Identification

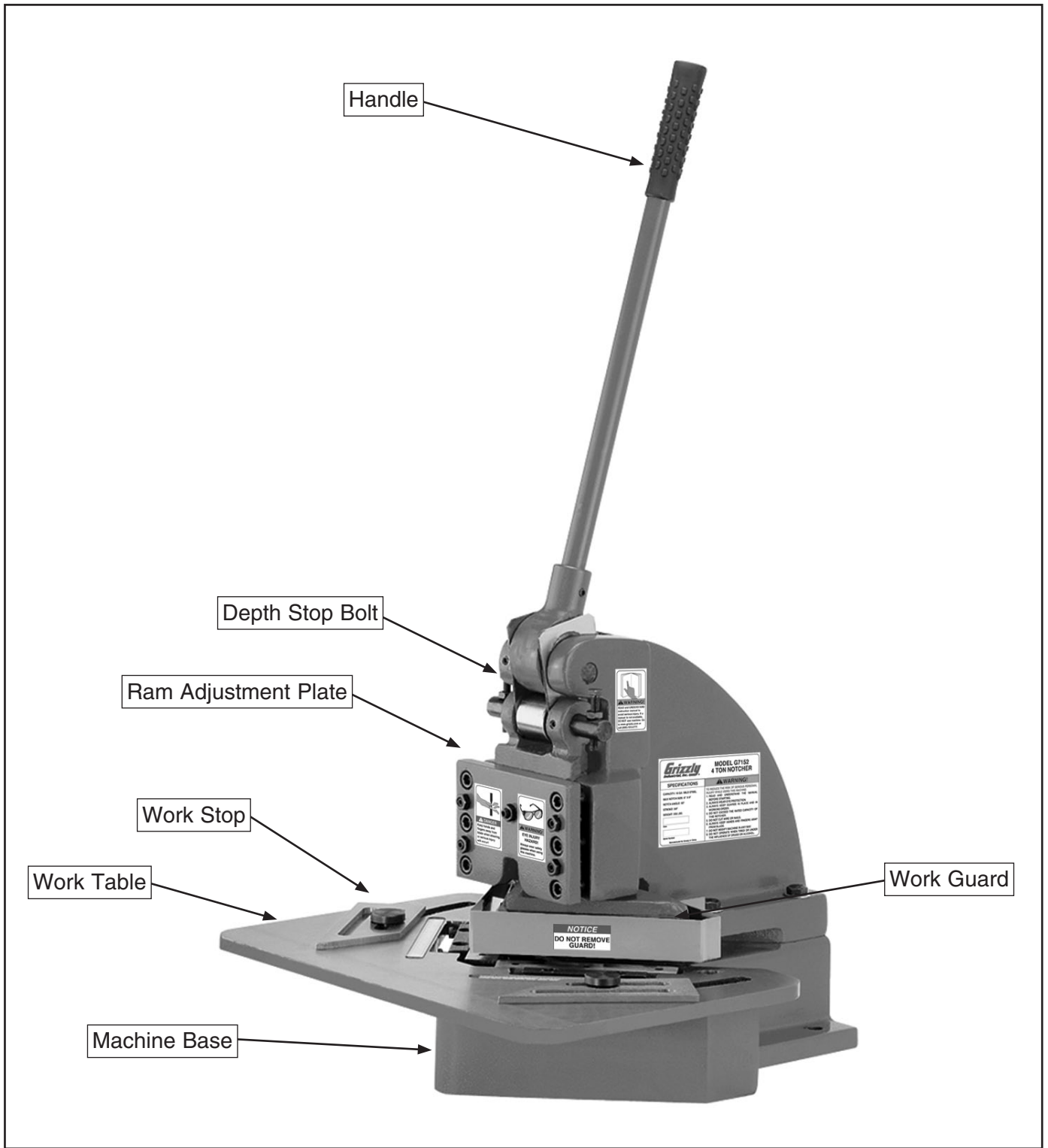


Figure 1. Identification.





MACHINE DATA SHEET

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

MODEL G7152 4-TON NOTCHER

Product Dimensions:

Weight 209 lbs.
 Length/Width/Height 33" x 18¼" x 36"
 Footprint (Length/Width) 46" x 24½"
 Work Table..... 12" x 18"

Shipping Dimensions:

Type Wood Crate
 Content..... Machine
 Weight..... 275 lbs.
 Length/Width/Height..... 23½" x 22" x 23"

Capacities:

Maximum Notch Size 6" x 6"
 Notch Angle 90°
 Maximum Thickness 16 Ga. Mild Steel
 Notch Stroke ¾"

Construction

Shear Blades Precision Ground Hardened Steel
 Frame..... Cast Iron
 Table Ground Cast Iron

Other Specifications:

Country Of Origin China
 Warranty..... 1 Year
 Serial Number Location ID Label on Side of Machine
 Assembly Time 15 minutes

Features:

Adjustable Work Stops
 4-Ton Notching Force



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 intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



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



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



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

NOTICE

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

WARNING

Safety Instructions for Machinery

- 1. READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
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 or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase 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.** Maintain stability and balance at all times.
23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.



WARNING

Additional Safety Instructions for Notchers

- 1. GUARDS.** Keep all guards in place and in working order. If the guard is removed or not in position, fingers may be accidentally placed in the path of the blades, resulting in severe injury during use.
- 2. HANDS AND FINGERS.** Always keep hands and fingers away from the blade during notching operations. If hands or fingers are in the path of the blades during use, severe injury may occur.
- 3. OPERATOR POSITION.** Keep all body parts out of the way of all moving parts. Serious pinches and cuts could occur.
- 4. CAPACITY.** Never exceed the rated capacity for this notcher. Doing so could result in machine failure and bodily injury as a result of flying debris or sudden movement.
- 5. COMFORTABLE CUTTING OPERATIONS.** Avoid awkward operations and hand positions where a sudden slip could cause your hand or body to fall into a sharp edge or corner.
- 6. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the notcher! Contact Tech Support at (570) 546-9663.

WARNING

Like all machinery there is potential danger when operating this machine. 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.

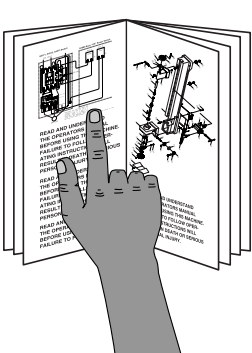
CAUTION

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: SETUP


Setup 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 operating the machine!



!WARNING
Wear safety glasses during the entire setup process!



!WARNING
This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Items Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Hex Wrench $\frac{5}{32}$ "	1
• Mounting Hardware	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.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Inventory: (Figure 2)	Qty
A. 4 Ton Notcher.....	1
B. Handle.....	1

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.

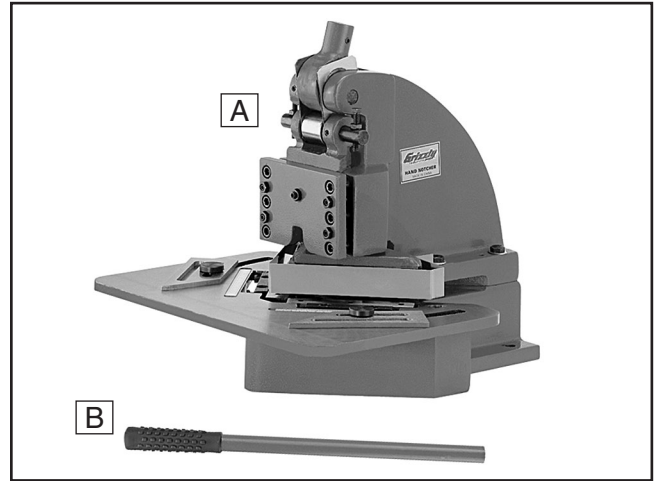



Figure 2. Inventory.

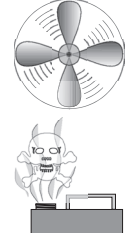
An icon showing a crumpled plastic bag being thrown into a recycling bin. The bin has a recycling symbol on it.	<p>! WARNING SUFFOCATION HAZARD! Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.</p>
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Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in **Figure 3**. For thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>! WARNING Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.</p>
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	<p>! CAUTION Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.</p>
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G2544—Solvent Cleaner & Degreaser
A great product for removing the waxy shipping grease from your machine during clean up.

<p>Call 1-800-523-4777 To Order</p>	
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Figure 3. Cleaner/degreaser available from Grizzly.

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.

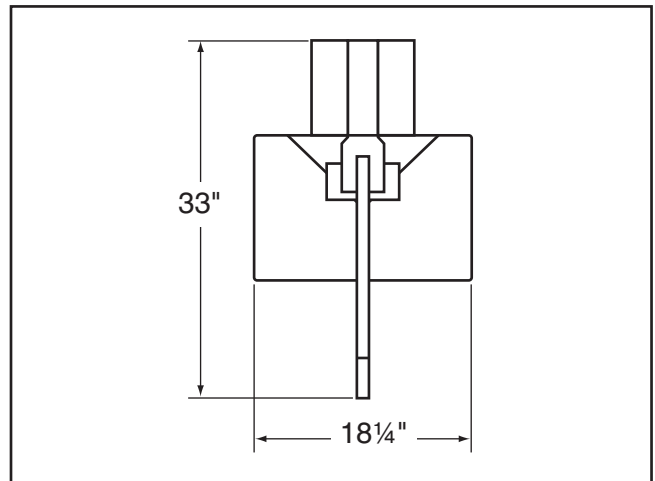
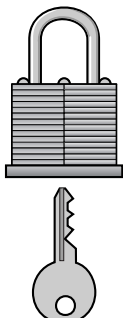


Figure 4. Minimum working clearances.

	<p>! 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.</p>
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Assembly

Assembly for the Model G7152 consists of attaching the handle to the machine. Insert the handle into the handle base, then tighten the set screw, as shown in **Figure 5**.

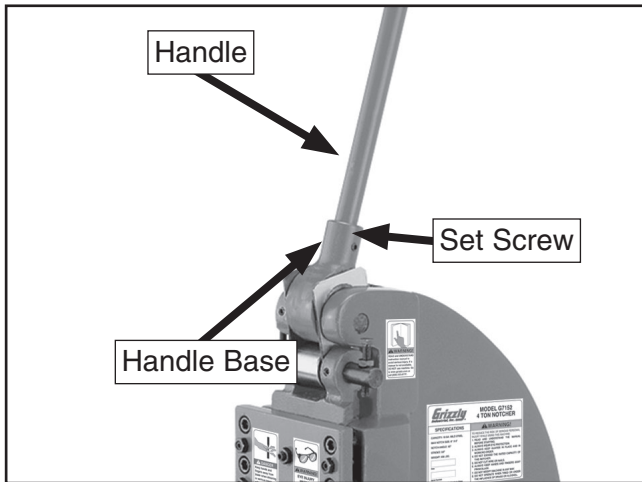


Figure 5. Attaching handle.

Mounting

Once your machine is assembled, mount it to a workbench through the holes in the base. Adjusting the blades, replacing the blades, or removing cutting waste on the Model G7152 requires open access to the underside of the machine. Keep this in mind when mounting the machine.

We recommend mounting the machine so that the front portion of the base hangs over the edge of the workbench. Due to the increase in force applied to the mounting hardware from this method, we strongly recommend that you use a "Through Mount" (**Figure 6**) and that your workbench is anchored to the floor or wall.

Another option is to make a hole in your workbench to allow access to the underside of the machine for blade adjustments and removal of waste material.

The alternative method is to mount the machine completely over the top of the workbench and remove the machine from the workbench whenever adjustments are made to the blades or when scraps must be removed.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the machine to the workbench.

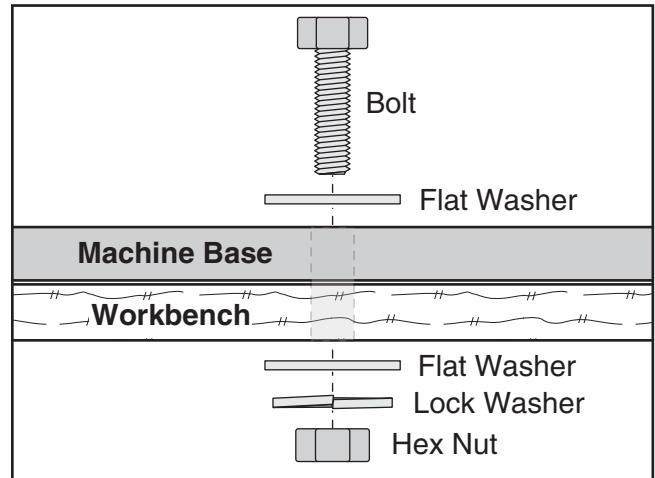


Figure 6. Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.

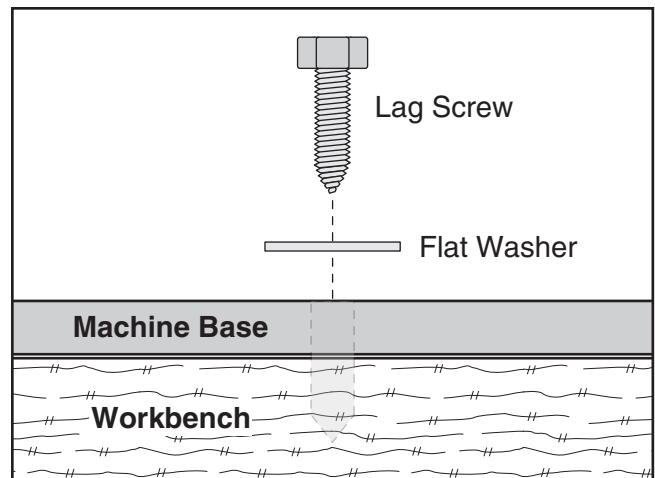
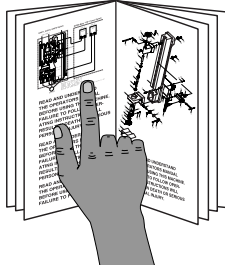


Figure 7. Example of a direct mount setup.



SECTION 3: OPERATIONS

Operation Safety



!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, hands and feet could result from using this machine without proper protective gear. Always wear safety glasses, leather gloves, and heavy-toed footwear when operating this machine.



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.

Basic Controls

Use the descriptions and **Figures 8–9** to become familiar with the basic controls of your machine.

Depth Stop Adjustment: Adjusts the distance that the blade ram moves into the table.

Ram Adjustment Plate: Adjusts to provide accurate, easy blade movement.

Blade Adjustment Bolts: Allow for precise positioning of the bottom blades.

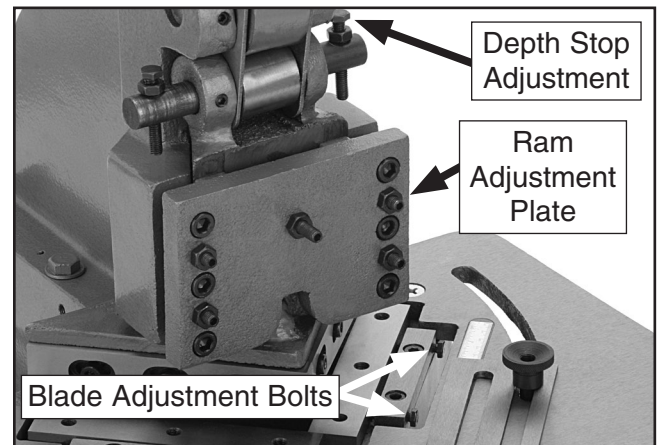


Figure 8. Adjustment knobs.

Handle: Actuates the ram, lowering the blades into the workpiece.

Work Stops: Easily align the workpiece for making repetitive cuts.

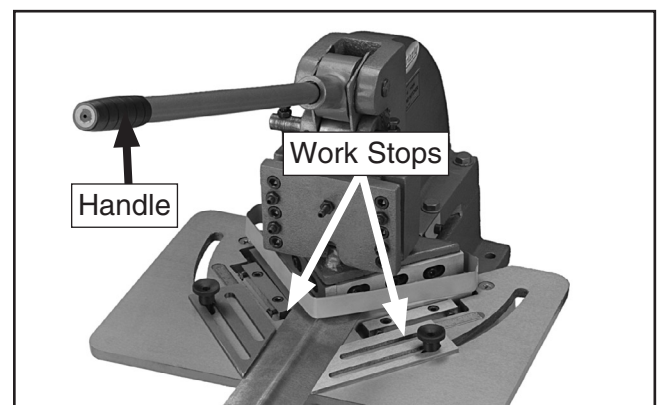


Figure 9. Controls.



Creating Notches

Be aware that during notching with the Model G7152, the waste from the cut will be ejected from the bottom of the machine. If the machine is mounted as recommended with the underside of the machine exposed, the waste will drop to the floor beneath the machine.

If the machine is mounted to a workbench in such a way that the underside of the table is not exposed, it will be necessary to periodically remove waste material from the base of the machine.

To make notches:

1. Wearing gloves and safety glasses or a face shield, place the workpiece on the table, lining it up with the blades as needed.

CAUTION

Injury to your feet could result when material is ejected from the bottom of the machine. Always wear heavy-toed leather footwear when operating this machine.

NOTICE

Only use the Model G7152 as it was designed. Use of a cheater bar or other method of increasing leverage may exceed the machine capacities, resulting in possible failure and personal injury, and will void the warranty.

2. Pull the handle down to move the top blades into and through the workpiece. Continue pulling until the cut is complete.
3. Lift the handle back to the uppermost position, then remove the workpiece.

Work Stops

The Model G7152 has adjustable stops attached to the work table. These allow rapid alignment of workpieces during repetitive operations.

To use the work stops:

1. Align the workpiece as necessary on the table and make the desired cut. Check that the cut meets your requirements.
2. Once the cut is to your standards, lower the blade so that the top blades are below the level of the table.
3. Position the workpiece on the work table so that the workpiece rests against the top blades (**Figure 10**).

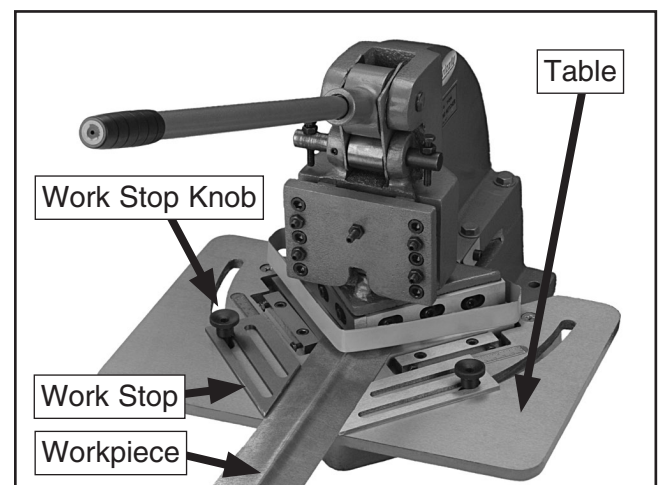


Figure 10. Work stops.

4. Adjust the work stops as necessary to provide adequate support and proper alignment with the workpiece, then tighten the work stop knobs (**Figure 10**).
5. Remove the workpiece and return the handle to the uppermost position.
6. For additional cuts, place the workpiece against the work stops and make the cut.



Blade Alignment

For optimal cutting performance, it is important that the blades on the Model G7152 are properly aligned.

Tools Needed	Qty
Hex Wrench 6mm.....	1
Feeler Gauge 0.004"	1
Wrench 10mm	1

To align the top blades:

1. Loosen the three cap screws that secure the longer top blade to the blade ram (**Figure 11**).

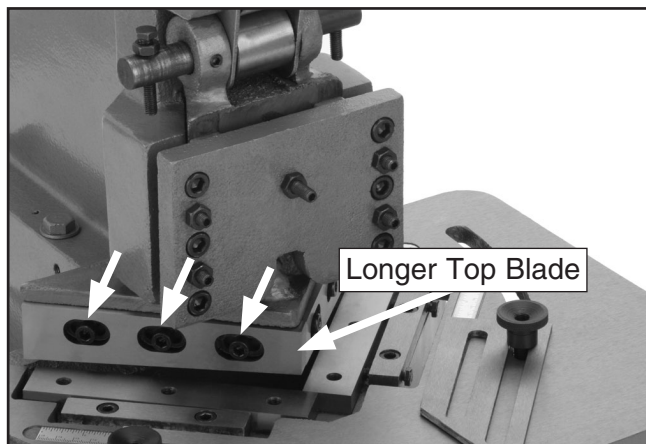


Figure 11. Longer blade alignment (guard removed for clarity).

2. Adjust the position of the longer blade so that its end is perfectly flush with the face of the shorter blade, then tighten the cap screws (**Figure 12**).

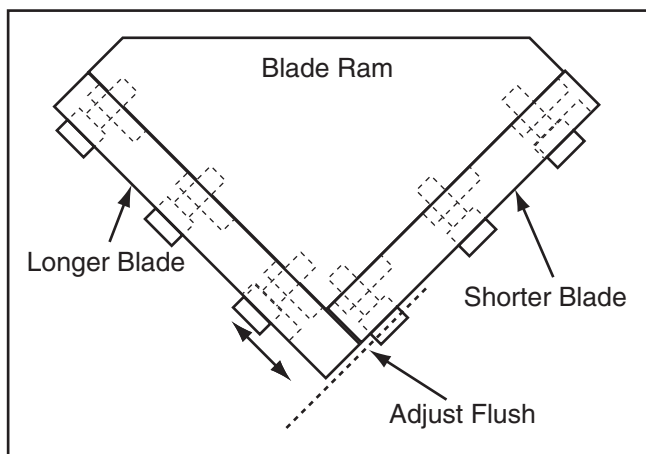


Figure 12. Aligning blades.

3. Loosen the three cap screws that secure the shorter top blade to the blade ram (**Figure 13**).

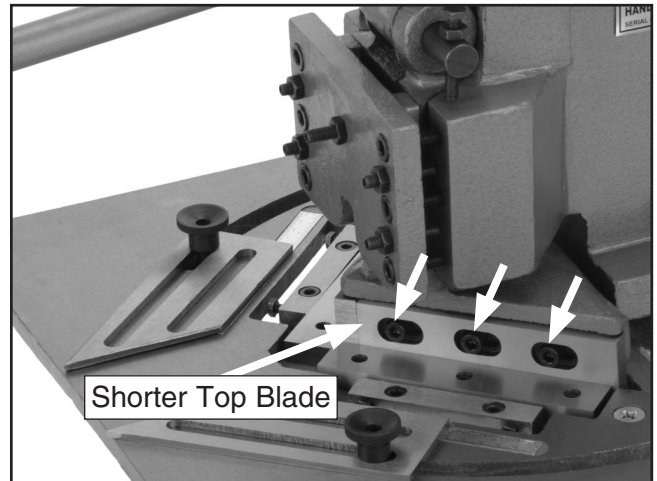


Figure 13. Shorter blade alignment (guard removed for clarity).

4. Adjust the position of the shorter blade so that its end is directly against the rear face of the longer blade to remove any gap, then tighten the cap screws (**Figure 14**).

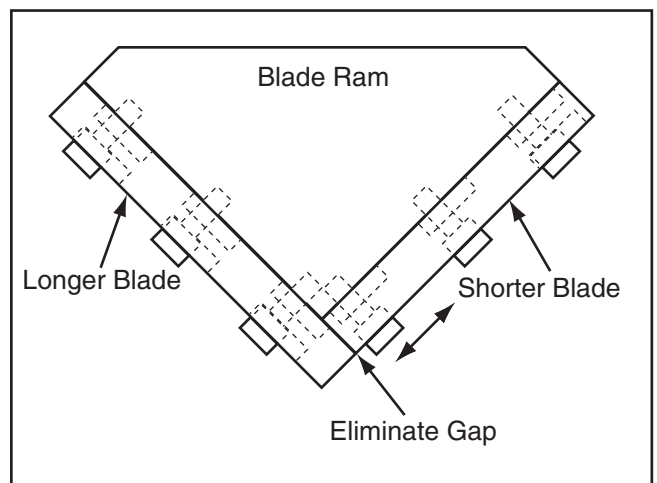


Figure 14. Eliminating blade gap.



To align the bottom blades:

1. Loosen the six cap screws located inside the machine base on the underside of the bottom blades (**Figure 15**).

—If your mounting position does not allow access to the underside of the machine, we recommend removing the work table, removing the mounting hardware, and carefully placing the machine on its side.

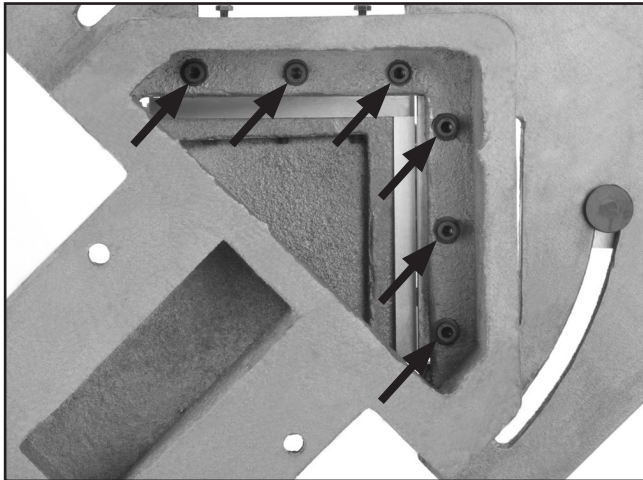


Figure 15. Loosening bottom blades.

2. Loosen the four hex bolts and slide the bottom blades back so that a feeler gauge can be placed between the top and bottom blades (**Figure 16**).

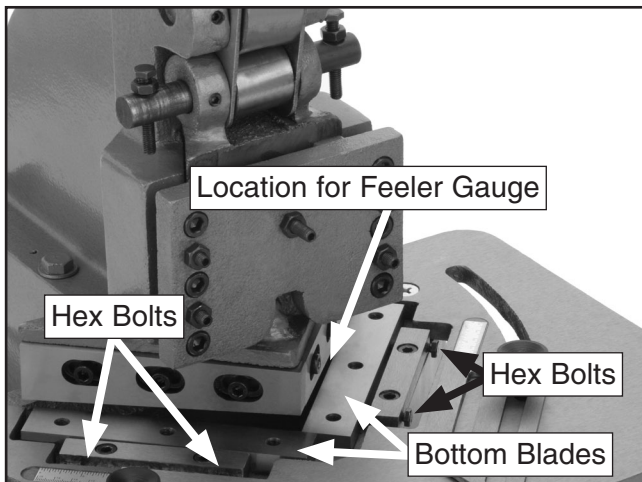


Figure 16. Adjusting bottom blades.

3. Pull the handle to lower the top blades into the table.
4. Place the 0.004" feeler gauge between the top and bottom blades in the position shown in **Figure 16**, then turn the hex bolts to adjust one bottom blade until it just pinches the feeler gauge between the blades.
5. Adjust the blade so the gap is even along its entire length.
6. Repeat **Steps 4–5** for the other bottom blade.
7. Tighten all six cap screws located inside the machine base on the underside of the bottom blades (**Figure 15**).

Depth Stops

The Model G7152 is equipped with depth stops to limit the vertical travel of the top blades. These must be adjusted to allow enough travel to complete the cut. As the blades wear and are re-sharpened, it may be necessary to adjust the depth stops to achieve the necessary travel.

To adjust the depth stop:

1. Loosen the jam nuts on the depth stop bolts (**Figure 17**)

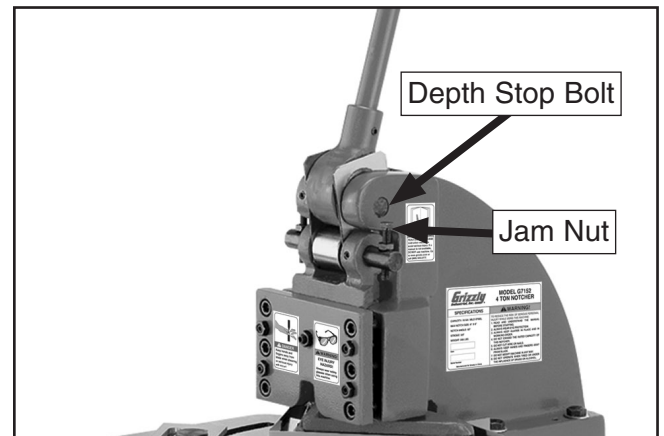


Figure 17. Depth stop adjustment.

2. Adjust the depth stop bolts to provide adequate blade travel, then tighten the jam nuts without turning the depth stop bolts.



SECTION 4: ACCESSORIES

G5618—Deburring Tool with two Blades

The quickest tool for smoothing freshly sheared metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



Figure 18. Model G5618 Deburring tool.

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

This ozone friendly protective spray penetrates deep and really holds up against corrosive environments. Lubricates metals for months and is safe for use on most paints, plastics, and vinyls.



Figure 19. Boeshield® T-9 spray.

H6073—Deluxe Power Snip

Lightweight aluminum cast handles. Full 3½" length of cut. Replaceable steel blades. Fully enclosed finger loops protect hands from sharp edges. Long handles provide plenty of leverage. Multi-purpose snip for sheet metal, vinyl and plastic.



Figure 20. Model H6073 Deluxe Power Snip.

G8124—Pneumatic Nibbler

Push type Pneumatic Nibbler makes quick work of sheet steel up to 1/16" thick and soft metal up to 5/64" thick. Features 3500 strokes per minute at an average air consumption of 6 CFM.



Figure 21. Model G8124 Pneumatic Nibbler

Call 1-800-523-4777 To Order



G4956—Super Nibbler

The super nibbler is just the ticket for cutting sheet metal up to $\frac{3}{64}$ " thick. Extremely narrow headed design allows cuts in hard-to-reach areas, yet still features a safety guard to prevent flying splinters. 10 $\frac{1}{4}$ " overall.



Figure 22. Model G4956 Super Nibbler.

H5958—Sheet Metal Pliers

For bending and forming sheet metal. Jaws are 3 $\frac{1}{2}$ " wide. Rubber grips. Overall length is 8". Ideal for HVAC Installers.

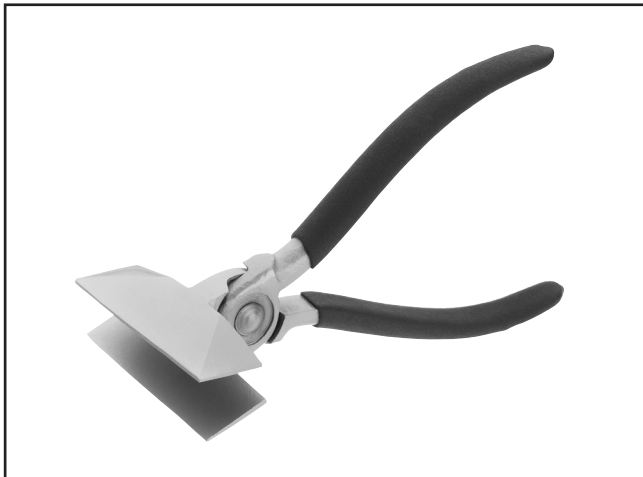


Figure 23. Model H5958 Sheet Metal Pliers.

G8781—4 $\frac{1}{2}$ " Suction Cup

Handle plate glass, glass mirrors and sheet metal with safety and security. Simple hand lever action provides tremendous gripping power on any flat, smooth material. Buy two Suction Cups for two-handed control!

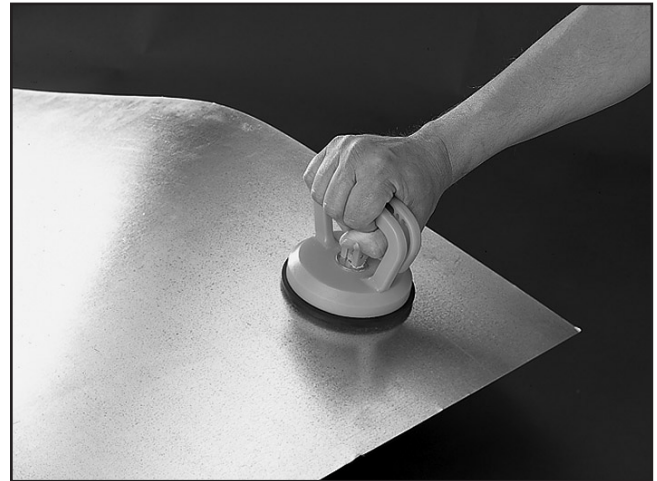


Figure 24. Model G8781 4 $\frac{1}{2}$ " Suction Cup.

H6131—Heavy-Duty Hand Riveter

Whether you're a full time sheet metal fabricator, or just making occasional repairs, you might as well invest in the best. This Heavy-Duty Hand Riveter with reinforced cast construction will be one of your most dependable tools.



Figure 25. Model H6131 Heavy-Duty Hand Riveter.

Call 1-800-523-4777 To Order



SECTION 5: MAINTENANCE

Schedule

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

Daily Check:

- Loose mounting bolts.
- Any other unsafe condition.
- Worn or damaged blades.

Weekly Maintenance:

- Clean machine.
- Lubricate apron pivots.
- Lubricate bushings.

Cleaning

Cleaning the Model G7152 is relatively easy. Periodically wipe down the machine to remove dust and oil. Treat all unpainted surfaces with a non-staining lubricant after cleaning.

Unpainted Surfaces

Protect the unpainted surfaces on the machine by wiping it clean after every use—this ensures rust-promoting debris does not remain on bare metal surfaces.

Keep the machine rust-free with regular applications of products like Boeshield® T-9 (see **Section 5: Accessories** on **Page 16** for more details).

Lubrication

Lubricating the Model G7152 consists of applying lubricant to all of the moving parts.

Oiling Locations

Apply several drops of SAE 30 or equivalent oil from an oil can into the joints and sliding surfaces shown in **Figure 26**. Move each component back and forth several times to disperse the oil, then wipe off excess oil.

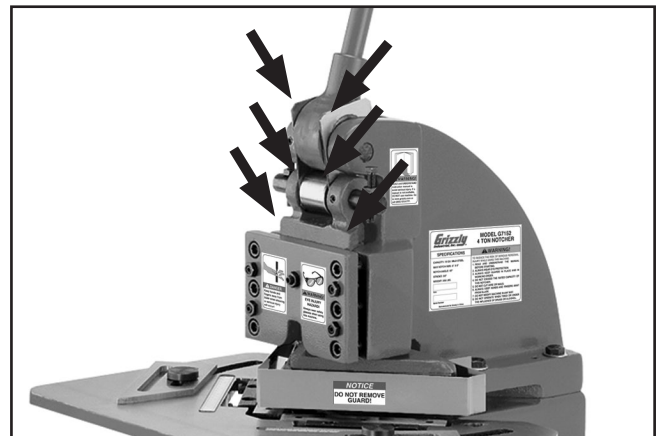


Figure 26. Oil locations.



SECTION 6: 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

Operations

Symptom	Possible Cause	Possible Solution
Heavy resistance is felt when cuts are attempted.	<ol style="list-style-type: none">1. Machine capacities are exceeded.2. Blades are dull.3. Blade alignment is improperly set.	<ol style="list-style-type: none">1. Use materials within the capacity of the machine.2. Rotate/sharpen blades (Page 20).3. Adjust blades (Page 14).
Cut is not consistent across workpiece.	<ol style="list-style-type: none">1. Machine capacities are exceeded.2. Blades are dull.3. Top and bottom blades are not parallel.4. Top blades are not aligned to one another.	<ol style="list-style-type: none">1. Use materials within the capacity of the machine.2. Rotate/sharpen blades (Page 20).3. Adjust blades (Page 14).4. Adjust blades (Page 14).



Rotating/Sharpening Blades

To maximize the blade life on the Model G7152, the top and bottom blades can be rotated to expose fresh cutting surfaces and sharpened to restore the cutting edge.

Each of the top blades has two cutting edges and each of the bottom blades has four cutting edges.

Top Blades

1. Remove the six cap screws that secure the top blades (**Figure 27**).

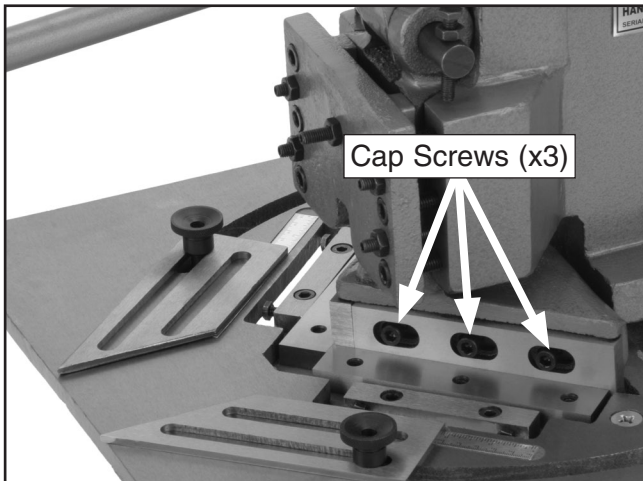


Figure 27. Screws for top blade removal.

2. Reverse the positions of the two upper blades. Doing this will place the dulled edge away from the bottom blade and position the fresh edge against the bottom blade.
3. Re-align the blades (See **Blade Alignment** on **Page 14**).

Bottom Blades

1. Remove the six cap screws located inside the machine base on the underside of the bottom blades (**Figure 28**).

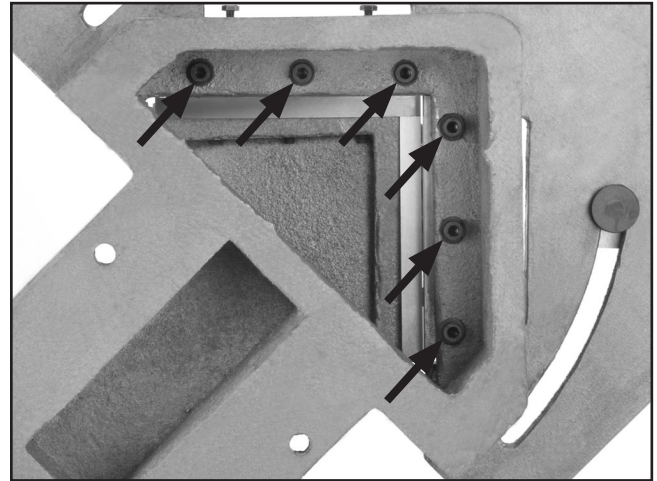


Figure 28. Screws for removing bottom blades.

2. Remove each of the bottom blades and rotate them as necessary to expose new blade edges, then loosely re-thread the six cap screws.
3. Align the bottom blades (See **To align the bottom blades** on **Page 15**).

Sharpening Blades

When rotating the blades no longer exposes a fresh cutting edge, the blades can be sharpened. We recommend using a surface grinder to restore a flat edge to the blades. Always sharpen the short edge of the blade (**Figure 29**).

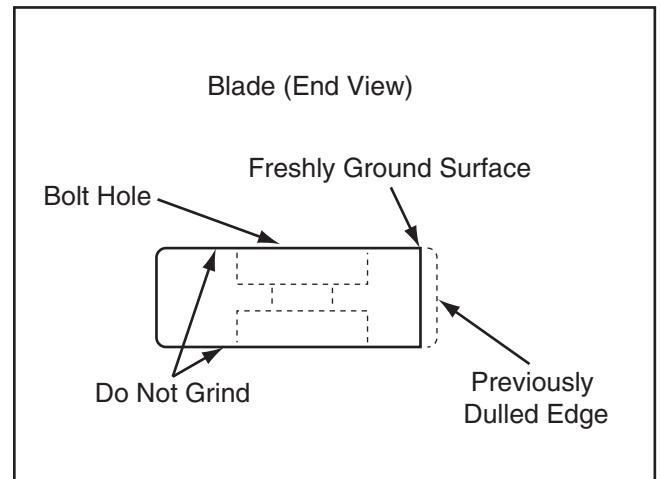
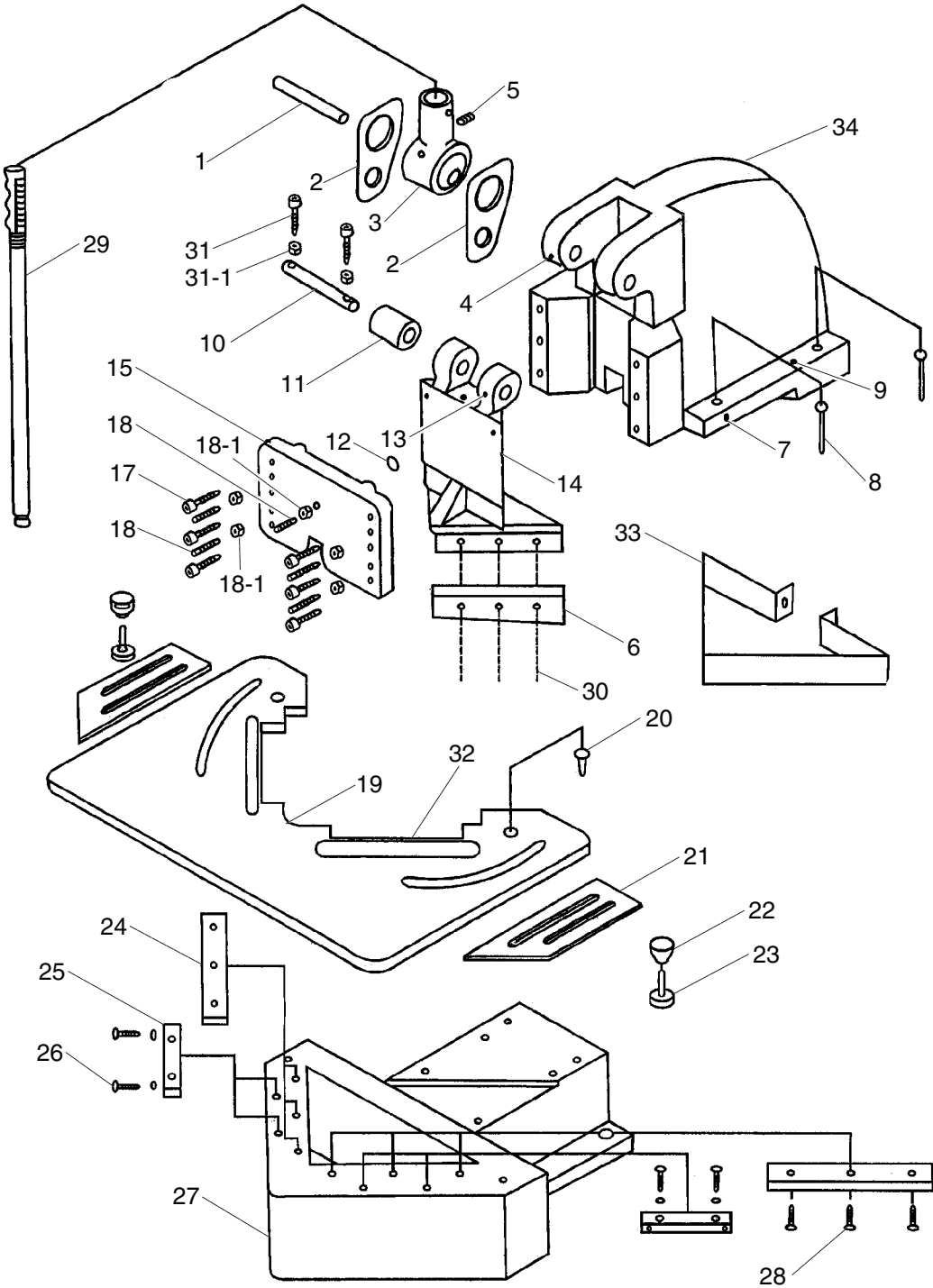


Figure 29. Blade grinding illustration.



SECTION 7: PARTS

Parts Breakdown

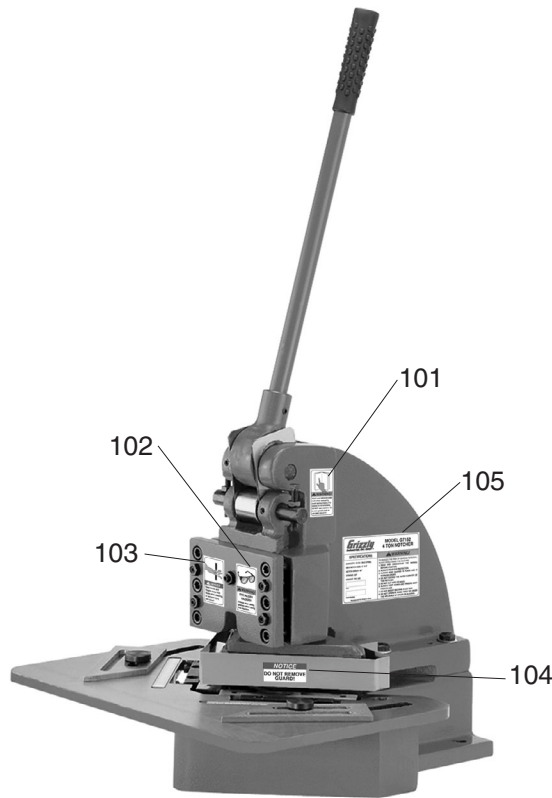


Parts List

REF	PART #	DESCRIPTION
1	P7152001	CAM FIXED SHAFT
2	P7152002	FIXED PLATE
3	P7152003	CAM
4	PSS08	SET SCREW 5/16-18 X 1/2
5	PSS08	SET SCREW 5/16-18 X 1/2
6	P7152006	UPPER BLADE SHORT/LONG
7	PSS03	SET SCREW 1/4-20 X 3/8
8	PB20	HEX BOLT 1/2-12 X 2-1/2
9	P7152009	ROLL PIN 3/8 X 2-3/8
10	P7152010	CAM ROLLER PIN
11	P7152011	ROLLER 23MM
12	P7152012	FLAT BUSHING
13	PSS08	SET SCREW 5/16-18 X 1/2
14	P7152014	RAM
15	P7152015	FRONT COVER
17	PSB26	CAP SCREW 3/8-16 X 1-1/2
18	PB11	HEX BOLT 5/16-18 X 1-1/2
18-1	PN02	HEX NUT 5/16"-18

REF	PART #	DESCRIPTION
19	P7152019	TABLE PLATE
20	P7152020	FLAT HEAD SCR 3/8-16 X 3/4
21	P7152021	ANGLE GAUGE
22	P7152022	SPECIAL NUT 3/8-16
23	P7152023	T-SCREW 3/8-16
24	P7152024	LOWER BLADE
25	P7152025	BLADE FIXED PLATE
26	PB31	HEX BOLT 1/4-20 X 1
27	P7152027	BOTTOM BASE
28	PSB11	CAP SCREW 5/16-18 X 1-1/4
29	P7152029	HANDLE LEVER
30	PSB03	CAP SCREW 5/16-18 X 1
31	PB06	HEX BOLT 5/16-18 X 2
31-1	PN02	HEX NUT 5/16"-18
32	P7152032	SCALE
33	P7152033	FENCE GUARD
34	P7152034	MAIN BODY CASTING

Labels Breakdown & List



REF	PART #	DESCRIPTION
101	PLABEL-12C	READ MANUAL LABEL
102	PLABEL-11B	SAFETY GLASSES LABEL
103	P7152103	FINGER SHEARING LABEL

REF	PART #	DESCRIPTION
104	P7152104	NO GUARD REMOVAL LABEL
105	P7152105	MACHINE ID LABEL





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 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?

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

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: _____

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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.

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