



MODEL H9565 BALL BEARING GUIDE FOR G0513/G0514 INSTRUCTION SHEET

Introduction

The Model H9565 replaces the upper and lower Euro-style guides on your G0513 or G0514 Bandsaw.

Inventory (Figure 1)

- A. Upper Blade Guide Assembly 1
- B. Lower Blade Guide Assembly 1
- C. Saw Blade Adjustment Assembly 1
- D. Cap Screw M10-1.5 x 25 1
- E. Flat Washers 10mm 2
- F. Right Cover 1
- G. Left Cover..... 1

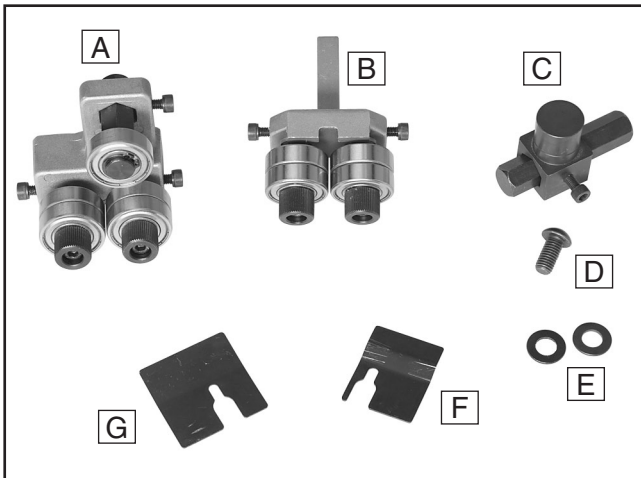


Figure 1. Model H9565 inventory.

Blade Guide Assembly Replacement

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the blade guide thumbscrews and move the upper roller guides away from the blade.
3. Using a 5mm hex wrench, loosen the guide block assembly cap screw (Figure 2), hold the assembly, and remove it from the bandsaw.

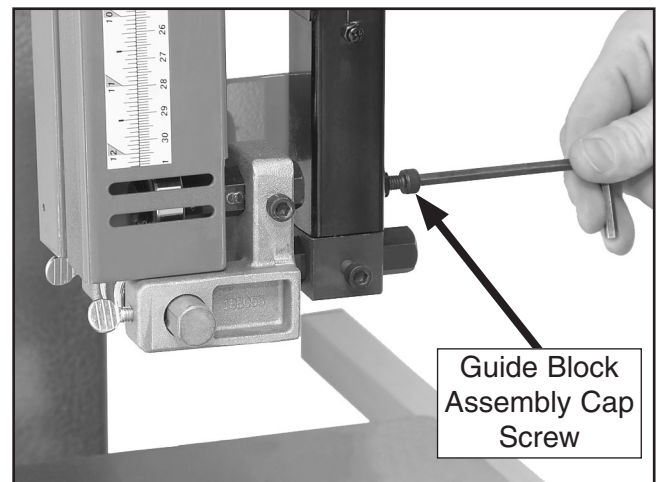


Figure 2. Loosening blade guide assembly.

COPYRIGHT © JANUARY, 2007 BY GRIZZLY INDUSTRIAL, INC.

WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.

#BL8965 PRINTED IN TAIWAN

- Using a 3mm hex wrench, loosen the set screw (**Figure 3**) on the left side of the blade guide assembly, slide the saw blade adjustment bar into the slot in the back of the blade guide assembly, then tighten the set screw.

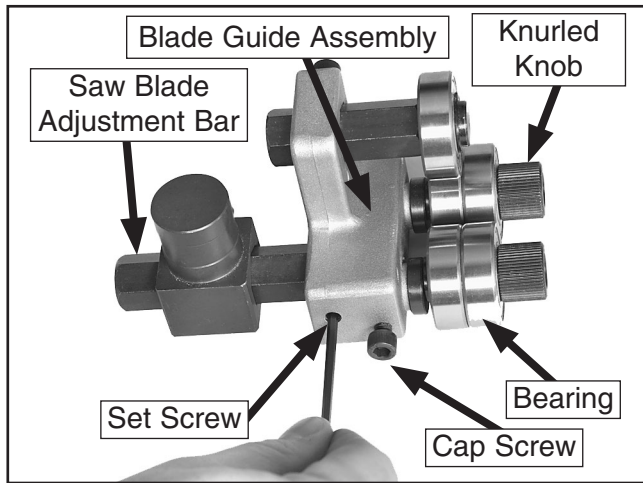


Figure 3. Securing upper blade guide assembly set screw.

- Loosen the cap screws (**Figure 3**) on either side of the blade guide bearings and rotate the knurled knobs so the bearings are positioned outward.
- Slide the upper blade assembly over the blade and up into the guide post, then tighten the guide block assembly cap screw (see **Figure 4**).

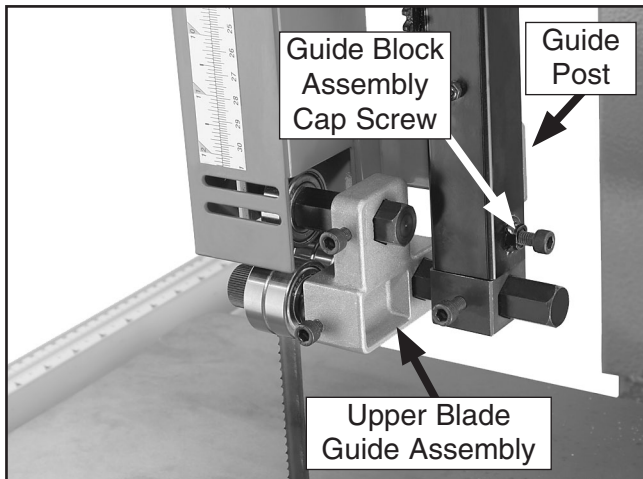


Figure 4. Upper blade guide assembly installed.

To replace the lower blade guide assembly:

- DISCONNECT BANDSAW FROM POWER!
- Release the blade tension by turning the blade tension quick release lever to the left.
- Remove the table insert and table pin.
- Loosen the lower blade guide thumbscrews and adjust the roller guides away from the blade.
- Open the upper and lower wheel covers, and with gloved hands, slide the blade off of both wheels.
- Rotate the blade 90° and slide it through the slot in the table.
- Loosen the guide block assembly cap screw (**Figure 5**) and remove the lower blade guide assembly.

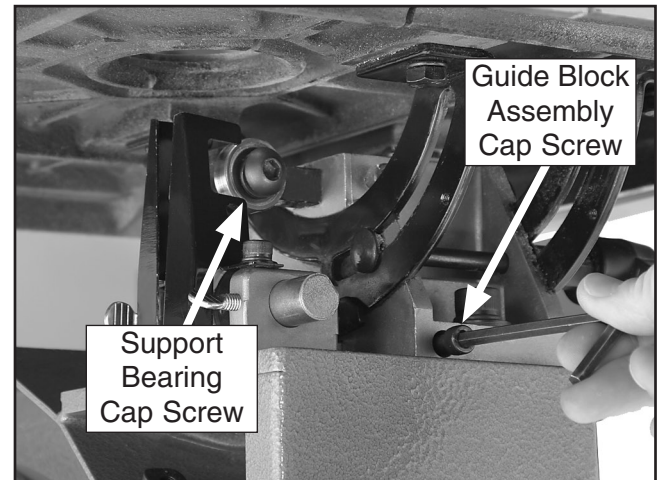


Figure 5. Loosening guide block shaft cap screw.

- Insert the new assembly into the shaft that held the former assembly, loosen the cap screws on either side of the blade guide bearings, and rotate the knurled knobs so the bearings are positioned outward.
- Remove the support bearing cap screw (**Figure 5**), support bearing, and lock washer.



10. Insert the new cap screw with the lock washer and flat washer through the support bearing and other flat washer as shown in **Figure 6**.

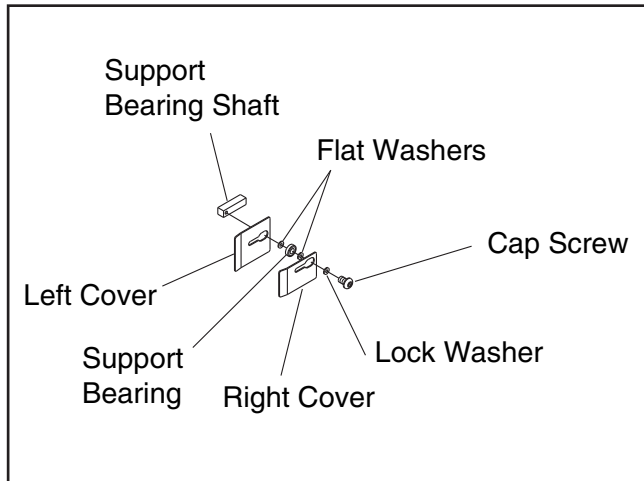


Figure 6. Lower support bearing assembly.

11. Thread this assembly several turns into the support bearing adjustment shaft as shown in **Figure 7**.

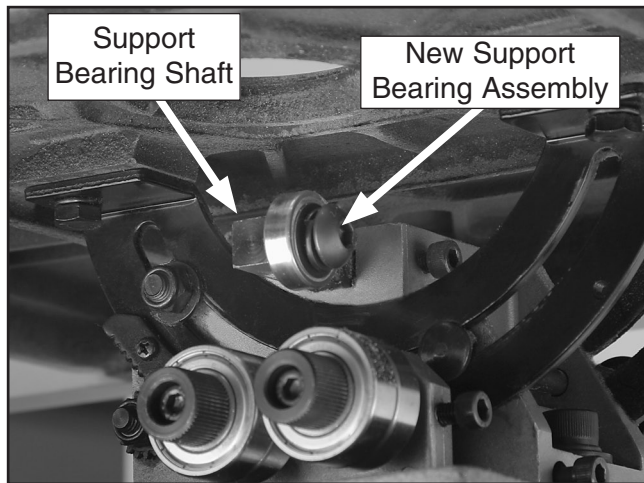


Figure 7. New lower support bearing assembly.

12. Replace the blade. (Refer to **Installing Saw Blade** on **Page 16** of the G0513/G0514 Manual.)
13. Insert the left and right covers over the cap screw on either side of the support bearing as shown in **Figures 6 & 8**, then tighten the cap screw.

Face the tabbed ends of the covers inward, make sure the covers do not touch the blade, and place the larger plate on the left side.

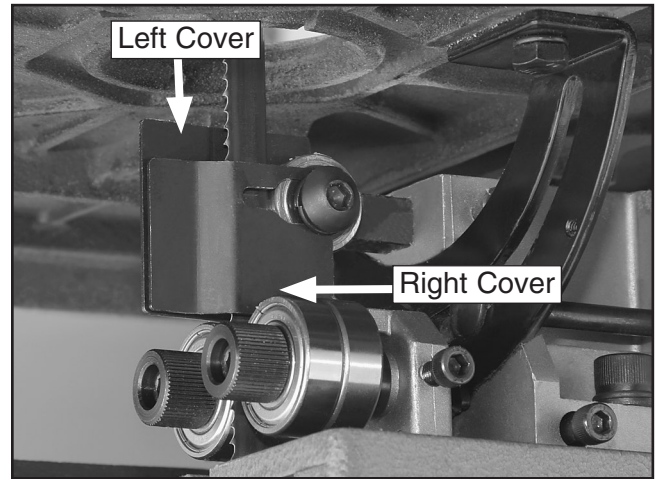


Figure 8. Support bearing covers.

14. Close the wheel covers.

Adjusting Blade Guide Bearings

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

To adjust the upper and lower blade guides:

1. Make sure the blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Familiarize yourself with the blade guide controls shown in **Figure 9**.

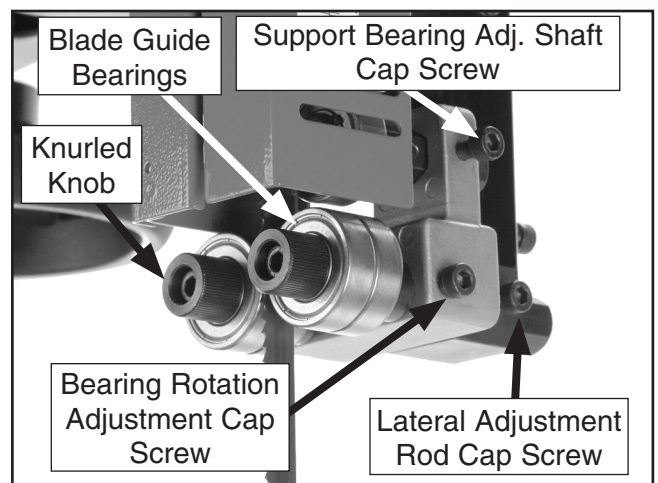


Figure 9. Blade guide controls.



- Loosen the cap screw on the lateral adjustment rod, loosen the support bearing adjustment shaft cap screw, and adjust the blade guides until the edges of the bearings are $\frac{1}{16}$ " behind the blade gullets as illustrated in **Figure 10**.

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

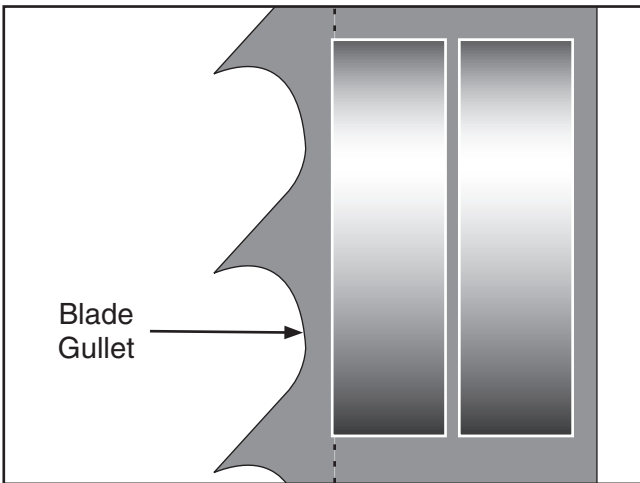


Figure 10. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut or the blade teeth will be ruined.

- Tighten the cap screw on the lateral adjustment rod.
- Loosen the bearing rotation adjustment cap screws.
- Rotate the knurled knob to position the bearings 0.004" away from the blade. **Note:** 0.004" is approximately the thickness of a dollar bill.
- Tighten the cap screws to lock the blade guide bearings in position.
- Repeat this procedure for the lower guides.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide bearings must be properly adjusted and locked before cutting operations.

If you need help with your new ball bearing guides, call our Tech Support at: (570) 546-9663.

Adjusting Support Bearings

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and blade guide bearings must be properly adjusted before cutting operations.

To adjust the upper support bearings:

- DISCONNECT BANDSAW FROM POWER!
- Make sure the blade is tracking properly and that it is correctly tensioned.
- Familiarize yourself with the upper support bearing controls shown in **Figure 11**.

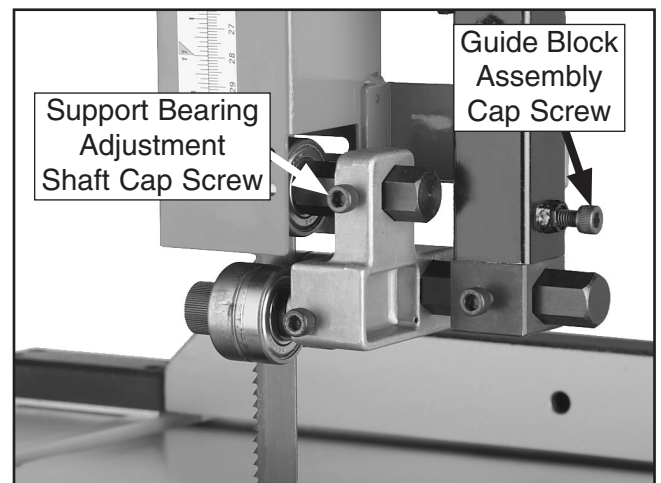


Figure 11. Upper support bearing controls.



- Loosen the guide block assembly cap screw and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing as illustrated in **Figure 12**.

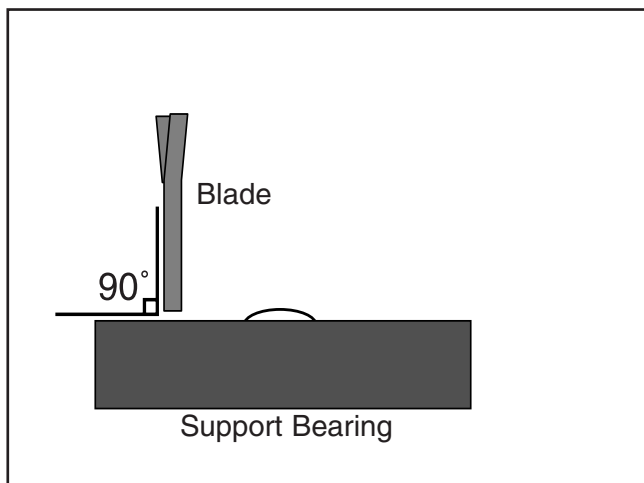


Figure 12. Illustration of blade set perpendicular (90°) to the support bearing face.

- Tighten the guide block assembly cap screw.
- Loosen the cap screw on the support bearing adjustment shaft—if it is not already loose.
- Using a 0.016" feeler gauge between the support bearing and the blade, position the bearing 0.016" away from the back of the blade as illustrated in **Figure 13**.

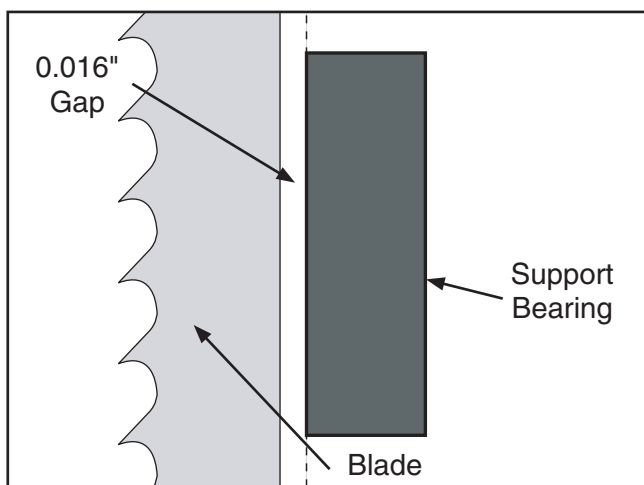


Figure 13. Blade aligned 0.016" away from the bearing edge.

Note: For a quick gauge, fold a crisp dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016") and place it between the support bearing and the blade as shown in **Figure 14**.

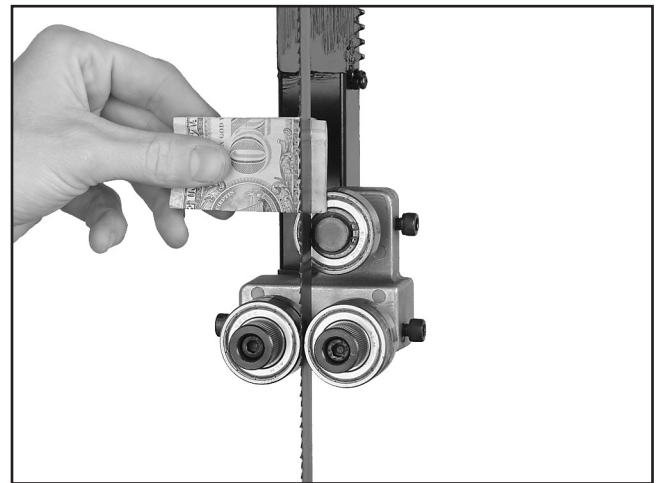


Figure 14. Dollar bill folded twice to make an approximate 0.016" gauge.

- Tighten the cap screw to keep the support bearing locked in place.

To adjust the lower support bearings:

- DISCONNECT BANDSAW FROM POWER!
- Make sure the blade is tracking properly and is correctly tensioned.
- Familiarize yourself with the lower support bearing controls shown in **Figure 15**.

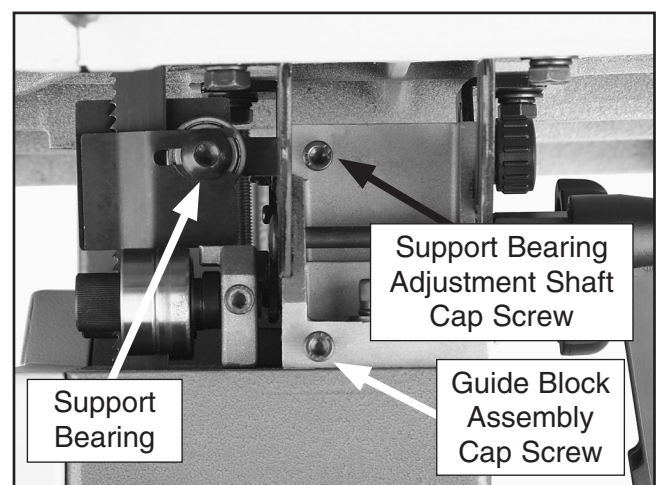


Figure 15. Lower support bearing controls.



4. Make sure that the blade guide assembly is perpendicular to the face of the support bearing as illustrated in **Figure 12**.

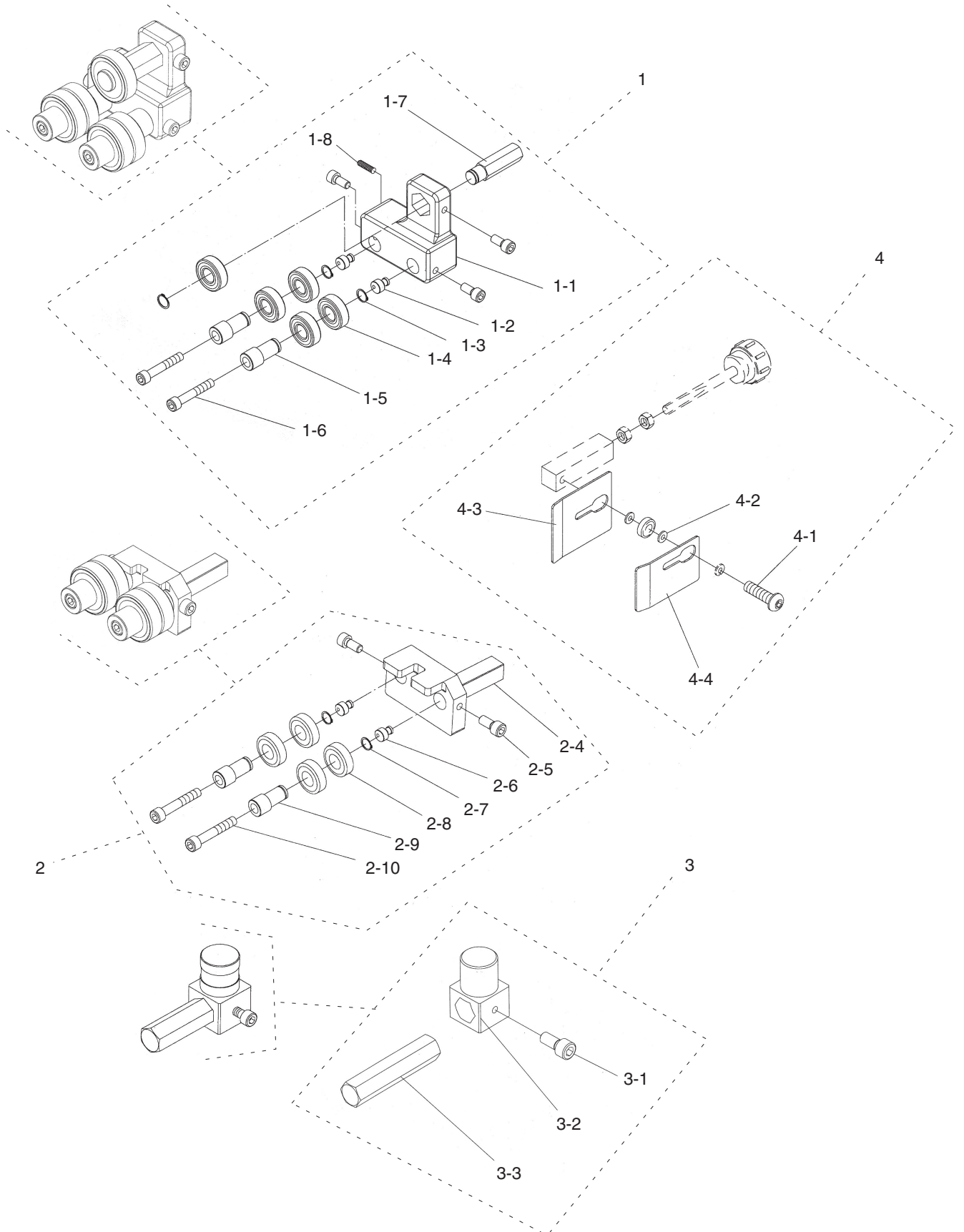
—If the blade guide assembly is perpendicular to the face of the support bearing, continue on to the next step.

—If the blade guide assembly is not perpendicular to the support bearing, loosen the guide block assembly cap screw and rotate the assembly side-to-side until it is perpendicular to the face of the support bearing, then re-tighten the cap screw.

5. Loosen the cap screw on the support bearing adjustment shaft.
6. Using a 0.016" feeler gauge, position the bearing 0.016" away from the back of the blade as illustrated in **Figure 13** or use a dollar bill as shown in **Figure 14**.
7. Tighten the cap screw to keep the support bearing locked in place.



H9565 Parts Breakdown



H9565 Parts List

REF PART #	DESCRIPTION
1	PH9565001 UPPER BLADE GUIDE ASSEMBLY
1-1	PH9565001-1 UPPER BLADE GUIDE SUPPORT
1-2	PH9565001-2 BIAS SHAFT
1-3	PR05M EXT RETAINING RING 15MM
1-4	P6202 BALL BEARING 6202ZZ
1-5	PH9565001-5 HANDLE BUSHING
1-6	PSB48M CAP SCREW M6-1 X 35
1-7	PH9565001-7 UPPER SPACING SLEEVE
1-8	PSS01M SET SCREW M6-1 X 10
2	PH9565002 LOWER BLADE GUIDE ASSEMBLY
2-4	PH9565002-4 LOWER BLADE GUIDE SUPPORT
2-5	PSB01M CAP SCREW M6-1 X 16
2-6	PH9565002-6 BIAS SHAFT

REF PART #	DESCRIPTION
2-7	PR05M EXT RETAINING RING 15MM
2-8	P6202 BALL BEARING 6202ZZ
2-9	PH9565002-9 HANDLE BUSHING
2-10	PSB48M CAP SCREW M6-1 X 35
3	PH9565003 SAW BLADE ADJUSTMENT
3-1	PH9565003-1 CAP SCREW M16-1 X 16
3-2	PH9565003-2 UPPER GUIDE SUPPORT BLOCK
3-3	PH9565003-3 ADJUST BAR
4	PH9565004 HARDWARE KIT
4-1	PH9565004-1 BUTTON HEAD SCREW M10-1.75 X 25
4-2	PW04M FLAT WASHER 10MM
4-3	PH9565004-3 LEFT COVER
4-4	PH9565004-4 RIGHT COVER

