



MODEL H8193 REPLACEMENT TRUNNION INSTRUCTION SHEET

Introduction

The Model H8193 cast iron trunnion assembly replaces the existing steel trunnion assembly on your G0513/G0514 series bandsaw.

If you cannot find the original copy of your G0513 or G0513X owner's manual, you can download a PDF copy from www.grizzly.com. You will need to refer to the G0513 or G0513X manual for complete instructions for your machine.

Inventory (Figure 1)

- A. Cast Iron Trunnion Assembly 1
- B. Hex Bolts M8-1.25 x 25 4
- C. Lock Washers 8mm 4
- D. Flat Washers 8mm 4

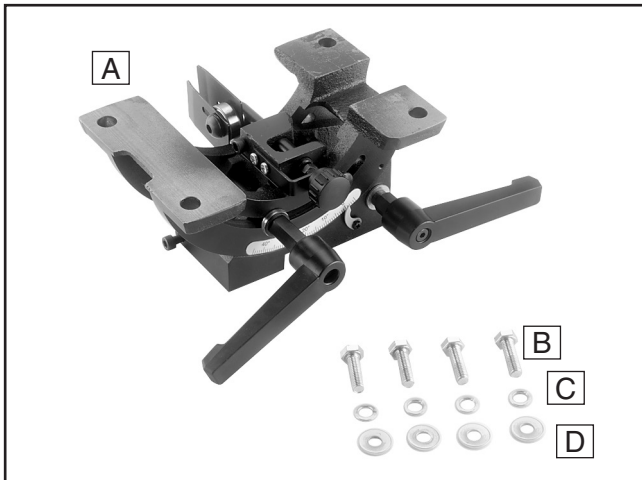


Figure 1. Model H8193 inventory.

Removing Existing Trunnion

1. DISCONNECT THE BANDSAW FROM POWER!
2. Remove the miter gauge, fence, and blade (refer to the G0513 manual, **Page 16**, or G0513X manual, **Page 21** for detailed removal instructions).

⚠ CAUTION

During the next step, have two assistants hold the table on either side, to prevent it from falling off the bandsaw. Failure to follow this warning could result in serious personal injury and damage to the bandsaw.

3. Remove the four hex bolts, flat washers, and lock washers securing the table to the trunnion (**Figure 2**).

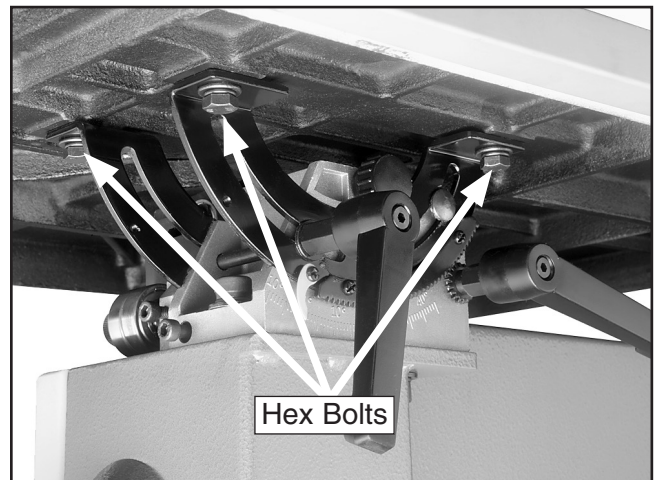


Figure 2. Trunnion mounting hex bolts.

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4. With the help of assistants, remove the table.
5. Remove the cap screws and hex nut securing the trunnion to the bandsaw (**Figure 3**), then remove the trunnion.

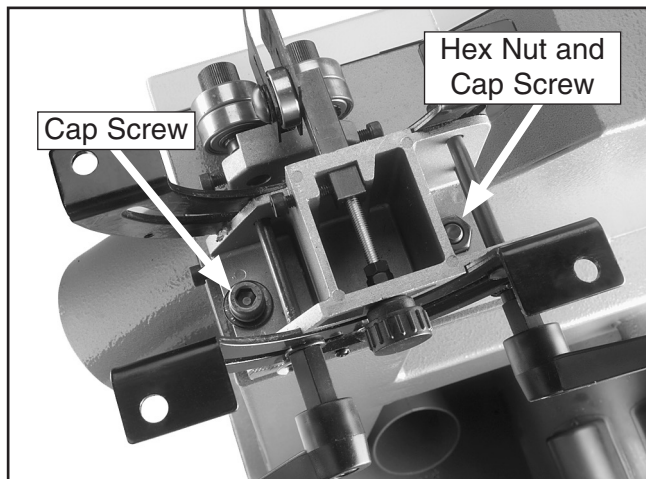


Figure 3 Cap screws and hex bolt.

Installing Cast Iron Trunnion

1. Align the mounting holes in the cast iron trunnion and bandsaw, and secure with the two cap screws removed from the previous trunnion (**Figure 4**). The hex nut you removed will not be used.

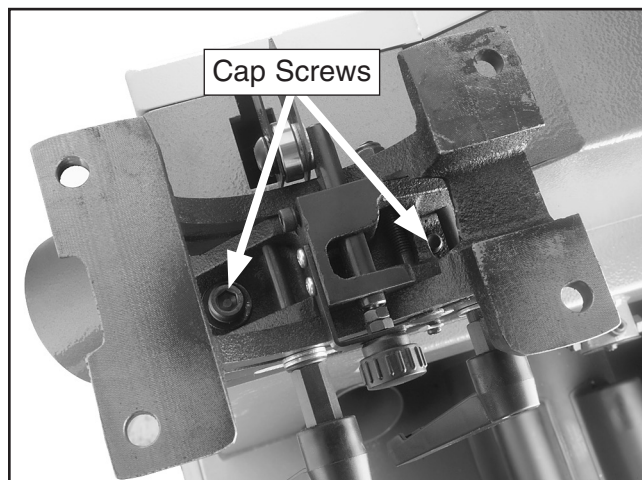


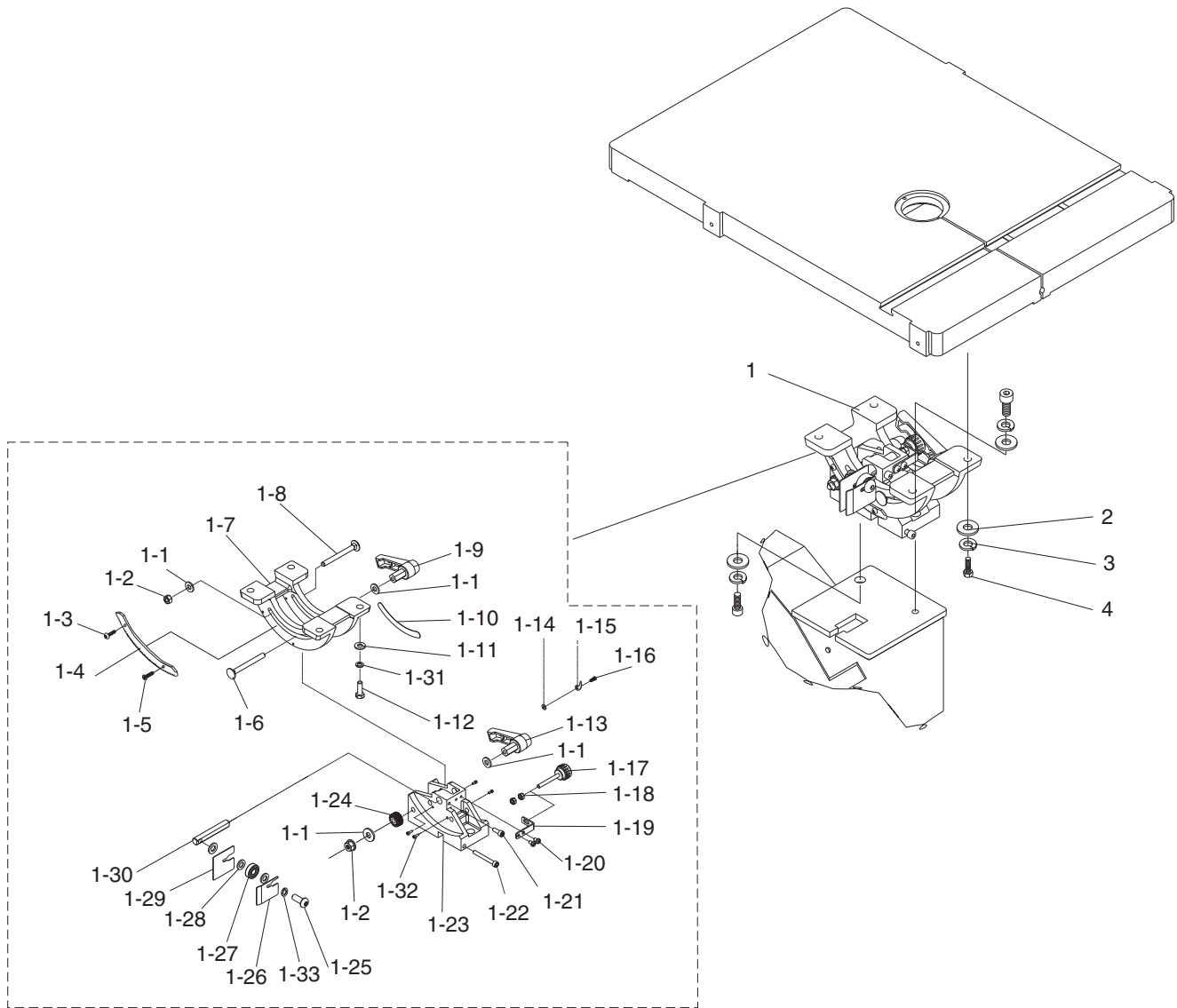
Figure 4. New trunnion installed.

2. With the help of assistants, install the table on the new trunnion with the four included M8-1.25 x 25 hex bolts, flat washers, and lock washers.
3. Reinstall the blade, close the wheel covers, and reinstall the table insert and pin.
4. Follow the **Blade Tracking, Test Run/Start Up, Tensioning Blade/Blade Tension, Adjusting Support Bearings/Blade Guides** instructions in the G0513/G0513X manual.
5. Follow **Table Alignment/Aligning Table** instructions in the G0513/G0513X manual to align the table.
6. Reinstall the fence and miter gauge, following instructions on **Page 20** of the G0513 manual and **Page 31** of the G0513X manual.

If you need additional help with this procedure, call our Tech Support at (570) 546-9663 or by email at techsupport@grizzly.com.



Parts List and Breakdown



REF	PART #	DESCRIPTION
1	PH8193001	CAST IRON TRUNNION ASSEMBLY
1-1	PW01M	FLAT WASHER 8MM
1-2	PLN04M	LOCK NUT M8-1.25
1-3	PS17M	PHLP HD SCR M4-.7 X 6
1-4	PH8193001-4	GEAR PLATE
1-5	PFH27M	FLAT HD SCR M4-.7 X 6
1-6	PCB10M	CARRIAGE BOLT M8-1.25 X 85
1-7	PH8193001-7	TRUNNION BLOCK
1-8	PCB23M	CARRIAGE BOLT M8-1.25 X 80
1-9	PH8193001-9	HANDLE
1-10	PH8193001-10	ANGLE LABEL
1-11	PW01M	FLAT WASHER 8MM
1-12	PB07M	HEX BOLT M8-1.25 X 25
1-13	PH8193001-13	LOCK HANDLE
1-14	PW05M	FLAT WASHER 4MM
1-15	PH8193001-15	POINTER
1-16	PS17M	PHLP HD SCR M4-.7 X 6
1-17	PH8193001-17	ADJUST BOLT M6
1-18	PH8193001-18	ADJUST PLATE
1-19	PH8193001-19	ADJUST PLATE
1-20	PS05M	PHLP HD SCR M5-.8 X 8
1-21	PSB01M	CAP SCREW M6-1 X 16
1-22	PSB37M	CAP SCREW M6-1 X 50
1-23	PH8193001-23	TRUNNION SUPPORT BRACKET
1-24	PH8193001-24	SMALL GEAR
1-25	PSBS19M	BUTTON HD CAP SCR M10-1.5 X 30
1-26	PH8193001-26	RIGHT COVER
1-27	P6000	BALL BEARING 6000ZZ
1-28	PW04M	FLAT WASHER 10MM
1-29	PH8193001-29	LEFT COVER
1-30	PH8193001-30	ADJUST BLOCK
1-31	PLW04M	LOCK WASHER 8MM
1-32	PSB97M	CAP SCREW M5-.8 X 6
1-33	PLW06M	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
1-19	PH8193001-19	ADJUST PLATE
1-20	PS05M	PHLP HD SCR M5-.8 X 8
1-21	PSB01M	CAP SCREW M6-1 X 16
1-22	PSB37M	CAP SCREW M6-1 X 50
1-23	PH8193001-23	TRUNNION SUPPORT BRACKET
1-24	PH8193001-24	SMALL GEAR
1-25	PSBS19M	BUTTON HD CAP SCR M10-1.5 X 30
1-26	PH8193001-26	RIGHT COVER
1-27	P6000	BALL BEARING 6000ZZ
1-28	PW04M	FLAT WASHER 10MM
1-29	PH8193001-29	LEFT COVER
1-30	PH8193001-30	ADJUST BLOCK
1-31	PLW04M	LOCK WASHER 8MM
1-32	PSB97M	CAP SCREW M5-.8 X 6
1-33	PLW06M	LOCK WASHER 10MM
2	PW01M	FLAT WASHER 8MM
3	PLW04M	LOCK WASHER 8MM
4	PB07M	HEX BOLT M8-1.25 X 25



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