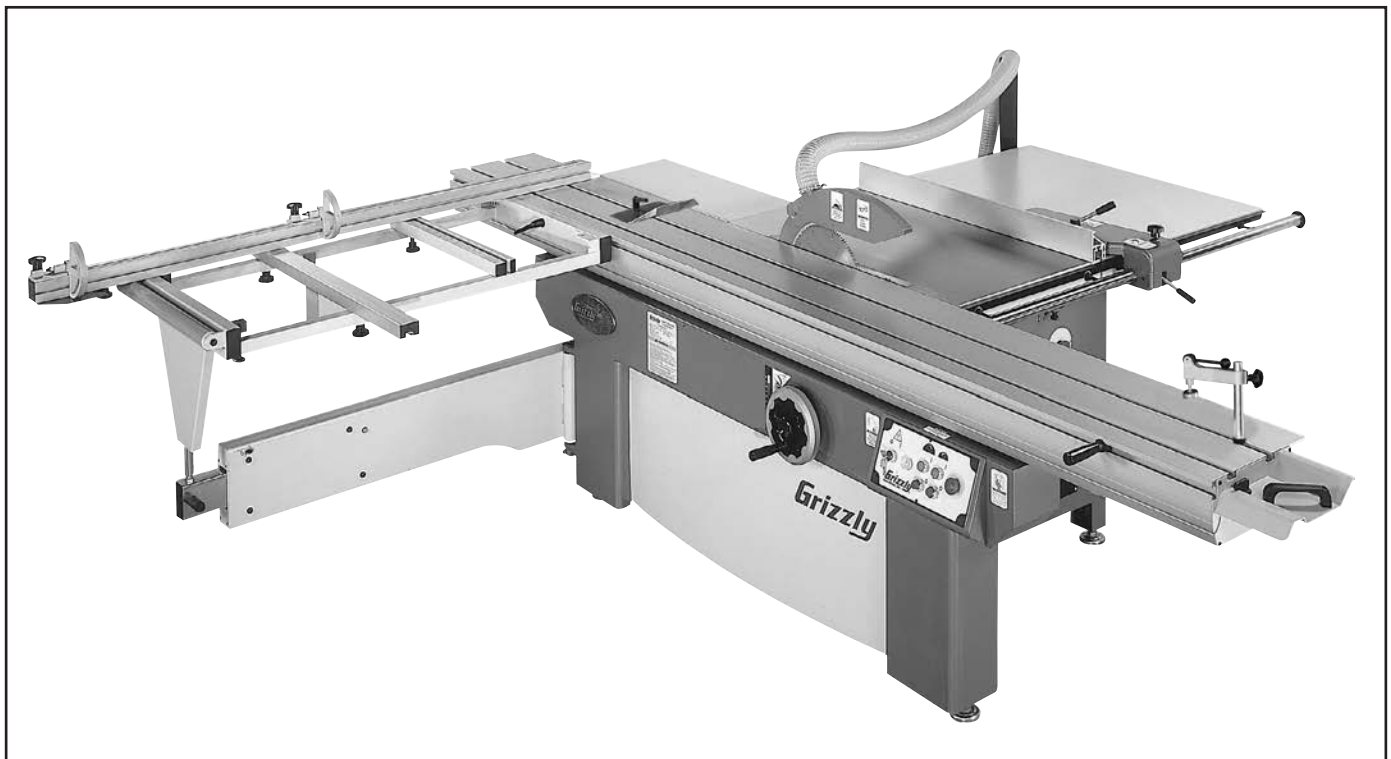


Grizzly **Industrial, Inc.**®

MODEL G0493 14" SLIDING TABLE SAW OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
(FOR MODELS MANUFACTURED SINCE 7/10) #TR9023 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 provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at www.grizzly.com.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

Grizzly Industrial MODEL GXXXX MACHINE NAME

SPECIFICATIONS	WARNING!
Motor: Specification: Specification: Specification: Weight: Date: Manufactured for Grizzly in Taiwan	To reduce risk of serious injury when using this machine: 1. Read manual before operation. 2. Wear safety glasses and respirator. 3. Make sure blade is correctly adjusted/setup and power is connected to grounded circuit before starting. 4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. 5. DO NOT expose to rain or dampness. 6. DO NOT modify this machine in any way. 7. 8. 9. Do not use while under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

With over 10' of table travel, the Model G0493 14" Sliding Table Saw can easily handle full-size sheet goods with room to spare. Maximum sheet size is 123" x 126" with the crosscutting table, and 48" wide with the traditional rip fence.

This saw has a 10 HP main motor for ample cutting power and a dedicated 1 HP scoring blade motor, so the main motor does not have to drive both blades.

Dust collection is handled by one 5" main dust hood and one 2.5" blade guard dust hood. However, an optional fully enclosed blade guard is also available for this saw.

This saw includes an nice assortment of accessories, including a hold down clamp, optional push handle, two flip stops, an end shoe, a roller on the crosscut table, and a push stick.



Identification

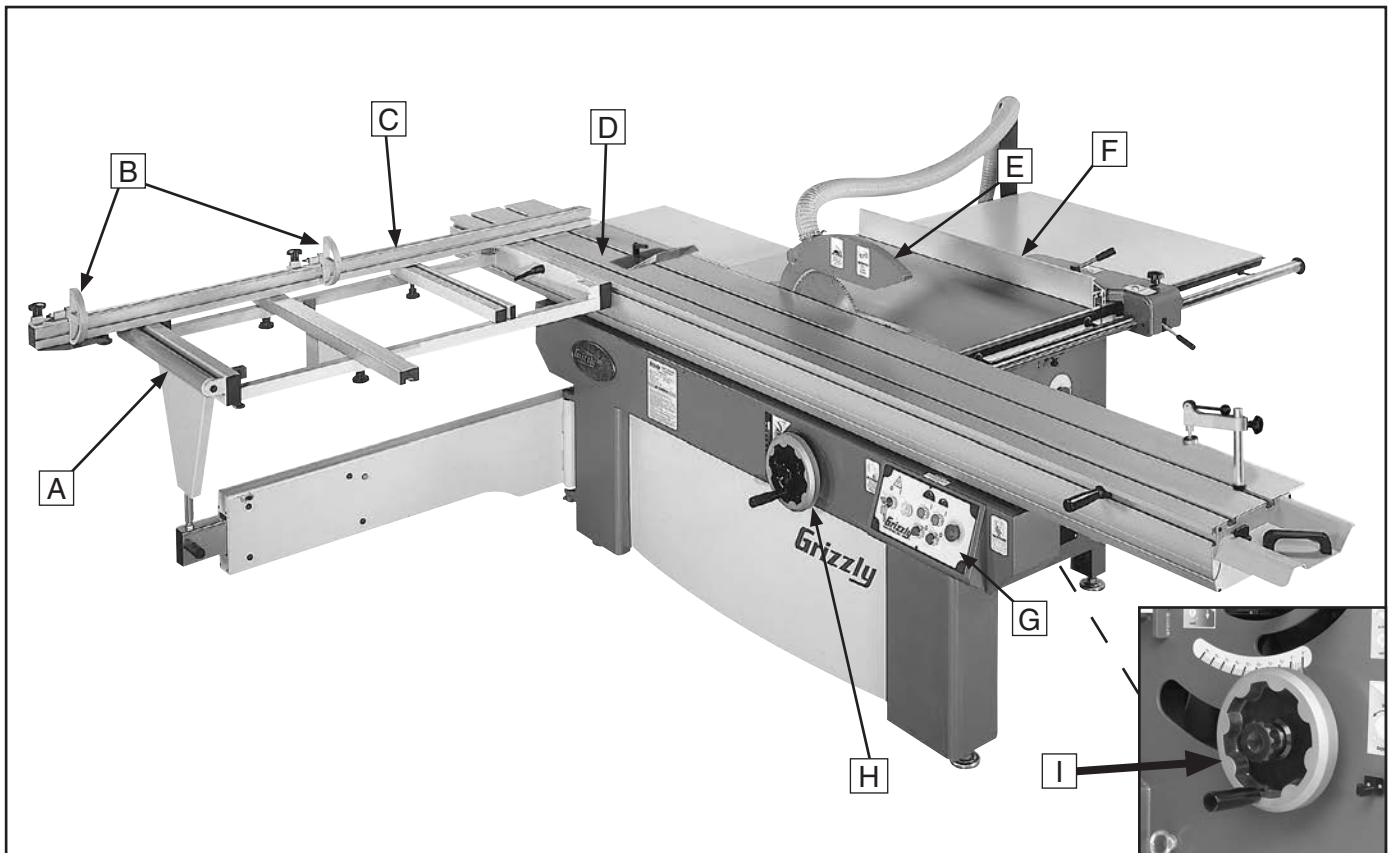


Figure 1. Main view of machine features and controls.

- A. Crosscut Table**—Provides a wide, stable platform for supporting full-size panels during crosscutting operations.
- B. Flip Stops**—Used for quick measurements for crosscutting.
- C. Crosscut Fence**—Used during crosscutting operations. Features a scale and multiple flip-style stop blocks for precise, repeatable crosscutting operations.
- D. Sliding Table**—Conveniently glides the workpiece through the blade with effortless precision and ease.
- E. Blade Guard**—Fully-adjustable blade guard maintains maximum protection around the saw blade and a 2½" dust port effectively extracts dust from the cutting operation.
- F. Rip Fence**—Fully adjustable with micro-adjustment knob for precision adjustments. Fence face can be positioned for standard cutting operations, or in the lower position for blade guard clearance during narrow ripping operations.
- G. Control Panel**—Features push-button controls for operating the many features of the saw.
- H. Blade Angle Handwheel**—Adjusts the angle of the saw blades.
- I. Blade Elevation Handwheel**—Located on the right-hand side of the cabinet, this handwheel adjusts the height of the main saw blade.



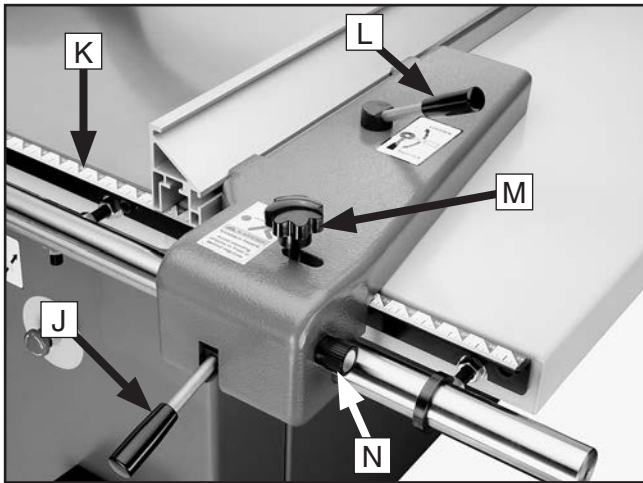


Figure 2. Fence controls.

- J. Fence Assembly Lock Down Lever**—Secures the fence assembly into position along the fence rail.
- K. Rip Fence Scale**—Allows precise measurement of rip cutting operations.
- L. Forward/Backward Slide Lock Handle**—Secures the aluminum fence piece on its forward/backward slide track.
- M. Micro-Adjust Lock Knob**—Secures the fence after it has been adjusted with the micro-adjustment knob.
- N. Micro-Adjust Knob**—Precisely adjusts the fence.

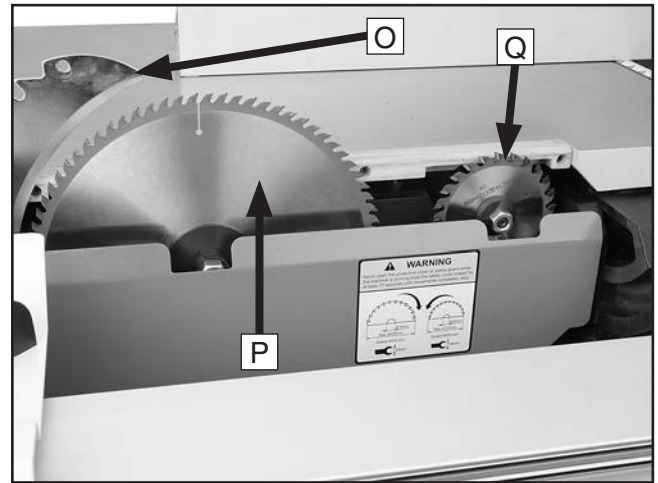


Figure 3. Blades.

- O. Riving Knife**—Maintains kerf opening during cutting operations. This function is crucial to preventing kickback caused by the kerf closing behind the blade.
- P. Main Blade**—Performs the cutting operations.
- Q. Scoring Blade**—Small cutting blade that rotates in the opposite direction of the main saw blade. The blade scores the workpiece before the actual cutting operation is performed, preventing tear-out in laminate materials. The scoring blade is adjustable forward and backward, up and down, and in kerf thickness.





Figure 4. Control panel close-up.

- R. **Power ON/OFF Key Switch**—Connects power to all motors in the saw.
- S. **Power Indicator Light**—Indicates a live connection to power.
- T. **Main Blade OFF Button**—Stops the main saw blade.
- U. **Scoring Blade OFF Button**—Stops the scoring blade.
- V. **#1 EMERGENCY STOP Button**—Disconnects power to all motors in the motor cabinet.
- W. **Scoring Blade ON Button**—Starts the scoring blade. **Note:** *The main saw blade must be ON for the scoring blade to start.*
- X. **Main Blade ON Button**—Starts the main saw blade.

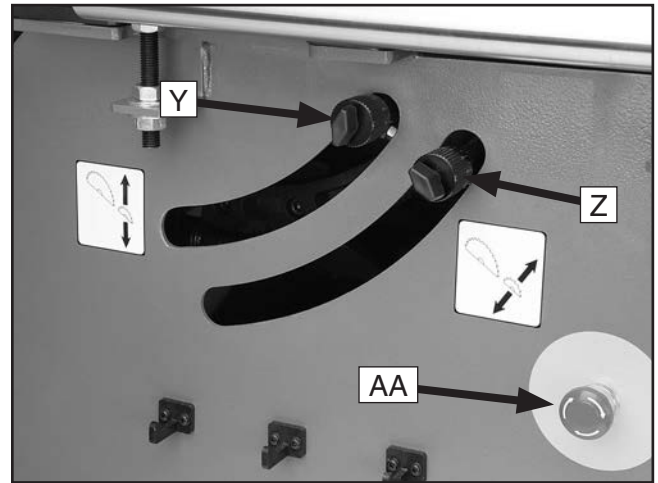


Figure 5. Scoring blade adjustment knobs.

- Y. **Scoring Blade Elevation Knob**—Adjusts the height of the scoring blade.
- Z. **Scoring Blade Alignment Knob**—Adjusts the alignment of the scoring blade to the main blade.
- AA. **#2 EMERGENCY STOP Button**—Disconnects power to all motors in the motor cabinet.





MACHINE DATA SHEET

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

MODEL G0493 14" 10 HP 3-PHASE SLIDING TABLE SAW

Product Dimensions:

Weight..... 1804 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 133-1/4 x 186 x 49 in.
 Footprint (Length x Width)..... 66 x 43 in.
 Space Required for Full Range of Movement (Width x Depth)..... 200 x 186 in.

Shipping Dimensions:

Carton #1

Type..... Wood Slat Crate
 Content..... Machine
 Weight..... 1650 lbs.
 Length x Width x Height..... 56 x 87 x 40 in.
 Must Ship Upright..... Yes

Carton #2

Type..... Wood Slat Crate
 Content..... Sliding Table
 Weight..... 278 lbs.
 Length x Width x Height..... 20 x 132 x 18 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
 Prewired Voltage..... 220V
 Full-Load Current Rating..... 28A at 220V, 11.5A at 440V
 Minimum Circuit Size..... 40A at 220V, 20A at 440V
 Connection Type..... Permanent (Hardwire to Shutoff Switch)
 Switch Type..... Control Panel w/Magnetic Switch Protection
 Voltage Conversion Kit..... G440VG0493 for 440V
 Recommended Phase Converter..... G7978

Motors:

Main

Horsepower..... 10 HP
 Phase..... 3-Phase
 Amps..... 25A/10A
 Speed..... 3450 RPM
 Type..... TEFC Induction
 Power Transfer Belt Drive
 Bearings..... Shielded & Permanently Lubricated
 Centrifugal Switch/Contacts Type..... N/A

Scoring Blade

Horsepower..... 1 HP
 Phase..... 3-Phase
 Amps..... 3A/1.5A
 Speed..... 3450 RPM
 Type..... TEFC Induction
 Power Transfer Belt Drive
 Bearings..... Shielded & Permanently Lubricated
 Centrifugal Switch/Contacts Type..... N/A



Main Specifications:

Operation Information

Main Blade Size.....	14 in.
Main Blade Arbor Size.....	1 in.
Scoring Blade Size.....	4-3/4 in.
Scoring Blade Arbor Size.....	22 mm
Main Blade Tilt.....	0 – 45 deg.
Main Blade Speed.....	4000, 5000, 6000 RPM
Scoring Blade Tilt.....	0 – 45 deg.
Scoring Blade Speed.....	8000 RPM

Cutting Capacities

Max Depth of Cut At 90 Deg.....	4-1/8 in.
Max Depth of Cut At 45 Deg.....	2-7/8 in.
Rip Fence Max Cut Width.....	48-1/2 in.
Sliding Table w/Crosscut Fence Max Cut Width.....	126 in.
Sliding Table w/Crosscut Fence Max Cut Length.....	123 in.
Miter Fence Max Cut Width at 45 Deg.....	123 in.

Table Information

Floor To Table Height.....	35-1/2 in.
Table Size Length.....	39-1/2 in.
Table Size Width.....	24 in.
Table Size Thickness.....	2-1/2 in.
Table Size With Ext Wings Length.....	39-1/2 in.
Table Size With Ext Wings Width.....	24 in.
Table Size With Ext Wings Thickness.....	2-1/2 in.
Sliding Table Length.....	126 in.
Sliding Table Width.....	13-3/4 in.
Sliding Table Thickness.....	6 in.
Sliding Table T-Slot Top Width.....	5/8 in.
Sliding Table T-Slot Height.....	5/8 in.
Sliding Table T-Slot Bottom Width.....	1-3/8 in.

Fence Information

Crosscut Fence Type.....	Single Lever Locking, Extruded Aluminum
Crosscut Fence Size Length.....	40 in.
Crosscut Fence Size Width.....	2-3/8 in.
Crosscut Fence Size Height.....	3-9/16 in.
Crosscut Fence Number of Stops.....	2

Construction Materials

Table.....	Precision-Ground Cast Iron
Sliding Table.....	Aluminum
Cabinet.....	Steel
Rip Fence Rails.....	Chromed Steel
Guard.....	Plastic
Spindle Bearing Type.....	Sealed & Permanently Lubricated
Cabinet Paint Type/Finish.....	Powder Coated

Other Related Information

No of Dust Ports.....	2
Dust Port Size.....	2-1/2, 5 in.



Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 3 Hours
Serial Number Location ID Label on Side of Machine
ISO 9001 Factory No
Certified by a Nationally Recognized Testing Laboratory (NRTL) No

Features:

Micro Adjustable Rip Fence
Scoring Saw Blade Ensures Tear-Out Free Cutting
Sliding Table on Bearing Guide System with Chromed Steel Ways
Alloy Crosscut Fence for Miter Cutting 45 deg. Right and Left
Miter Fence has Two Swing Stops for Repetitive Cutting
Safety Limit Switch for Blade Cover
Adjustable Riving Knife Adjustment

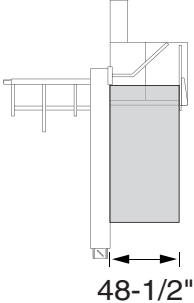
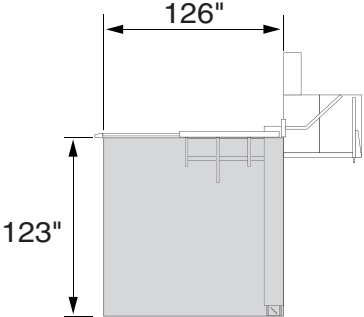
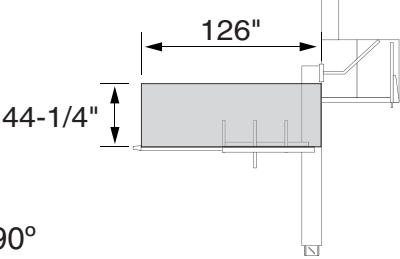
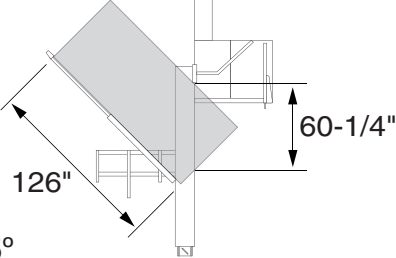
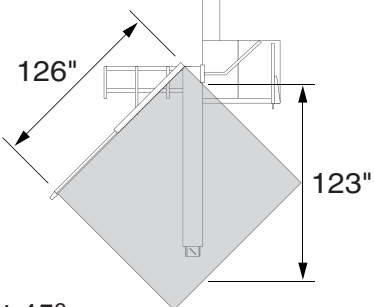
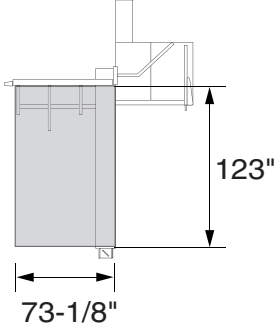
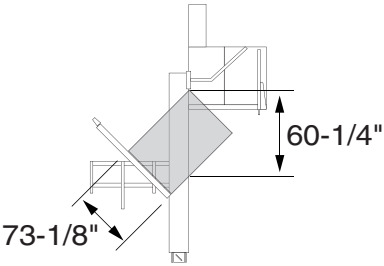
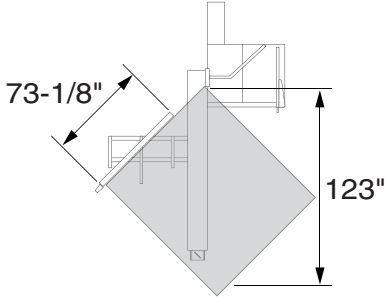




SLIDING TABLE SAW CAPACITIES

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

MODEL G0493 14" SLIDING TABLE SAW

 <p>Ripping Width 48-1/2"</p>	 <p>Cross Cut 126" 123"</p>
 <p>Miter Cut 90° (push cut) 126" 44-1/4"</p>	 <p>Miter Cut 45° (push cut) 126" 60-1/4"</p>
 <p>Miter Cut 45° 126" 123"</p>	 <p>Cross Cut (fence not extended) 123" 73-1/8"</p>
 <p>Miter Cut 45° (push cut, fence not extended) 73-1/8" 60-1/4"</p>	 <p>Miter Cut 45° (fence not extended) 73-1/8" 123"</p>



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.



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

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

Safety Instructions for Machinery

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 your 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 reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. 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 **BEFORE** operating machine.

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.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace **BEFORE** operating machine. For your own safety, **DO NOT** operate machine with damaged parts!

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.



Additional Safety for Sliding Table Saws

WARNING

HAND POSITIONING. Never purposely touch a saw blade during operation. Always keep hands/fingers out of the blade path; place them where they cannot slip into the blade accidentally. Never reach around, behind, or over the blade. Touching a spinning saw blade will cause serious laceration or amputation injuries.

BLADE GUARD. Use the blade guard for all “through cuts” for which it can be used. (A through cut is an operation where the blade cuts completely through the top of the workpiece.) Make sure the blade guard is installed and adjusted correctly; promptly repair or replace it if damaged. Always re-install blade guard immediately after operations that require its removal. Operating saw with the blade guard removed greatly increases the risk of severe laceration or amputation injuries from accidental blade contact.

RIVING KNIFE. Use the riving knife for all “non-through cuts” for which it can be used. (A non-through cut is an operation where the blade does not cut through the top of the workpiece.) Make sure the riving knife is aligned and positioned correctly; and promptly repair or replace it if damaged. Using the riving knife incorrectly will increase the risk of kickback or accidental blade contact.

KICKBACK. Kickback occurs when the saw blade ejects the workpiece back toward the operator. Know how to reduce the risk of kickback, and learn how to protect yourself if it does occur.

FEEDING WORKPIECE. Feeding the workpiece incorrectly will increase risk of kickback. Never start the saw with a workpiece touching the blade; allow the blade to reach full speed before cutting. Only feed the workpiece against the direction of blade rotation. Always use some type of guide (fence, miter gauge, sliding table or sled, etc.) to feed the workpiece in a straight line. Never back a workpiece out of a cut or try to move it backwards or sideways after starting a cut. Feed cuts all the way through to completion. Never perform any operation “freehand” (making a cut without using a fence, miter gauge, or other guide).

FENCE. Make sure the fence remains properly adjusted and parallel with the blade. Always lock the fence in place before using. Using or adjusting the fence incorrectly will increase risk of kickback.

PUSH STICKS/BLOCKS. Use push sticks or push blocks whenever possible to keep your hands farther away from the blade while cutting; in the event of an accident these devices will often take damage that would have happened to hands/fingers.

CUT-OFF PIECES. Never use your hands to move cut-offs away from the blade while the saw is running. If a cut-off becomes trapped between the blade and table insert, turn the saw **OFF** and allow the blade to completely stop before removing it.

BLADE ADJUSTMENTS. Adjusting the blade height or tilt during operation increases the risk of crashing the blade and sending metal fragments flying with deadly force at the operator or bystanders. Only adjust the blade height and tilt when the blade is completely stopped and the saw is **OFF**.

CHANGING BLADES. Always disconnect power before changing blades. Changing blades while the saw is connected to power greatly increases the injury risk if saw is accidentally powered up.

DAMAGED SAW BLADES. Never use blades that have been dropped or otherwise damaged. Damaged blades can fly apart and strike the operator with shards of metal.

DADO AND RABBET OPERATIONS. DO NOT attempt dado or rabbeting operations without first reading those sections in this manual. Dado and rabbeting operations require special attention because they must be performed with the blade guard removed.

CUTTING CORRECT MATERIAL. Never cut materials not intended for this saw; only cut natural and man-made wood products, laminate covered wood products, and some plastics. Cutting metal, glass, stone, tile, etc. increases the risk of operator injury due to kickback or flying particles.



Preventing Kickback

Below are ways to avoid the most common causes of kickback:

- Only cut workpieces with at least one smooth and straight edge. DO NOT cut excessively warped, cupped or twisted wood. If the workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, a kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.
- Make sure the spreader/riving knife is aligned with the blade. A misaligned spreader/riving knife can cause the workpiece to catch or bind, increasing the chance of kickback. If you think that the spreader/riving knife is not aligned with the blade, check and adjust it before making additional cuts!
- Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are greatly increased. Take the time to check and adjust the sliding table to be parallel with the blade.
- Do not make cuts with the blade guard or riving knife removed from the saw. The blade guard spreader and riving knife maintain the kerf in the workpiece, reducing the chance of kickback.
- Keep the blade guard installed and working correctly for all through cuts.
- Feed cuts through to completion. Anytime you stop feeding a workpiece in the middle of a cut, the chance of kickback is increased.
- Never move the workpiece backwards while cutting or try to back it out of a cut while the blade is moving. If you cannot complete a cut for some reason, stop the saw motor and allow the blade to completely stop moving before backing the workpiece out. Before starting the saw again, promptly fix the condition that prevented you from completing the cut.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some tips to protect yourself if kickback DOES occur:

- Stand to the side of the blade during every cut. If a kickback does occur, the thrown workpiece usually travels directly in front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.
- Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade, which could cause amputation.
- Use a push stick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to assist with feeding and prevent or slow down kickback.

WARNING

Statistics show that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed ejection of stock from the table saw toward its operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.



Glossary of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this table saw and woodworking in general. Become familiar with these terms before assembling, adjusting or operating this machine.

Arbor: The metal shaft on which the blade is mounted.

Bevel Edge Cut: A cut made along the edge of a workpiece with the saw blade tilted between 0° and 45°. Refer to **Page 68** for more details.

Blade Guard Assembly: A safety device that mounts over the saw blade to help prevent accidental contact with the saw blade and to contain flying chips and dust. Includes protective shield and spreader. Refer to **Page 39** for more details.

Crosscut: A "through" cutting operation in which the miter gauge is used to hold the workpiece while it is cut across its shortest width. Refer to **Page 47** for more details.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets. (A dado blade cannot be used on this saw.)

Dado Cut: A "non-through" cutting operation that results in a flat bottomed groove in the workpiece. Refer to **Page 50** for more details.

Featherboard: Safety device used to keep the workpiece held firmly against the rip fence or table surface. Refer to **Page 54** for more details.

Kerf: The resulting cut or gap in the workpiece after the saw blade passes through during a cutting operation.

Kickback: An event in which the spinning blade ejects the workpiece toward the front of the saw at a high rate of speed.

Non-Through Cut: A cut in which the blade does not cut through the top of the workpiece. Refer to **Page 38** for more details.

Parallel: Two lines or surfaces being an equal distance apart at every point along their given planes (i.e. the rip fence face is parallel to the face of the saw blade).

Perpendicular: Lines or planes that intersect and form right angles (i.e. the blade is perpendicular to the table surface).

Push Stick: Safety device used to push the workpiece through a cutting operation while keeping hands at a safe distance away. Used most often when rip cutting thin workpieces. Refer to **Page 57** for more details.

Rabbet: A "non-through" cutting operation that creates an L-shaped channel along the edge of the workpiece. Refer to **Page 51** for more details.

Rip Cut: A "through" cutting operation in which the rip fence is used to cut across the widest width of the workpiece. Refer to **Page 45** for more details.

Riving Knife: Curved metal plate located behind the blade. Maintains kerf opening in wood when performing a cutting operation. Acts as a barrier behind blade to shield hands from being pulled into the blade if a kickback occurs while hands are behind the blade. Refer to **Page 39** for more details.

Spreader: Curved metal plate to which the blade guard attaches. Maintains kerf opening in wood when performing a cutting operation. Acts as a barrier behind blade to shield hands from being pulled into the blade if a kickback occurs while hands are behind the blade.

Straightedge: A tool used to check flatness, parallelism, or alignment.

Thin Kerf Blade: A blade with a kerf or thickness that is thinner than a standard blade. Thin kerf blades should only be used if they meet the blade size requirements on **Page 41**.

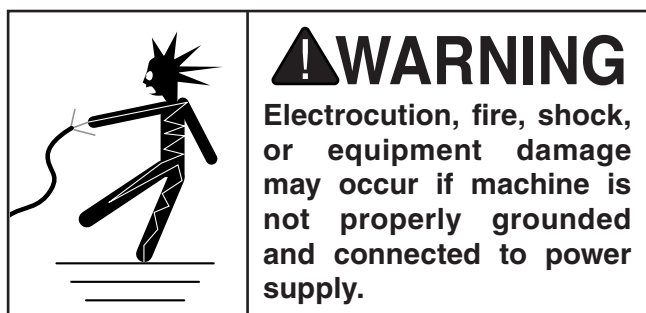
Through Cut: A cut in which the blade cuts completely through the workpiece (refer to **Page 38**).



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V 28 Amps

Full-Load Current Rating at 440V 14 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this

! CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Circuit Requirements for 220V

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V/240V
Cycle 60 Hz
Phase 3-Phase
Circuit Rating 40 Amps

Circuit Requirements for 440V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 440V/480V
Cycle 60 Hz
Phase 3-Phase
Rated Size 20 Amps



Connection Type

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

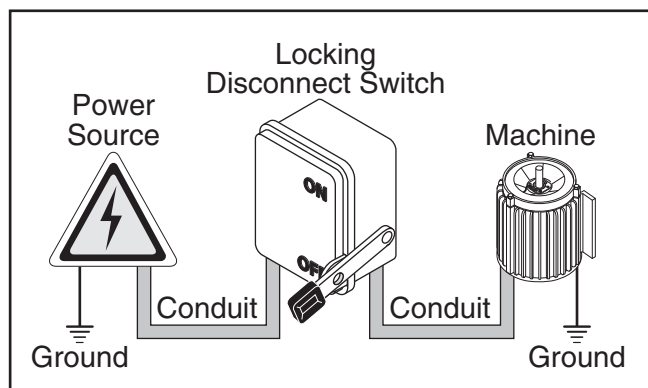


Figure 6. Typical setup of a permanently connected machine.

Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

⚠️ WARNING

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

Extension Cords

Since this machine must be permanently connected to the power supply, an extension cord cannot be used.

Phase Converter

When using a phase converter, the power from the manufactured power leg (sometimes called the wild wire) can fluctuate. Connect the manufactured power leg to the S terminal to prevent damage to the transformer. The wire from the S terminal can handle some fluctuation because it goes directly to the motor. The power going to the R and T terminals goes to the transformer and must be consistent to prevent damage.



Rewiring to 440V

The Model G0493 can be rewired for 440V operation. The necessary parts for this procedure can be purchased by calling our customer service at (800) 523-4777 and ordering part #P04510016.

This rewiring job must be inspected by a qualified electrician before the saw is connected to the power source. Also, the motors can be accessed easier for rewiring if the blade is moved to 0° (90° to table) before beginning.

To rewire the machine for 440V operation:

1. DISCONNECT SAW FROM POWER!
2. Open the electrical panel and locate the voltage transformer shown in **Figure 7**.

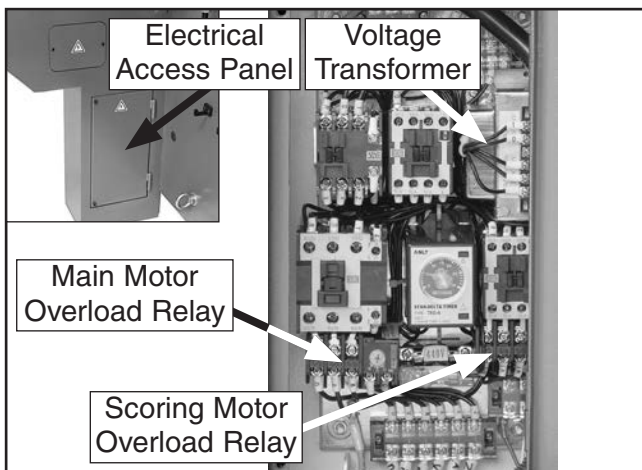


Figure 7. Inside view of the control panel.

3. Pull the fuse that is in the “220” slot and push it into the “440” slot (see **Figure 8**).

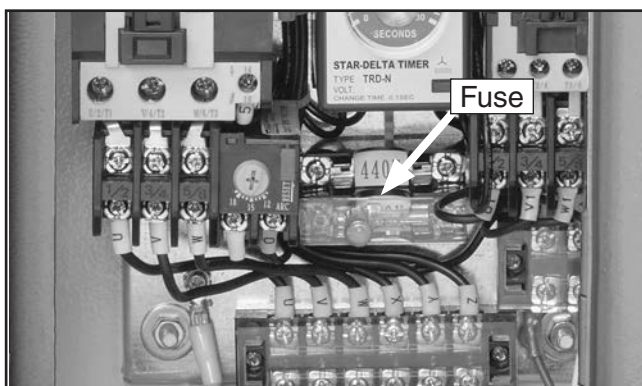


Figure 8. Fuse installed at the 220V location.

4. Remove the main motor overload relay (**Figure 9**) and replace it with the overload relay from the 440V conversion kit. Turn the dial on the main motor overload relay to 9A.

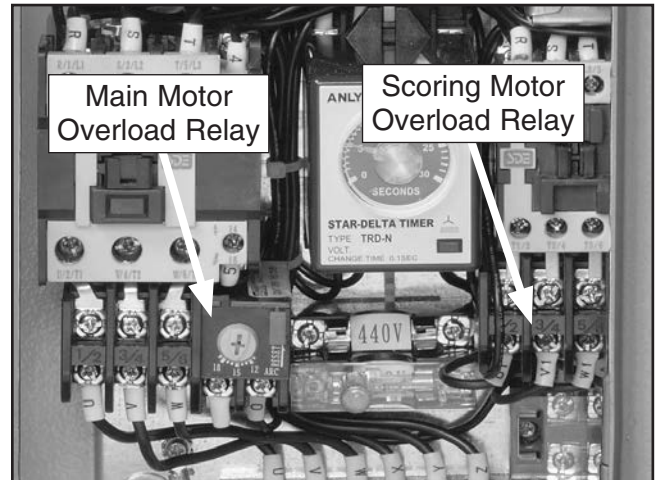


Figure 9. Motor overload relays.

5. On the scoring motor overload relay, change the dial setting to 2.6A.
6. Open the motor cabinet door and remove the motor wiring covers from the main motor and the scoring motor (see **Figure 10**).

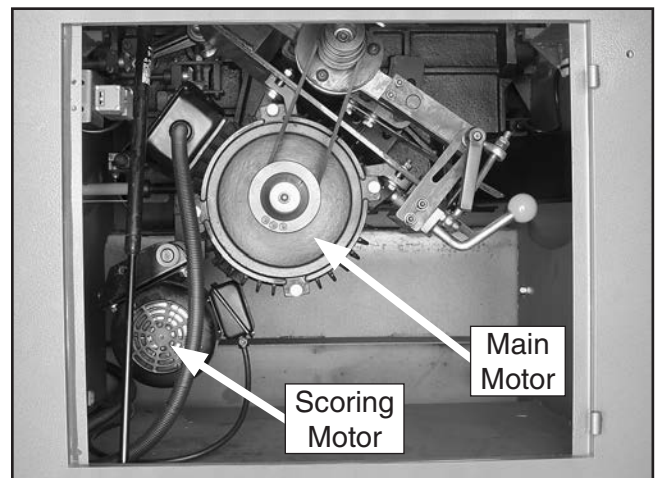


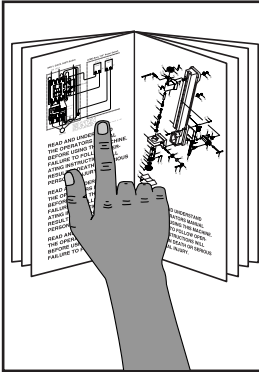
Figure 10. Motor locations.

7. Rewire the motors as shown on the diagrams that are placed on the inside of the motor wiring covers.

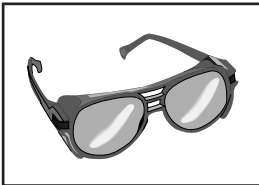


SECTION 3: SETUP

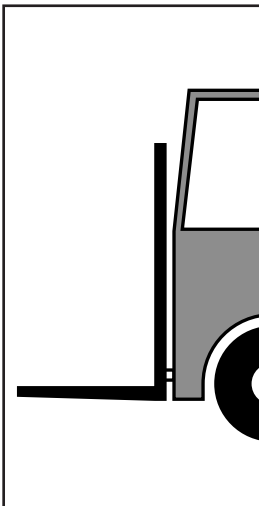
Setup Safety



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



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



!WARNING
 The Model G0493 is a heavy machine that weighs over 1300 lbs. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.

Unpacking

This machine was carefully packed when it left our warehouse. If you discover that it is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

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

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

Items Needed For Setup

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

Description	Qty
• Safety Glasses (for each person).....	1
• Power Lifting Equipment	1
• Lifting Straps (1500 lb capacity)	2
• An Assistant	1
• Straightedge 4' (or longer).....	1
• Main Blade 12" or 14".....	1
• Phillips Head Screwdriver #2	1
• Hex Wrenches 3, 4, 6, & 8mm	1 Each
• Wrenches or Sockets, 16 & 18mm....	1 Each
• Dust Collection System	1
• 5" Dust Hose (length as needed)	1
• 5" Hose Clamp	2
• 2½" Dust Hose (length as needed)	1
• Power Cord (length as needed)	1
• Power Disconnect Box	1
• Electrician.....	1



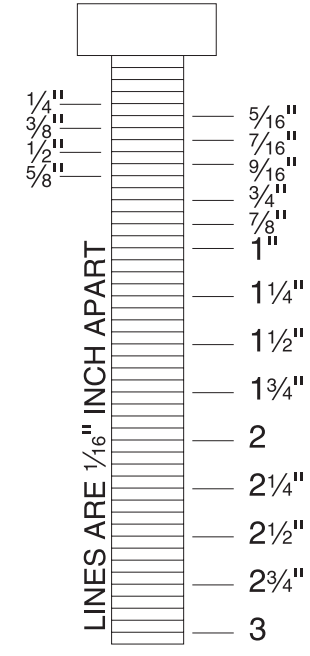
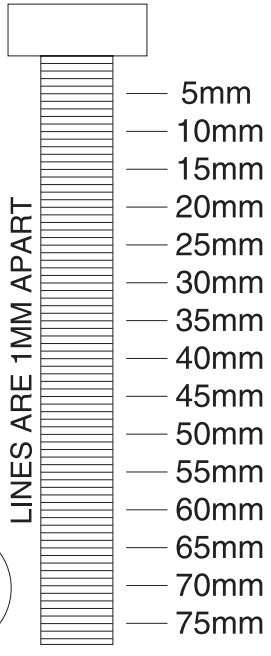
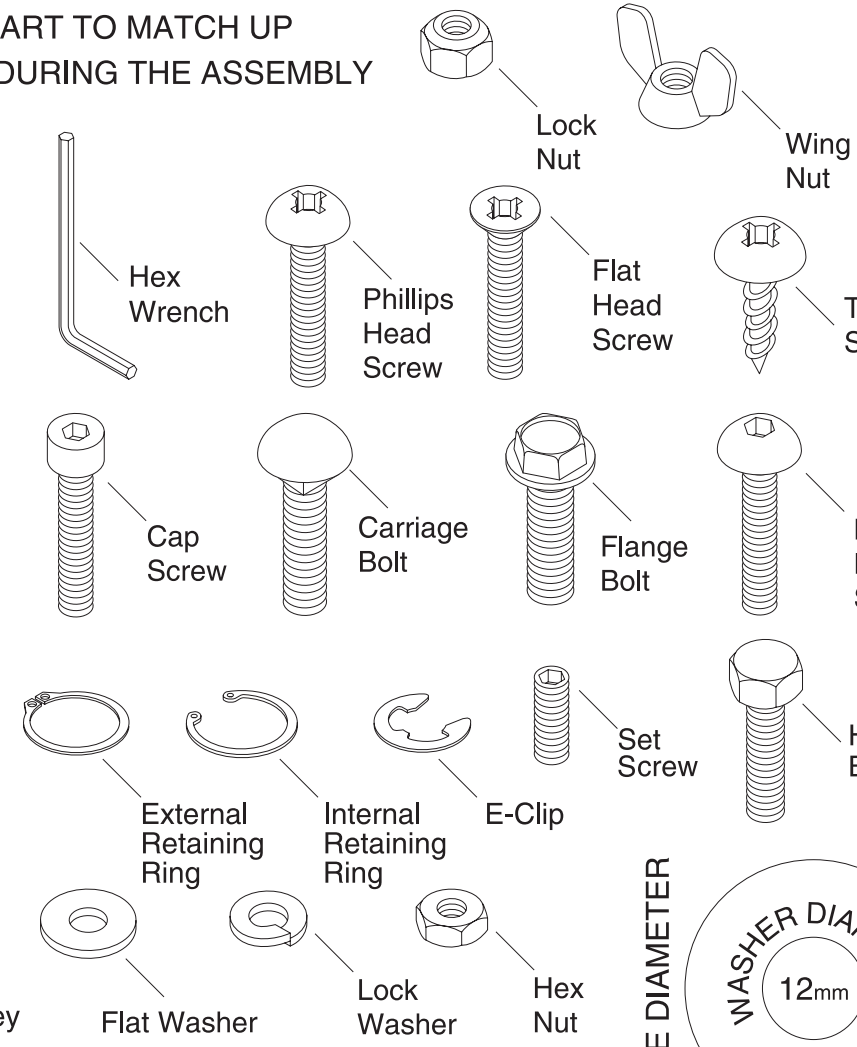
Hardware Recognition Chart

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

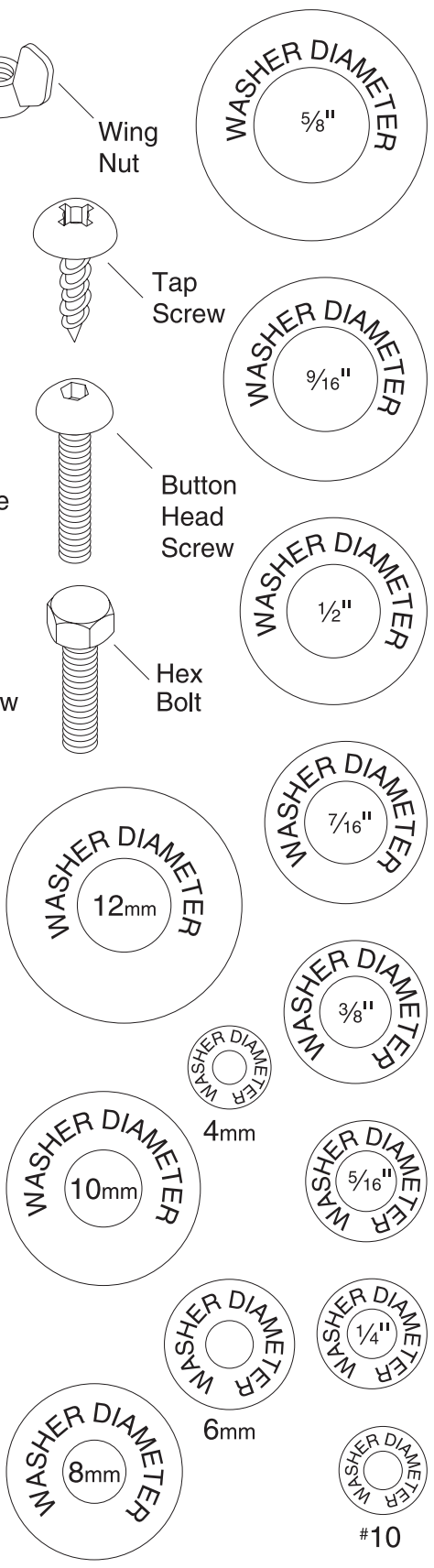
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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

- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Inventory

After all the parts have been removed from shipping crate #1, you should have the following:

- Box 1: (Figure 11)** Qty
- A. Large Extension Table 1
 - B. Small Extension Table..... 1
 - C. Support Brace 1

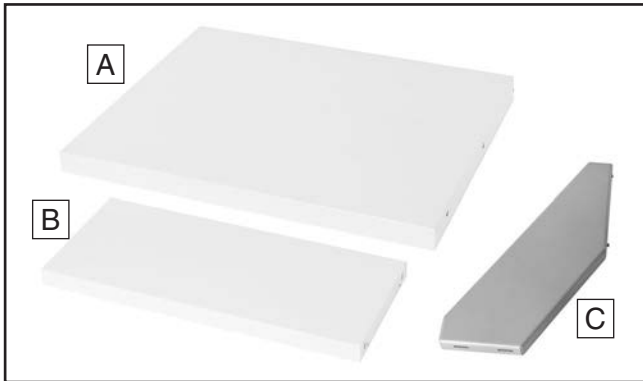


Figure 11. Box 1 contents.

- Box 2 & 3: (Figure 12)** Qty
- D. Crosscut Fence 1
 - E. Round Rail..... 1

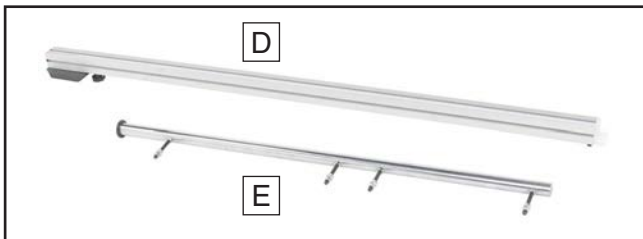


Figure 12. Box 2 & 3 contents.

- Box 4: (Figure 13)** Qty
- F. Crosscut Table 1

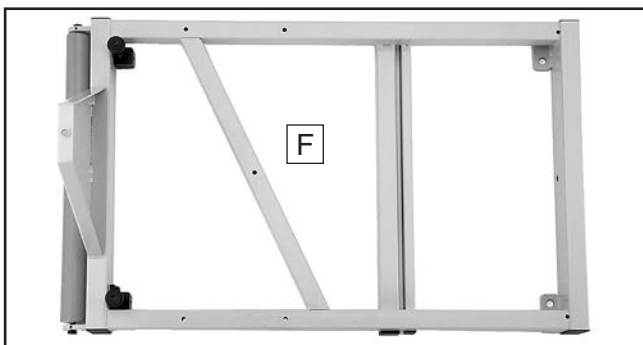


Figure 13. Box 4 contents.

- Box 5 & 6: (Figure 14)** Qty
- G. Sliding Table End Handle..... 1
 - H. Sliding Table Lock Plate..... 1
 - I. Flip Stops 2
 - J. Edge Shoe..... 1
 - K. Hold Down..... 1

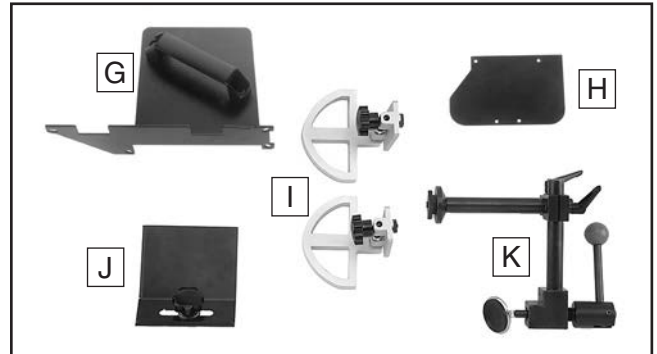


Figure 14. Box 5 & 6 contents.

- Box 7: (Figure 15)** Qty
- L. Rip Fence Body..... 1
 - M. Blade Guard/Dust Hood..... 1
 - N. Push Stick 1
 - O. Dust Hose Support..... 1
 - P. Hose Clamps 2½" 2
 - Q. Spreader..... 1
 - R. Toolbox 1
 - S. Flat Belt 15 x 787mm..... 1
 - T. Feet M16-2.0 x 100 w/Hex Nuts 4
 - U. Arbor Wrenches 19 x 24mm..... 2
 - V. Support Brace 1

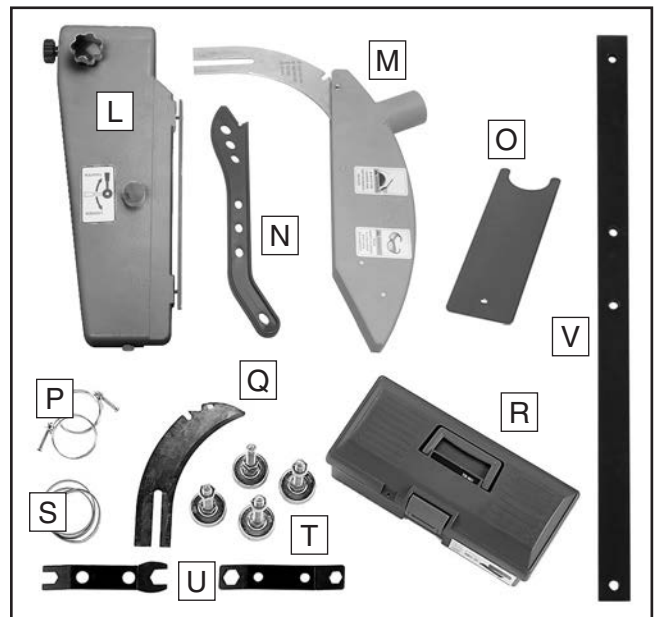


Figure 15. Box 7 contents.



Box 8 & 9: (Figure 16)	Qty
V. Scale Bar.....	1
W. Crosscut Table Brace.....	1
X. Rip Fence.....	1



Figure 16. Box 8 & 9 contents.

Crate #2: (not shown)	
Sliding Table.....	1

Component Hardware (not shown)	Qty
T-Bolts (Sliding Table) M12-1.75 x 60	3
Hex Nuts M12-1.75 (Sliding Table).....	3
Flat Washers 12mm (Sliding Table).....	3
Lock Washers 12mm (Sliding Table).....	3
Push Handle M12-1.75 x 12 (Sliding Table)	1
Flat Washer 12mm (Sliding Table).....	1
T-Nut M12-1.75 (Sliding Table).....	1
Set Screws M6-1.0 x 12 (Small Table).....	2
Cap Screws M10-1.5 x 20 (Small Table).....	2
Lock Washers 10mm (Small Table).....	2
Flat Washers 10mm (Small Table)	2
Cap Screws M10-1.5 x 20 (Large Table)	4
Lock Washers 10mm (Large Table)	4
Flat Washers 10mm (Large Table)	4
Set Screws M10-1.5 x 25 (Large Table)	4
Cap Screw M10-1.5 x 30 (Hose Support).....	1
Lock Washer 10mm (Hose Support)	1
Hex Nut M10-1.5 (Hose Support)	1
Cap Screws M10-1.5 x 30 (Support Brace)	4
Lock Washer 10mm (Support Brace)	4
Hex Nut M10-1.5 (Support Brace)	2

Hex Bolts M6-1 x 25 (Scale Bar).....	3
Flat Washers 6mm (Scale Bar)	3
Lock Washers 6mm (Scale Bar).....	3
Hex Nuts M6-1 (Scale Bar).....	3
Adjustable Ring w/Set Screw (R Rail)	1
End Washer 8mm (R Rail)	1
Lock Washer 8mm (R Rail)	1
Cap Screw M8-1.25 x 16 (R Rail).....	1
Lock Handles M10-1.5 x 12 (Rip Fence Body) ..	2
Knob M10-1.5 x 70 (Rip Fence Body)	1
Adjustable Handle M12-1.75 x 55 (Crosscut)....	1
Flat Washer 12mm (Crosscut Table).....	1
T-Nut M12-1.75 (Crosscut Table)	1
T-Nuts M8-1.25 (Crosscut Brace)	2
Knobs M8-1.25 x 50 (Crosscut Brace)	3
Flat Washers 8mm (Crosscut Brace)	2
Center Stud M8-1.25 x 10 (Crosscut Fence)	1
Fiber Washer 8mm (Crosscut Fence)	1
T-Bolt M8-1.25 x 60 (Crosscut Fence).....	1
T-Nuts M8-1.25 (Crosscut Fence).....	3
Knob M8-1.25 (Crosscut Fence).....	1
Knob M8-1.25 x 25 (Crosscut Fence).....	1
Flat Washer 8mm (Crosscut Fence).....	1
Block (Crosscut Fence)	1
Cap Screw M8-1.25 x 35 (Crosscut Fence)	1
Lock Washer 8mm (Crosscut Fence).....	1
Button Hd Cap Screw M8-1.25 x 40 (Guard)	1
Flat Washer 8mm (Guard).....	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.

NOTICE

Some hardware/fasteners on the inventory list may arrive pre-installed. Check mounting locations on main components before assuming inventory list items are missing.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

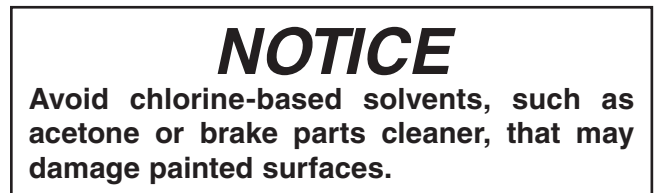
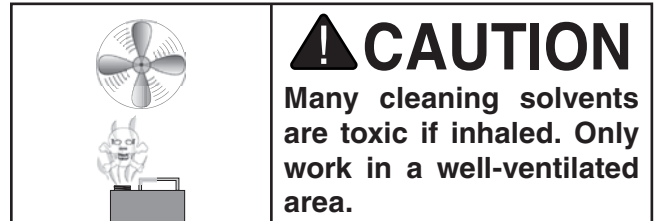
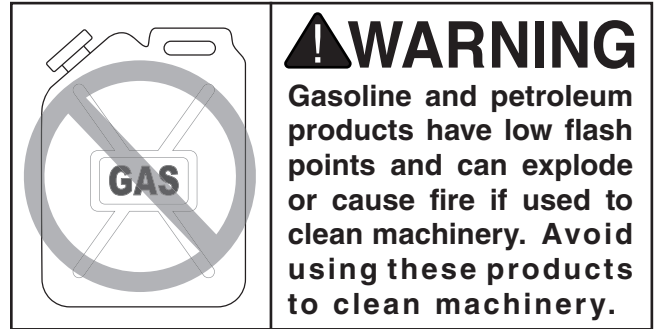
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



H9692—Orange Power Cleaner & Degreaser
One of the best cleaners we've found for quickly and easily removing rust preventative.



Figure 17. Model H9692 Industrial Orange Power Cleaner/Degreaser.



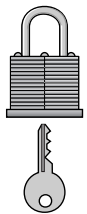
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

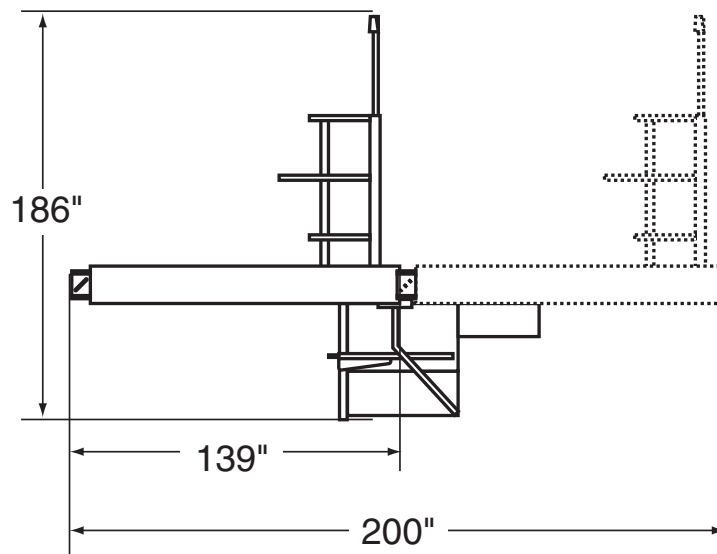
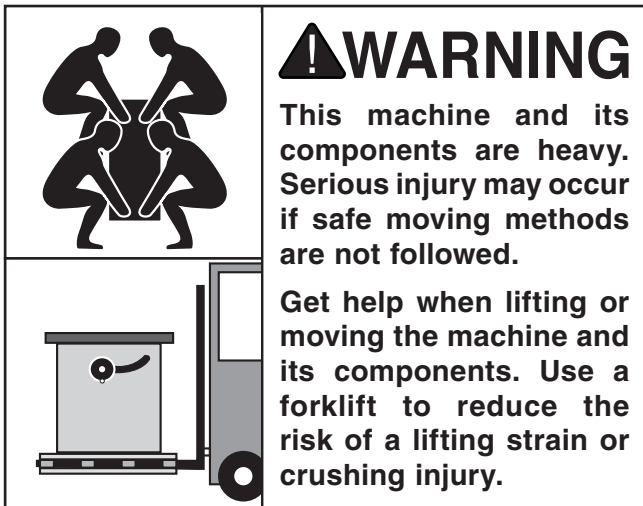


Figure 18. Minimum working clearances.



Moving & Placing Base Unit



To remove the saw base unit from the crate pallet:

1. Remove the top of the crate and position the forklift forks together and directly above the saw.
2. Place two lifting straps over the forks and attach the ends to the lifting bolts as shown in **Figure 19**.



Figure 19. Lifting the saw base unit.



3. Lift the saw base unit and move it to your predetermined location.
4. Before lowering the saw into position, place safety blocks under the frame and thread the four feet into the frame at least half of the length.
5. Remove the safety blocks and lower the saw onto the feet as shown in **Figure 20** and remove the forklift straps.



Figure 20. Foot installed in cabinet leg.

6. Place a level on the saw table and adjust the feet so the saw table is level from left-to-right and from front-to-back. This will allow the table to slide smoothly.
7. Lock the feet in position by tightening the two hex nuts together against the cabinet leg.



Assembly & Setup

Before shipping, the sliding table was set at the factory to be even with the main table and parallel with the blade.

The sliding table and extension tables are heavy so you must get help lifting them during the installation process. We recommend having four strong helpers lift the sliding table and having an additional person help position the T-bolts into the holes when the table is lowered.

To assemble the sliding table saw:

1. Remove the red shipping brace (**Figure 21**) and the screws indicated. Set the screws aside for use in the following steps.

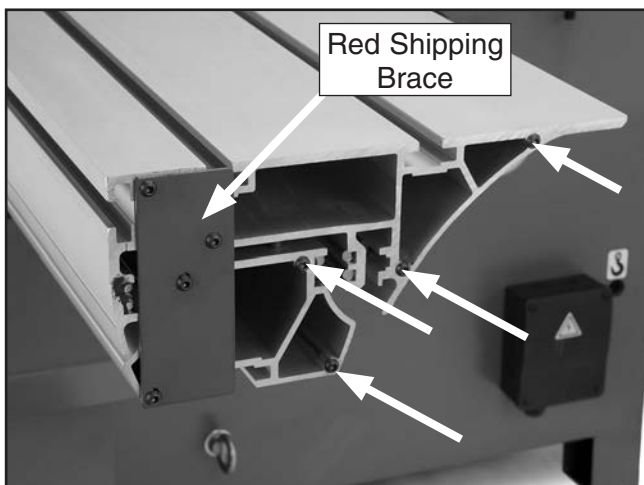


Figure 21. Sliding table.

2. Turn the sliding table upside down, as shown in **Figure 22**.



Figure 22. Sliding table upside down.

3. Insert the three T-bolts into the track along the bottom of the sliding table base (**Figure 23**), and space them apart the same distance as the mounting holes in the cabinet.

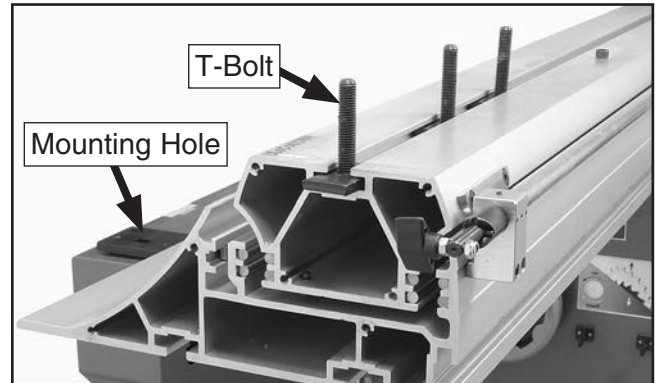


Figure 23. T-bolts inserted into table track.

4. Install the two locating blocks with the four M6-1 x 16 flat head screws.
5. Install the lock rod with the six M6-1 x 35 cap screws and six 6mm lock washers, as shown in **Figure 24**.

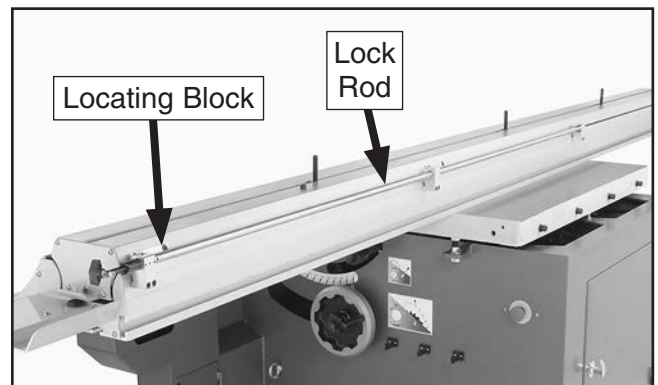


Figure 24. Locating blocks and lock rod installed on sliding table.

6. Lift the sliding table up and fit the T-bolts into the mounting holes on the cabinet. (An additional person may need to adjust the T-bolt spacing to allow the sliding table to fit.)

Continued on next page →



- Secure the sliding table to the cabinet with three M12-1.75 hex nuts, three 12mm lock washers, and three 12mm flat washers.

Note: Use the access holes on each side of the cabinet to reach the T-bolts on the ends of the sliding table (**Figures 25 & 26**). To access the T-bolt in the center of the sliding table, tilt the blade to 0° and reach through the dust port (**Figure 27**).

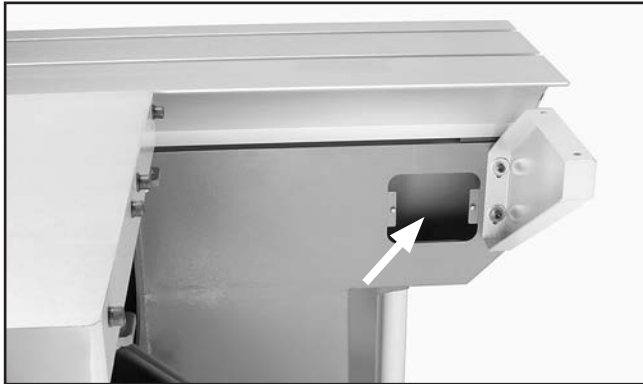


Figure 25. Left end access hole.

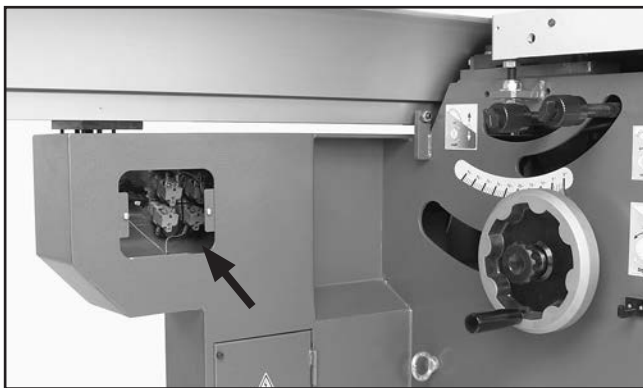


Figure 26. Right end access hole.

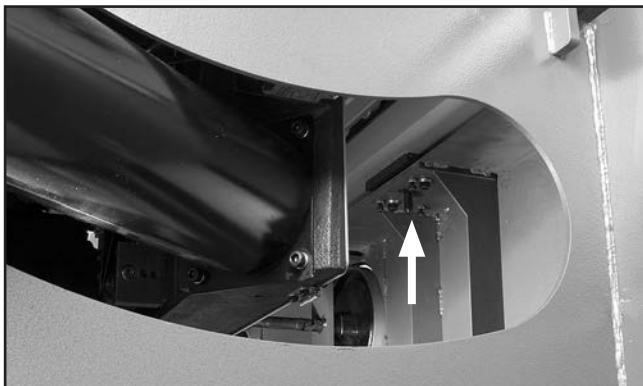


Figure 27. Dust port access hole to access center T-bolt.

- Insert the end cap into the sliding table, as shown in **Figure 28**.

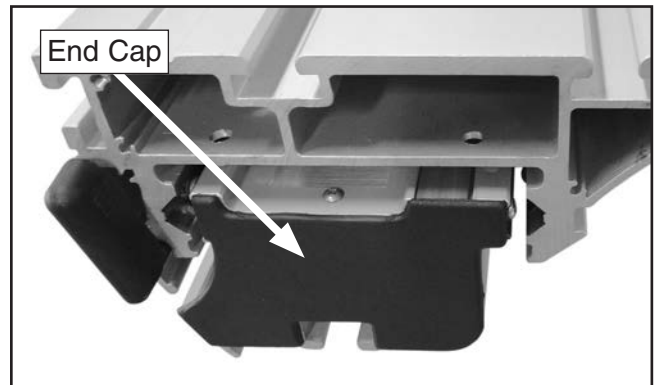


Figure 28. Installing the lock plate.

- Install the end handle, as shown in **Figure 29**, using screws removed in **Step 1**.

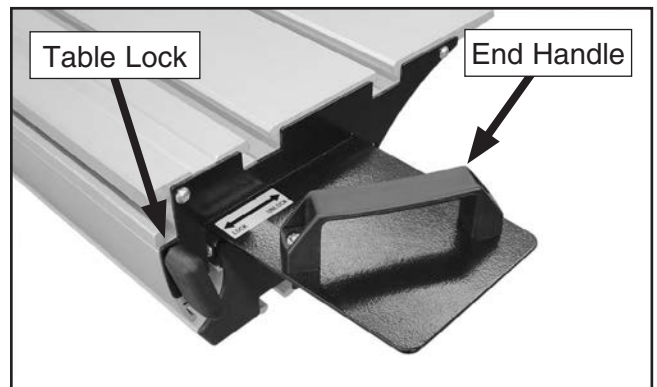


Figure 29. Sliding table end handle.

- Rotate the table lock up to unlock the sliding table. The sliding table is locked in place when in the position shown in **Figure 29**.

- Install the push handle into the table, as shown in **Figure 30**, with a 12mm flat washer and M12-1.75 T-nut.

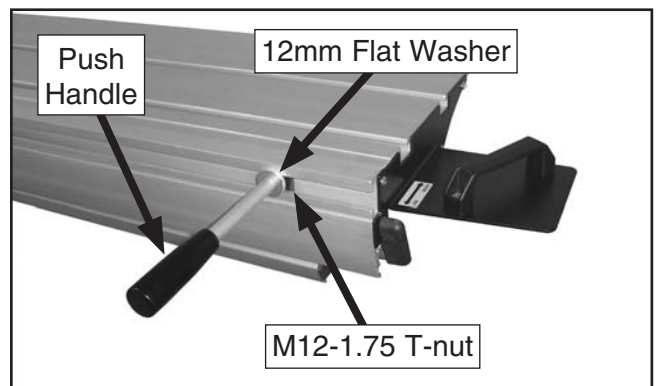


Figure 30. Sliding table push handle installed.



12. Attach the table support to the saw body, as shown in **Figure 31**, with the cap screws and washers already installed on the saw body.

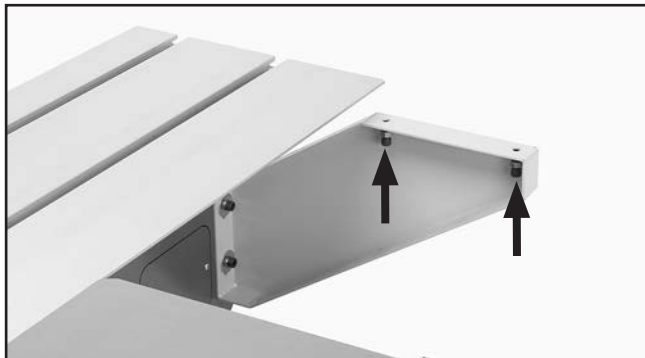


Figure 31. Small extension table support cap screws (table removed for photo clarity).

13. Thread an M10-1.5 hex nut all the way onto two M10-1.5 x 20 cap screws, then install the cap screws where shown in **Figure 31** to help level the small extension table level once it is installed. Tighten the hex nuts against the table support to lock the cap screws in place.

14. Loosely attach the small extension table to the left side of the cast iron table with two M10-1.5 x 20 cap screws, two 10mm lock washers, and two 10mm flat washers as shown in **Figure 32**. **Note:** *The cap screws will be tightened during a later step.*

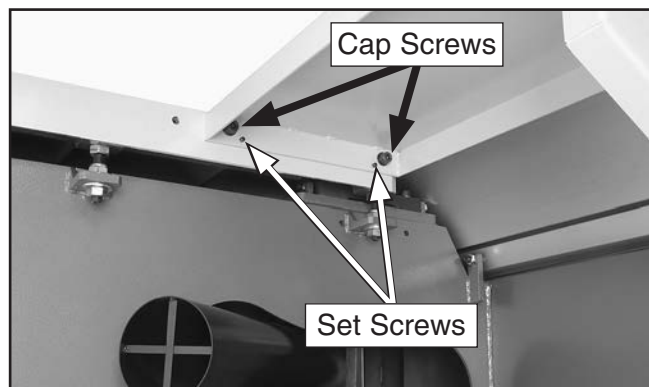


Figure 32. Small extension table attached.

15. Thread two M6-1 x 12 set screws into the small holes in the small extension table. Make sure the set screws do not stick out from the mating surface.

16. Loosely attach the large extension table to the back of the cast iron table with four M10-1.5 x 20 cap screws, four 10mm lock washers, and four 10mm flat washers, as shown in **Figure 33**. **Note:** *The cap screws will be tightened during a later step.*

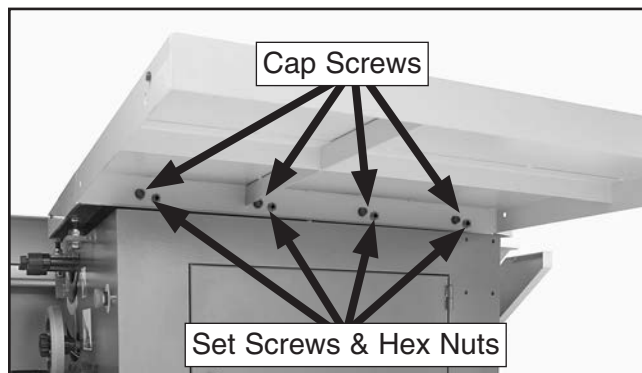


Figure 33. Large extension table attached.

17. Thread an M10-1.5 hex nut onto each of four M10-1.5 x 20 set screws, then thread each of the set screws into the small holes in the large extension table, as shown in **Figure 33**. Make sure the set screws do not stick out from the mating surface.

18. Use a straightedge, as shown in **Figure 34**, to make sure the extension tables are even with the cast iron table. Use the set screws under the extension tables to level the top surfaces, then tighten all the mounting cap screws.



Figure 34. Checking with a straightedge.



19. Attach the support brace and dust collection hose support to the table with five M10-1.5 x 30 cap screws and 10mm lock washers, as shown in **Figure 35**.

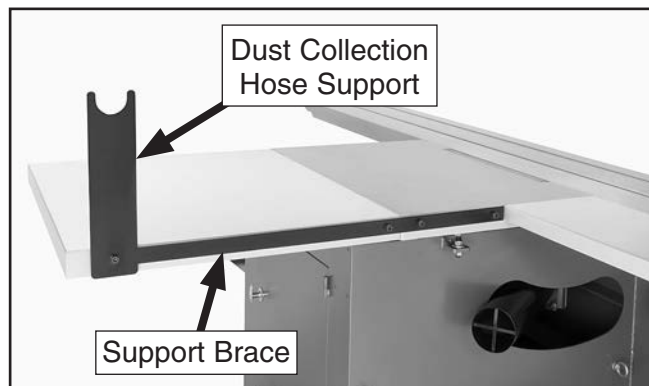


Figure 35. Dust collection hose support installation.

20. Mount the scale bar to the cast iron table and large extension table, making sure it is even with the top of the tables. Use the three M6-1 x 25 hex bolts, three 6mm flat washers, three 6mm lock washers, and three M6-1 hex nuts, as shown in **Figure 36**, to mount it. (The top of the hex bolts slide into the scale bar.)

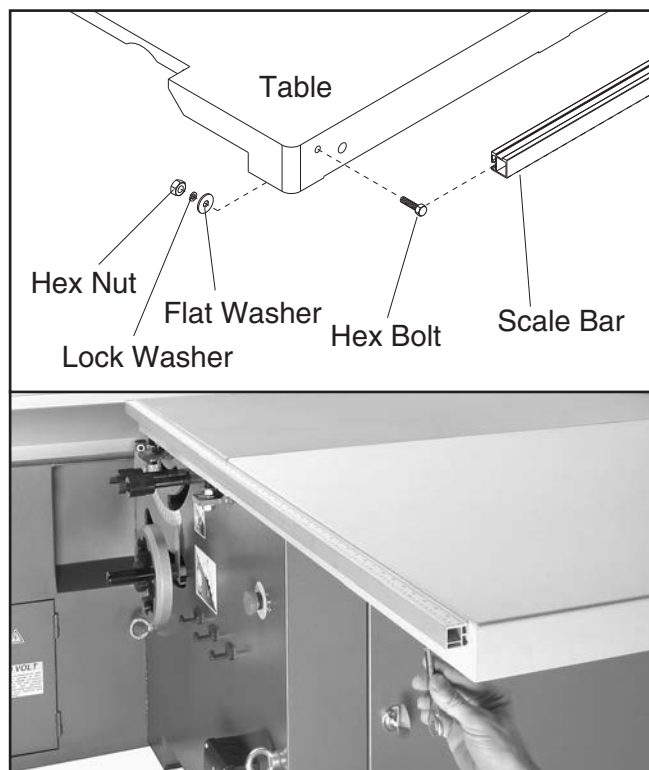


Figure 36. Attaching the scale bar.

21. The fence rail is pre-assembled with four rail studs and accompanying hardware. Remove one hex nut, flat washer, and lock washer from the end of each stud, as shown in **Figure 37**.

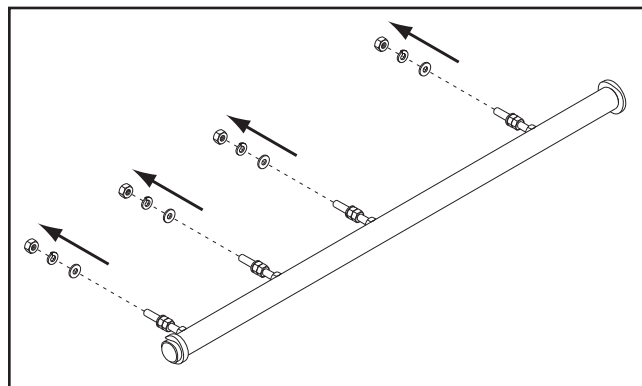


Figure 37. Hardware removed from fence rail studs to prepare for installation.

22. Insert the studs into the tables as shown in **Figure 38**. Put a 12mm flat washer, 12mm lock washer and a M12-1.75 hex nut on the end of each stud to hold the round rail on the tables. Do not tighten the hex nuts at this time.

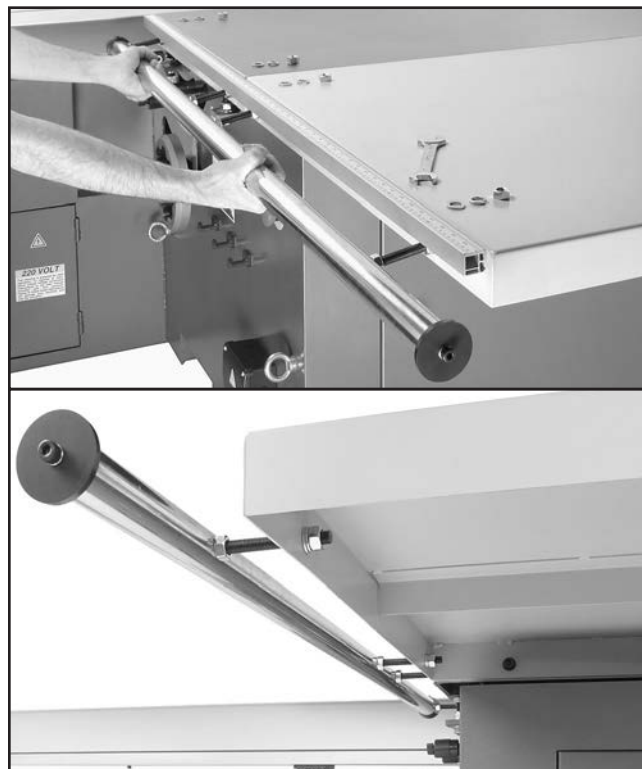


Figure 38. Installing the round rail.



23. Slide the rip fence body onto the round rail. Thread the lock handles M10-1.5 x 12 and knob M10-1.5 x 70 into the rip fence body, where shown in **Figure 39**.

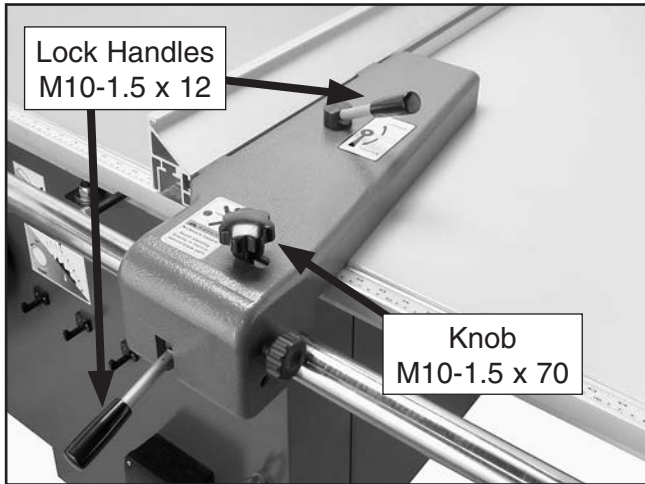


Figure 39. Rip fence handles.

24. Slide the aluminum rip fence onto the clamping plate as shown in **Figure 40**, and lock it with the fence lock handle.

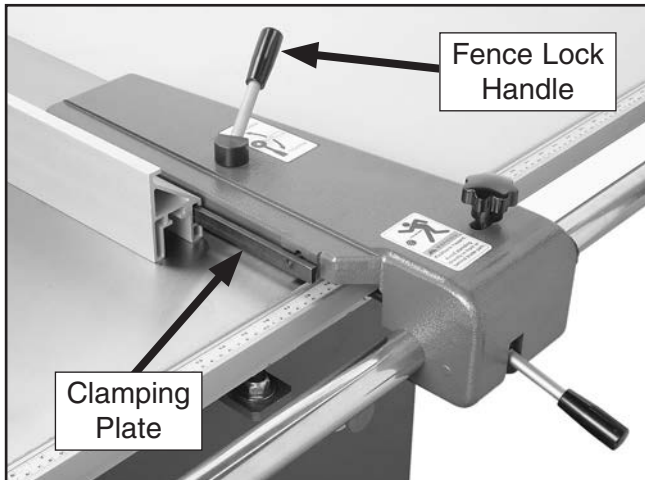


Figure 40. Installing the rip fence.

25. Open the motor compartment and remove the red shipping braces from both motors, then re-install the shipping brace fasteners back into the holes from which they came.
26. Move the blade arbor tilt to 0° and raise it as far as it will go.

27. Install the flat belt on the scoring motor and arbor pulley as shown in **Figure 41**.

Note: The scoring motor adjusts by lifting it up. The weight of the scoring motor dictates the correct belt tension.

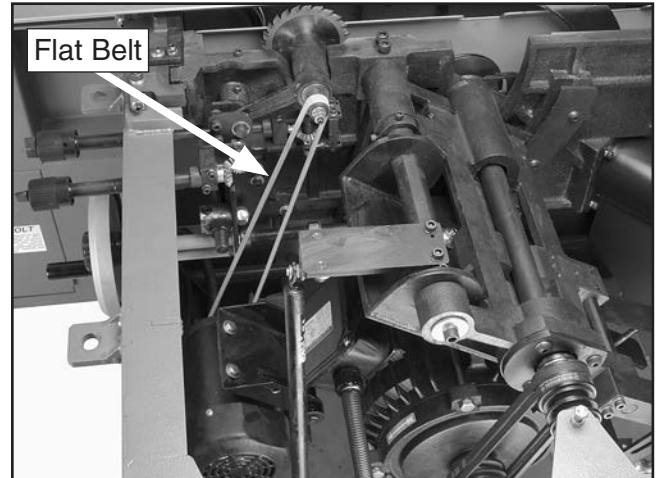


Figure 41. Flat belt installed on scoring motor and arbor pulley (table removed for clarity).

28. Slide the table all the way forward to access the blade arbor and pull open the blade guard (see **Figure 42**).

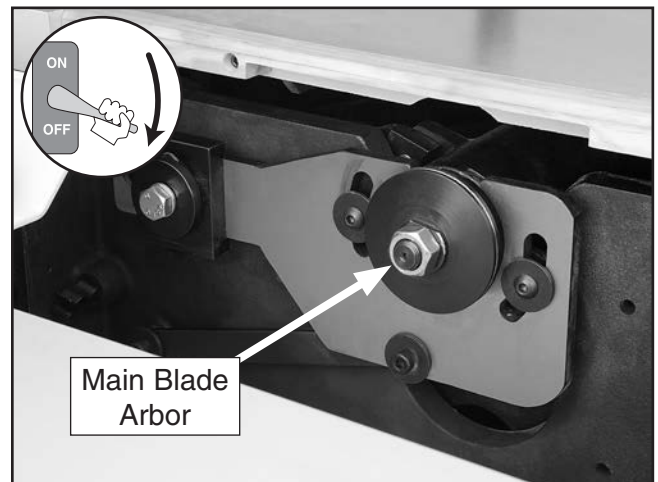


Figure 42. Main blade arbor components.

29. Use the arbor wrench to remove the arbor nut and arbor flange. **Note:** The arbor nut has left hand threads and loosens by turning clockwise.



CAUTION

Before proceeding with the next steps, wear gloves to protect your hands when handling and installing the blade.

- Slide the blade over the arbor with the teeth facing the right side of the saw, and re-install the arbor flange and the arbor nut. The main blade arbor nut has left-hand threads and tightens counterclockwise. Hold the arbor with one arbor wrench and tighten the nut with the other arbor wrench as shown in **Figure 43**.



Figure 43. Installing the main blade.

- Slide the rip fence over until it just touches the blade.
- Adjust the mounting position of the round rail until the rip fence evenly touches the entire width of the blade from front to back.

Note: To adjust the mounting position of the round rail, use the hex nuts (on the round rail studs) that are on both sides of the tables.

- Check if the metal part of the rip fence rests on the surface of the table.

Note: The rip fence body will scratch the table surface if the ride height is not adjusted correctly. Only the roller should touch the table surface.

—If the rip fence body **does not** rest on the table, then the fence is correctly adjusted.

—If the rip fence body **does** rest on the table, remove the rip fence and turn it upside down. Loosen the set screw shown in **Figure 44** and rotate the hex bolt to raise the roller. Tighten the set screw to lock the ride height and recheck how the rip fence rests on the table.

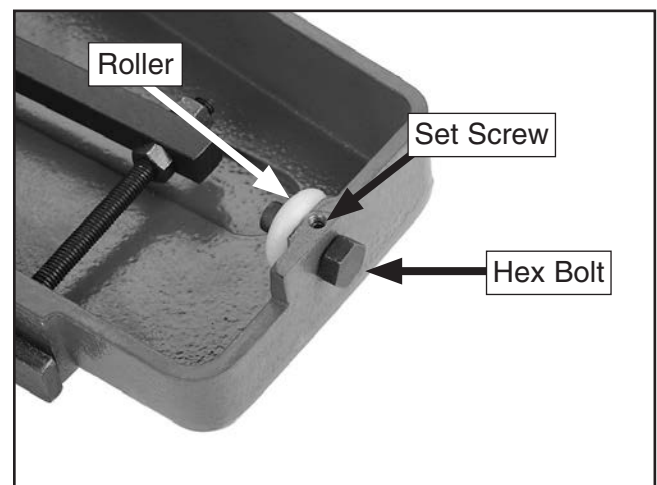


Figure 44. Rip fence height adjustment.

- Check the height of the rip fence rail by sliding the rip fence along the rail and comparing the gap between the rip fence body and the tables.
- Adjust the height of the rip fence rail, then tighten all of the hex nuts to secure the round rail in place.



36. Loosen the riving knife center bolt, slide the riving knife over the bolt as shown in **Figure 45**, and slightly tighten.

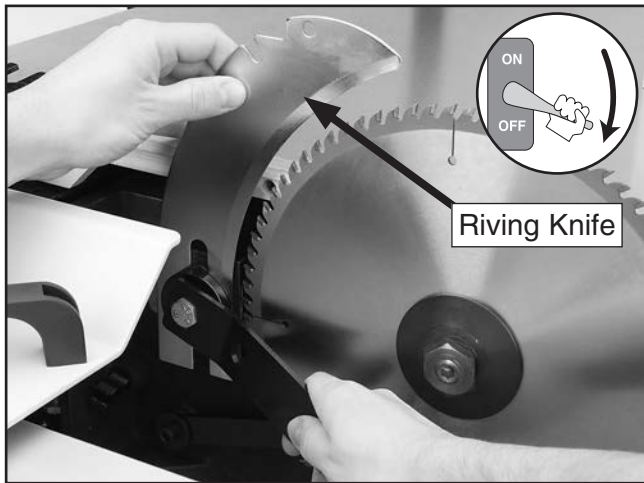


Figure 45. Installing the riving knife.

37. Position the riving knife about 3mm or 1/8" away from the nearest carbide tooth on the main blade. **Note:** For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife, as shown in **Figure 46**.

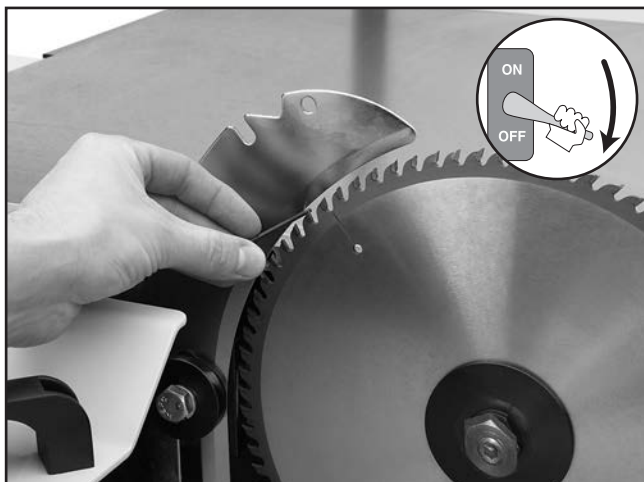


Figure 46. Adjusting the riving knife.

38. Tighten the center bolt to secure the riving knife in position.

39. Use both arbor wrenches, as shown in **Figure 47**, to verify that the scoring blade arbor nut is tight. (The scoring blade arbor nut has right-hand threads and tightens clockwise.)

Note: If the scoring blade is not pre-installed, install it now, making sure to place the arbor flange between the arbor nut and blade during installation.

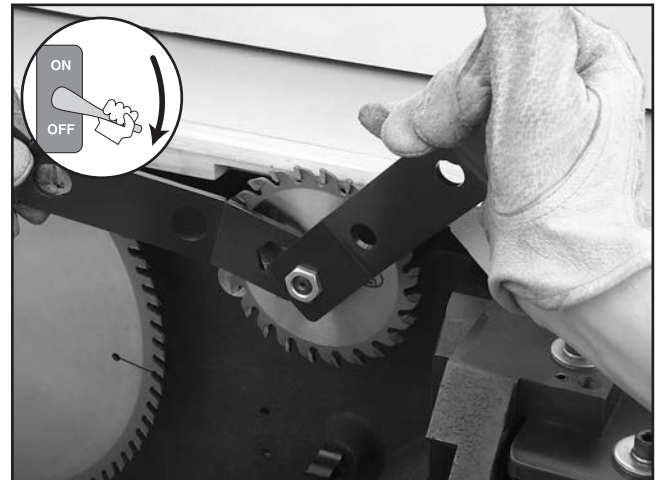


Figure 47. Removing the scoring blade.

40. Move the scoring blade tilt to 0° (blade 90° to table), then raise it up, using the vertical adjustment knob (**Figure 48**), until enough of the wedge shaped teeth are exposed from the table surface to equal the same width as the main blade teeth.

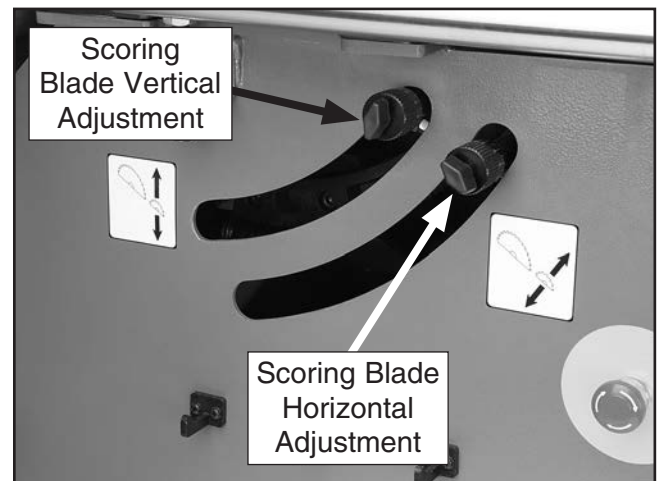


Figure 48. Scoring blade adjustment controls.

Continued on next page →



41. Move the rip fence against the main blade (or scoring blade) as shown in **Figure 49**.



Figure 49. Fence used to align blades.

42. Adjust the scoring blade, using the horizontal adjustment controls, until the rip fence evenly touches both blades.
43. Move the rip fence against the blades again. Loosen the screws securing the scale bar, line up the 0" mark on the scale with the left edge of the rip fence, then tighten the scale bar mounting screws.
44. Set the rip fence to $\frac{1}{8}$ ", slide the adjustable ring with set screw on the round rail against the fence housing. Without moving the ring, move the fence housing out of the way, and secure the set screw on the ring, as shown in **Figure 50**. When installed correctly, this ring will prevent the fence from contacting the blade.



Figure 50. Securing the adjustable ring.

45. Move the blade guard back to its original position, and move the sliding table back to center.
46. Place the end washer (**Figure 51**) on the end of the round rail and secure it with the M8-1.25 x 16 cap screw and 8mm lock washer.

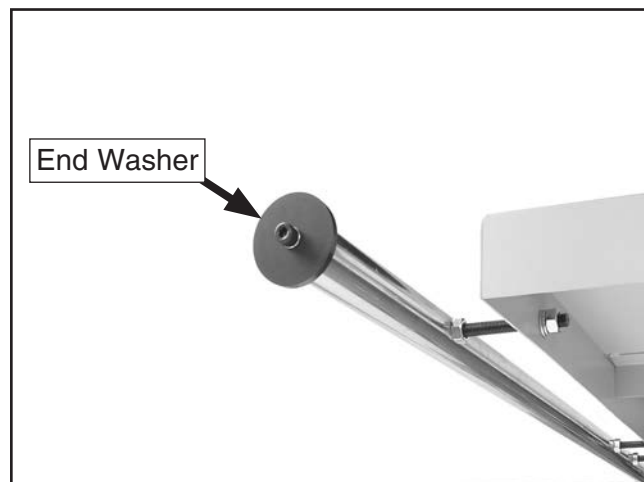


Figure 51. End washer on round rail.

47. Thread the M12-1.75 x 55 adjustable handle, with a 12mm flat washer, through the cross-cut table and into a M12-1.75 T-nut as shown in **Figure 52**.



Figure 52. Installing the adjustable handle.



48. With the help of an assistant, place the crosscut table on the pivot pin of the swing arm and slide the T-nut into the T-slot in the sliding table (see **Figure 53**).

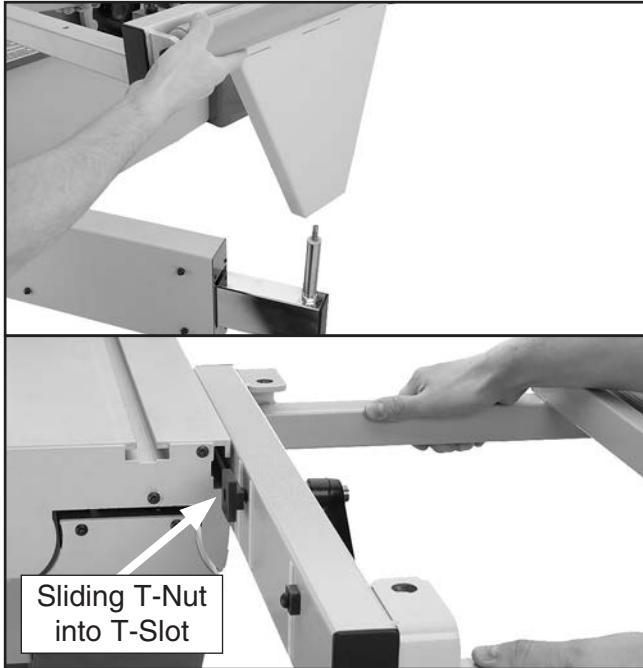


Figure 53. Installing the crosscut table.

49. Slide two M8-1.25 T-nuts into the crosscut table brace. Align the T-nuts in the crosscut table brace with the holes in the crosscut table, and thread the two M8-1.25 x 50 knobs, with two 8mm flat washers, into the T-nuts as shown in **Figure 54**.

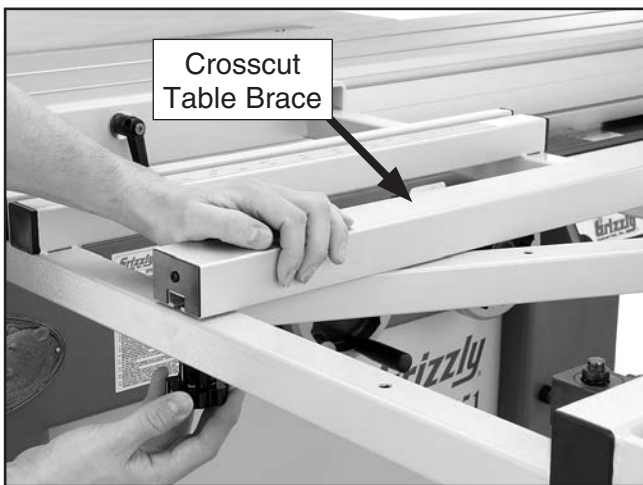


Figure 54. Installing the crosscut table brace.

50. Install the components shown in **Figure 55** on the crosscut fence.

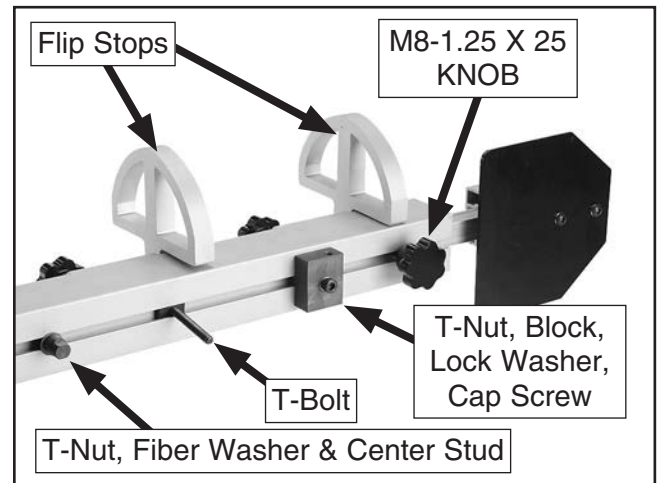


Figure 55. Crosscut fence assembly.

51. Position the center stud and the T-bolt over the placement holes shown in **Figure 56**, then tighten the center stud.

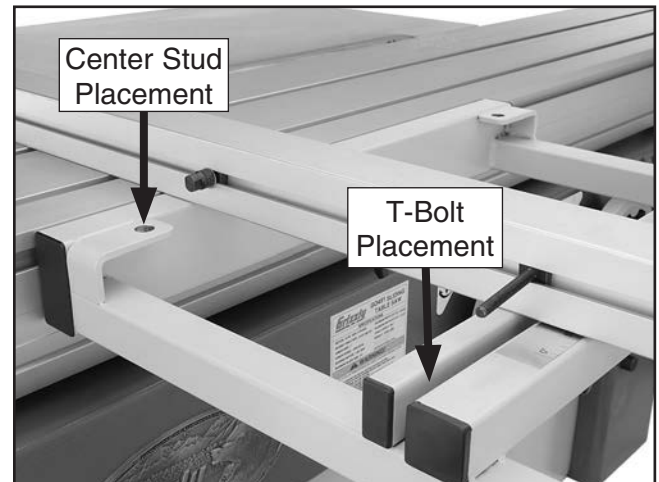


Figure 56. Crosscut fence placement.

52. Thread the M8-1.25 knob with an 8mm flat washer onto the T-bolt to secure the crosscut fence.
53. Slide the blade guard/dust hood over the riving knife, and attach it with an M8-1.25 x 40 button head cap screw and an 8mm flat washer.
54. (Optional) If needed, slide the edge shoe and hold down clamp into the table T-slot, and tighten the respective knob/handle. Position where necessary. (The front cover picture shows these items installed.)



⚠ CAUTION

DO NOT operate the Model G0493 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Required CFM at 5" Dust Port: 625 CFM
Required CFM at 2½" Dust Port: 150 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

55. Secure a 5" dust hose to the dust port located under the saw table (Figure 57).

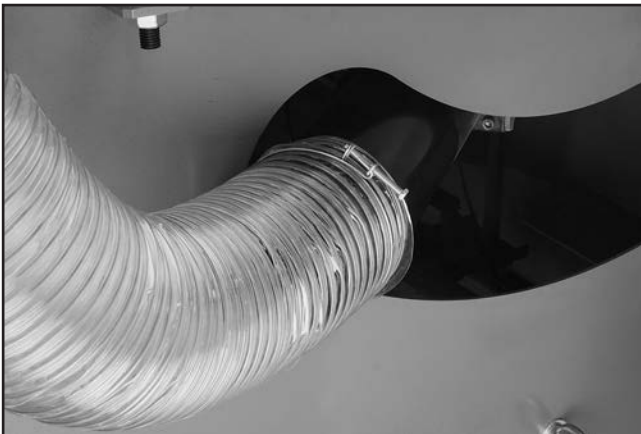


Figure 57. 5" dust port location.

56. Attach the blade guard/dust hood to the riveting knife with the M8-1.25 x 40 button head cap screw and 8mm flat washer. (The blade guard/dust hood **MUST** be installed.)
57. Attach a 2½" dust hose to the dust port, as shown in Figure 58.

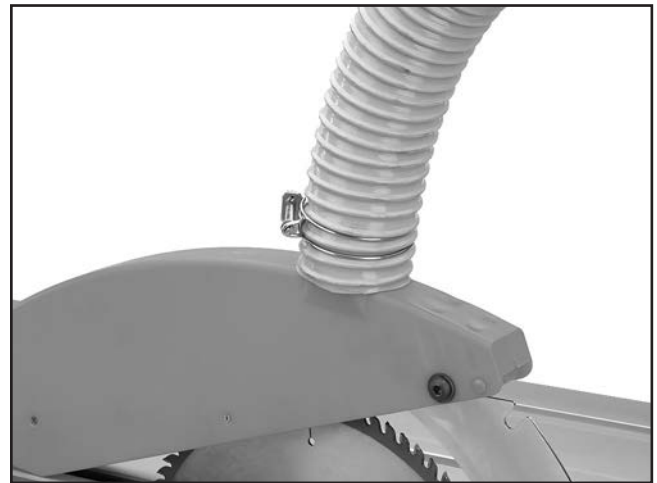


Figure 58. 2½" Dust port location.

58. Run the 2½" hose over the hose support, as shown in Figure 59.

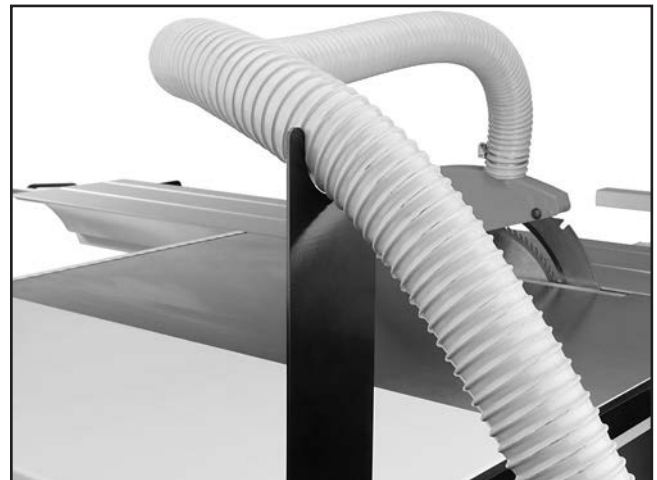


Figure 59. Dust hose support in use.

59. Run ground wires through the dust hoses and attach the wires to the machine to protect against static electricity.



Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.

Connecting to Power Source

Move the disconnect switch handle to the ON position, as illustrated below. The machine is now connected to the power source.

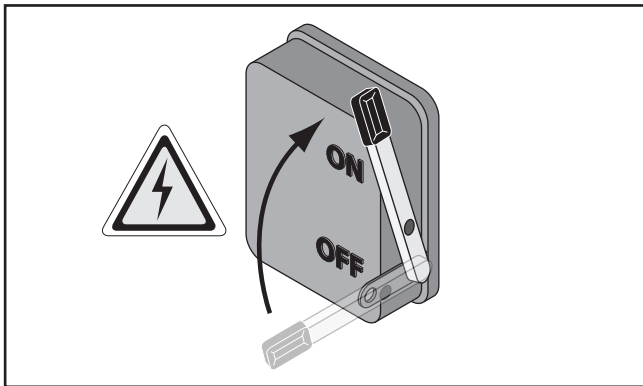


Figure 60. Connecting power to machine.

Disconnecting from Power Source

Move the disconnect switch handle to the OFF position, as illustrated below. The machine is now disconnected from the power source.

Note: Lock the switch in the OFF position to restrict others from starting the machine.

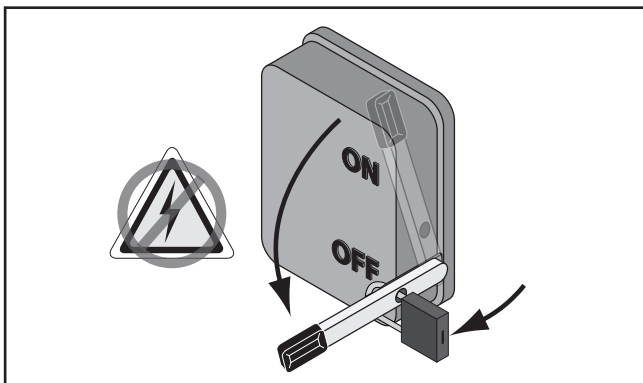


Figure 61. Disconnecting power from machine.

Test Run

After the machine has been connected to the power source, it **MUST** be test run to make sure all the controls are working properly.

The test run includes verifying that the safety disabling components on the machine work correctly.

Before beginning the test run, review the controls shown in **Figures 62–63**.

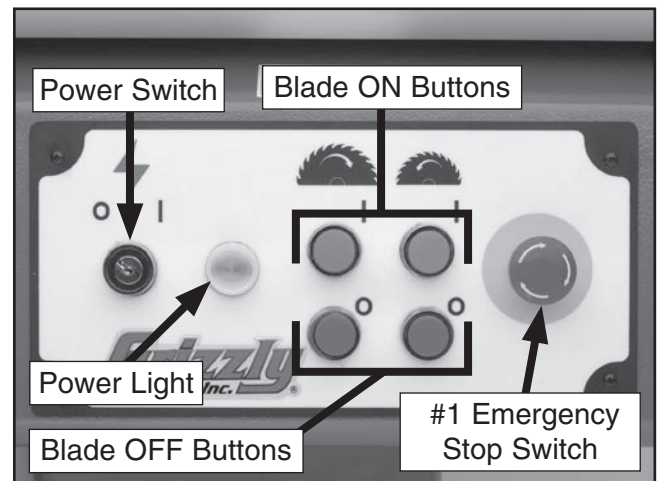


Figure 62. Main power controls.

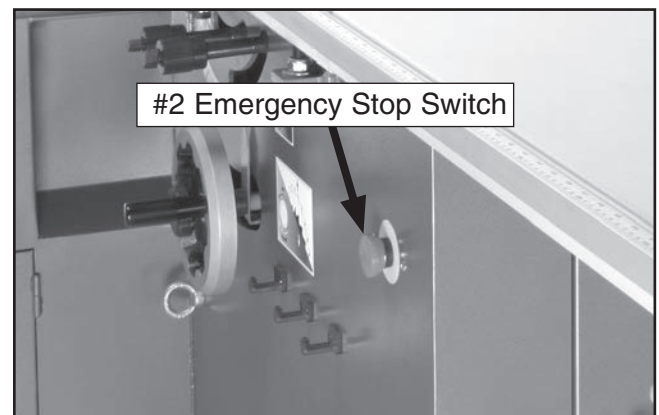


Figure 63. Emergency stop switch #2.

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WARNING

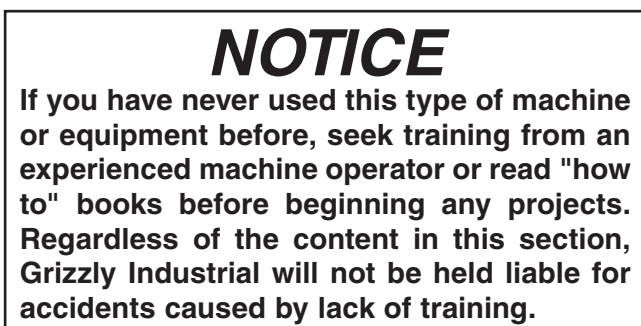
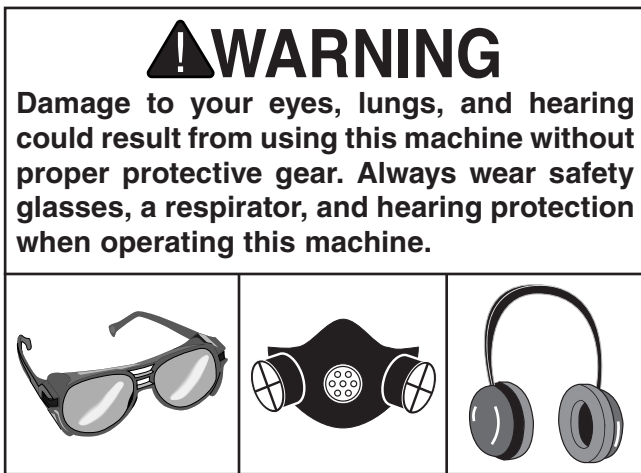
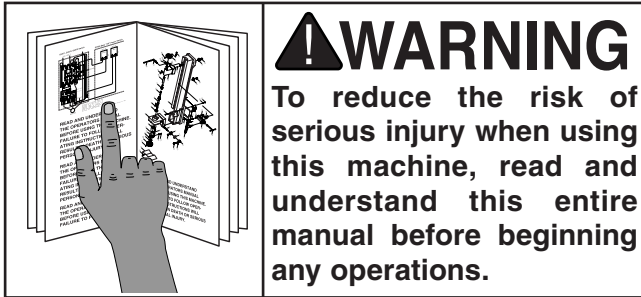
If the machine does not operate as stated in this section, review the troubleshooting section on Page 65. If you need additional help, call Tech Support at (570) 546-9663. **DO NOT** place a machine into regular operation if you suspect that it is malfunctioning or serious injury could occur.

To test run the saw:

1. Put on safety glasses, make sure any bystanders are out of the way, and that all tools have been removed from the saw.
2. Insert the key into the power switch and turn it clockwise.
3. Push in, then rotate both emergency stop switches clockwise until they pop out. This resets the emergency stop switches so the machine can operate.
4. One at a time, press the blade ON buttons. The blades should startup and run smoothly without any problems.
—If any problems occur, press the nearest emergency stop switch.
5. One at a time, press the blade OFF buttons. The blades should stop running. As the main blade comes to a stop, watch the direction that it is spinning.
—If the main blade is rotating counterclockwise, disconnect the saw from power and exchange wires R & T in the power connection box.
6. Depress the #1 emergency stop switch.
7. Press the blade ON buttons. Nothing should happen.
—If the stop switch is working correctly, reset the switch.
8. Repeat **Steps 6–7** with the #2 emergency stop switch.
9. Make sure both emergency stop buttons are reset before continuing.
10. Open the cabinet door at the rear of the machine. This opens the limit switch at the door.
11. Press the blade ON buttons. Nothing should happen.
12. Close and latch the cabinet door.
13. Turn the key switch **OFF** and DISCONNECT SAW FROM POWER!
14. Move the sliding table all the way forward, then open the orange blade guard. This opens the blade guard limit switch.
15. Connect the saw to the power source and turn the power switch key ON.
16. (During this step, be prepared to immediately press the #1 emergency stop switch if the blades start operating.) Press the blade ON buttons. Nothing should happen.
17. Turn the key switch **OFF** and DISCONNECT SAW FROM POWER!
18. Close the orange blade guard and move the sliding table back to the center of the machine.



SECTION 4: OPERATIONS



Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during a typical operation, so the controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is not intended to be an instructional guide. To learn more about specific operations, read this entire manual, read "how to" books, and seek additional training from experienced machine operators.

To complete a typical operation, the operator does the following:

- Examines the workpiece to make sure it is suitable for cutting.
- Adjusts the blade tilt, if necessary, to the correct angle of the desired cut.
- Adjusts the blade height approximately $\frac{1}{4}$ " higher than the thickness of the workpiece.
- Adjusts the fence to the desired width of cut then locks it in place.
- Checks the outfeed side of the machine for proper support and to make sure the workpiece can safely pass all the way through the blade without interference.
- Puts on safety glasses and a respirator, and locates push sticks if needed.
- Starts the saw.
- Feeds the workpiece all the way through the blade while maintaining firm pressure on the workpiece against the table and fence, and keeping hands and fingers out of the blade path and away from the blade.
- Stops the machine immediately after the cut is complete.



Workpiece Inspection

Some workpieces are not safe to cut on this machine or may need to be modified before they can be safely cut. **Before cutting, inspect all workpieces for the following:**

- **Material Type:** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the motor bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw greatly increases the risk of injury and damage to the saw or blade.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- **Wet or "Green" Stock:** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and may move unpredictably when being cut.
- **Minor Warping:** Slightly cupped workpieces can be safely supported with cupped side facing the table or fence; however, workpieces supported on the bowed side will rock during the cut, which could cause kickback.

Non-Through & Through Cuts

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in the **Figure** below.

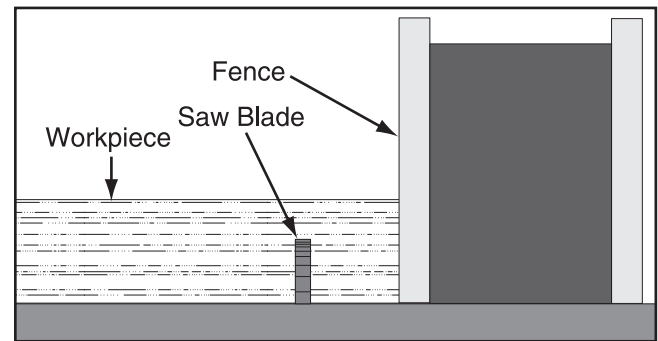


Figure 64. Example of a non-through cut.

Examples of non-through cuts include dadoes and rabbets. Non-through cuts have a higher risk of injury from kickback because the blade guard must be removed. However, the riving knife **MUST** be installed because it still provides some protection. When making non-through cuts with a dado blade, do not attempt to cut the full depth in one pass. Instead, take multiple light passes to reduce the load on the blade. A dado blade smaller than 10" will require removal of the riving knife, because the riving knife will be higher than the blade.

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through, as shown in the **Figure** below. Examples of through cuts are rip cuts, cross cuts, miter cuts, and beveled cuts. The blade guard assembly **MUST** be used when performing through cuts.

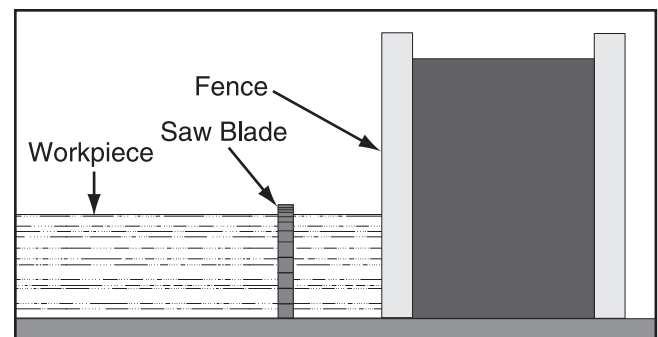


Figure 65. Example of a through cut (blade guard not shown for illustrative clarity).



Blade Guard & Riving Knife

The term "blade guard" refers to the assembly that consists of the guard and spreader assembly (see **Figure 66** below). Each of these components have important safety functions.

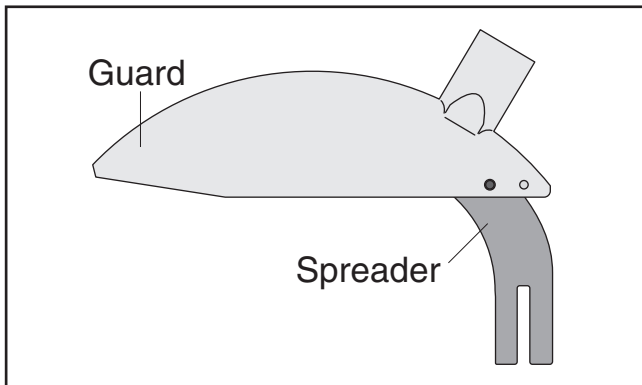


Figure 66. Blade guard assembly components.

Understanding Blade Guard

The guard encloses the top of the blade to reduce the risk of accidental blade contact and contain flying chips or dust.

The guard is designed to lift as the workpiece is pushed into the blade, remain in contact with the workpiece during the cut, then return to a resting position against the table when the cut is complete. When installed and properly maintained, the guard is an excellent tool for reducing the risk of injury when operating the table saw.

To ensure that the guard does its job effectively, it **MUST** be installed and adjusted so that it moves up and down properly to accommodate workpieces and maintain coverage over the blade.

Understanding Spreader & Riving Knife

The spreader and riving knife are metal plates that prevent the freshly cut workpiece from pinching the backside of the blade and causing a kick-back. These items also act as a barrier to shield hands from being pulled into the blade if a kick-back occurs and the operator is reaching behind the blade. (Reaching behind the blade is a major safety risk and should not be done).

The spreader is used with the blade guard for through cuts. The riving knife is used without the blade guard for non-through cuts.

⚠️ WARNING

To ensure that the spreader or riving knife works correctly, it must be correctly aligned and adjusted to the blade.

When to Use the Blade Guard

The blade guard **MUST** be installed on the saw for all normal through cuts (defined on **Page 38**).

Sometimes the blade guard or its components can get in the way when cutting very narrow workpieces or other specialized cuts. Because the blade guard is provided to decrease your risk of injury, it should not be used if it gets in the way of making a safe cut. Use good judgment!

In general, the blade guard **MUST** remain installed on the saw—unless a specific operation requires its removal. If the blade guard is removed for specific operations, always immediately replace it after those operations are complete.

When to Use the Riving Knife Only

Use the riving knife without the blade guard for any non-through cuts (defined on **Page 38**) or narrow/specialized cuts in which the blade guard gets in the way of a safe cut.

Always immediately replace the blade guard when these cuts are complete!



Blade Guard Spreader & Riving Knife Installation & Adjustment

The blade guard spreader and riving knife must be correctly installed, adjusted, and aligned in order to provide the maximum safety benefit. Aside from the height setting, the blade guard spreader should be installed and adjusted in the same manner as described for the riving knife.

The spreader/riving knife attaches to the mounting block as shown in **Figure 67**.

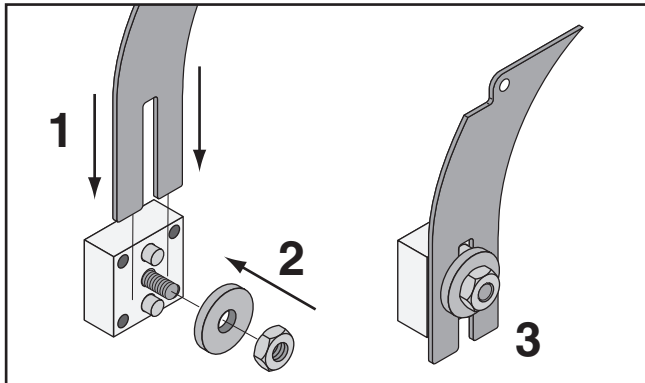


Figure 67. Installing spreader/riving knife on the mounting block.

Secure the riving knife so that the top of it is 1–5mm below the top level of the blade, as shown in **Figure 68**.

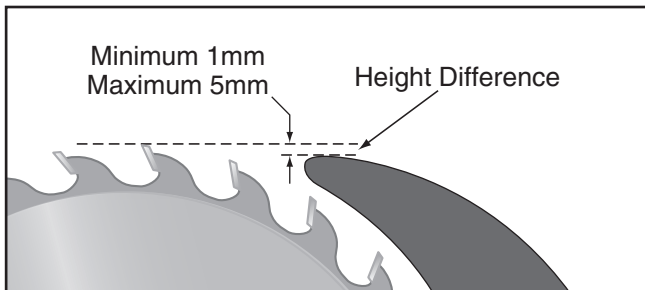


Figure 68. Riving knife height setting below blade.

The height difference between the riving knife and the blade allows the workpiece to pass over the blade during non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

The spreader/riving knife prevents the freshly cut workpiece from pinching the blade and causing kickback. For maximum effectiveness, the spreader/riving knife must be positioned 3–8mm from the blade, as shown in **Figure 69**.

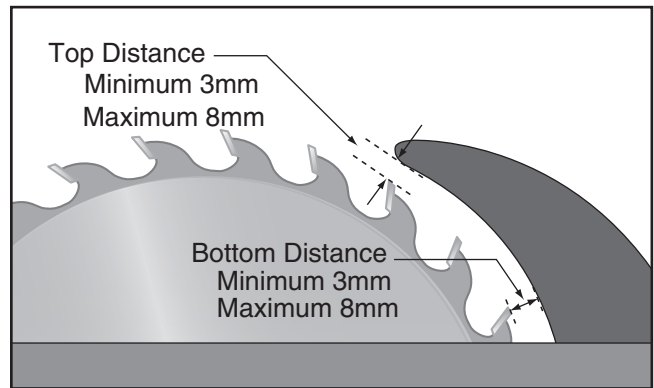


Figure 69. Allowable top and bottom distances between spreader/riving knife and blade.

Once the spreader/riving knife is properly positioned behind the blade, verify that it is also aligned with the blade by placing a straightedge along the top and bottom locations shown in **Figure 70**.

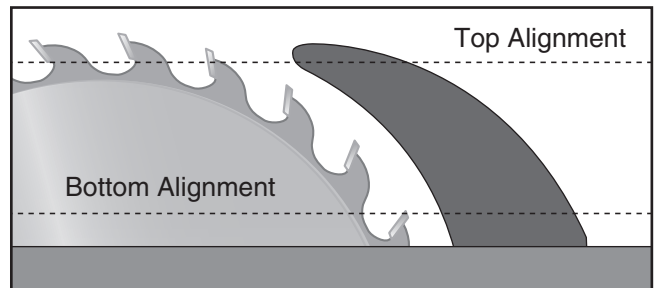


Figure 70. Checking spreader/riving knife alignment with blade at the top and bottom.

The spreader/riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in **Figure 71**.

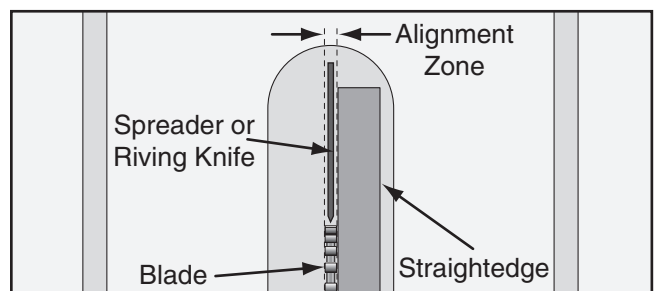


Figure 71. Verifying that spreader/riving knife is in the alignment zone behind the blade.

If the spreader/riving knife is not aligned or parallel with the blade, refer to **Adjusting Mounting Block** on **Page 72**.



Guard Installation & Removal

The guard may need to be removed from the spreader in order to make room to properly adjust the position of the spreader. The guard is secured in place with a mounting screw (see **Figure 72**). Remove the mounting screw to pull the guard off of the spreader.

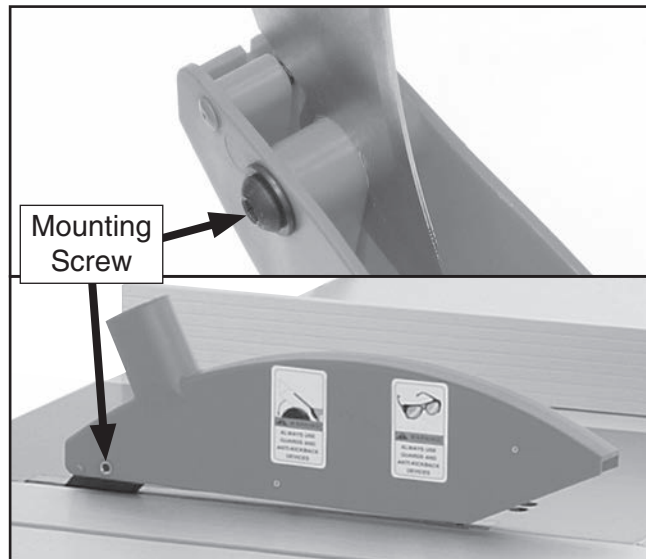


Figure 72. Blade guard mounted to spreader.

When re-installing the guard, the mounting screw must be left loose enough that the guard can freely pivot up and down, but not so loose that there is side-to-side play when pivoting.

Testing Guard for Correct Operation

After installing the blade guard, you must verify that it functions correctly before making a cut. To test the blade guard operation, lift up the front end about 4" then release it.

- If the blade guard freely drops down against the table surface, then it is functioning correctly and is ready for operation.
- If the blade guard remains in the position where you released it, or it does not drop down against the surface of the table, then the mounting screw is too tight. Loosen it a little and repeat this test until the guard functions correctly.
- If the blade guard feels loose and easily moves back and forth as you raise it, then the mounting screw is too loose. Tighten it a little and repeat this test until the guard functions correctly.



Blade Requirements

The riving knives included with this machine are 0.1" (2.5mm) thick and only designed for 12" or 14" diameter blades, respectively.

When choosing a main blade, make sure the blade size meets the requirements listed below. The thickness of the blade body and teeth can be measured with calipers or any precision measuring device.

Blade Size Requirements:

- Body Thickness: 0.09"–0.1" (2.3mm–2.5mm)
- Kerf (Tooth) Thickness: 0.102"–0.128" (2.6mm–3.2mm)

Blade Selection

This section on blade selection is by no means comprehensive. Always follow the saw blade manufacturer's recommendations to ensure safe and efficient operation of your table saw.

Ripping Blade Features:

- Best for cutting with the grain
- 20-40 teeth
- Flat-top ground tooth profile
- Large gullets for large chip removal

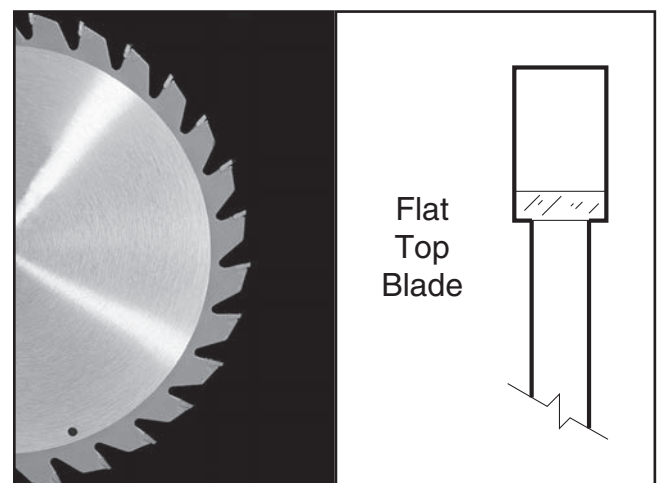


Figure 73. Ripping blade.

Crosscut blade features:

- Best for cutting across the grain
- 60-80 teeth
- Alternate top bevel tooth profile
- Small hook angle and a shallow gullet

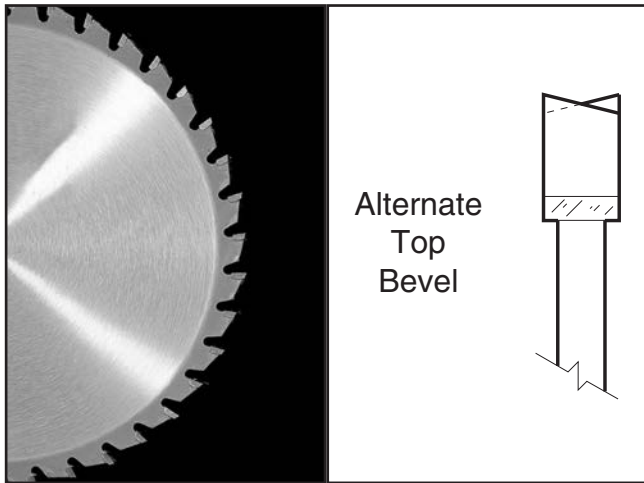


Figure 74. Crosscutting blade.

Laminate blade features:

- Best for cutting plywood or veneer
- 40-80 teeth
- Triple chip tooth profile
- Very shallow gullet

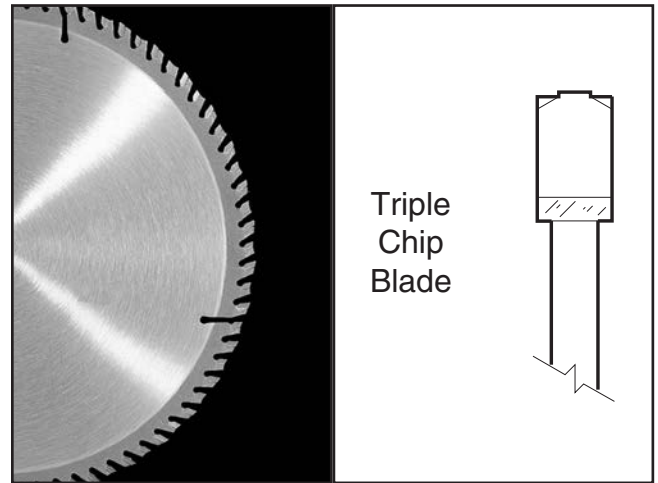


Figure 76. Laminate blade.

Combination blade features:

- Designed to cut both with and across grain
- 40-50 teeth
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile
- Teeth are arranged in groups
- Gullets are small and shallow (similar to a cross-cut blade), then large and deep (similar to a ripping blade)

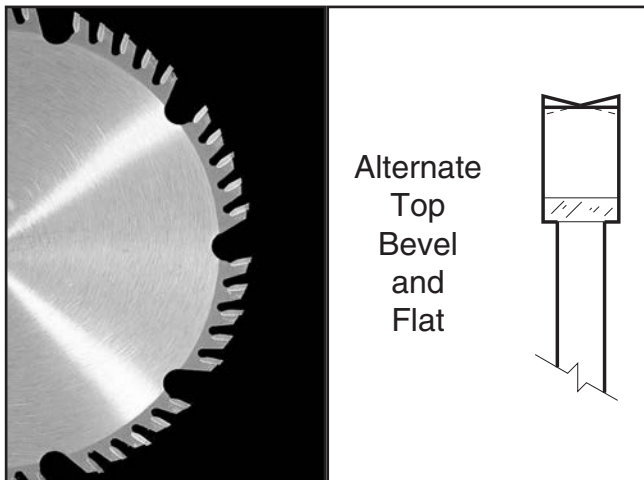


Figure 75. Combination blade.

Thin Kerf Blade: A blade with thinner kerf than a standard blade. Since the spreader/riving knife included with this table saw is sized for standard blades, thin kerf blades cannot be used on this saw unless they meet the **Blade Requirements** specified in this manual; otherwise, they will increase the risk of kickback.



Changing Main Blade

The Model G0493 performs best when using high quality, sharp blades. Whenever the main blade starts to get dull, sharpen or replace it with a new blade.

Any time you change blade size, adjust the riving knife to appropriately to the blade (see **Page 40**).

To change the main blade:

1. DISCONNECT SAW FROM POWER!
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade cover, as shown in **Figure 77**.

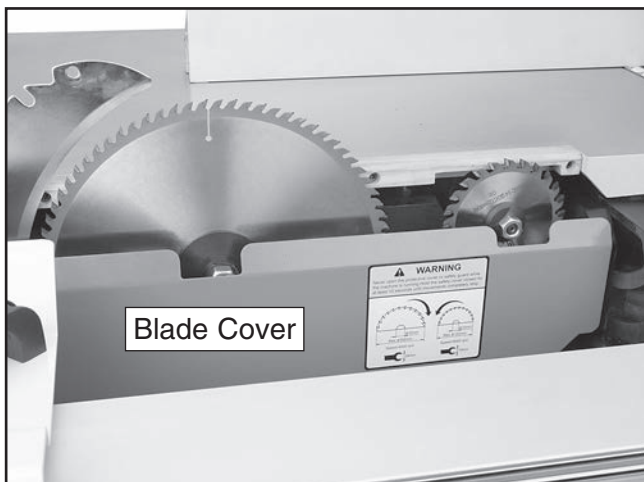


Figure 77. Internal blade cover exposed.

4. Pull the blade cover away from the blades to expose the mounting assembly. (The internal blade cover is held in place with a magnet.)

CAUTION

Before proceeding with the next step, wear gloves to protect your hands while handling and installing the blade.

5. Use the arbor wrenches, as shown in **Figure 78**, to remove the arbor nut and arbor flange, then pull the old blade off the arbor. *The arbor nut has left hand threads and loosens by turning clockwise.*

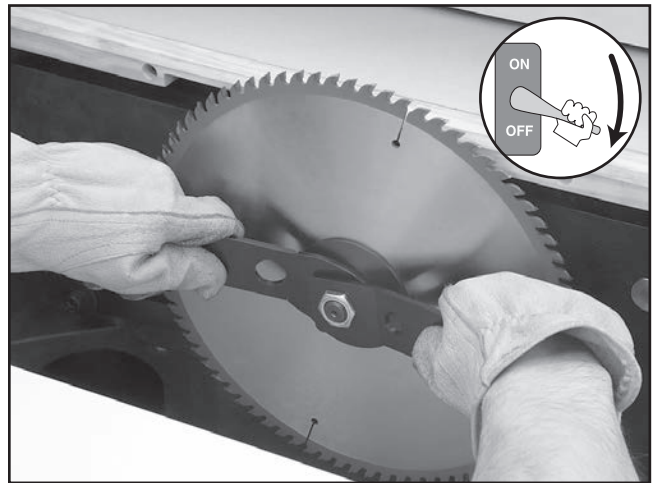


Figure 78. Replacing the main blade.

6. Install the blade as shown in **Figure 79**, making sure the teeth face toward the scoring blade. **DO NOT** overtighten the arbor nut.

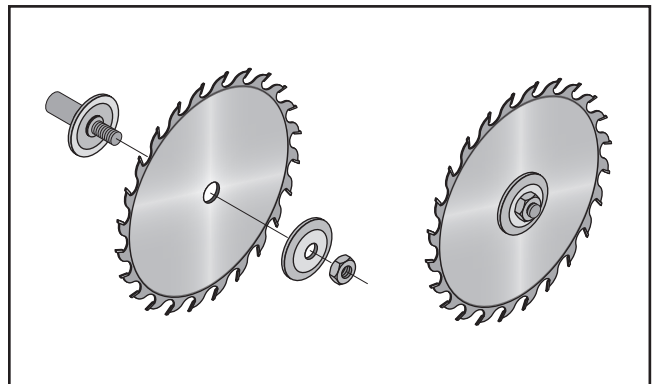


Figure 79. Main blade installation and order of assembly.

— If you changed the diameter of the blade during this procedure, adjust the riving knife the blade.

7. Move the blade cover back into its original position next to the blades, then center the sliding table.



Changing & Adjusting Scoring Blade

The scoring blade included with the Model G0493 has wedge shaped teeth. With this style of scoring blade, the kerf thickness is adjusted by changing the height of the scoring blade. Raising the scoring blade higher increases the kerf thickness.

Changing Scoring Blade

1. DISCONNECT SAW FROM POWER!
2. Move the blade tilt to 0° (blade 90° to table), and raise the scoring blade all the way up.
3. Move the sliding table all the way forward to expose the internal blade cover that covers the blades and riving knife.
4. Pull the blade guard away from the riving knife to expose the mounting assembly. (The internal blade cover is held in place with a magnet.)
5. To remove the scoring blade, use the arbor wrenches to remove the arbor nut and arbor flange (see **Figure 80**). **Note:** *The arbor nut has right-hand threads and loosens by turning counterclockwise.*



Figure 80. Removing the scoring blade.

6. Adjust the width of the scoring blade to equal the kerf thickness of the main blade.

The scoring blade included with the sliding table saw has wedge shaped teeth. The kerf thickness is adjusted by changing the height of the scoring blade until enough of the tooth is exposed to equal the main blade kerf. If you are re-installing this style of blade, adjust the kerf after **Step 7** with the scoring blade vertical adjustment controls.

7. Install the new scoring blade, re-install the arbor flange and the arbor nut, and tighten them against the blade set.
8. Move the blade cover back into its original position next to the blades, then center the sliding table.

Adjusting Scoring Blade

1. DISCONNECT SAW FROM POWER!
2. Place a straightedge across the body of the main blade (not the teeth) and align the body of the scoring blade to the main blade, by turning the horizontal adjustment control shown in **Figure 81**.

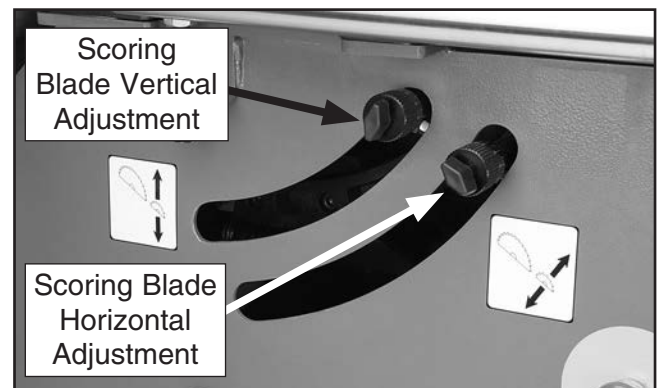


Figure 81. Scoring blade adjustment controls.

2. Adjust the height of the scoring blade, by turning the vertical adjustment control (see **Figure 81**), until the exposed portion equals the kerf thickness of the main blade.
3. Move the blade cover back into its original position, then center the sliding table.
4. Perform a test cut and check for chip-out. If there is chip-out, re-adjust the scoring blade and repeat the test/adjustment until correct.



Rip Cutting

The Model G0493 has the capability of rip cutting full size panels (**Figure 82**). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

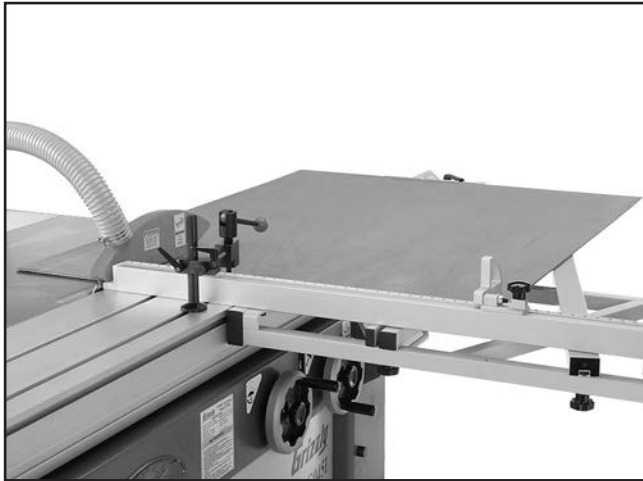


Figure 82. Rip cutting with the sliding table.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (**Figure 83**). Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.



Figure 83. Traditional rip cutting.

Determine which cutting operation will be best suited for the workpiece to be ripped.

—To use the sliding table, read the instructions titled “Rip Cutting w/Sliding Table.”

—To use the machine as a traditional table saw, skip ahead to “Rip Cutting w/Rip Fence.”

Rip Cutting with Sliding Table

1. Drop the crosscut fence into the center stud hole and rotate it until the block shown in **Figure 84** touches the 90° stop bolt.
2. Check to make sure the fence is at 90° and adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 71** if necessary.

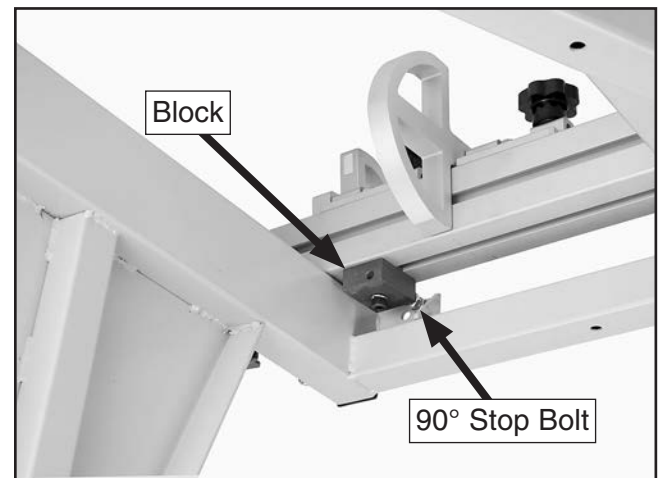


Figure 84. Crosscut fence mounting locations.

3. Slide the protection block next to the blade teeth to calibrate the scale, then tighten the lock knob.

Note: *The scale will not be accurate if the protection block is cut.*

4. Set a flip stop to the desired width-of-cut.
5. Position the blade guard to the correct height for your workpiece.
6. Load the workpiece onto the table saw. The set up should look similar to **Figure 82**.
7. Take all the necessary safety precautions, then perform the cutting operation.



Rip Cutting with Rip Fence

1. Slide the crosscut table out of the way.
2. Lock the sliding table into a stationary position (see **Figure 85**).

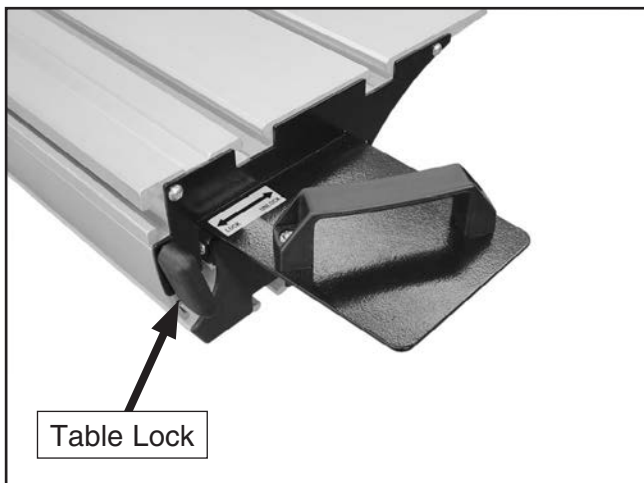


Figure 85. Sliding table lock.

3. Place the fence in the vertical position for larger workpieces, or in the horizontal position for angled cuts and for small workpieces (see **Figure 86**).

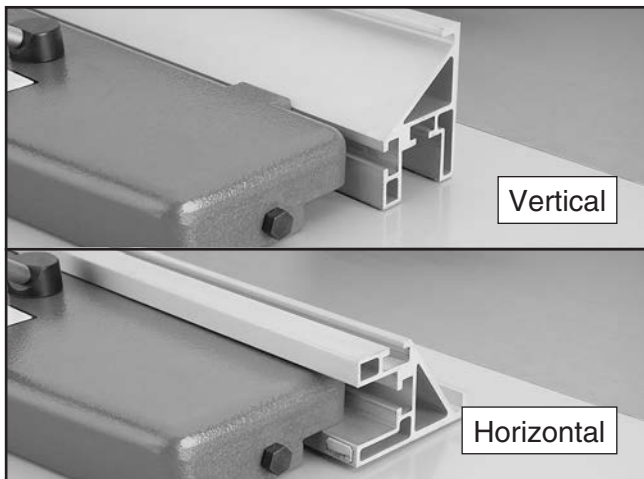


Figure 86. Rip fence positions.

4. Slide the leading end of the rip fence so it is even with the center of the main saw blade as shown in **Figure 87**. **Note:** This technique allows the finished cut-off piece to “fall” away from the blade when the cutting operation is complete; reducing the possibility of kick-back.

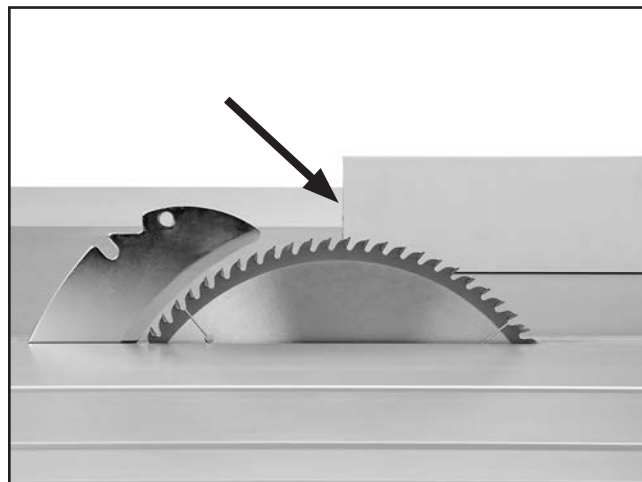


Figure 87. Rip fence even with center of blade (guard removed from spreader for clarity).

5. Lift the lock lever and position the rip fence to approximately the desired width-of-cut.
6. Tighten down the micro-adjust lock knob (**Figure 88**) and turn the micro-adjust knob to zero in on the desired width-of-cut.

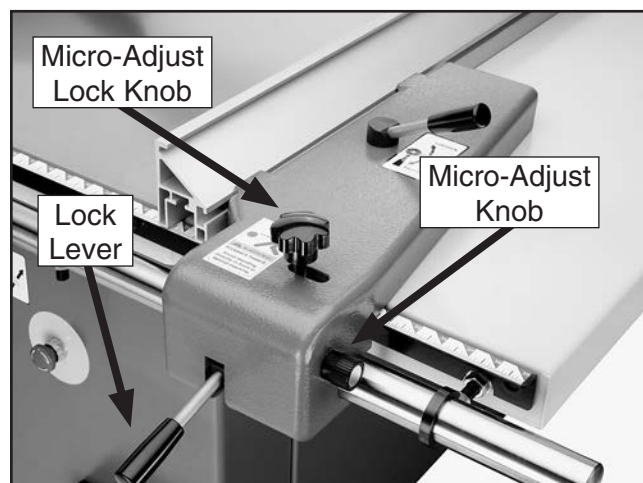


Figure 88. Rip fence micro-adjusting controls.

7. Push down the lock lever, then perform the cutting operation.



Crosscutting

The Model G0493 can crosscut full size panels with the fence in the forward or rear position, although it is easier to load full size panels with the crosscut fence mounted in the forward position (see **Figure 89**).

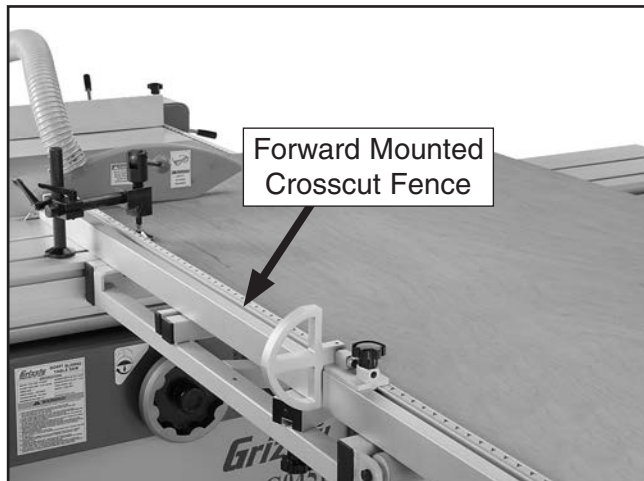


Figure 89. Crosscutting full size panel.

Mounting the crosscut fence in the rear position (**Figure 90**) gives greater stability for crosscutting smaller panels.

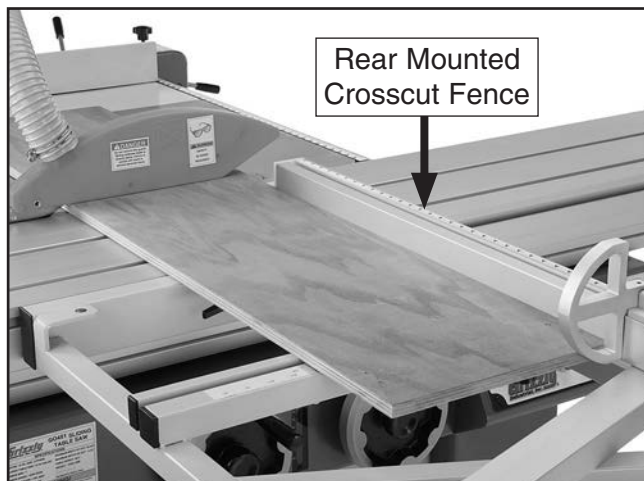


Figure 90. Crosscutting smaller panels.

Lastly, this machine has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge (**Figure 91**).

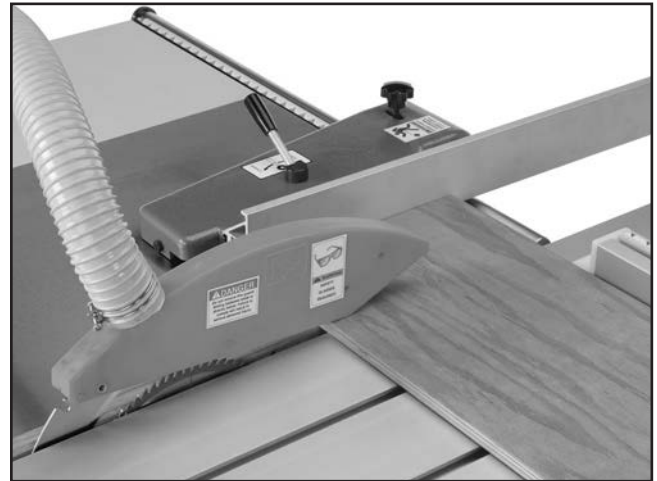


Figure 91. Crosscutting workpieces using the rip fence as a cut-off gauge.

Determine which cutting operation will be best suited for the workpiece to be crosscut.

- If you will be crosscutting full size panels, then skip ahead to “Crosscutting Full Size Panels.”
- If you will be crosscutting smaller panels, then skip ahead to “Crosscutting Smaller Panels.”
- If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to “Crosscutting Using Rip Fence as a Cut-Off Gauge.”



Crosscutting Full Size Panels

1. Install the crosscut fence in the forward mounting location shown in **Figure 92** and lock it in place.
2. Check to make sure the fence is at 90° and adjust it as described in "Squaring Crosscut Fence to Blade" on **Page 71** if necessary.

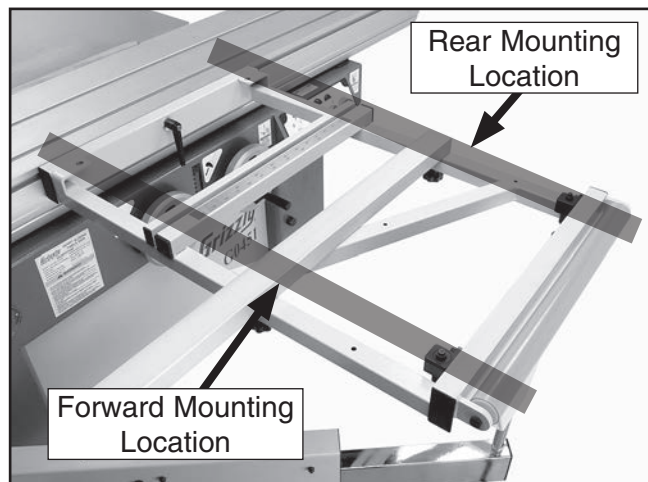


Figure 92. Crosscut fence mounting points.

3. Set either flip stop to the desired width-of-cut. **Note:** *Extend the crosscut fence slide if the workpiece is more than 74".*
4. Load the workpiece onto the table saw. The set up should look similar to **Figure 89**.
5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting Smaller Panels

1. Install the crosscut fence in the rear mounting points shown in **Figure 92** and lock it in place.
2. Check to make sure the fence is at 90° and adjust it as described in "Squaring Crosscut Fence to Blade" on **Page 71** if necessary.
3. Set either flip stop to the desired width-of-cut. **Note:** *Extend the crosscut fence slide if the workpiece is more than 74".*

4. Load the workpiece onto the table saw. The set up should look similar to **Figure 90**.
5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting Using Rip Fence as a Cut-Off Gauge

1. Install the crosscut fence in the rear mounting points shown in **Figure 92** and lock it in place.
2. Check to make sure the fence is at 90° and adjust it as described in **Squaring Crosscut Fence to Blade** on **Page 71** if necessary.
3. Position the rip fence for the desired width.
4. Load the workpiece onto the table saw. The setup should look similar to **Figure 91**.
5. Slide the leading end of the rip fence behind the front edge of the blade as shown in **Figure 93**. (**This step is critical to reduce the risk of blade binding and kickback.**)

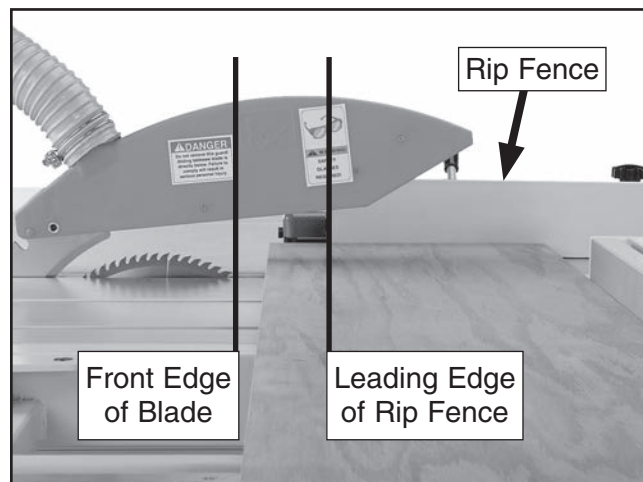


Figure 93. Correct rip fence position when using it as a cut-off gauge.

6. Take all the necessary safety precautions, then perform the cutting operation.



Miter Cutting

The crosscut fence allows miter cuts from 0° through 135°. The table mounted miter scale has a resolution of 1°.

To perform a miter cut:

1. Slide the crosscut table to the front edge of the sliding table and lock it in place.
2. Place the crosscut fence center stud in the center stud hole of the crosscut table. The fence can be installed as shown in **Figure 94** for 90° to 135° cuts, or as shown in **Figure 95** for 0° to 90° cuts.

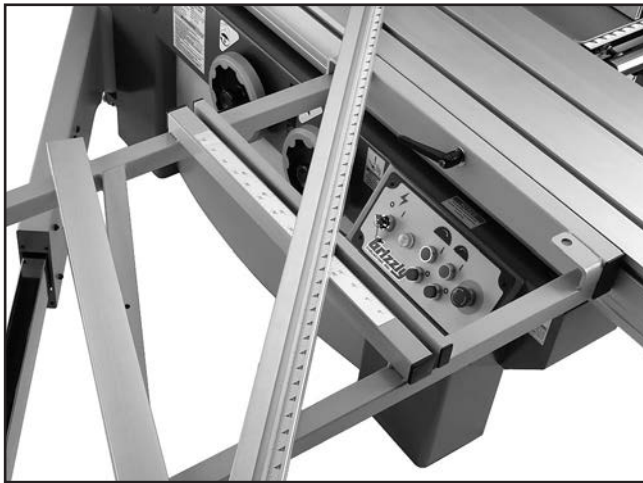


Figure 94. Fence set-up for 90° to 135° cuts.

3. Rotate the fence to the desired angle and use the lock knob to lock the fence in place.
4. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.
5. Load the workpiece onto the table saw. The set up should look similar to **Figure 95**.



Figure 95. Example of miter cutting operation.

6. Once all the necessary safety precautions have been taken, perform the cutting operation.



Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece. Typically, dados can be cut using either a dedicated dado blade or a standard saw blade. **Figure 96** shows a cutaway view of a dado cut being made with a dado blade.

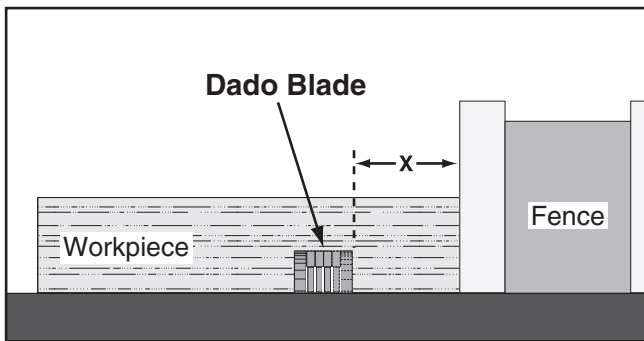


Figure 96. Example of a dado cut with a dado blade.

IMPORTANT: A dado blade cannot be used with this machine; therefore, all dados cut with this machine must be done with a standard blade.

Cutting Dados with Standard Blade

A ripping blade (described on **Page 41**) is typically the best blade to use for cutting dados when using a standard blade, because it removes sawdust very efficiently.

To use a standard saw blade to cut dados:

1. DISCONNECT SAW FROM POWER!
2. Ensure that the riving knife and standard table insert are installed and properly adjusted. Do not use the standard insert if it has lost the zero clearance feature by modification; if so, you must install the optional Model T21879.
3. Mark the width of the dado cut on the workpiece. Include marks on the edge of the workpiece so the cut path can be aligned when the workpiece is lying on the table.
4. Raise the blade up to the desired depth of cut (depth of dado channel desired).

5. Set up the saw for the type of cut you need to make, depending on if it is a rip cut.
6. Align the blade to cut one of the dado sides, as shown in **Figure 97**.

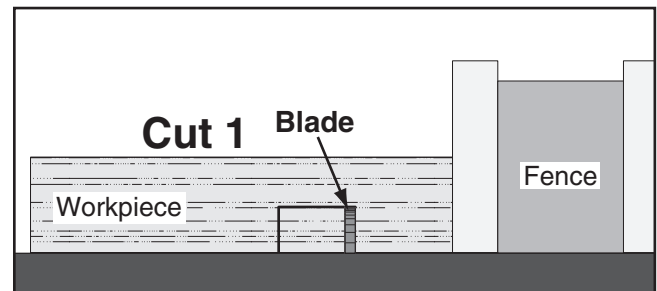


Figure 97. First cut for a single-blade dado.

7. Reconnect the saw to the power source and turn the saw **ON**. Allow the blade to reach full speed, then perform the cutting operation.
8. Repeat the cutting operation on the other side of the dado channel, as shown in **Figure 98**.

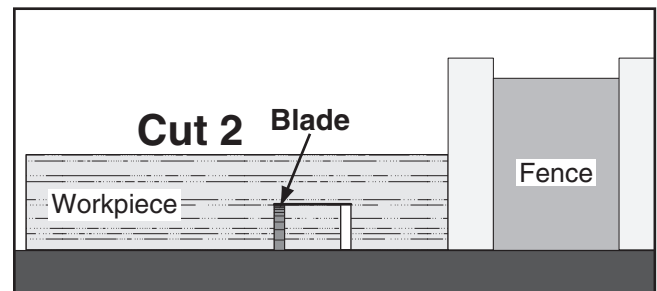


Figure 98. Second cut for a single blade dado.

9. Make additional cuts (see **Figure 99**) in the center of the dado to clear out the necessary material. The dado is complete when the channel is completely cleared out.

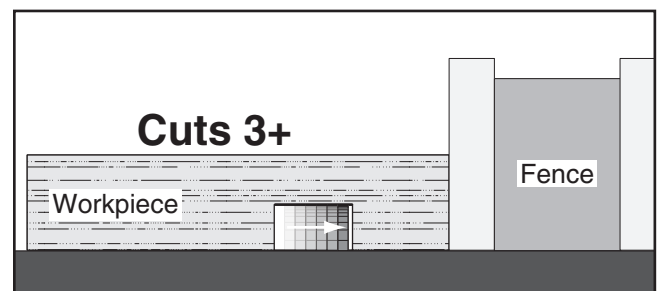


Figure 99. Additional single blade dado cuts.



Rabbet Cutting

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece. Typically, rabbets can be cut with either a dado blade or a standard saw blade; however, because the Model G0453 cannot accept dado blades, rabbets must be cut with a standard saw blade only.

⚠ CAUTION

Always use push sticks, featherboards, push paddles and other safety accessories whenever possible to increase safety and control during operations which require that the blade guard be removed from the saw. ALWAYS replace the blade guard after the operation is complete.

Cutting Rabbets with a Standard Blade

A ripping blade is typically the best blade to use for cutting rabbets when using a standard blade because it removes sawdust very efficiently. (See **Page 41** for blade details.) Also, a sacrificial fence is not required when cutting rabbets with a standard blade.

To cut rabbets with the standard blade:

1. DISCONNECT SAW FROM POWER!
2. Ensure that the riving knife and standard table insert are installed.
3. Mark the width of the rabbet cut on the edge of the workpiece, so you can clearly identify the intended cut while it is laying flat on the saw table.
4. Raise the blade up to the desired depth of cut (depth of rabbet channel desired).
5. Stand the workpiece on edge, as shown in **Figure 100**, then adjust the fence so the blade is aligned with the inside of your rabbet channel.

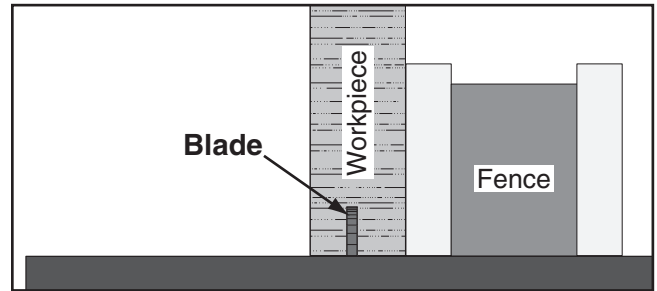
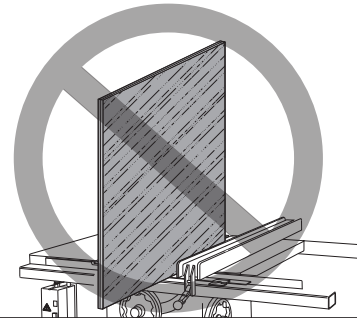


Figure 100. Rabbet cutting with a standard blade.

⚠ WARNING



DO NOT place a tall board on edge when cutting a rabbet. Overly tall workpieces cannot be properly supported with the fence and can easily shift during operation, causing kickback or loss of control. Instead, use another tool to cut these types of rabbets.

6. Reconnect the saw to the power source, then perform the cut.
7. Lay the workpiece flat on the table, as shown in **Figure 101**, adjust the saw blade height to intersect with the first cut, then perform the second cut to complete the rabbet.

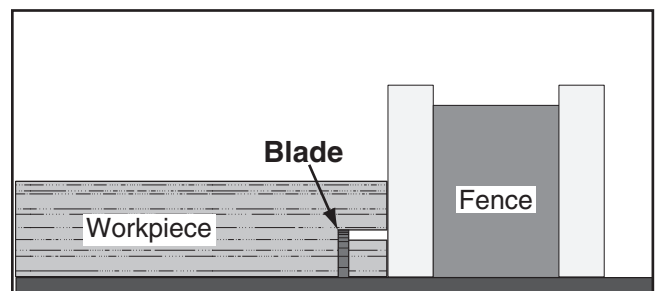


Figure 101. Second cut to create a rabbet.



Resawing

!WARNING

Resawing operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when resawing. Any tilting or movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

Resawing is the process of cutting a thick piece of stock into one or more thinner pieces. Although resawing can be done with a table saw, we strongly recommend that you use a bandsaw instead.

A bandsaw is the ideal machine for resawing, and resawing with one is fairly easy and safe. A table saw is not intended for resawing, and resawing with one is difficult and dangerous due to the increased risk of kickback from binding and deep cuts, and the increased risk of injury from having to remove the guard.

If you insist on resawing with a table saw, DO NOT do so without using a resaw barrier and wearing a full face shield. The following instructions describe how to build a resaw barrier.

IMPORTANT: This table saw can only resaw wood that is less than 8" tall, and the rip fence must be used (rather than the sliding table).

Making Resaw Barrier

The resaw barrier acts in tandem with the rip fence when resawing to provide tall support for the workpiece to minimize the probability of it binding against the blade and causing kickback.

Tools Needed:

	Qty
Table Saw	1
Jointer and Planer	Recommended
Clamps	2 Minimum
Drill and Drill Bits.....	1

Components Needed for Resaw Barrier:

Wood* $\frac{3}{4}$ " x $7\frac{1}{2}$ " x (Length of Fence).....	1
Wood* $\frac{3}{4}$ " x 3" x (Length of Fence).....	1
Wood Screws #8 x 2"	4
Wood Glue	As Needed

* Only use furniture grade plywood, kiln dried hardwood, or HDPE plastic to prevent warping.

To build the resaw barrier:

1. Cut your wood pieces to the size specified above. If you are using hardwood, cut the pieces oversize, then joint and plane them to the correct size to make sure they are square and flat.
2. Pre-drill and countersink four holes approximately $\frac{3}{8}$ " from the bottom of the $7\frac{1}{2}$ " tall wood piece.
3. Glue the end of the 3" board, then clamp the boards at a 90° angle with the larger board in the vertical position, as shown in **Figure 102**, then fasten together with the wood screws.

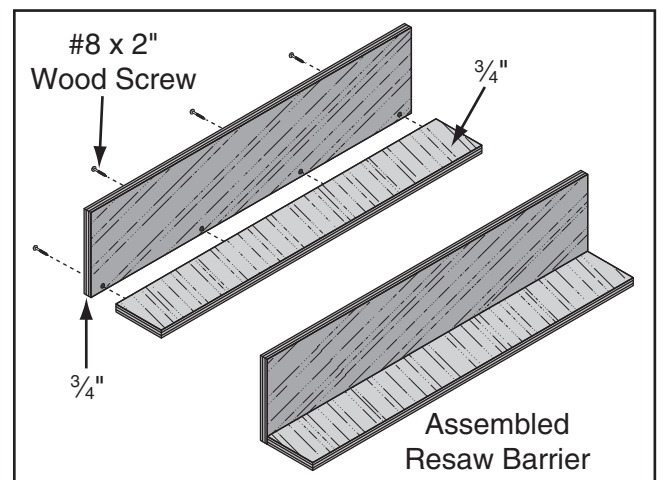


Figure 102. Resaw barrier.



Resawing Operations

The table saw motor is pushed to its limits when resawing. If the motor starts to bog down, slow down your feed rate. Motor overloading and blade wear can be reduced by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.

Components Needed for Resawing:

Ripping Blade	1
Clamps	2
Shop Made Resaw Barrier	1

!WARNING

You may experience kickback during this procedure. Stand to the side of the blade path and wear safety glasses or a face shield to prevent injury.

To perform resawing operations:

1. DISCONNECT SAW FROM POWER!
2. Install the rip fence in the vertical position, and remove the blade guard so only the riving knife will be used during the cut.
3. Place the workpiece against the rip fence and slide the resaw barrier against the workpiece. Now clamp the resaw barrier to the top of the table saw (see **Figure 103**).

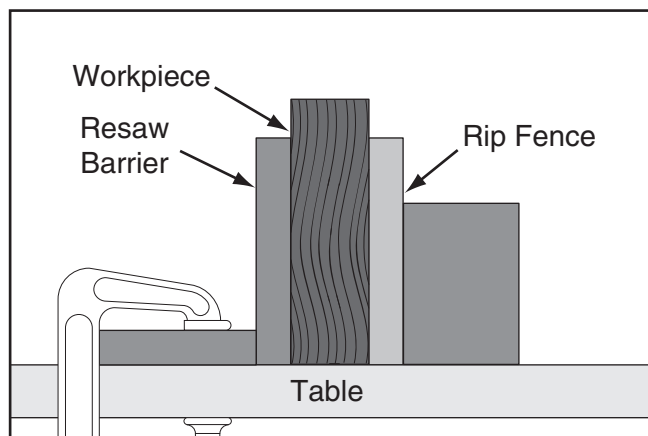


Figure 103. Resaw setup.

4. Lower the blade completely below the table, and slide the workpiece over the blade to make sure it moves smoothly and fits between the resaw barrier and fence.

5. Raise the blade approximately an inch, or close to half the height of the workpiece, whichever is less.

!WARNING

Operations requiring the blade guard to be removed increase the risk of accidental contact with the blade. To reduce this risk, use push sticks/paddles and featherboards to keep your hands at a safe distance from the blade throughout the entire cut. Always replace guard after completing the cut!

6. Plug in the table saw, turn it **ON**, and use a push stick to feed the workpiece through the blade using a slow, steady feed rate.
7. Flip the workpiece end for end, keeping the same side against the fence, and run the workpiece through the blade.
8. Repeat **Steps 4–6** until the blade is close to half of the height of the board to be resawn. The ideal completed resaw cut will leave a $\frac{1}{8}$ " connection when the resawing is complete as shown in **Figure 103**. Leaving a $\frac{1}{8}$ " connection will reduce the risk of kickback.

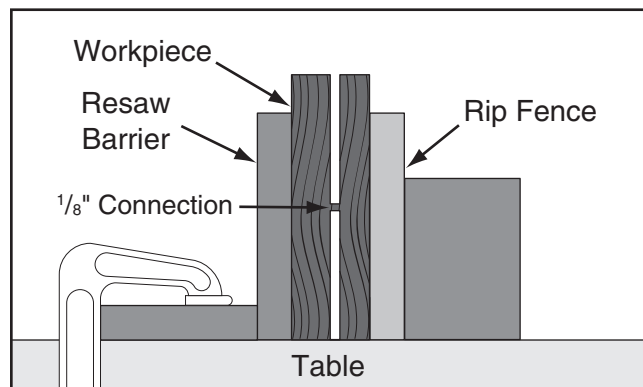


Figure 104. Resaw cut completed.

9. Turn **OFF** the table saw, then separate the parts of the workpiece and hand plane the remaining ridge.
10. When finished resawing, remove the resaw barrier and re-install the blade guard.



SECTION 5: SHOP MADE SAFETY ACCESSORIES

Featherboards

Easily made from scrap stock, featherboards provide an added degree of protection against kickback, especially when used together with push sticks. They also maintain pressure on the workpiece to keep it against the fence or table while cutting, which makes the operation easier and safer because the cut can be completed without the operator's hands getting near the blade. The angled ends and flexibility of the fingers allow the workpiece to move in only one direction.

Making a Featherboard

This sub-section covers the two basic types of featherboards: 1) Those secured by clamps to the table or fence, or 2) those secured by a wood runner that mounts in the table saw miter slot.

Material Needed for Featherboard Mounted with Clamps

- Hardwood $\frac{3}{4}$ " x 3" x 10" (Minimum)
- Hardwood $\frac{3}{4}$ " x 6" x 28" (Maximum) 1

Material Needed for Featherboard Mounted in Miter Slot

- Hardwood $\frac{3}{4}$ " x 3" x 10" (Minimum)
- Hardwood $\frac{3}{4}$ " x 6" x 28" (Maximum) 1
- Hardwood $\frac{3}{8}$ " x (Miter Slot Width) x 5"L 1
- Wing Nut $\frac{1}{4}$ "-20..... 1
- Flat Head Screw $\frac{1}{4}$ "-20 x 2" 1
- Flat Washer $\frac{1}{4}$ "-20..... 1

To make a featherboard:

1. Cut a hardwood board approximately $\frac{3}{4}$ " thick to size. The length and width of the board can vary according to your design. Most featherboards are 10"–28" long and 3"–6" wide. Make sure the wood grain runs parallel with the length of the featherboard, so the fingers you will create in **Step 3** will bend without breaking.

2. Cut a 30° angle at one end of the board.
3. Make a series of end cuts with the grain $\frac{3}{8}$ "– $\frac{1}{4}$ " apart and 2"–3" long, as shown in **Figure 105 (A)**. Alternatively, start cuts at 2"–3" deep, then make them progressively deeper, as shown in **Figure 105 (B)**. Cuts made across the grain will result in weak fingers that will easily break.

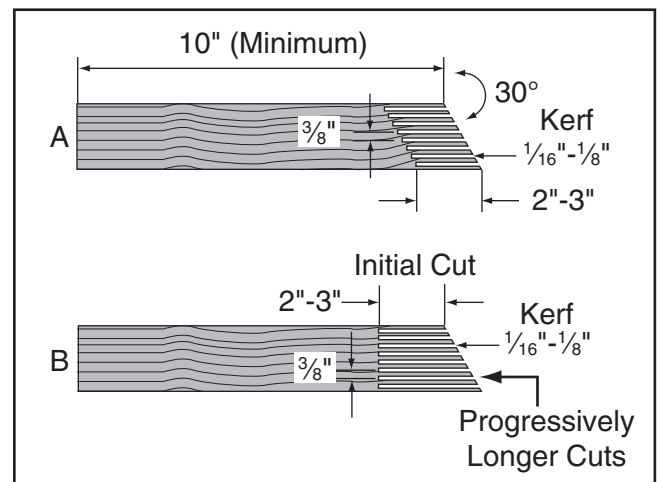


Figure 105. Patterns for featherboards (top view shown).

When complete, the fingers should flex when pushed with moderate pressure. If the fingers do not flex, they are too thick.

Note: We recommend using a bandsaw for making fingers because it tends to be safer. A table saw can be used, but it will over-cut the underside of the ends, produce a thicker kerf, and require you to stop the blade half-way through the cut, which can be dangerous.

If you are securing the featherboard with clamps, no further steps are necessary. Your featherboard is complete! If you are making a featherboard that mounts in the miter slot, continue with **Step 4**.



4. Rout a $\frac{1}{4}$ "– $\frac{3}{8}$ " wide slot 4"–5" long in the workpiece and 1"–2" from the short end of the featherboard (see **Figure 106**).

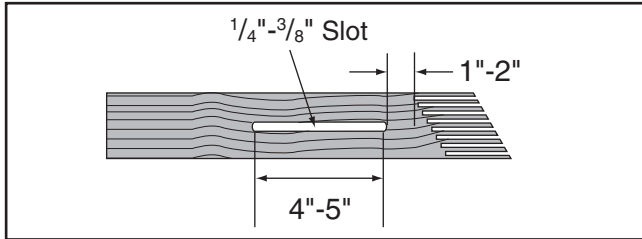


Figure 106. Slot routed in featherboard.

5. Cut a miter bar that will fit in the table miter slot approximately 5" long, as shown in **Figure 107**.

Tip: Consider making the miter bar longer for larger featherboards—approximately half the length of the total featherboard—to support the force applied to the featherboard during use.

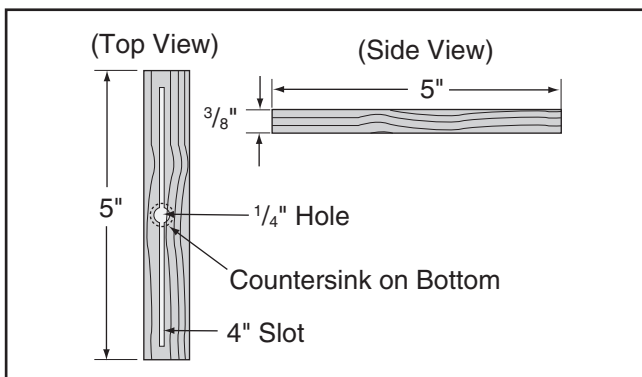


Figure 107. Miter bar pattern.

6. Drill a $\frac{1}{4}$ " hole in the center of the bar, then countersink the bottom to fit a $\frac{1}{4}$ "-20 flat head screw.
7. Mark a 4" line through the center of the countersunk hole in the center, then use a jig saw with a narrow blade to cut it out.
8. Assemble the miter bar and featherboard with a $\frac{1}{4}$ "-20 x flat head screw, flat washer, and a wing nut or a star knob (see **Figure 108**). Congratulations! Your featherboard is complete.

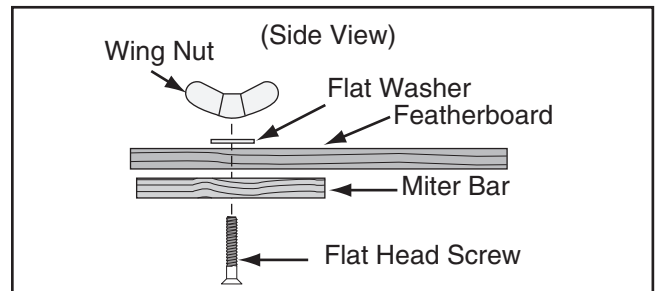


Figure 108. Assembling miter slot featherboard components.

Tip: The length of the flat head screw depends on the thickness of the featherboard—though $1\frac{1}{2}$ " to 2" lengths usually work.

Now, proceed to **Mounting Featherboard in Miter Slot** on **Page 56**.



Mounting Featherboards w/Clamps

1. Lower the saw blade, then adjust the fence to the desired width and secure it.
2. Place the workpiece against the fence, making sure it is 1" in front of the blade.
3. Place a featherboard on the table away from the blade so all fingers point forward and contact the workpiece (see **Figure 109**).

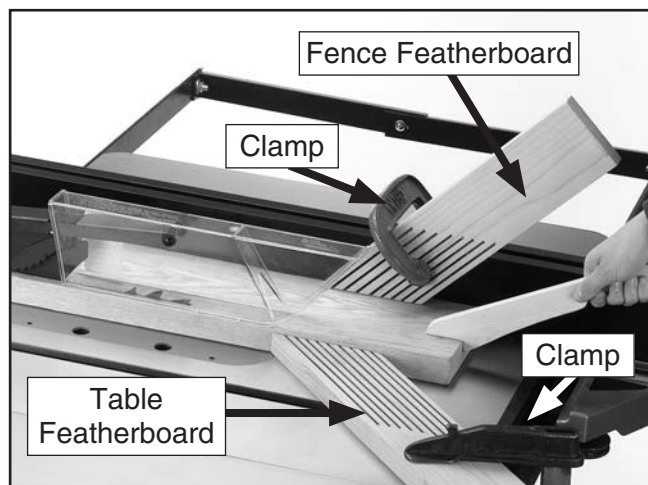


Figure 109. Example of featherboards secured with clamps.

4. Secure the featherboard to the table with a clamp.
5. Check the featherboard by pushing it with your thumb to ensure it is secure.
—If the featherboard moves, tighten the clamp more.
6. Mount a second featherboard to the fence with another clamp (see **Figure 109**), then repeat **Step 5** to ensure it is secure.

Mounting Featherboard in Miter Slot

1. Lower the saw blade, then adjust the fence to the desired width and secure it.
2. Place the workpiece evenly against the fence, making sure it is 1" in front of the blade.
3. Slide the featherboard miter bar into the miter slot, making sure the fingers slant toward the blade, as shown in **Figure 110**.

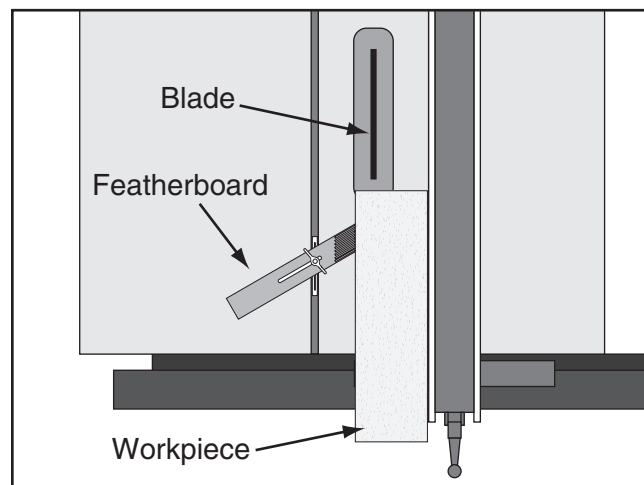


Figure 110. Featherboard installed in miter slot and supporting workpiece for ripping cut.

4. Position the fingered edge of the featherboard against the edge of the workpiece, so that all of the fingers contact the workpiece. Slide the featherboard toward the blade until the first finger is nearly even with the end of the workpiece, which should be 1" away from the blade.
5. Double check the workpiece and the featherboard to ensure they are properly positioned as described in **Step 4**. Then secure the featherboard to the table. Check the featherboard by hand to make sure it is tight.

Note: *The featherboard should be placed firmly enough against the workpiece to keep it against the fence but not so tight that it is difficult to feed the workpiece.*



Push Sticks

When used correctly, push sticks reduce the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push stick can also absorb damage that would have otherwise happened to hands or fingers.

Using a Push Stick

Use push sticks whenever your hands will get within 12" of the blade. To maintain control when cutting large workpieces, start the cut by feeding with your hands then use push sticks to finish the cut, so your hands are not on the end of the workpiece as it passes through the blade.

Feeding: Place the notched end of the push stick against the end of the workpiece (see inset **Figure** below), and move the workpiece into the blade with steady downward and forward pressure.

Supporting: A second push stick can be used to keep the workpiece firmly against the fence while cutting. When using a push stick in this manner, only apply pressure before the blade; otherwise, pushing the workpiece against or behind the blade will increase the risk of kickback (see "Push Stick Prohibition Zone" in the **Figure** below).

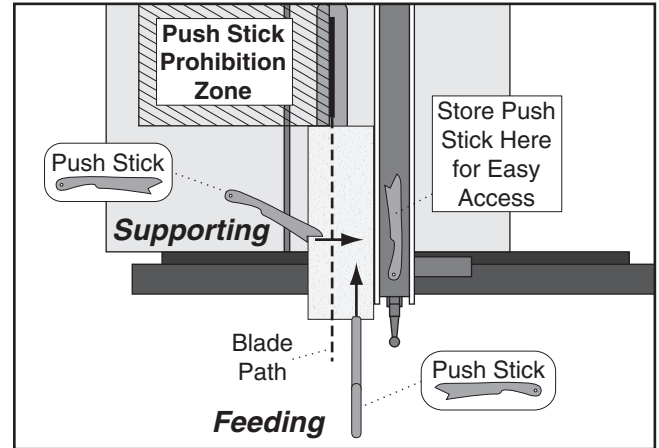


Figure 111. Using push sticks to rip narrow stock.

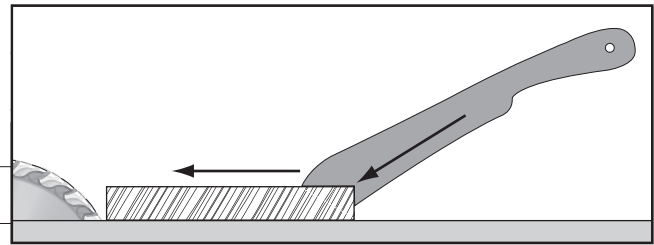
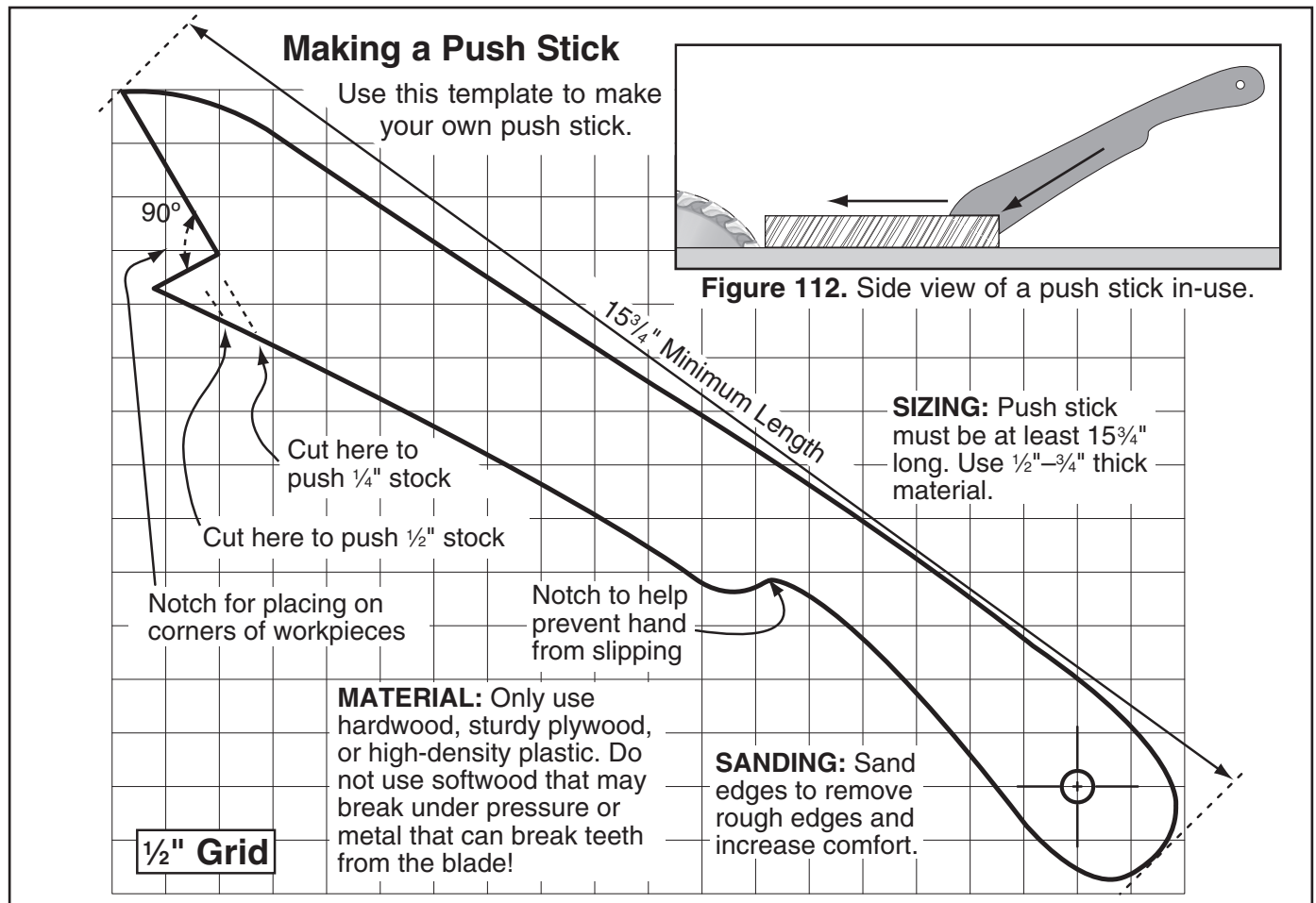


Figure 112. Side view of a push stick in-use.

Figure 113. Template for a basic shop-made push stick (not shown at actual size).



Push Blocks

When used correctly, a push block reduces the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push block often takes the damage that would have otherwise happened to hands or fingers.

Using a Push Block

A push block can be used in place of or in addition to a push stick for feeding workpieces into the blade. Due to their design, push blocks allow the operator to apply firm downward pressure on the workpiece that could not otherwise be achieved with a push stick.

The push block design on this page can be used in two different ways (see inset **Figure** below). Typically, the bottom of the push block is used until the end of the workpiece reaches the blade.

The notched end of the push block is then used to push the workpiece the rest of the way through the cut, keeping the operator's hands at a safe distance from the blade. A push stick is often used at the same time in the other hand to support the workpiece during the cut (see "Using a Push Stick" on previous page).

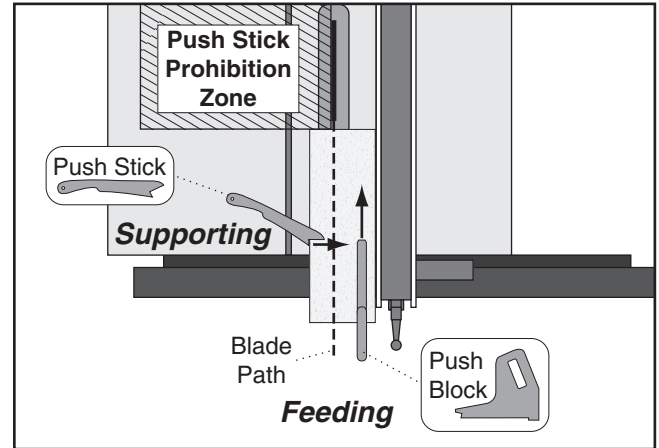


Figure 115. Using a push block and push stick to make a rip cut.

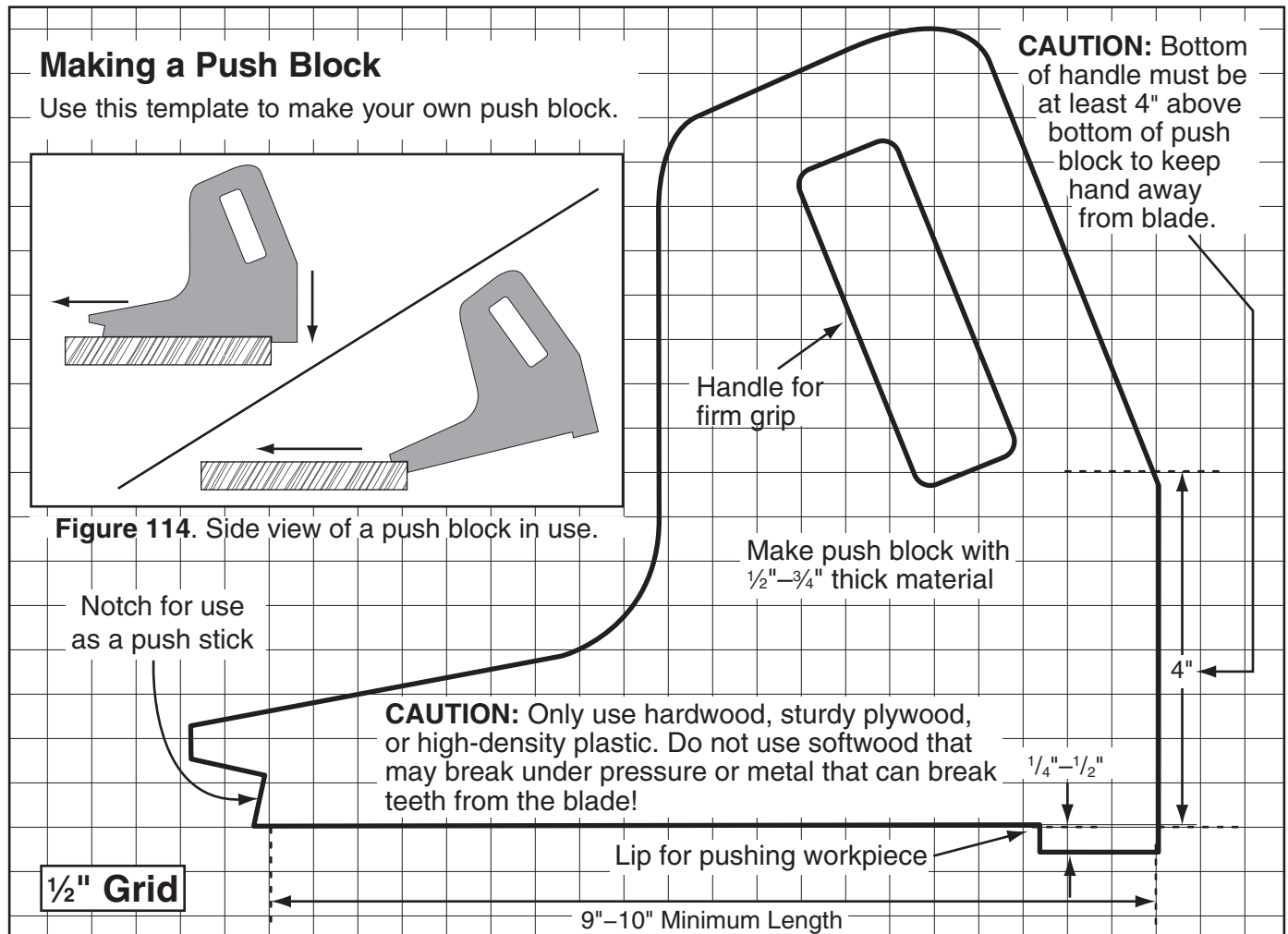


Figure 116. Template for a shop-made push block (shown at 50% of full size).



Narrow-Rip Auxiliary Fence & Push Block

There are designs for hundreds of specialty jigs that can be found in books, trade magazines, and on the internet. These types of jigs can greatly improve the safety and consistency of cuts. They are particularly useful during production runs when dozens or hundreds of the same type of cut need to be made.

The narrow-rip auxiliary fence and push block system shown in this section is an example of a specialty jig that can be made to increase the safety of very narrow rip cuts.

Material Needed for Narrow Rip Auxiliary Fence & Push Block

Hardwood $\frac{3}{4}$ " x 3" x Length of Fence 1
 Plywood $\frac{3}{4}$ " x $5\frac{1}{4}$ " x Length of Fence 1
 Wood Screws #8 x $1\frac{1}{2}$ " 8

Material Needed for Push Block

Hardwood or Plywood $\frac{3}{4}$ " x 15" x $5\frac{5}{8}$ " 1
 Hardwood or Plywood $\frac{3}{4}$ " x 10" x 5"–9" 1
 Cyanoacrylate Wood Glue Varies
 Wood Screws #8 x $1\frac{1}{2}$ " As Needed

Making a Narrow-Rip Push Block for an Auxiliary Fence

1. Cut a piece of $\frac{3}{4}$ " thick plywood $5\frac{1}{4}$ " wide and as long as your table saw fence; cut a piece of $\frac{3}{4}$ " thick hardwood 3" wide and as long as your table saw fence, as shown in **Figure 117**.

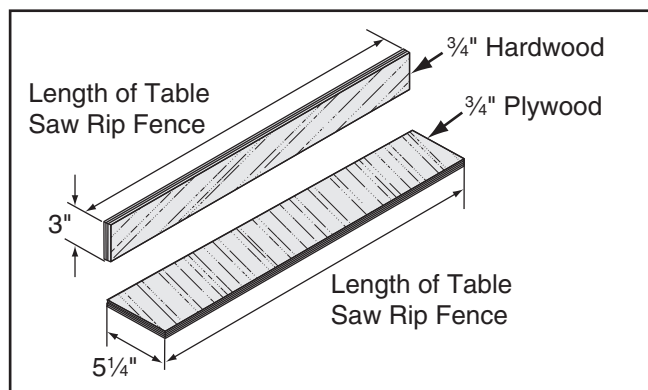


Figure 117. Auxiliary fence dimensions.

Note: We recommend cutting the hardwood board oversize, then jointing and planing it to the correct size to make sure the board is square and flat. Only use furniture grade plywood or kiln dried hardwood to prevent warping.

2. Pre-drill and countersink eight pilot holes $\frac{3}{8}$ " from the bottom of the 3" wide board, then secure the boards together with eight #8 x $1\frac{1}{2}$ " wood screws, as shown in **Figure 118**.

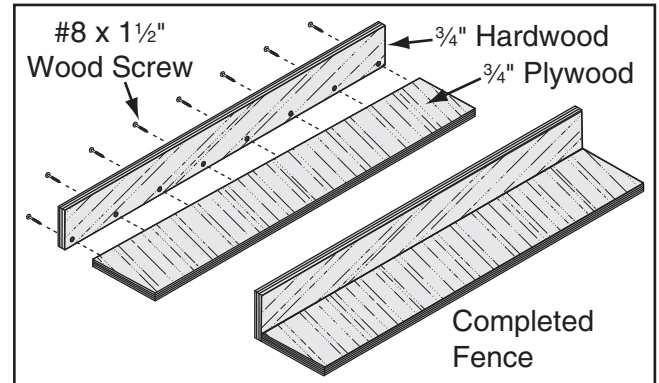


Figure 118. Location of pilot holes.

3. Using the $\frac{3}{4}$ " material you used in the previous steps, cut out pieces for the push block per the dimensions shown in **Figure 119**; for the handle, cut a piece 10" long by 5"–9" high and shape it as desired to fit your hand.

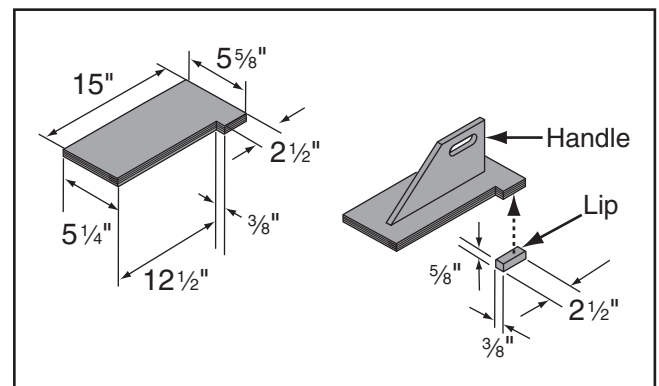


Figure 119. Push block dimensions and construction.

4. Attach the handle to the base with #8 x $1\frac{1}{2}$ " wood screws, and attach the lip to the base with cyanoacrylate type wood glue.



Using the Auxiliary Fence and Push Block

1. Place the auxiliary fence on the table and clamp it to the fence at both ends, then adjust the distance between the auxiliary fence and the blade—this determines how wide the workpiece will be ripped (see **Figure 120**).

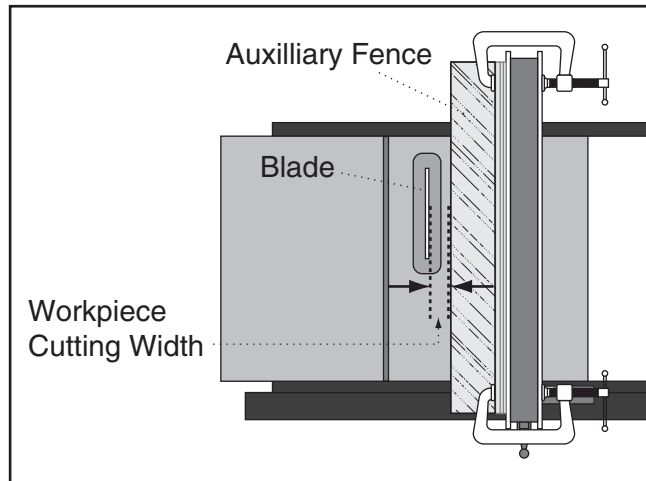
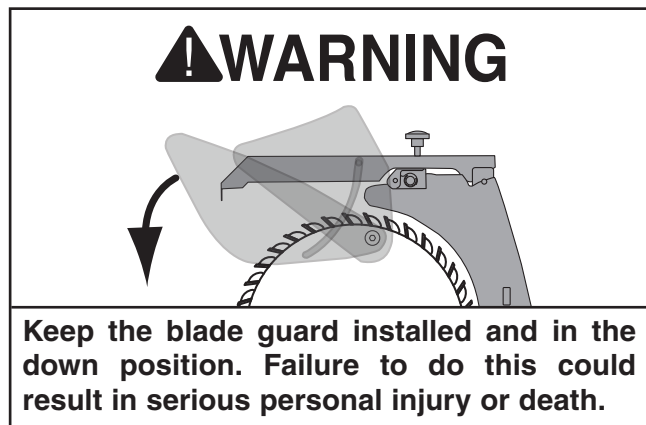


Figure 120. Adjusting ripping distance between blade and auxiliary fence.

2. Install the blade guard.



3. Place the workpiece 1" behind the blade and evenly against the table and the auxiliary fence.

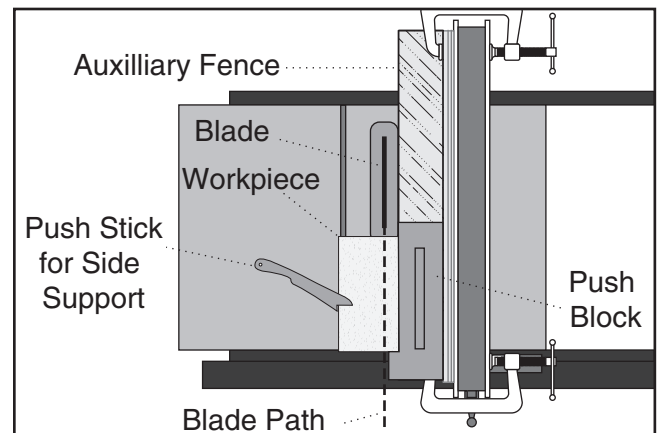


Figure 121. Push block in position to push workpiece through blade.

4. Turn the saw **ON**, then begin ripping the workpiece using a push stick for side support.

As the workpiece nears the end of the cut, place the push block on the auxiliary fence with the lip directly behind the workpiece, then release the push stick just before it is even with the blade (see **Figure 122**).

Guide the workpiece the rest of the way through the cut with the push block.

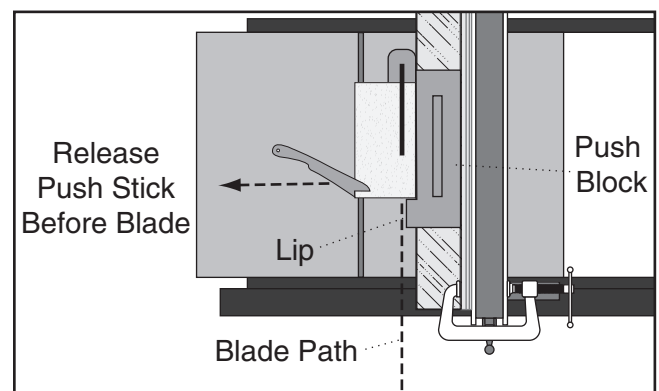


Figure 122. Ripping with push block.

! WARNING

Turn the saw **OFF** and allow the blade to come to a complete stop before removing the cut-off piece. Failure to follow this warning could result in serious personal injury.



SECTION 6: AFTERMARKET ACCESSORIES FROM GRIZZLY

⚠️ WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

H7833—Fully Enclosed Blade Guard

This fully enclosed blade guard was specially designed for the Model G0493, and dramatically improves dust collection over the standard dust hood. This is important if the saw will be used for cutting a lot of OSB, MDF, or other engineered sheet goods that contain formaldehyde or other VOC's, which can result in more toxic dust than natural wood alone. Proper collection of this dust is especially important in workplace settings where exposure occurs daily. Includes a sturdy mounting arm constructed from steel tube and 2.5" dust port for superb dust collection.



Figure 123. H7833 fully enclosed blade guard for Model G0493.

H3388—14" Carbide Tipped Saw Blade, 80T

H3389—14" Carbide Tipped Saw Blade, 100T

These blades are designed especially for sliding table saws and manufactured for heavy-duty use.



Figure 124. Carbide-tipped saw blade.

H4935—Stackable Scoring Blade Set

The scoring blade set consists of an inner and outer blade and four internal shims. Two shims are 0.008" thick and two are 0.004". The shims are provided so the scoring blade set can match the kerf thickness of the main blade.

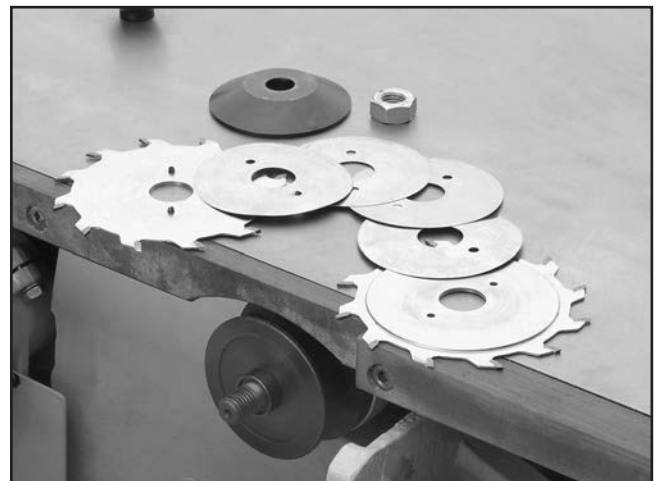


Figure 125. H4935 Scoring Blade Set.



- 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 126. Recommended products for protecting unpainted cast iron/steel part on machinery.

- H2499—Small Half-Mask Respirator
 - H3631—Medium Half-Mask Respirator
 - H3632—Large Half-Mask Respirator
 - H3635—Disposable Cartridge Filter Pair P100
- Wood dust is now considered a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 127. Half-mask respirator and disposable cartridge filters.

- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20452—"Kirova" Anti-Reflective S. Glasses
- T20451—"Kirova" Clear Safety Glasses
- H0736—Shop Fox® Safety Glasses
- H7194—Bifocal Safety Glasses 1.5
- H7195—Bifocal Safety Glasses 2.0
- H7196—Bifocal Safety Glasses 2.5



Figure 128. Eye protection assortment.

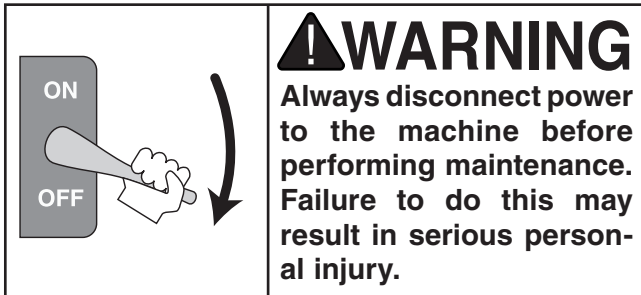
- H8003—Hydraulic Lifting Table - 450 lbs.
- This rugged and affordable lifting table allows you to lift stacks of sheet goods right up to the table saw table with minimal effort. Features 39³/₈" x 19³/₄" table, 39¹/₂" maximum table height, 8" fixed and swivel casters with brakes.



Figure 129. Model H8003 Hydraulic Lifting Table.



SECTION 7: MAINTENANCE



Schedule

The frequency of maintenance necessary for any machine will always depend on the operating conditions and environment. The schedule below is a basic guideline for keeping your machine in proper operating condition. Always repair any adverse conditions immediately upon discovery.

Daily (Ongoing)

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

Weekly

- Clean sliding table surface and grooves.
- Lubricate sliding table ways (**Figure 130**).
- Clean the cast iron saw table.
- Clean the sliding table roller guideways.
- Clean the rip fence.
- Clean the rip fence bracket and rail.

Monthly

- Clean/vacuum dust buildup from inside cabinet and off motor.
- Check V-belt tension, damage, or wear.

Every 6–12 Months

- Lubricate the trunnions (**Page 64**).
- Lubricate the elevation and tilt leadscrews (**Page 64**).

Note: To ensure optimum power transmission from the motor to the blades, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension.

Cleaning

Cleaning the Model G0493 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. Use compressed air to blow dust from between the two sections of the sliding table. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. DO NOT clean cast iron with water or it will rust!

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



Lubrication

The bearings are sealed and pre-lubricated and require no lubrication during their usable life. However, your saw components will operate at their best if the bearing surfaces are kept clean—this is especially important for the trunnion bearings. ALWAYS DISCONNECT POWER BEFORE DOING MAINTENANCE!

Lubricate the areas indicated below with general purpose grease every 6–12 months, depending on frequency of use (see Figure 131):

- Blade Angling Trunnions (can be accessed from front of machine)
- Bevel Gears and Leadscrew
- Blade Height Trunnion

Sliding Table Ways: Spray or wipe on a light machine oil (such as those shown on **Page 62**) the entire length of the steel rods (see **Figure 130**).



Figure 130. Sliding table ways.

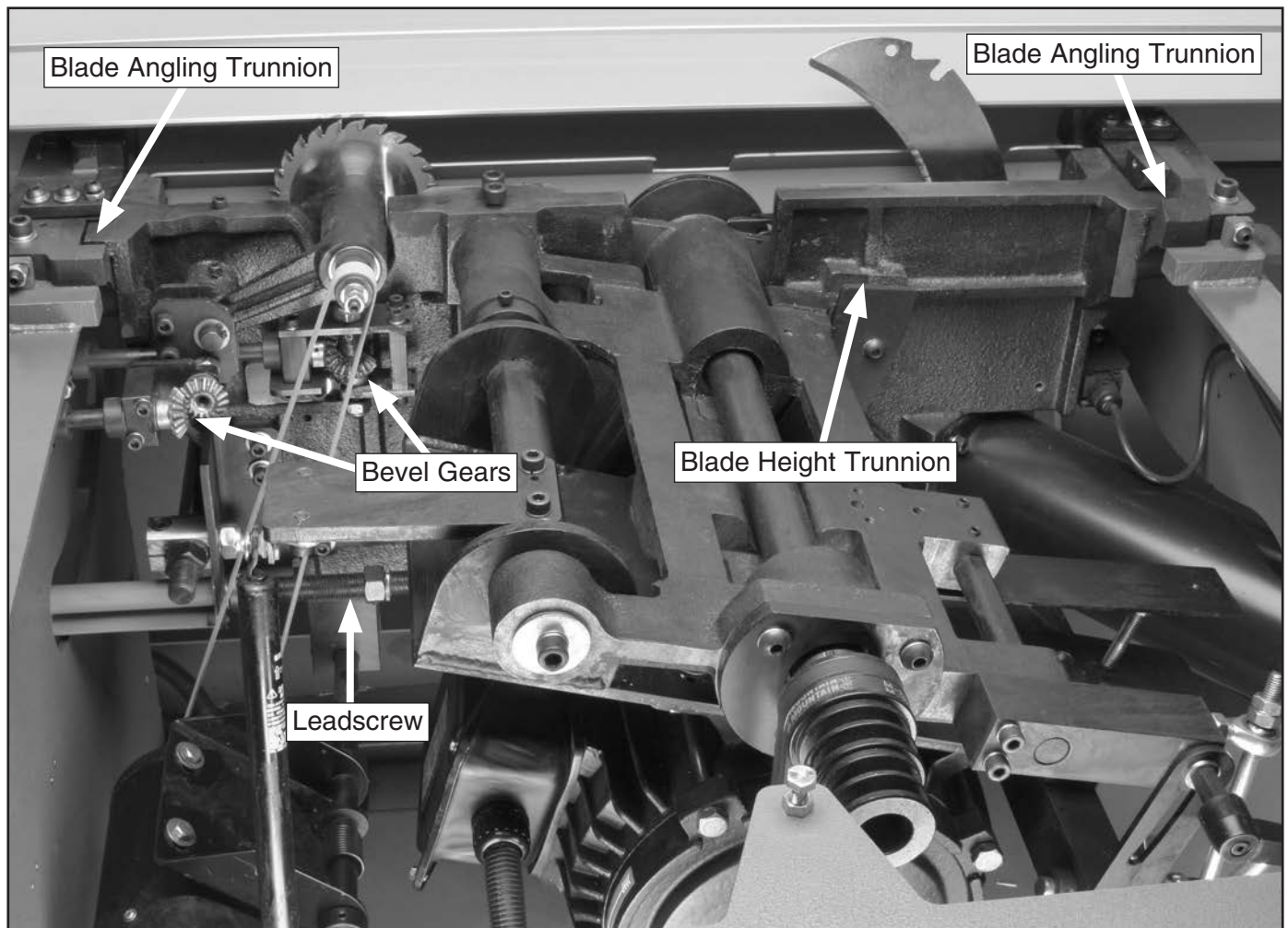


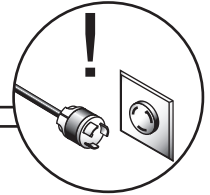
Figure 131. Lubrication locations (table removed for clarity).



SECTION 8: 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	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Switch disabling key is removed. 2. Emergency stop push-button is engaged/faulty. 3. Power supply switched OFF or is at fault. 4. Blade guard limit switch engaged/at fault. 5. Electrical box door is open/door safety switch is at fault. 6. Motor connection wired incorrectly. 7. Thermal overload relay has tripped. 8. Wall fuse/circuit breaker is blown/tripped. 9. Contactor not getting energized/has burnt contacts. 10. Wiring is open/has high resistance. 11. Motor ON button or ON/OFF switch is at fault. 12. Start delay module is at fault. 13. Motor is at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key. 2. Rotate clockwise slightly until it pops out/replace it. 3. Ensure power supply is switch on; ensure power supply has the correct voltage. 4. Move blade guard to the working position; replace faulty limit switch. 5. Close door/replace faulty safety switch. 6. Correct motor wiring connections. 7. Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times (weak relay). 8. Ensure circuit size is suitable for this machine; replace weak breaker. 9. Test for power on all legs and contactor operation. Replace unit if faulty. 10. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 11. Replace faulty ON button or ON/OFF switch. 12. Adjust to correct delay; replace module. 13. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Feed rate/cutting speed too fast for task. 2. Workpiece material is not suitable for this machine. 3. Belt(s) slipping. 4. Motor connection is wired incorrectly. 5. Motor bearings are at fault. 6. Start delay module is at fault. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Decrease feed rate/cutting speed. 2. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece. 3. Replace bad belt(s) as a matched set, align pulleys, and re-tension. 4. Correct motor wiring connections. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Adjust to correct delay; replace module. 7. Test/repair/replace.



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. Blade is at fault. 3. V-belt(s) worn or loose. 4. Pulley is loose. 5. Motor mount loose/broken. 6. Machine is incorrectly mounted or sits unevenly. 7. Arbor pulley is loose. 8. Motor fan is rubbing on fan cover. 9. Arbor bearings are at fault. 10. Motor bearings are at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Inspect/replace belts with a new matched set (refer to Page 67). 4. Realign/replace shaft, pulley, setscrew, and key as required. 5. Tighten/replace. 6. Tighten/replace anchor studs in floor; relocate/shim machine. 7. Retighten/replace arbor pulley with shaft and thread locking liquid. 8. Replace dented fan cover; replace loose/damaged fan. 9. Replace arbor housing bearings; replace arbor. 10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Main blade runs backwards.	<ol style="list-style-type: none"> 1. Two of the power wires are reversed. 	<ol style="list-style-type: none"> 1. Exchange wires R & T in the terminal box.

Operation

Symptom	Possible Cause	Possible Solution
Workpiece has burned edges, binds, or kicks back.	<ol style="list-style-type: none"> 1. Sliding table is not parallel to blade. 2. Riving knife is not aligned with the blade. 3. Blade is warped. 	<ol style="list-style-type: none"> 1. Make sliding table parallel to the blade (Page 69). 2. Shim the riving knife to align it with the main blade. 3. Replace the blade.
Workpiece has chip out on the bottom edge.	<ol style="list-style-type: none"> 1. Scoring blade height is incorrect. 2. Scoring blade is not aligned with the main blade. 3. Scoring blade kerf does not match the main blade. 	<ol style="list-style-type: none"> 1. Adjust the height of the scoring blade. 2. Align the scoring blade (Page 44). 3. Adjust the scoring blade kerf (Page 44).
Sliding table saw does not cut square.	<ol style="list-style-type: none"> 1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Crosscut fence is not perpendicular to the blade. 	<ol style="list-style-type: none"> 1. Adjust the sliding table (Page 69). 2. Adjust the rip fence parallel to blade. 3. Adjust the crosscut fence perpendicular to the blade (Page 71).
Fence hits table top when sliding across table.	<ol style="list-style-type: none"> 1. Front rail is too low. 2. Rip fence roller is too low. 	<ol style="list-style-type: none"> 1. Raise the front rail. 2. Adjust the rip fence roller.
Blade does not reach 90°, or blade does not reach 45°.	<ol style="list-style-type: none"> 1. Blade stop bolts are out of adjustment. 	<ol style="list-style-type: none"> 1. Adjust the stop bolts (Page 68).
The rip fence scale is not accurate.	<ol style="list-style-type: none"> 1. The rip fence scale is out of calibration or was not set up correctly. 	<ol style="list-style-type: none"> 1. Adjust the rip fence scale.
Tilt or blade height handwheels difficult to turn.	<ol style="list-style-type: none"> 1. Lock knob is tight. 2. Gears caked with dust. 	<ol style="list-style-type: none"> 1. Release the lock knob. 2. Clean out dust and grease the gears.



Belt Service

Main Belt Replacement/Tension

1. DISCONNECT SAW FROM POWER!
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade and scoring blade up as far as they will go.
3. Open the motor cabinet door.
4. Loosen the lock handle (**Figure 132**), rotate the pivot handle down 180°, then tighten the lock handle.

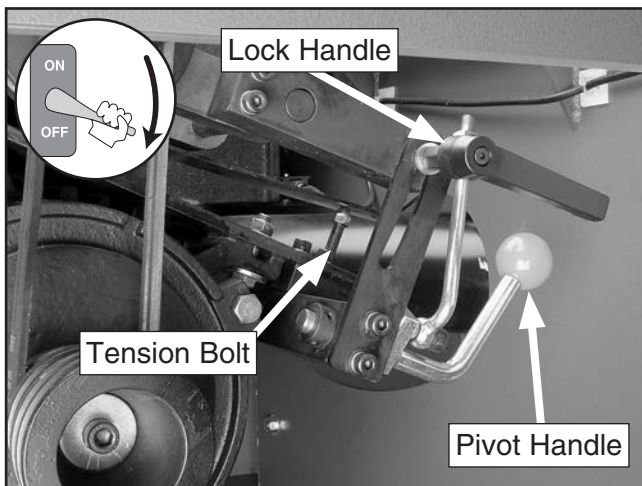


Figure 132. Main blade belt tension controls.

5. Remove the old V-belts and replace them with new belts. *Always replace all of the belts as a matched set.*
6. Loosen the lock handle, rotate the pivot handle up 180°, then tighten the lock handle.
7. Check the belt tension by pushing on belt in the center, as shown in **Figure 133**, and noting the amount of deflection.

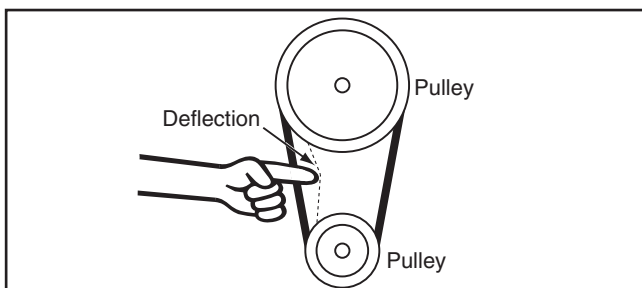


Figure 133. Checking belt deflection.

The correct range of belt deflection for this machine is 1/4"–1/2".

—If the belt deflection is correct, continue to **Step 8**.

—If the belt deflection is incorrect, use the tension bolt to adjust the belt to the proper range of tension. Turning the bolt clockwise loosens the tension; turning the bolt counterclockwise increases the tension. After adjusting, tighten the jam nut on the tension bolt against the motor plate to secure it in position. Repeat **Step 7**.

8. Close the motor cabinet door.

Scoring Belt Replacement/Tension

1. DISCONNECT SAW FROM POWER!
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade and scoring blade set up as far as they will go.
3. Open the motor cabinet door.
4. Push the scoring blade motor up and remove the flat belt.
5. Place the flat belt on the scoring blade arbor as shown in **Figure 134**, lift the scoring motor, and slide the flat belt over the scoring motor pulley.

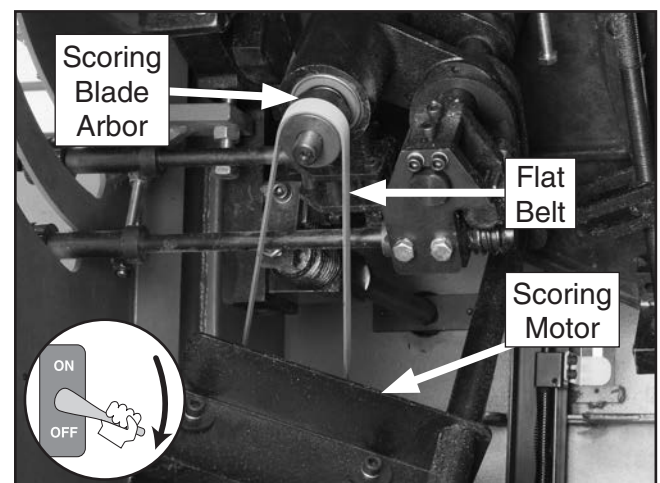


Figure 134. Replacing the scoring motor belt.

6. Close and secure the motor cabinet door.



Blade Tilt Calibration

The blade tilt is calibrated at the factory, but can be calibrated if it changes during the life of the machine.

90° Stop

1. DISCONNECT SAW FROM POWER!
2. Move the blade tilt to 90° according to the gauge, and raise the main blade as far as it will go.
3. Use a machinist's square to inspect if the blade is square to the table.

—If the blade is not square to the table, loosen the two set screws that secure the 90° tilt stop nut shown in **Figure 135**.

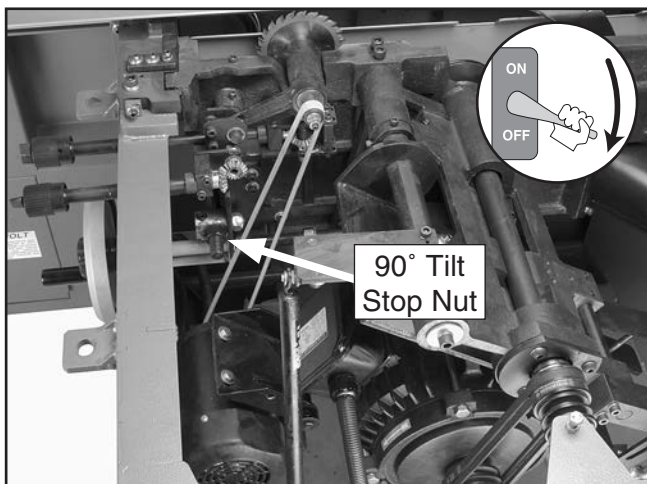


Figure 135. Blade tilt stop nut (90°).

4. Adjust the stop nut and recheck the blade tilt as many times as necessary until the blade is 90° to the table.
5. Tighten the two set screws in the stop nut.
6. Check the blade tilt pointer mechanism to ensure that it points to 90°.

—If the blade tilt pointer shows an incorrect tilt, adjust it by loosening the mounting screws, rotating the pointer until it points to 90°, then tightening the mounting screws.

45° Stop

1. DISCONNECT SAW FROM POWER!
2. Adjust the blade angle until you hit the 45° positive stop and check the blade angle with a 45° square.

—If the blade is not 45° to the table, loosen the two set screws that secure the 45° tilt stop nut shown in **Figure 136**. (This nut can also be accessed from the front of the saw by moving the sliding table all the way forward.)

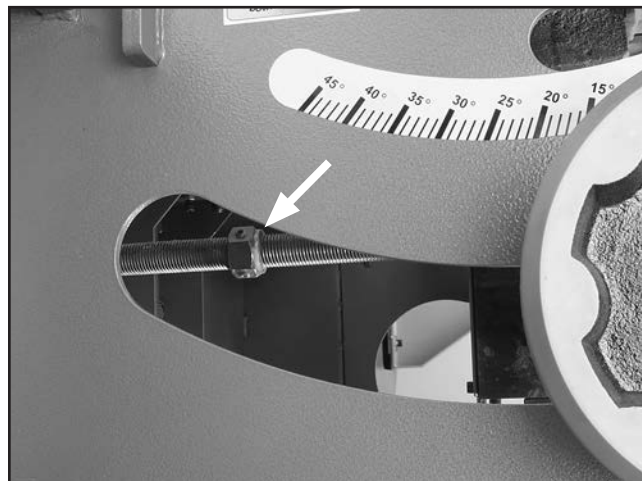


Figure 136. 45° Blade tilt stop nut.

3. Adjust the stop nut and recheck the blade tilt as many times as necessary until the blade is 45° to the table.
4. Tighten the two set screws in the stop nut.



Sliding Table Parallel Adjustment

The table is calibrated at the factory, but can be adjusted slightly if it is not parallel to the blade.

Tools Needed:	Qty
Felt Tip Pen.....	1
90° Square	1
Precise Measuring Tool.....	1
Wrench 17mm.....	1
Hex Wrench 5mm.....	1

To adjust the sliding table parallel with the main blade:

1. DISCONNECT SAW FROM POWER!
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade up to the maximum height.
3. Mark one of the blade teeth with a felt tip pen. This will be your reference point when taking measuring points, so you take them in the same location each time.
4. Move the sliding table all the way back, and measure the distance "A" in **Figure 137**, between the marked tooth and the edge of the miter slot.

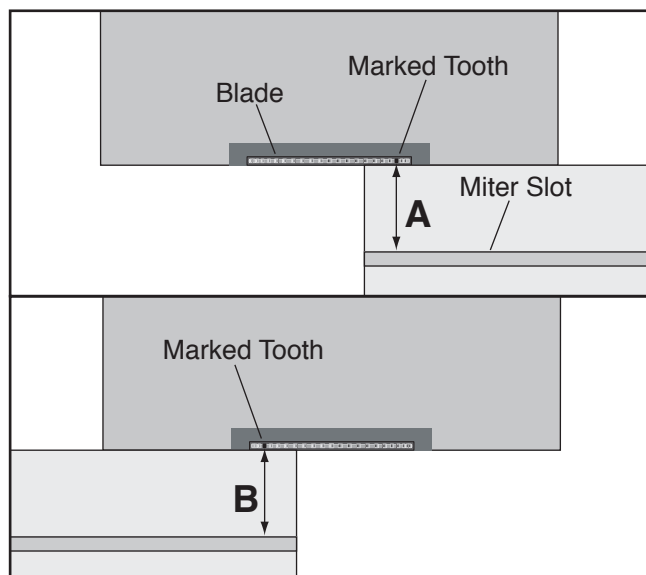


Figure 137. Measuring distance between table and blade.

5. Rotate the blade 180°, move the sliding table all the way forward, and measure the distance between "B" in **Figure 137**.
6. Note the difference between the two positions.
 - If the gap is the same on both sides or the difference is 0.004" or less, no adjustments to the table parallelism need to be made.
 - If the difference is greater than 0.004", then the sliding table parallelism must be adjusted. Proceed to **Step 7**.
7. Loosen the nuts on T-bolts that are used to mount the sliding table to the base (refer to **Page 26** for T-bolt locations and photos).
8. Loosen the hex nut on the parallel adjustment screw (see **Figure 138**), then adjust the screw as necessary to move the table. If you move the adjustment screw away from the table, then push the table against the screw before proceeding.

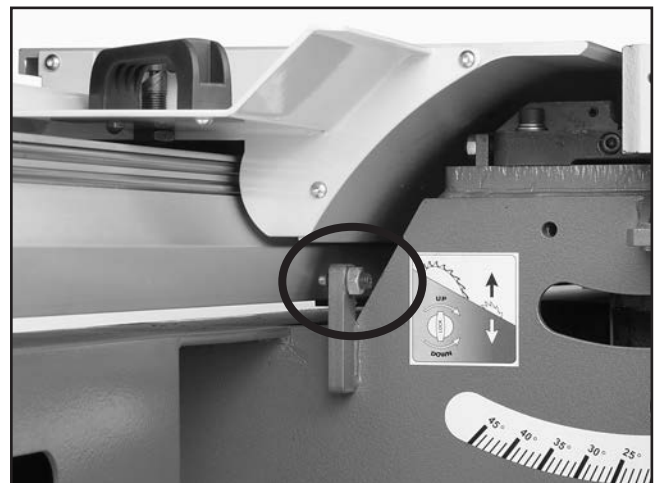


Figure 138. Table parallelism adjustment screw.

9. Tighten the hex nut on the parallel adjustment screw to secure it in place, then tighten the table mounting nuts. Repeat **Steps 4–6** as necessary until the sliding table is parallel with the blade.



Table Movement Adjustment

The sliding table features an adjustment bar with bolts that control how easily the sliding table moves across the base (see **Figure 139**). These adjustment bolts are factory set. They can only be accessed by removing the end covers from both ends of the sliding table base and sliding the thin plate out of the way.

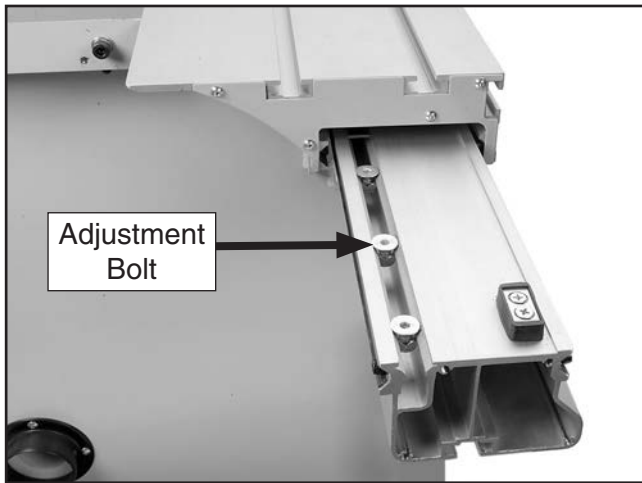


Figure 139. Adjustment bolt access location.

If the adjustment bolts do require adjustments, turning them counterclockwise increases and clockwise decreases pressure against the steel rails. Increasing pressure against the rails reduces table movement slop, which increases accuracy, but makes it harder to slide the table. Decreasing pressure against the rails makes it easier to slide the table, but increases table movement slop, which reduces accuracy.

Adjusting this part of the sliding table correctly is a matter of trial-and-error by making adjustments, moving the sliding table, then making additional adjustments and repeating the process until the sliding table moves as desired. Ideally, the table will move easily but without any slop.



Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

To square the crosscut fence with the blade:

1. Make sure the blade is parallel with the sliding table and that the block on the crosscut fence is resting against the 90° stop bolt (see **Figure 141** for locations).
2. Prepare the scrap test piece by cutting it to 32" x 32", then number all four sides of the test piece.
3. Use the crosscut fence to cut $\frac{1}{2}$ " off of each side of the test piece, then cut side 1 again (make five cuts total).
4. Measure the test piece diagonally from corner-to-corner as shown in **Figure 140**.

—If both measurements are not within $\frac{1}{16}$ ", then the crosscut fence needs to be adjusted. Proceed to **Steps 5–8**.

—If both measurements are within $\frac{1}{16}$ " then you are finished with this procedure.

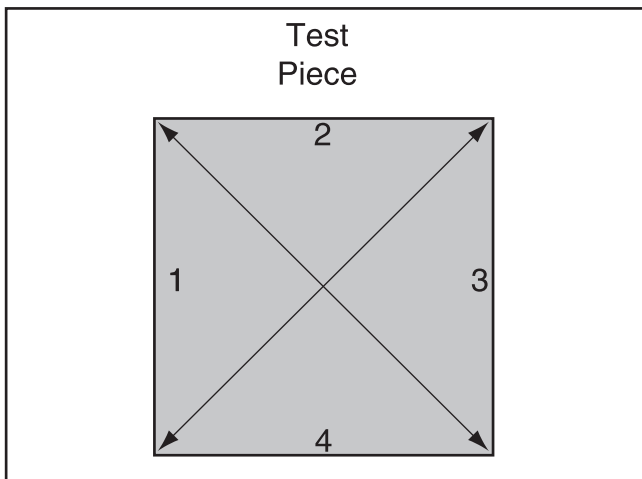


Figure 140. Fence adjustment test piece.

5. Loosen the knob on the crosscut fence to allow it to pivot (make sure the block remains against the 90° stop bolt during adjustments).
6. Loosen the hex nut on the 90° stop bolt shown in **Figure 141**, and rotate the 90° stop bolt to square the crosscut fence.

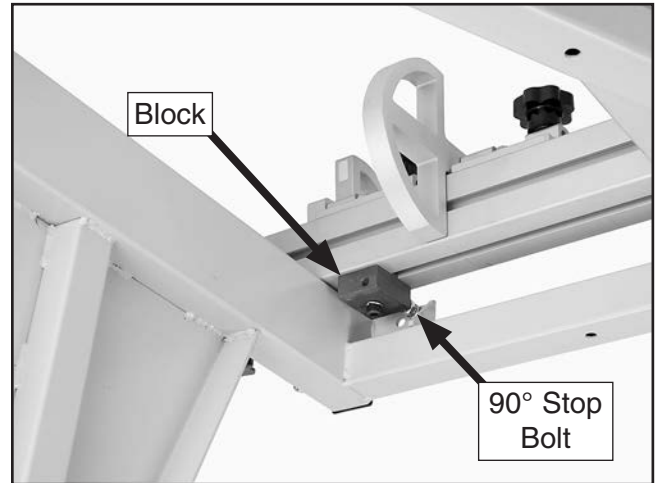


Figure 141. Crosscut fence adjustment cam.

7. Tighten the hex nut on the 90° stop bolt, then tighten the crosscut fence knob, making sure the block is touching the 90° stop bolt.
8. Repeat **Steps 3-4**.



Adjusting Mounting Block

The spreader/riving knife must be aligned with the blade when installed. If the spreader/riving knife is not aligned with the blade, then the workpiece will be forced sideways during the cut, which will increase the risk of kickback.

The spreader/riving knife mounts to a block that can be repositioned to correctly align the spreader/riving knife to the blade.

The mounting block adjusts by turning the set screws in each corner of the block. **Figure 142** shows the set screws associated with controlling the mounting block position. Have patience when adjusting the mounting block, because it requires trial-and-error to perform with accuracy.

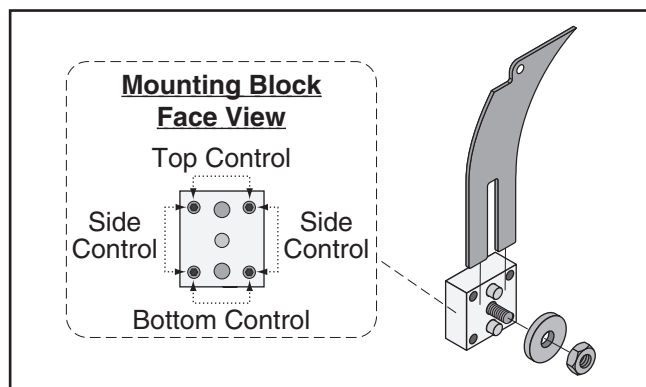


Figure 142. Riving knife mounting block adjustment controls.

All adjustment and alignment positions for the riving knife are covered on **Page 40** in the subsection **Riving Knife Installation & Removal**; the mounting block should not be adjusted unless you have been unable to mount the riving knife as instructed by these procedures.

Tools Needed	Qty
Straightedge	1
Wrench 17mm.....	1
Hex Wrench 4mm.....	1

To adjust the mounting block:

1. DISCONNECT SAW FROM POWER!
2. Raise the blade all the way up, move the sliding table to the side, and open the lower blade cover to gain access to the mounting block.
3. Loosen the lock nut that secures the spreader/riving knife to the mounting block, and remove the spreader/riving knife.
4. Adjust the each pair of set screws that controls the direction required to move the mounting block so the spreader/riving knife can be aligned with the blade. Make sure to move both set screws in even increments.
5. Reinstall the spreader/riving knife and check the alignment with the blade. Repeat **Step 4** as necessary until the spreader/riving knife is properly aligned to the blade.

Note: *If you discover that the spreader/riving knife is bent and cannot be properly aligned with the blade, it is possible to bend it into alignment, but make sure that the final result is precisely aligned so the risk of kickback is not increased. If the spreader/riving knife is bent, and you cannot easily bend it back into alignment, we recommend replacing it with a new one.*
6. Properly re-install the spreader/riving knife as described on **Page 40**, close the blade cover, and move the sliding table back to the center position.



SECTION 9: 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

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!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

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.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

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.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.
















CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

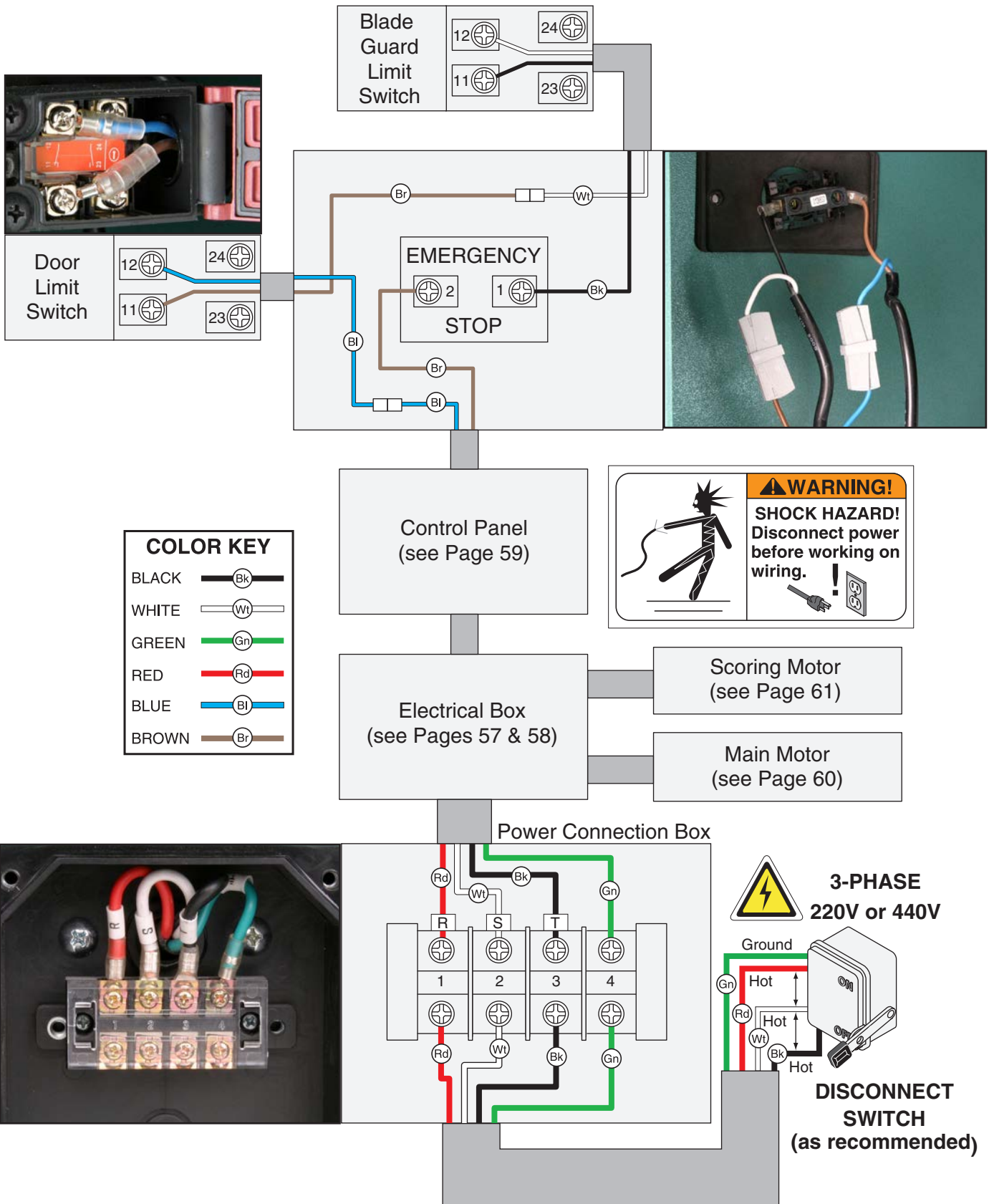
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

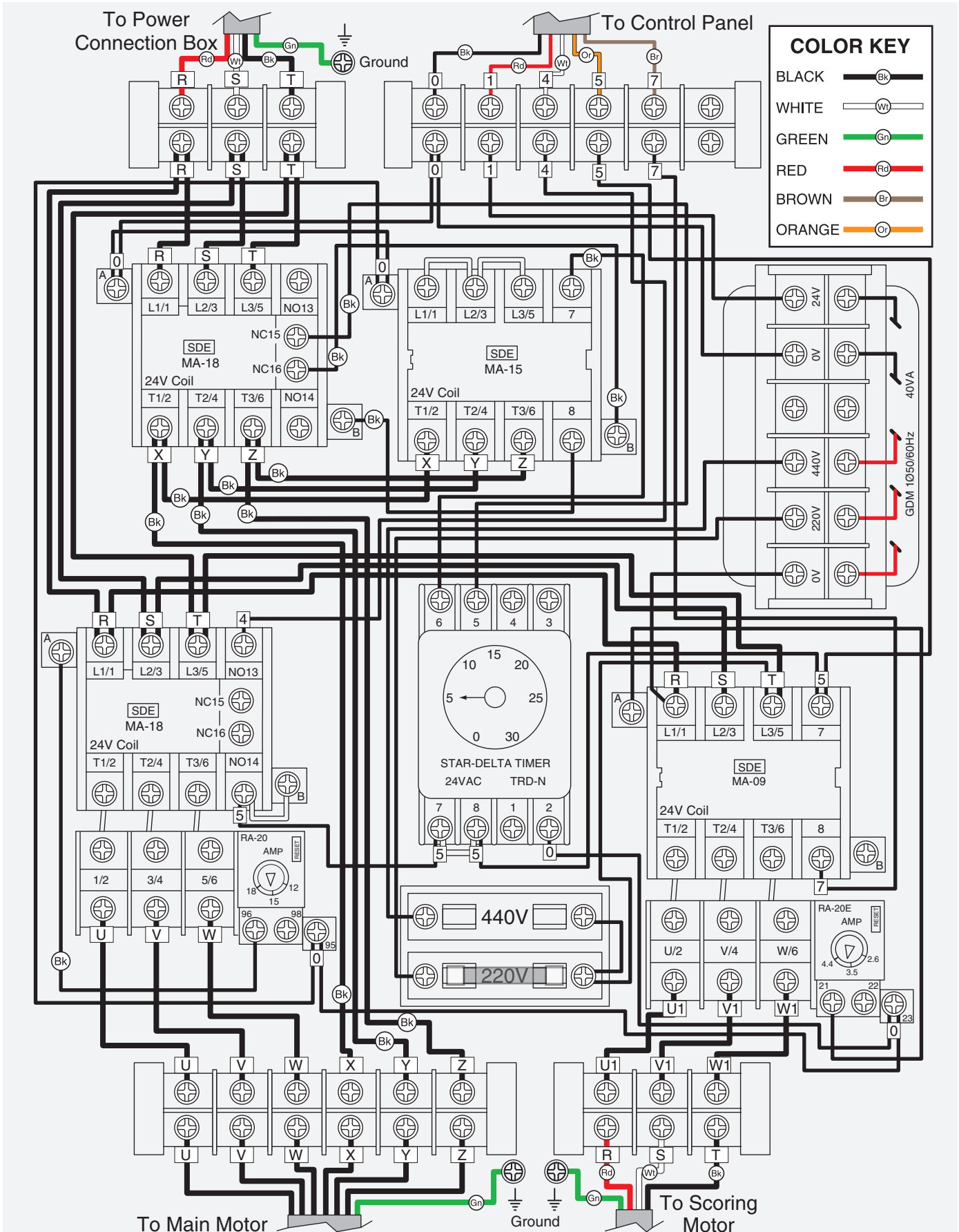
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WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



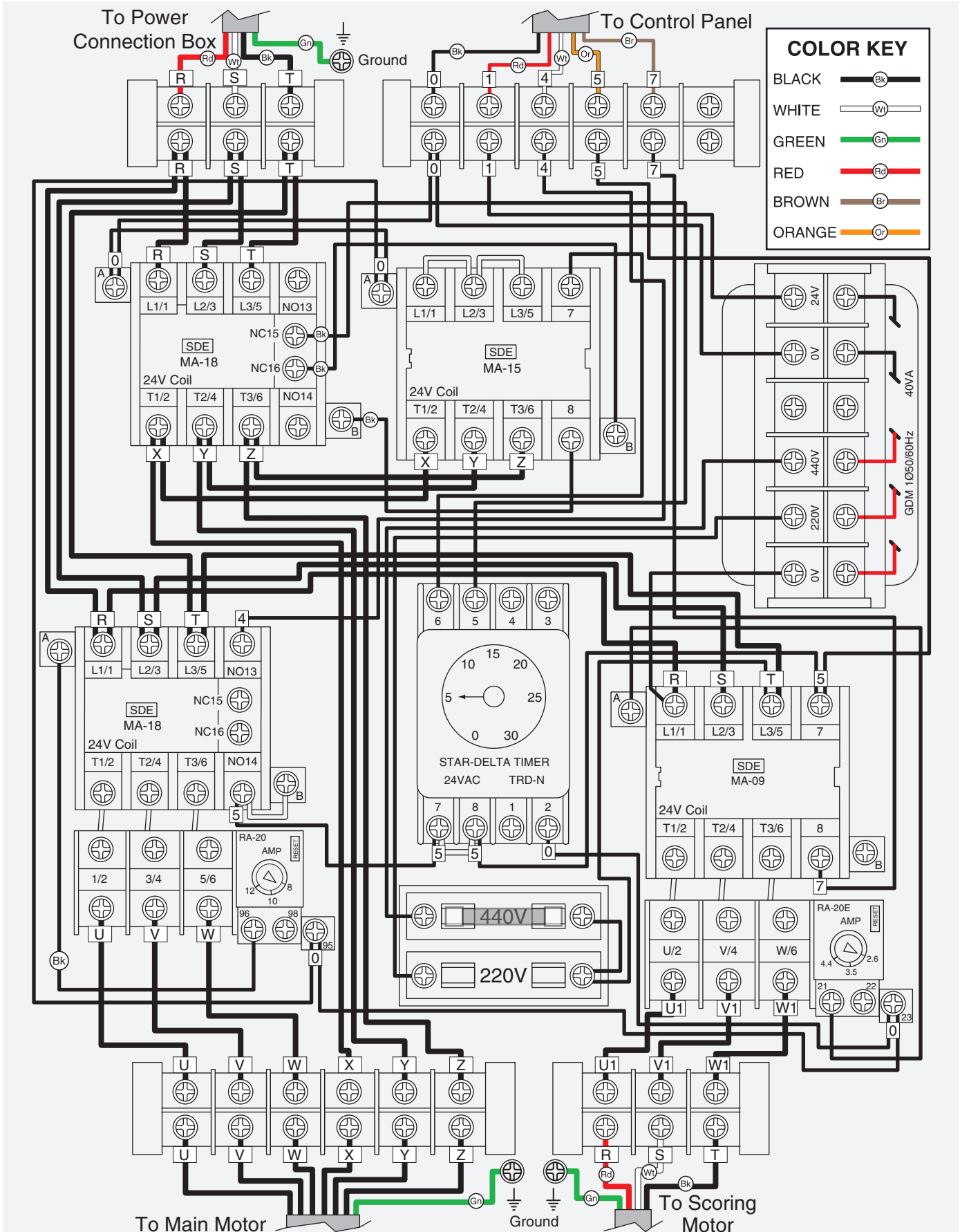
Overview



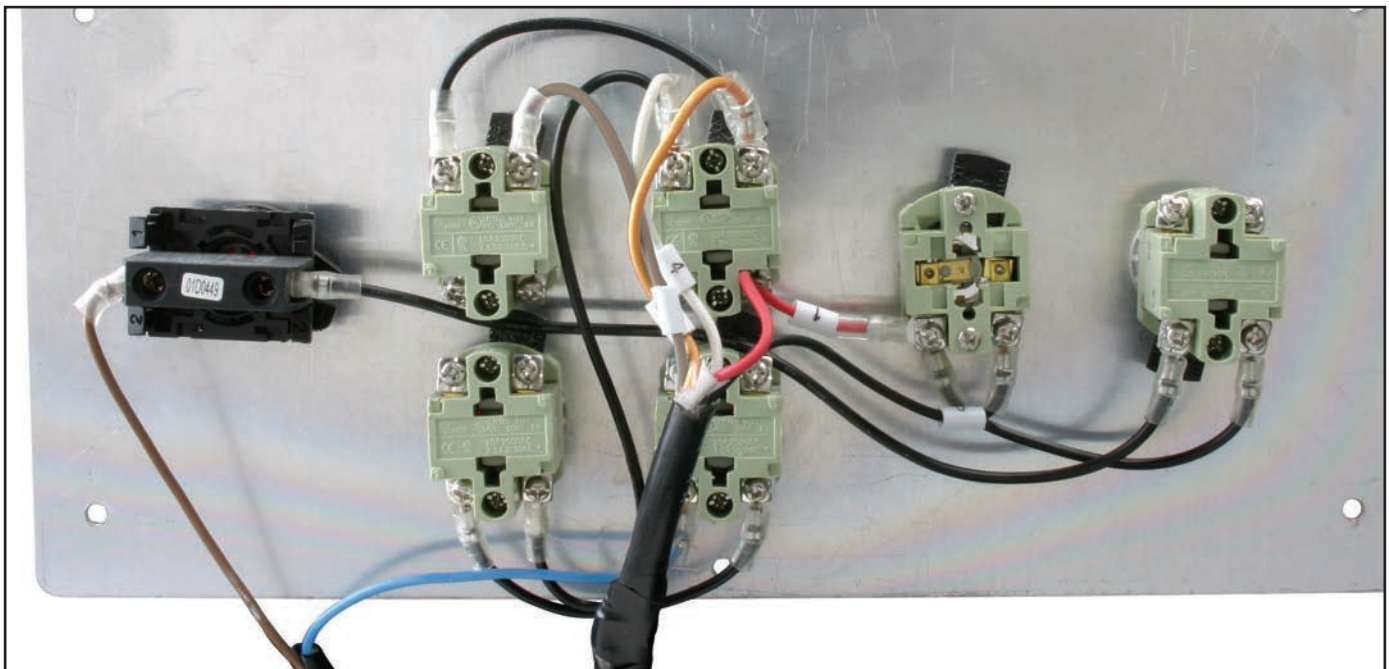
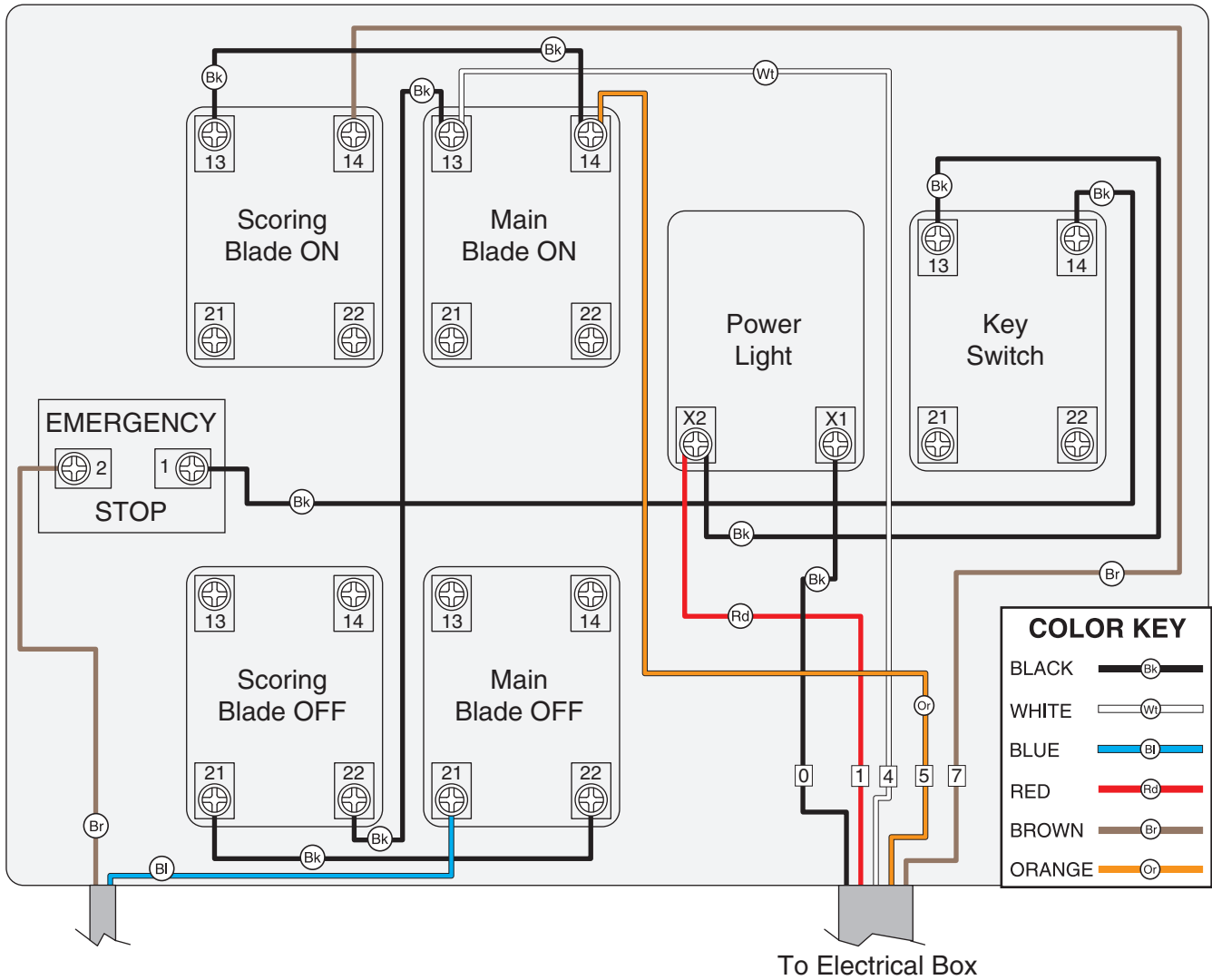
Electrical Box at 220V



Electrical Box at 440V



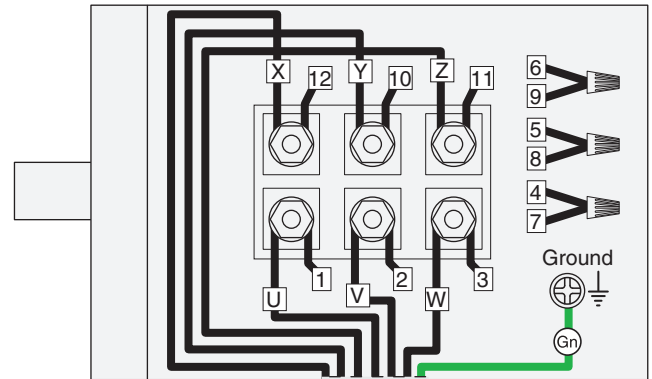
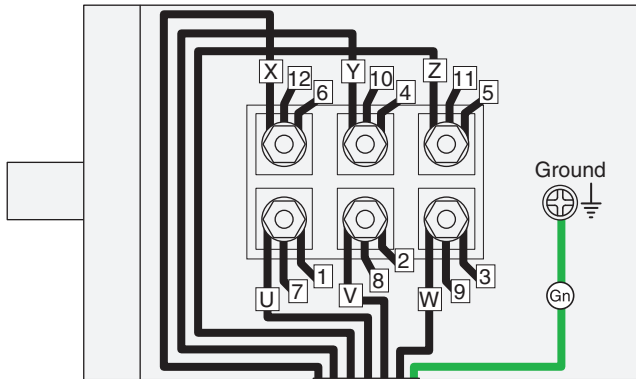
Control Panel



Main Motor

220V

440V



(additional conversions required for 440V operation)

To Electrical Box



⚠ WARNING!

SHOCK HAZARD!
Disconnect power before working on wiring.



NOTICE

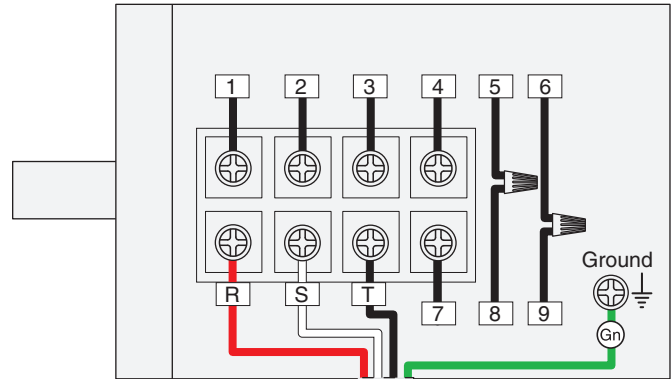
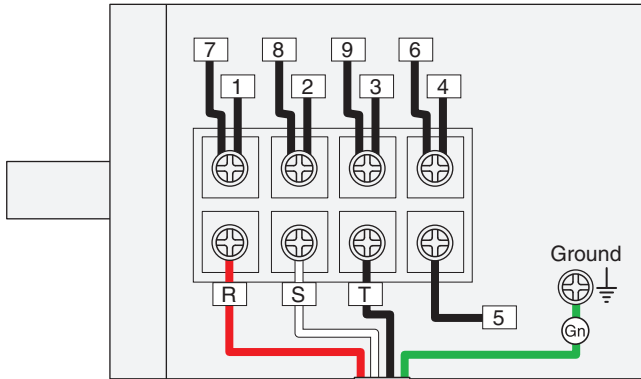
These motor wiring diagrams are current at the time of printing; however, always use the diagram on the inside of the junction box cover when rewiring your motor!



Scoring Motor

220V

440V



(additional conversions required for 440V operation)



⚠ WARNING!

SHOCK HAZARD!
Disconnect power before working on wiring.



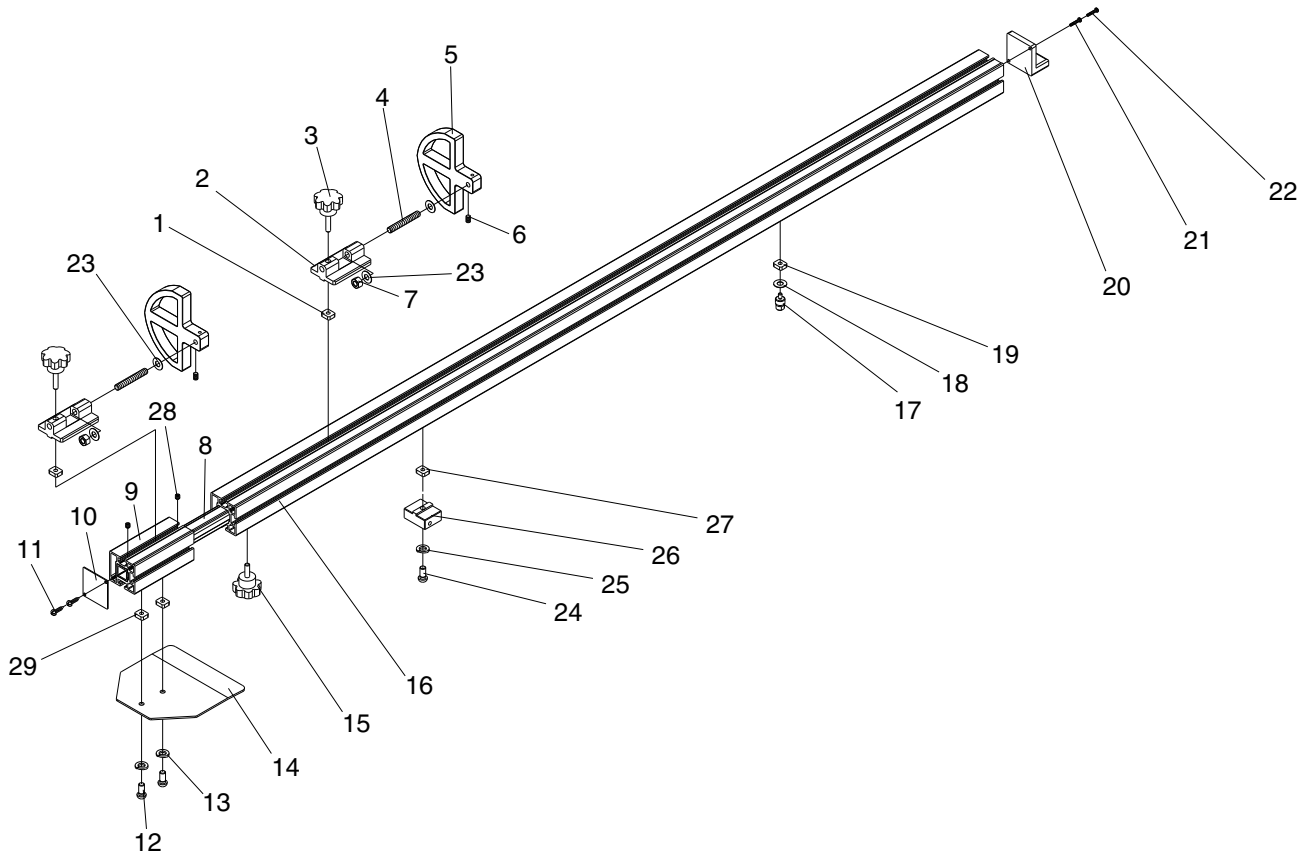
NOTICE

The motor wiring shown here is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.



SECTION 10: PARTS

Crosscut Fence

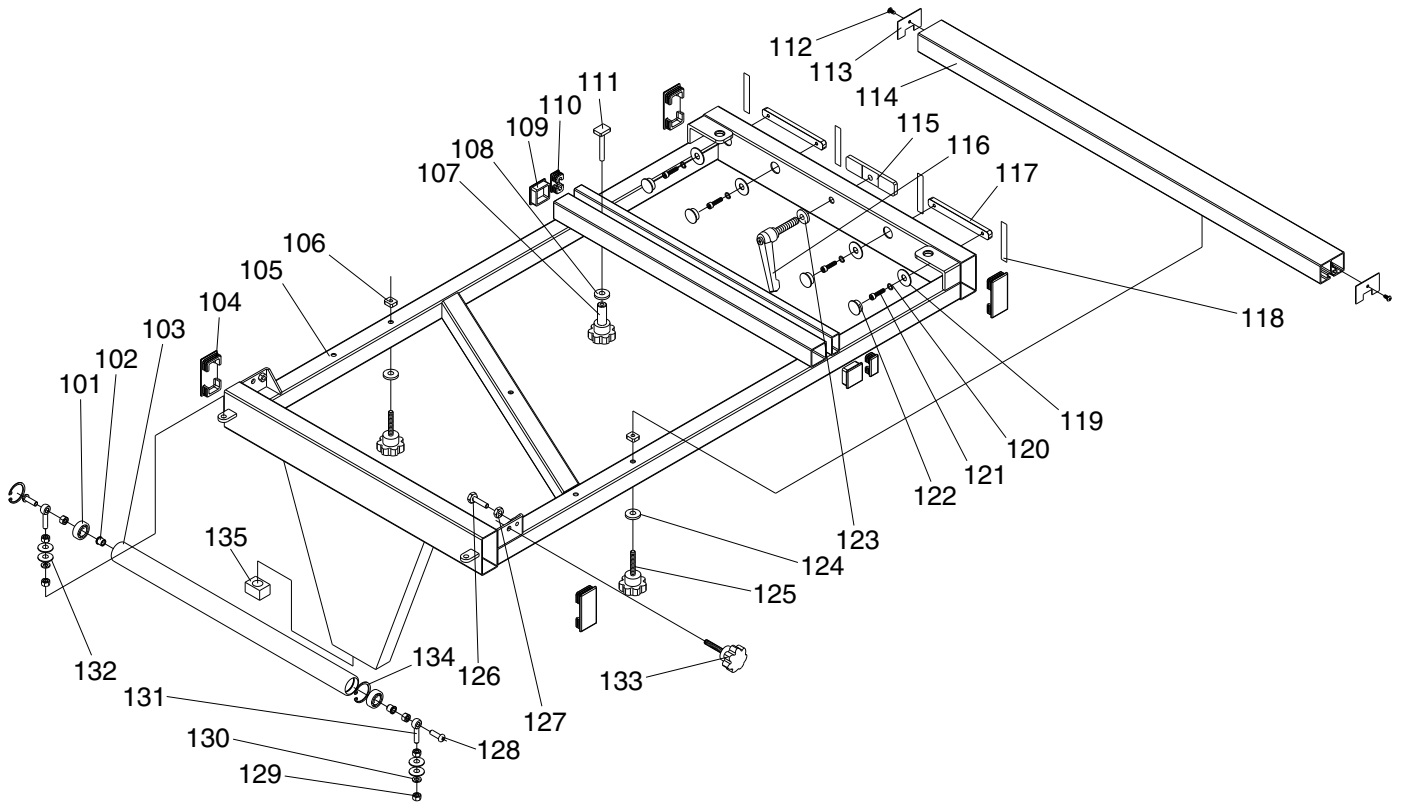


REF	PART #	DESCRIPTION
1	P04930001	T-NUT M8-1.25
2	P04930002	STOP BRACKET
3	P04930003	KNOB M8-1.25 X 40
4	P04930004	STUD M10-1.5 X 70 V1
5	P04930005	FLIP STOP
6	P04930006	SET SCREW M6-1 X 10
7	P04930007	LOCK NUT M10-1.5
8	P04930008	SQUARE TUBE
9	P04930009	EXT FENCE V1
10	P04930010	COVER V1
11	P04930011	TAP SCREW #8 X 3/8
12	P04930012	BUTTON HD CAP SCR M8-1.25 X 16
13	P04930013	LOCK WASHER 8MM
14	P04930014	LOCATE PLATE
15	P04930015	KNOB SCREW M8-1.25 X 25

REF	PART #	DESCRIPTION
16	P04930016	SQUARE FENCE V1
17	P04930017	ROTATE SHAFT
18	P04930018	FIBER WASHER 10MM
19	P04930019	T-NUT M8-1.25
20	P04930020	ROTATE BLOCK V1
21	P04930021	PHLP HD SCR M4-.7 X 10
22	P04930022	PHLP HD SCR M4-.7 X 35
23	P04930023	FIBER WASHER 10MM
24	P04930024	CAP SCREW M8-1.25 X 35
25	P04930025	LOCK WASHER 8MM
26	P04930026	BLOCK
27	P04930027	T-NUT M8-1.25
28	P04930028	SET SCREW M6-1 X 6
29	P04930029	T-NUT M8-1.25



Crosscut Table

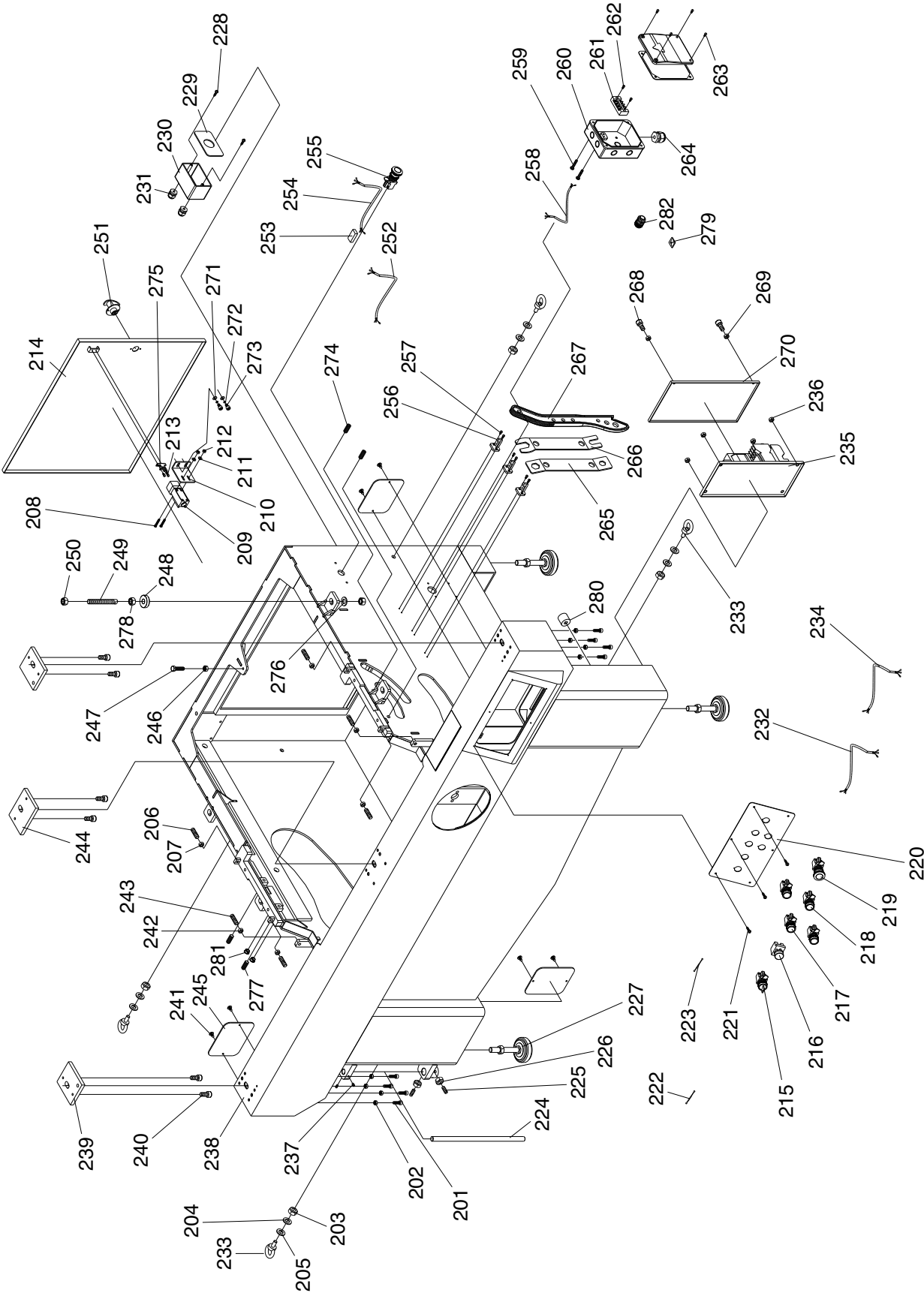


REF	PART #	DESCRIPTION
101	P04930101	BALL BEARING 6201ZZ
102	P04930102	OIL BEARING 12 X 12MM
103	P04930103	ROLLER
104	P04930104	PLUG 80 X 40MM
105V2	P04930105V2	SUPPORT FRAME V2.05.12
106	P04930106	T-NUT M8-1.25
107	P04930107	KNOB SCREW M8-1.25 X 25
108	P04930108	FLAT WASHER 8MM
109	P04930109	PLUG 38 X 38MM
110	P04930110	PLUG 40 X 20MM
111	P04930111	T-BOLT M8-1.25 X 60
112	P04930112	TAP SCREW #8 X 3/8
113	P04930113	COVER
114	P04930114	SQUARE BRACE
115	P04930115	T-BLOCK
116	P04930116	ADJUST HANDLE M12-1.75 X 55
117	P04930117	PLATE
118	P04930118	PAD

REF	PART #	DESCRIPTION
119	P04930119	FLAT WASHER 6MM
120	P04930120	LOCK WASHER 6MM
121	P04930121	BUTTON HD CAP SCR M6-1 X 16
122	P04930122	PLUG
123	P04930123	FLAT WASHER 12MM
124	P04930124	FLAT WASHER 8MM
125	P04930125	KNOB SCREW M8-1.25 X 50
126	P04930126	HEX BOLT M8-1.25 X 30
127	P04930127	HEX NUT M8-1.25
128	P04930128	BUTTON HD CAP SCR M8-1.25 X 25
129	P04930129	HEX NUT M8-1.25
130	P04930130	LOCK WASHER 8MM
131	P04930131	EYE BOLT M8-1.25 X 40
132	P04930132	FLAT WASHER 8MM
133	P04930133	KNOB SCREW M8-1.25 X 50
134	P04930134	INT RETAINING RING 32MM
135	P04930135	PLUG



Cabinet Body



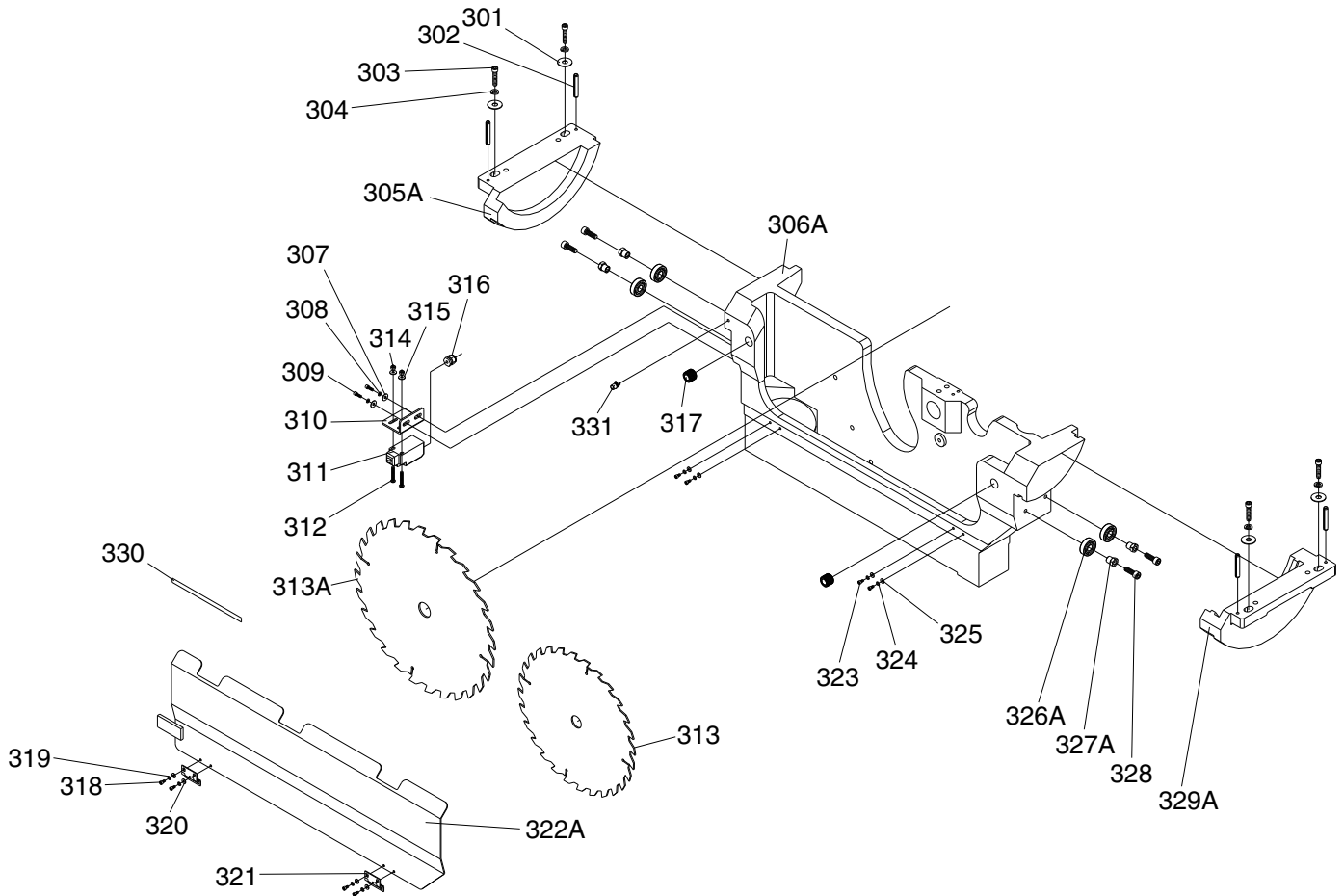
Cabinet Body Parts

REF	PART #	DESCRIPTION
201	P04930201	CAP SCREW M6-1 X 30
202	P04930202	HEX NUT M6-1
203	P04930203	HEX NUT M12-1.75
204	P04930204	FLAT WASHER 12MM
205	P04930205	PLASTIC WASHER 13MM
206	P04930206	SET SCREW M10-1.5 X 35
207	P04930207	HEX NUT M10-1.5
208	P04930208	PHLP HD SCR M4-.7 X 35
209	P04930209	DOOR SAFETY SWITCH ADZ-S11
210	P04930210	FIXED PLATE
211	P04930211	FLAT WASHER 4MM
212	P04930212	HEX NUT M4-.7
213	P04930213	PHLP HD SCR M4-.7 X 12
214	P04930214	PLATE
215	P04930215	KEY SWITCH
216	P04930216	POWER LAMP YK.24V
217	P04930217	SWITCH BUTTON ON
218	P04930218	SWITCH BUTTON OFF
219	P04930219	EMERGENCY STOP BUTTON E2R1R(1B)
220	P04930220	CONTROL PANEL FACE
221	P04930221	PHLP HD SCR M4-.7 X 6
222	P04930222	CORD 1C
223	P04930223	CORD 1C
224	P04930224	SHAFT
225	P04930225	SET SCREW M10-1.5 X 20
226	P04930226	HEX NUT M10-1.5
227	P04930227	FOOT M16-2 X 100
228	P04930228	TAP SCREW M5 X 20
229	P04930229	PAD
230	P04930230	SWITCH BOX
231	P04930231	STRAIN RELIEF PG11
232	P04930232	CORD 6W
233	P04930233	EYE BOLT 12MM
234	P04930234	CORD STOP 2C
235	P04930235	ELECTRIC PANEL 220/440V 3PH
236	P04930236	FLANGE NUT M6-1
237	P04930237	SET SCREW M6-1 X 12
238	P04930238	MACHINE BODY
239	P04930239	LOCATE BLOCK
240	P04930240	CAP SCREW M8-1.25 X 16
241	P04930241	FLANGE SCREW M4-.7 X 6

REF	PART #	DESCRIPTION
242	P04930242	HEX NUT M10-1.5
243	P04930243	SET SCREW M10-1.5 X 35
244	P04930244	LOCATE BLOCK
245	P04930245	PLATE
246	P04930246	HEX NUT M8-1.25
247	P04930247	HEX BOLT M8-1.25 X 30
248	P04930248	SPACER RING 14MM
249	P04930249	STUD M14-2 X 110
250	P04930250	HEX NUT M14-2
251	P04930251	DOOR KNOB
252	P04930252	STOP CORD 2C
253	P04930253	WIRE CONNECTOR 224-201
254	P04930254	STOP CORD 2C
255	P04930255	EMERGENCY STOP BUTTON E2R1R(1B)
256	P04930256	HANGER
257	P04930257	FLANGE SCREW M4-.7 X 16
258	P04930258	POWER CORD
259	P04930259	BUTTON HD CAP SCR M6-1 X 20
260	P04930260	POWER BOX
261	P04930261	TERMINAL 4P
262	P04930262	PHLP HD SCR M5-.8 X 8
263	P04930263	BUTTON HD CAP SCR M5-.8 X 12
264	P04930264	STRAIN RELIEF 20MM
265	P04930265	ARBOR WRENCH 24,19MM CLOSED
266	P04930266	ARBOR WRENCH 24,19MM OPEN
267	P04930267	PUSH STICK
268	P04930268	CAP SCREW M6-1 X 20
269	P04930269	LOCK NUT M6-1
270	P04930270	PLATE
271	P04930271	FLAT WASHER 6MM
272	P04930272	LOCK WASHER 6MM
273	P04930273	CAP SCREW M6-1 X 10
274	P04930274	SET SCREW M10-1.5 X 25
275	P04930275	LOCK WASHER 4MM
276	P04930276	FLAT WASHER 14MM
277	P04930277	SET SCREW M10-1.5 X 40
278	P04930278	LOCK NUT M14-2
279	P04930279	BLOCK
280	P04930280	COTTON PAD
281	P04930281	HOLE PLUGS
282	P04930282	STRAIN RELIEF



Main Blade Trunnion

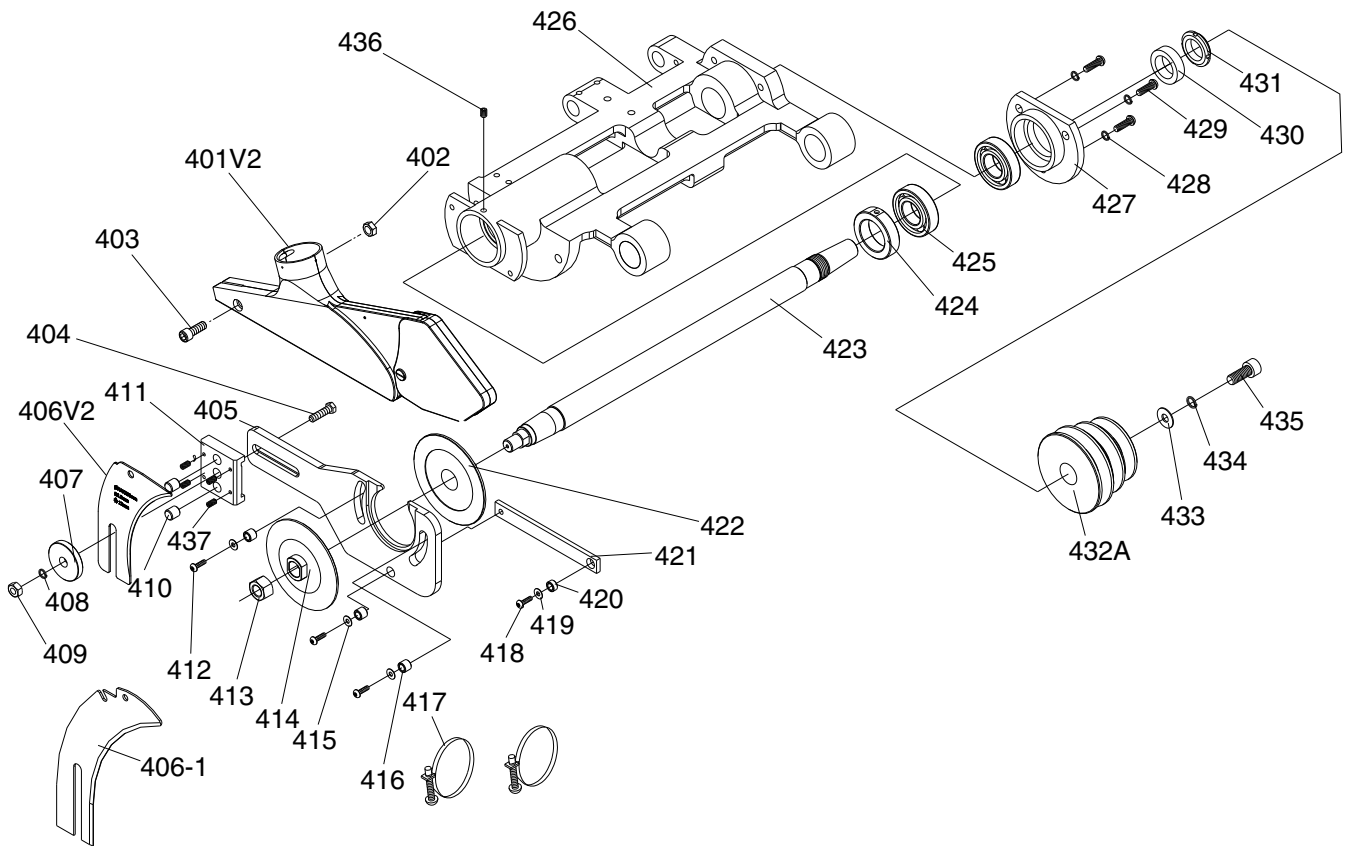


REF	PART #	DESCRIPTION
301	P04930301	FLAT WASHER 10MM
302	P04930302	ROLL PIN 6 X 45
303	P04930303	CAP SCREW M10-1.5 X 45
304	P04930304	LOCK WASHER 10MM
305A	P04930305A	LEFT TRUNNION BRACKET V2.08.07
306A	P04930306A	CHANNEL BASE V2.08.07
307	P04930307	FLAT WASHER 6MM
308	P04930308	LOCK WASHER 6MM
309	P04930309	CAP SCREW M6-1 X 10
310	P04930310	FIX PLATE
311	P04930311	DOOR SAFETY SWITCH
312	P04930312	PHLP HD SCR M4-.7 X 35
313	P04930313	SAW BLADE 12" X 1" X 100T
314	P04930314	HEX NUT M4-.7
315	P04930315	FLAT WASHER 4MM
316	P04930316	STRAIN RELIEF PG11
317	P04930317	MAGNETIC IRON ASSY

REF	PART #	DESCRIPTION
317-1	P04930317-1	MAGNETIC IRON
317-2	P04930317-2	BRACKET
317-3	P04930317-3	HEX BOLT M20-1.5 X 15
318	P04930318	CAP SCREW M5-.8 X 6
319	P04930319	LOCK WASHER 5MM
320	P04930320	FLAT WASHER 5MM
321	P04930321	HINGE
322A	P04930322A	COVER V2.08.07
323	P04930323	CAP SCREW M5-.8 X 12
324	P04930324	LOCK WASHER 5MM
325	P04930325	FLAT WASHER 5MM
326	P04930326	BALL BEARING 6201ZZ
327A	P04930327A	ECCENTRIC SHAFT V2.08.07
328	P04930328	CAP SCREW M8-1.25 X 30
329A	P04930329A	RIGHT TRUNNION BRACKET V2.08.07
330	P04930330	SPONGE
331	P04930331	OIL INLET M6-1



Main Blade Arbor

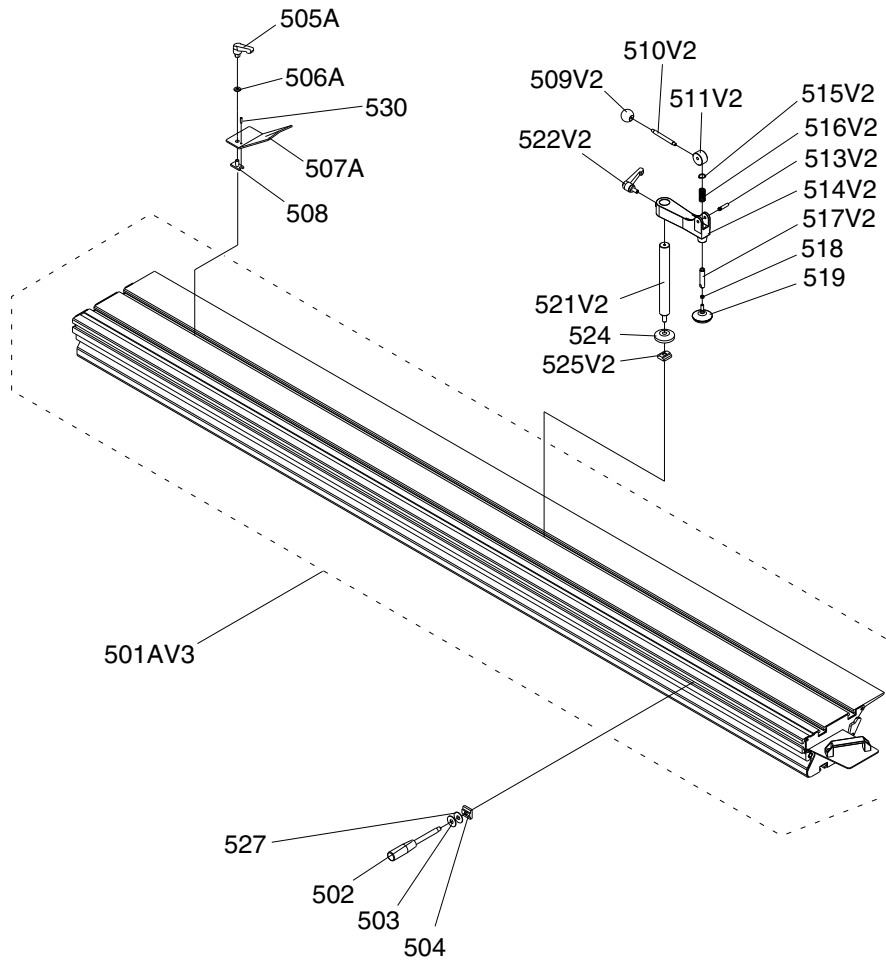


REF	PART #	DESCRIPTION
401V2	P04930401V2	BLADE GUARD ASSEMBLY CLEAR V2.05.12
402	P04930402	FLAT WASHER 8MM
403	P04930403	BUTTON HD CAP SCR M8-1.25 X 40
404	P04930404	HEX BOLT M12-1.75 X 40
405	P04930405	LOCATE PLATE
406	P04930406	RIVING KNIFE V1
406-1	P04930406-1	RIVING KNIFE V1
407	P04930407	LOCK PLATE
408	P04930408	LOCK WASHER 12MM
409	P04930409	HEX NUT M12-1.75
410	P04930410	PIN
411	P04930411	FIX BLOCK
412	P04930412	BUTTON HD CAP SCR M8-1.25 X 20
413	P04930413	HEX NUT M16-2 LH
414	P04930414	ARBOR FLANGE
415	P04930415	FENDER WASHER 8MM
416	P04930416	BUSHING
417	P04930417	HOSE CLAMP 2-1/2"
418	P04930418	BUTTON HD CAP SCR M8-1.25 X 25

REF	PART #	DESCRIPTION
419	P04930419	FLAT WASHER 8MM
420	P04930420	BUSHING
421	P04930421	LINK PLATE
422	P04930422	ARBOR FLANGE
423	P04930423	MAIN ARBOR 25.4MM
424	P04930424	COLLAR
425	P04930425	BALL BEARING 6206 2RS
426	P04930426	MAIN HOUSING
427	P04930427	BEARING HOUSING
428	P04930428	LOCK WASHER 10MM
429	P04930429	BUTTON HD CAP SCR M10-1.5 X 35
430	P04930430	COLLAR
431	P04930431	HEX NUT M30-1.5
432A	P04930432A	ARBOR PULLEY V2.08.07
433	P04930433	FLAT WASHER 10MM
434	P04930434	LOCK WASHER 10MM
435	P04930435	CAP SCREW M10-1.5 X 25
436	P04930436	SET SCREW M6-1 X 8
437	P04930437	SET SCREW M5-.8 X 10



Table Accessories

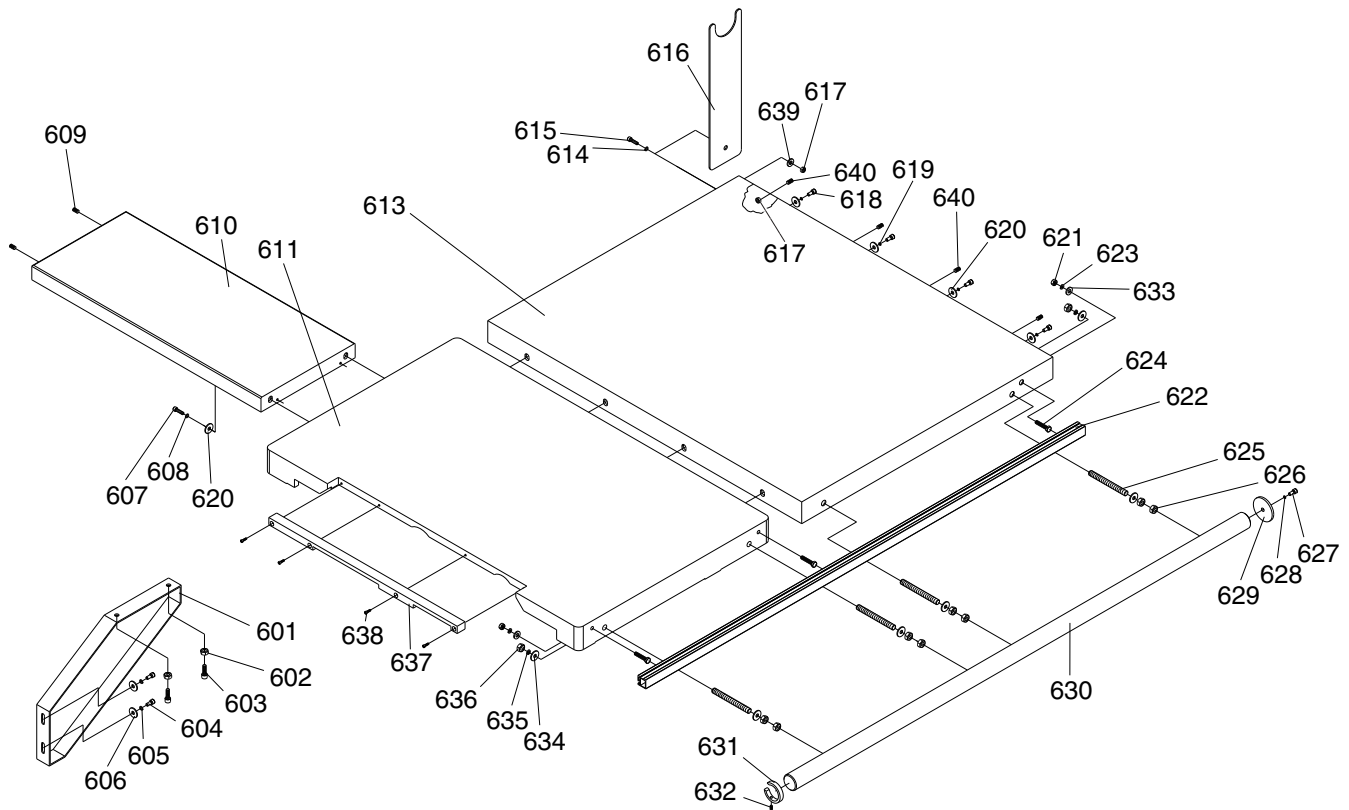


REF	PART #	DESCRIPTION
501AV3	P04930501AV3	SLIDING TABLE SET 3200MM V3.07.10
502	P04930502	HANDLE
503	P04930503	FLAT WASHER 12MM
504	P04930504	T-NUT M12-1.75
505A	P04930505A	KNOB SCREW M12-1.75 X 20
506A	P04930506A	FLAT WASHER 12MM
507A	P04930507A	EDGE SHOE PLATE V2.10.07
508	P04930508	T-NUT M12-1.75
509V2	P04930509V2	*DISCD*BALL KNOB M8-1.25 BLACK
510V2	P04930510V2	*DISCD*HANDLE BAR 125 X 12.7
511V2	P04930511V2	CAM 76.5 X 17

REF	PART #	DESCRIPTION
513V2	P04930513V2	ROLL PIN 6 X 40
514V2	P04930514V2	HOLD DOWN BLOCK V2.07.10
515V2	P04930515V2	EXT RETAINING RING 12MM
516V2	P04930516V2	SPRING 12.5
517V2	P04930517V2	SHAFT 120 X 12
518	P04930518	HEX NUT 5/16-18
519	P04930519	LARGE WASHER
521V2	P04930521V2	SHAFT 200 X 25
522V2	P04930522V2	FASTEN HANDLE M8 X 1.25
524	P04930524	DISC
525V2	P04930525V2	T-NUT M12-1.75 V2.07.10



Tables

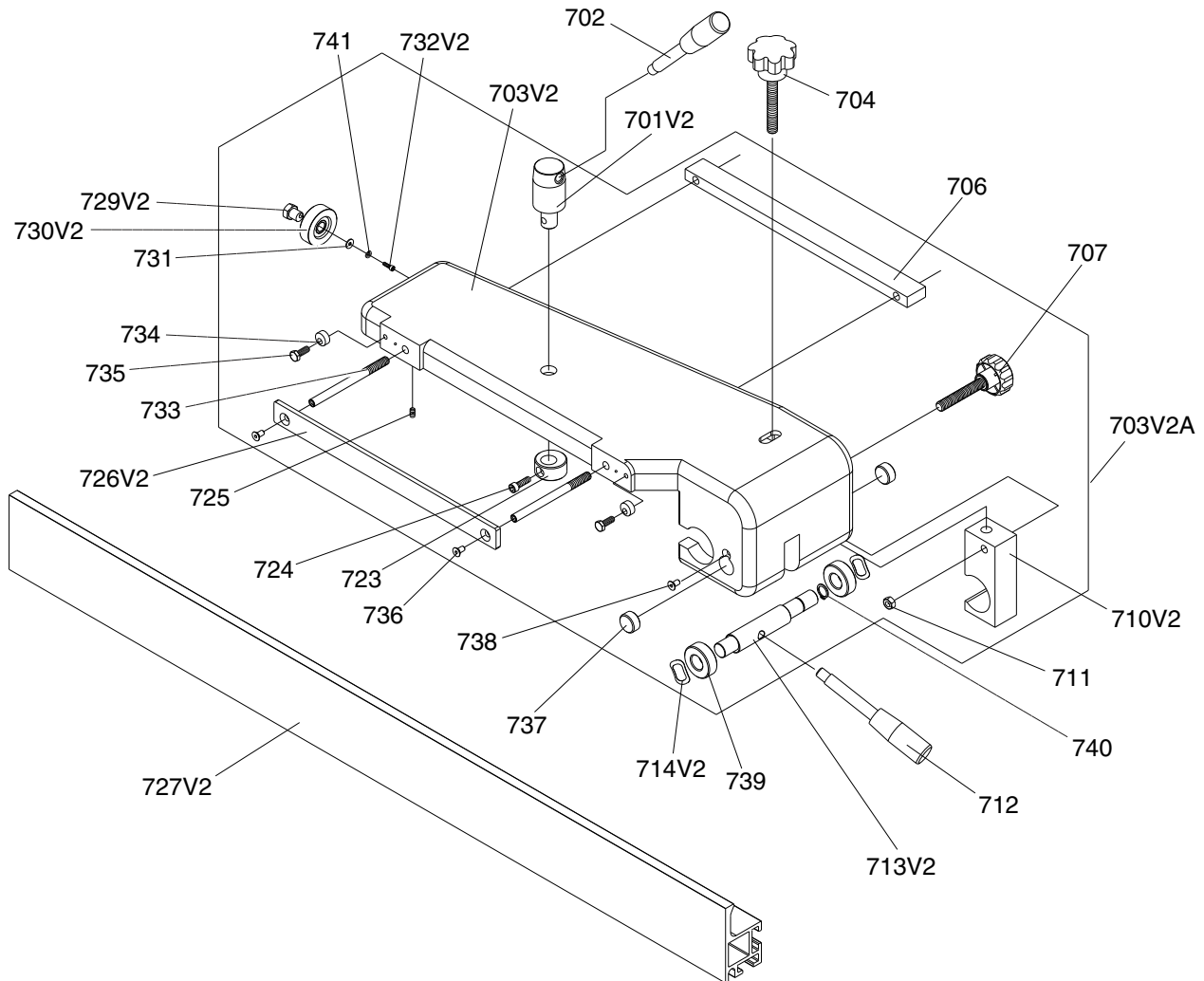


REF	PART #	DESCRIPTION
601	P04930601	SUPPORT BRACE
602	P04930602	HEX NUT M8-1.25
603	P04930603	CAP SCREW M8-1.25 X 20
604	P04930604	CAP SCREW M8-1.25 X 20
605	P04930605	LOCK WASHER 8MM
606	P04930606	FLAT WASHER 8MM
607	P04930607	CAP SCREW M10-1.5 X 20
608	P04930608	LOCK WASHER 10MM
609	P04930609	SET SCREW M6-1 X 12
610	P04930610	SMALL EXTENSION TABLE
611	P04930611	CAST IRON MAIN TABLE
612	P04930612	SUPPORT BRACE
613	P04930613	LARGE EXTENSION TABLE
614	P04930614	LOCK WASHER 10MM
615	P04930615	CAP SCREW M10-1.5 X 30
616	P04930616	DUST HOSE SUPPORT
617	P04930617	HEX NUT M10-1.5
618	P04930618	CAP SCREW M10-1.5 X 20
619	P04930619	LOCK WASHER 10MM
620	P04930620	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
621	P04930621	HEX NUT M6-1
622	P04930622	RIGHT SUPPORT PLATE
623	P04930623	LOCK WASHER 6MM
624	P04930624	HEX BOLT M6-1 X 25
625	P04930625	STUD-FT M12-1.75 X 115
626	P04930626	HEX NUT M12-1.75
627	P04930627	CAP SCREW M8-1.25 X 16
628	P04930628	LOCK WASHER 8MM
629	P04930629	END WASHER CIRCULAR V1
630	P04930630	ROUND RAIL
631	P04930631	STOP RING V1
632	P04930632	SET SCREW M6-1 X 10
633	P04930633	FLAT WASHER 6MM
634	P04930634	FLAT WASHER 12MM
635	P04930635	LOCK WASHER 12MM
636	P04930636	HEX NUT M12-1.75
637	P04930637	TABLE INSERT
638	P04930638	CAP SCREW M5-.8 X 25
639	P04930639	FLAT WASHER 10MM
640	P04930640	SET SCREW M10-1.5 X 20



Rip Fence

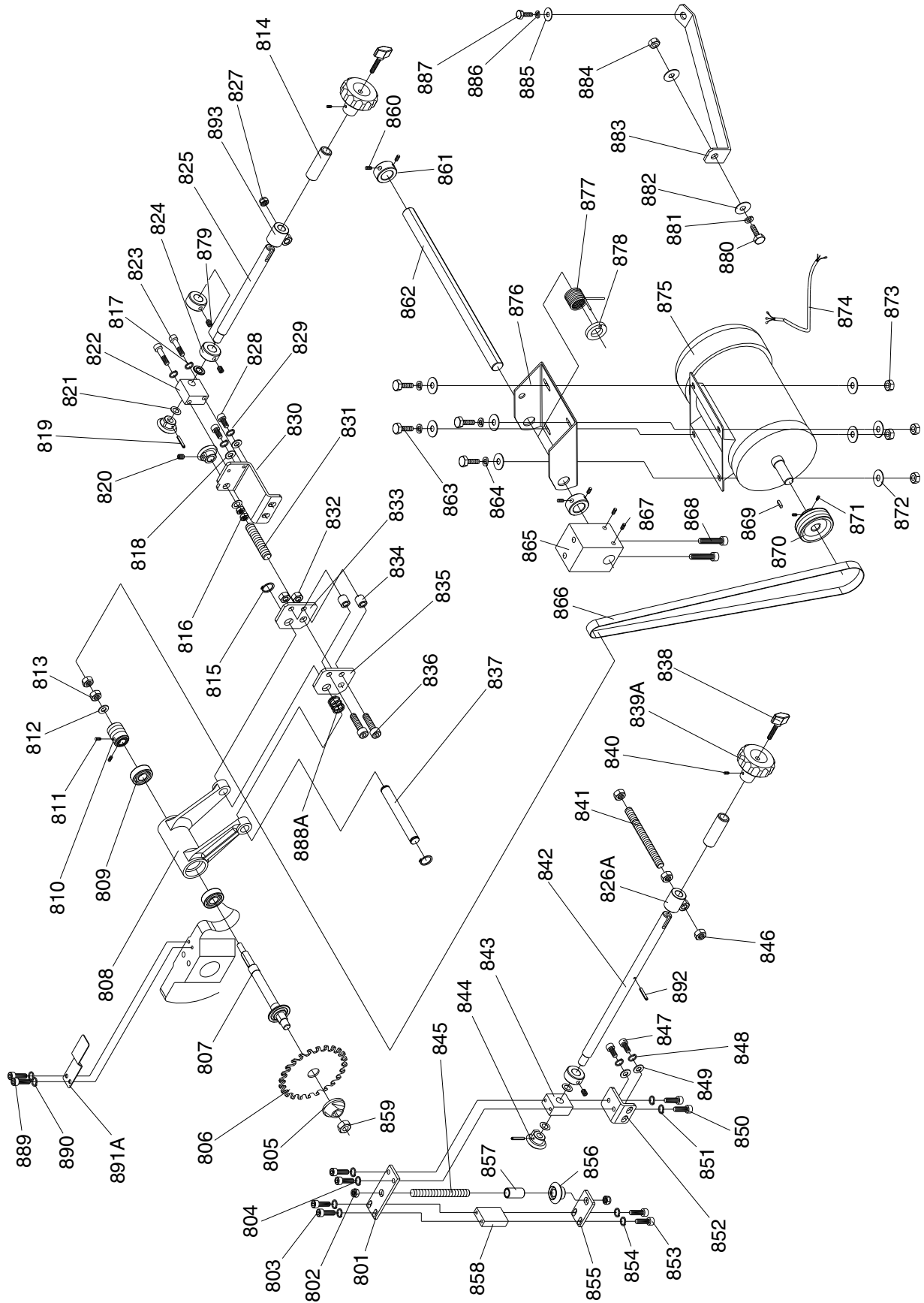


REF	PART #	DESCRIPTION
701V2	P04930701V2	ROTATE SHAFT V2.07.10
702	P04930702	HANDLE
703V2	P04930703V2	RIP FENCE HOUSING V2.07.10
703V2A	P04930703V2A	RIP FENCE ASSY V2.07.10
704	P04930704	KNOB SCREW M10-1.5 X 70
706	P04930706	LOCATE PLATE
707	P04930707	MICRO ADJUSTING KNOB
710V2	P04930710V2	LOCATE BLOCK V2.07.10
711	P04930711	LOCK NUT M10-1.5
712	P04930712	HANDLE
713V2	P04930713V2	CAM SHAFT V2.07.10
714V2	P04930714V2	WAVE WASHER 24MM V2.07.10
723	P04930723	CAM
724	P04930724	CAP SCREW M8-1.25 X 16
725	P04930725	SET SCREW M5-.8 X 10

REF	PART #	DESCRIPTION
726V2	P04930726V2	CLAMP PLATE V2.07.10
727V2	P04930727V2	FENCE PLATE 1M V2.07.10
729V2	P04930729V2	ECCENTRIC SHAFT V2.07.10
730V2	P04930730V2	PLASTIC BEARING V2.07.10
731	P04930731	FLAT WASHER 6MM
732V2	P04930732V2	CAP SCREW M6-1 X 10
733	P04930733	STUD-SE M8-1.25 X 105 30
734	P04930734	ECCENTRIC RING
735	P04930735	HEX BOLT M6-1 X 16
736	P04930736	FLAT HD SCR M5-.8 X 12
737	P04930737	PLUG
738	P04930738	FLAT HD SCR M5-.8 X 8
739	P04930739	RING
740	P04930740	EXT RETAINING RING 15MM
741	P04930741	LOCK WASHER 6MM



Scoring Motor



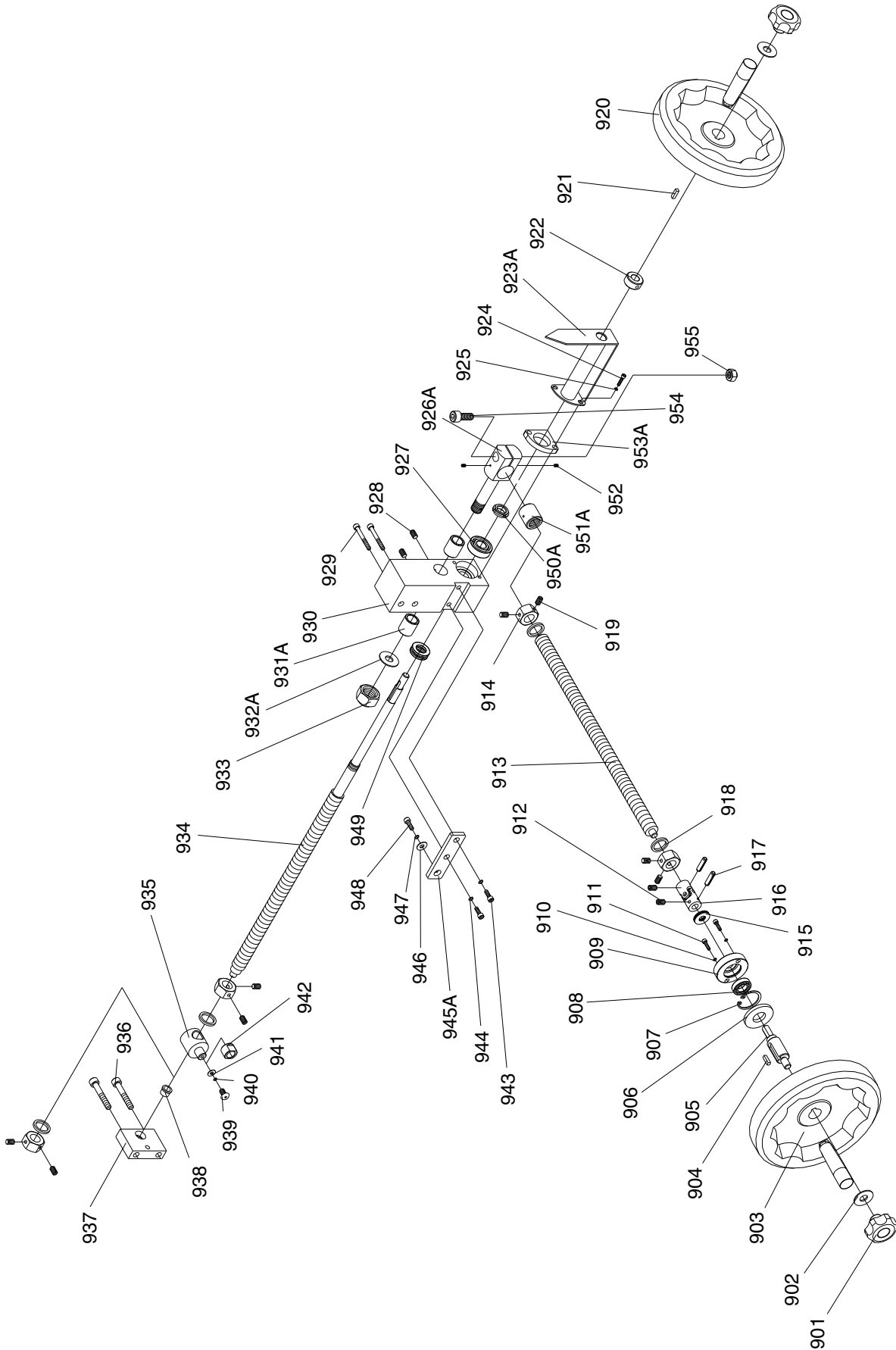
Scoring Motor Parts

REF	PART #	DESCRIPTION
801	P04930801	FIX PLATE
802	P04930802	LOCK NUT M12-1.75
803	P04930803	CAP SCREW M6-1 X 16
804	P04930804	LOCK WASHER 6MM
805	P04930805	SCORING FLANGE
806	P04930806	SCORING SAW BLADE 22MM ARBOR
807	P04930807	SCORING ARBOR 22MM
808	P04930808	REGULATOR
809	P04930809	BALL BEARING 6202 2RS
810	P04930810	SCORING PULLEY
811	P04930811	SET SCREW M6-1 X 6
812	P04930812	FLAT WASHER 8MM
813	P04930813	HEX NUT M8-1.25
814	P04930814	BUSHING
815	P04930815	CHECK RING
816	P04930816	HEX NUT M12-1.75
817	P04930817	LOCK WASHER 6MM
818	P04930818	FLAT WASHER 8MM
819	P04930819	ROLL PIN 3 X 20
820	P04930820	SET SCREW M6-1 X 8
821	P04930821	ASBESTOS WASHER 13MM
822	P04930822	LOCATE PLATE
823	P04930823	CAP SCREW M6-1 X 45
824	P04930824	LOCATE BUSHING
825	P04930825	ADJUST SHAFT
826A	P04930826A	BUSHING V2.10.07
827	P04930827	LOCK NUT M8-1.25
828	P04930828	CAP SCREW M8-1.25 X 20
829	P04930829	LOCK WASHER 8MM
830	P04930830	FIXED PLATE
831	P04930831	SET SCREW M12-1.75 X 65
832	P04930832	LOCK NUT M8-1.25
833	P04930833	FIXED PLATE
834	P04930834	BUSHING
835	P04930835	FIXED PLATE
836	P04930836	CAP SCREW M8-1.25 X 35
837	P04930837	REGULATING SHAFT
838	P04930838	LOCK KNOB M6-1 X 40
839A	P04930839A	ADJUST KNOB V2.10.07
840	P04930840	SET SCREW M5-.8 X 10
841	P04930841	PIN M8-1.25 X 120
842	P04930842	ADJUST SHAFT
843	P04930843	LOCATE PLATE
844	P04930844	GEAR
845	P04930845	STUD-FT M12-1.75 X 120
846	P04930846	HEX NUT M8-1.25

REF	PART #	DESCRIPTION
847	P04930847	CAP SCREW M8-1.25 X 20
848	P04930848	LOCK WASHER 8MM
849	P04930849	FLAT WASHER 8MM
850	P04930850	CAP SCREW M6-1 X 20
851	P04930851	LOCK WASHER 6MM
852	P04930852	FIXED PLATE
853	P04930853	CAP SCREW M6-1 X 16
854	P04930854	LOCK WASHER 6MM
855	P04930855	GEAR FIXED PLATE
856	P04930856	GEAR
857	P04930857	BUSHING
858	P04930858	LOCATE BLOCK
859	P04930859	HEX NUT M12-1.75
860	P04930860	SET SCREW M8-1.25 X 8
861	P04930861	BUSHING
862	P04930862	ROTATE SHAFT
863	P04930863	HEX BOLT M8-1.25 X 25
864	P04930864	LOCK WASHER 8MM
865	P04930865	MOTOR LOCATE BLOCK
866	P04930866	FLAT BELT 15 X 1045 V2.05.07
867	P04930867	SET SCREW M8-1.25 X 12
868	P04930868	CAP SCREW M8-1.25 X 90
869	P04930869	KEY 5 X 5 X 25
870	P04930870	MOTOR PULLEY 60HZ
871	P04930871	SET SCREW M6-1 X 10
872	P04930872	FLAT WASHER 8MM
873	P04930873	HEX NUT M8-1.25
874	P04930874	SCORING MOTOR CORD
875	P04930875	SCORING MOTOR 0.75P-60HZ
876	P04930876	MOTOR PLATE
877	P04930877	SPRING
878	P04930878	COLLAR
879	P04930879	SET SCREW M6-1 X 6
880	P04930880	HEX BOLT M10-1.5 X 30
881	P04930881	LOCK WASHER 10MM
882	P04930882	FLAT WASHER 10MM
883	P04930883	FIX PLATE
884	P04930884	HEX NUT M10-1.5
885	P04930885	FENDER WASHER 8MM
886	P04930886	LOCK WASHER 8MM
887	P04930887	HEX BOLT M8-1.25 X 16
888A	P04930888A	SPRING V2.08.07
889	P04930889	CAP SCREW M6-1 X 16
890	P04930890	LOCK WASHER 6MM
891A	P04930891A	SPRING PLATE V2.08.07
892	P04930892	ROLL PIN 3 X 20



Adjustment Wheels



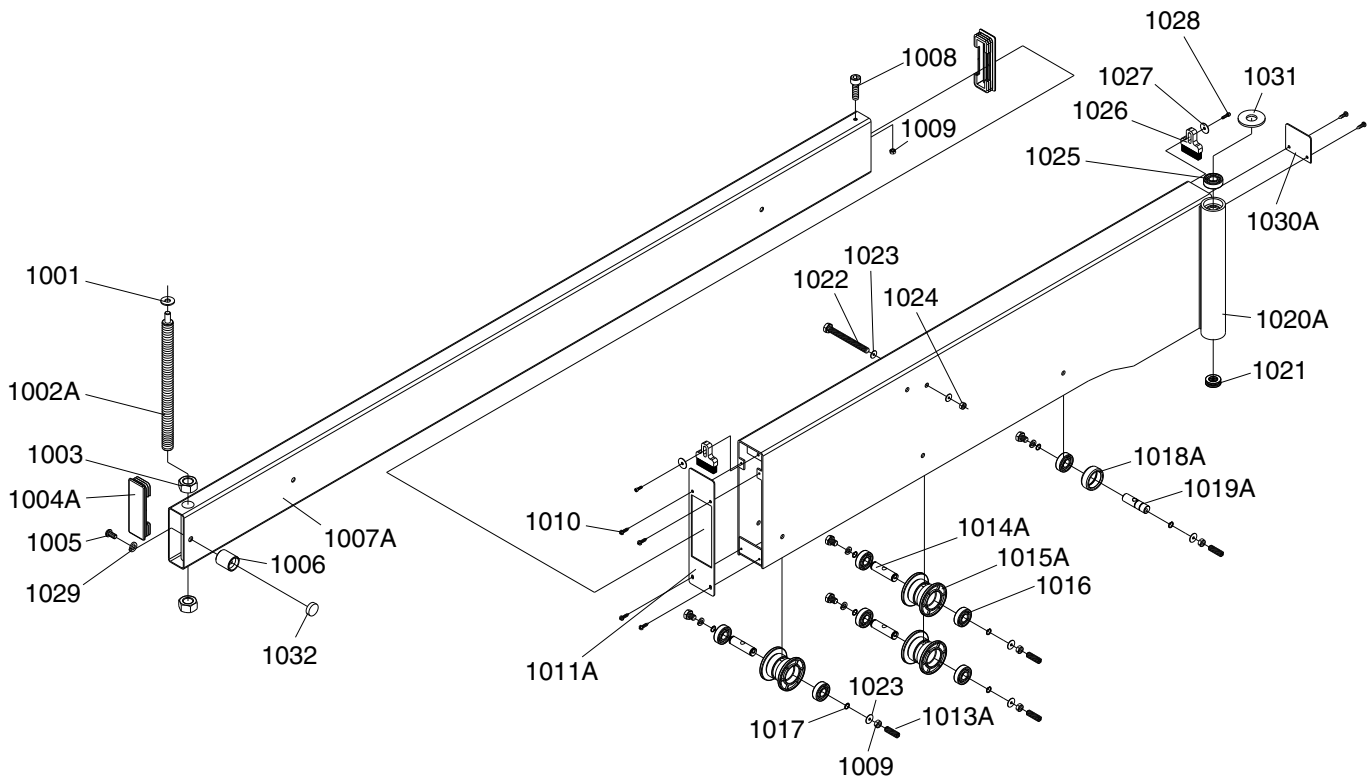
Adjustment Wheels Parts

REF	PART #	DESCRIPTION
901	P04930901	LOCK KNOB 10MM
902	P04930902	FLAT WASHER 10MM
903	P04930903	HAND WHEEL 8"
904	P04930904	KEY 7 X 7 X 20
905	P04930905	HAND WHEEL SHAFT
906	P04930906	SPACER
907	P04930907	INT RETAINING RING 28MM
908	P04930908	BALL BEARING 6902 ZZ
909	P04930909	LOCATE RING
910	P04930910	LOCK WASHER 8MM
911	P04930911	CAP SCREW M8-1.25 20
912	P04930912	SET SCREW M6-1 X 10
913	P04930913	SCREW TR20-2.0 X 2T
914	P04930914	SET NUT TR20-2.0 X 2T
915	P04930915	THRUST BEARING 10 X 12MM
916	P04930916	FREE JOINT
917	P04930917	ROLL PIN 5 X 20
918	P04930918	SPACER RING
919	P04930919	SET SCREW M6-1 X 6
920	P04930920	HAND WHEEL 8"
921	P04930921	KEY 5 X 5 X 30
922	P04930922	LOCATE BUSHING
923A	P04930923A	FINGER GUIDE V2.08.07
924	P04930924	CAP SCREW M6-1 X 20
925	P04930925	LOCK WASHER 6MM
926A	P04930926A	BRACKET NUT V2.08.07
927	P04930927	BALL BEARING 6902 ZZ
928	P04930928	SET SCREW M6-1 X 10

REF	PART #	DESCRIPTION
929	P04930929	CAP SCREW M8-1.25 X 65
930	P04930930	LOCATE BLOCK
931A	P04930931A	SLEEVE V2.08.07
932A	P04930932A	FLAT WASHER 16MM COPPER
933	P04930933	LOCK NUT M16-2
934	P04930934	LEADSCREW TR20-2.0 X 2T
935	P04930935	NUT TR20-2.0 X 2T
936	P04930936	CAP SCREW M8-1.25 X 50
937	P04930937	LOCATE BLOCK
938	P04930938	BUSHING
939	P04930939	CAP SCREW M6-1 X 10
940	P04930940	LOCK WASHER 6MM
941	P04930941	FLAT WASHER 6MM
942	P04930942	SLEEVE
943	P04930943	CAP SCREW M8-1.25 X 20
944	P04930944	LOCK WASHER 8MM
945A	P04930945A	LOCATE PLATE V2.08.07
946	P04930946	FLAT WASHER 8MM
947	P04930947	LOCK WASHER 8MM
948	P04930948	CAP SCREW M8-1.25 X 20
949	P04930949	THRUST BEARING 51102
950A	P04930950A	HEX NUT M15-1 V2.08.07
951A	P04930951A	THREADED BUSHING V2.08.07
952	P04930952	SET SCREW M3-.5 X 10
953A	P04930953A	SPACER PLATE V2.08.07
954	P04930954	CAP SCREW M8-1.25 X 35
955	P04930955	LOCK NUT M8-1.25



Swing Arm

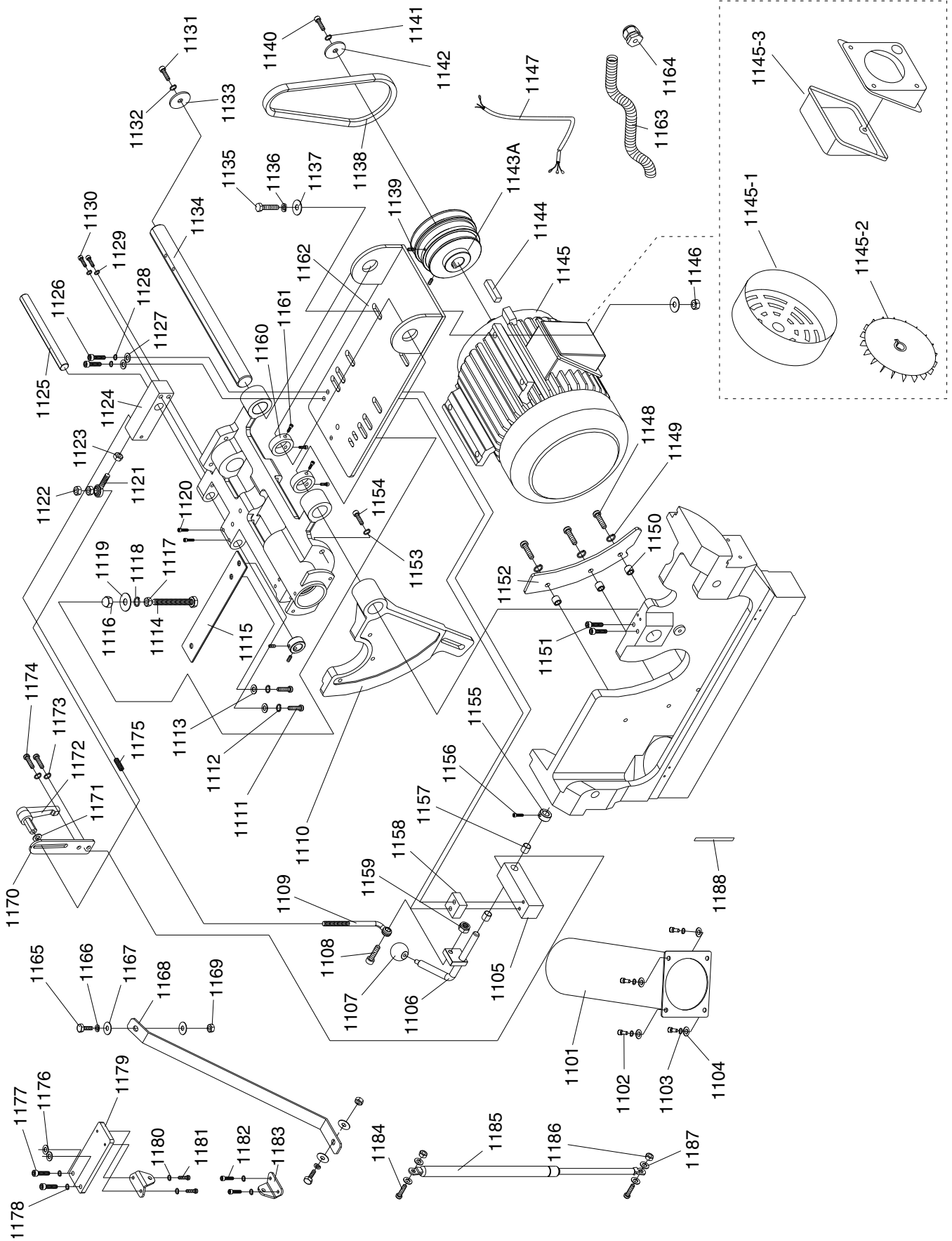


REF	PART #	DESCRIPTION
1001	P04931001	NYLON WASHER 10MM
1002A	P04931002A	SUPPORT SHAFT V2.08.07
1003	P04931003	HEX NUT M20-2.5
1004A	P04931004A	PLUG 40 X 120MM V2.08.07
1005	P04931005	BUTTON HD CAP SCR M8-1.25 X 16
1006	P04931006	MAGNETIC BRACKET
1007A	P04931007A	SLIDING TUBE V2.08.07
1008	P04931008	CAP SCREW M8-1.25 X 30
1009	P04931009	HEX NUT M8-1.25
1010	P04931010	FLANGE SCREW M4-.7 X 6
1011A	P04931011A	COVER V2.08.07
1013A	P04931013A	SET SCREW M8-1.25 X 25
1014A	P04931014A	SHAFT V2.08.07
1015A	P04931015A	ROLLER V2.08.07
1016	P04931016	BALL BEARING 6902 ZZ
1017	P04931017	EXT RETAINING RING 15MM

REF	PART #	DESCRIPTION
1018A	P04931018A	RING V2.08.07
1019A	P04931019A	SHAFT V2.08.07
1020A	P04931020A	SWING ARM V2.08.07
1021	P04931021	THRUST BEARING 51102
1022	P04931022	HEX BOLT M8-1.25 X 80
1023	P04931023	FLAT WASHER 8MM
1024	P04931024	LOCK NUT M8-1.25
1025	P04931025	BALL BEARING 6902 ZZ
1026	P04931026	BRUSH
1027	P04931027	FLAT WASHER 6MM
1028	P04931028	CAP SCREW M6-1 X 20
1029	P04931029	LOCK WASHER 8MM
1030	P04931030	PLATE
1031	P04931031	FLAT WASHER 16MM
1032	P04931032	MAGNET



Main Motor



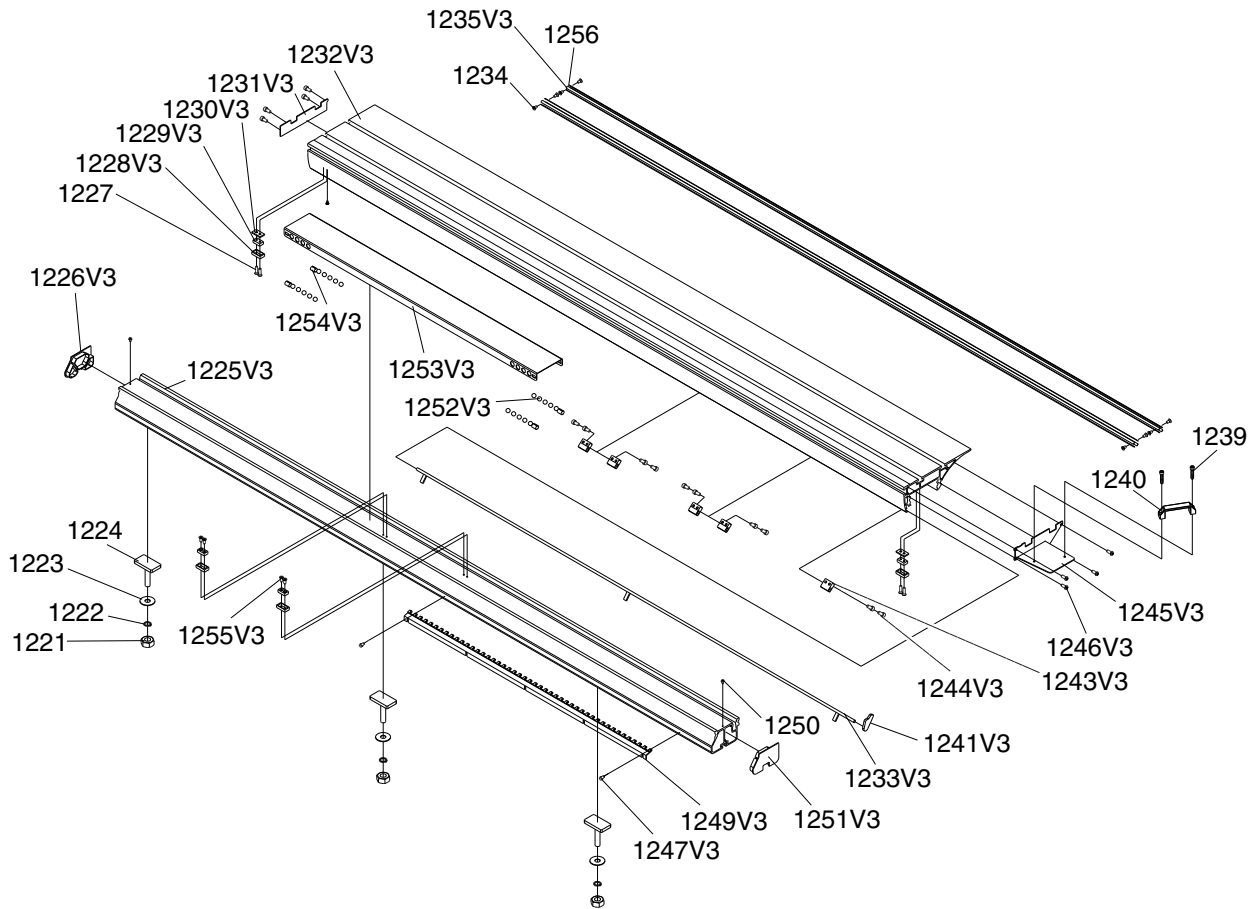
Main Motor Parts

REF	PART #	DESCRIPTION
1101	P04931101	DUST PORT
1102	P04931102	CAP SCREW M8-1.25 X 16
1103	P04931103	LOCK WASHER 8MM
1104	P04931104	FLAT WASHER 8MM
1105	P04931105	FIXED BLOCK
1106	P04931106	HANDLE
1107	P04931107	BALL KNOB M8-1.25
1108	P04931108	CAP SCREW M10-1.5 X 30
1109	P04931109	SHACK BOLT
1110	P04931110	ROTATE PLATE
1111	P04931111	BUTTON HD CAP SCR M10-1.5 X 25
1112	P04931112	LOCK WASHER 10MM
1113	P04931113	FLAT WASHER 10MM
1114	P04931114	HEX BOLT M10-1.5 X 100
1115	P04931115	SPRING PLATE
1116	P04931116	ACORN NUT M10-1.5
1117	P04931117	HEX NUT M10-1.5
1118	P04931118	LOCK WASHER 10MM
1119	P04931119	FLAT WASHER 10MM
1120	P04931120	CAP SCREW M8-1.25 X 10
1121	P04931121	BALL JOINT BEARING M10-1.5 X 65
1122	P04931122	HEX NUT M10-1.5
1123	P04931123	HEX NUT M10-1.5
1124	P04931124	FIXED BLOCK
1125	P04931125	SHAFT
1126	P04931126	CAP SCREW M8-1.25 X 45
1127	P04931127	FLAT WASHER 8MM
1128	P04931128	LOCK WASHER 8MM
1129	P04931129	LOCK WASHER 8MM
1130	P04931130	CAP SCREW M8-1.25 X 55
1131	P04931131	CAP SCREW M10-1.5 X 20
1132	P04931132	LOCK WASHER 10MM
1133	P04931133	FLAT WASHER 10MM
1134	P04931134	SHAFT
1135	P04931135	HEX BOLT M10-1.5 X 40
1136	P04931136	LOCK WASHER 10MM
1137	P04931137	FLAT WASHER 10MM
1138	P04931138	V-BELT B-30 5L300
1139	P04931139	SET SCREW M6-1 X 10
1140	P04931140	CAP SCREW M10-1.5 X 20
1141	P04931141	LOCK WASHER 10MM
1142	P04931142	FLAT WASHER 10MM
1143A	P04931143A	MAIN MOTOR PULLEY V2.08.07
1144	P04931144	KEY 8 X 7 X 50
1145	P04931145	MOTOR 10HP
1145-1	P04931145-1	MOTOR FAN COVER

REF	PART #	DESCRIPTION
1145-2	P04931145-2	MOTOR FAN
1145-3	P04931145-3	MOTOR JUNCTION BOX
1146	P04931146	HEX NUT M10-1.5
1147	P04931147	MAIN MOTOR CORD
1148	P04931148	BUTTON HD CAP SCR M10-1.5 X 25
1149	P04931149	LOCK WASHER 10MM
1150	P04931150	COLLAR
1151	P04931151	CAP SCREW M10-1.5 X 20
1152	P04931152	GIB PLATE
1153	P04931153	LOCK WASHER 10MM
1154	P04931154	CAP SCREW M10-1.5 X 40
1155	P04931155	COLLAR
1156	P04931156	CAP SCREW M6-1 X 10
1157	P04931157	BUSHING BEARING DU1415
1158	P04931158	FIXED BLOCK
1159	P04931159	LOCK NUT M10-1.5
1160	P04931160	BUSHING
1161	P04931161	CAP SCREW M10-1.5 X 16
1162	P04931162	MAIN MOTOR PLATE
1163	P04931163	WAVE HOSE 2M
1164	P04931164	STRAIN RELIEF BG-04
1165	P04931165	HEX BOLT M10-1.5 X 30
1166	P04931166	LOCK WASHER 10MM
1167	P04931167	FLAT WASHER 10MM
1168	P04931168	FIX PLATE
1169	P04931169	HEX NUT M10-1.5
1170	P04931170	FIX PLATE
1171	P04931171	FLAT WASHER 8MM
1172	P04931172	FASTEN HANDLE 8MM
1173	P04931173	LOCK WASHER 8MM
1174	P04931174	CAP SCREW M8-1.25 X 20
1175	P04931175	SET SCREW M8-1.25 X 30
1176	P04931176	FLAT WASHER 8MM
1177	P04931177	CAP SCREW M8-1.25 X 25
1178	P04931178	LOCK WASHER 8MM
1179	P04931179	FIXED PLATE
1180	P04931180	LOCK WASHER 6MM
1181	P04931181	CAP SCREW M6-1 X 20
1182	P04931182	CAP SCREW M6-1 X 12
1183	P04931183	FIXED PLATE
1184	P04931184	CAP SCREW M8-1.25 X 20
1185	P04931185	GAS PRESSURE REGULATOR
1186	P04931186	LOCK NUT M8-1.25
1187	P04931187	FLAT WASHER 8MM
1188	P04931188	SPONGE



Sliding Table

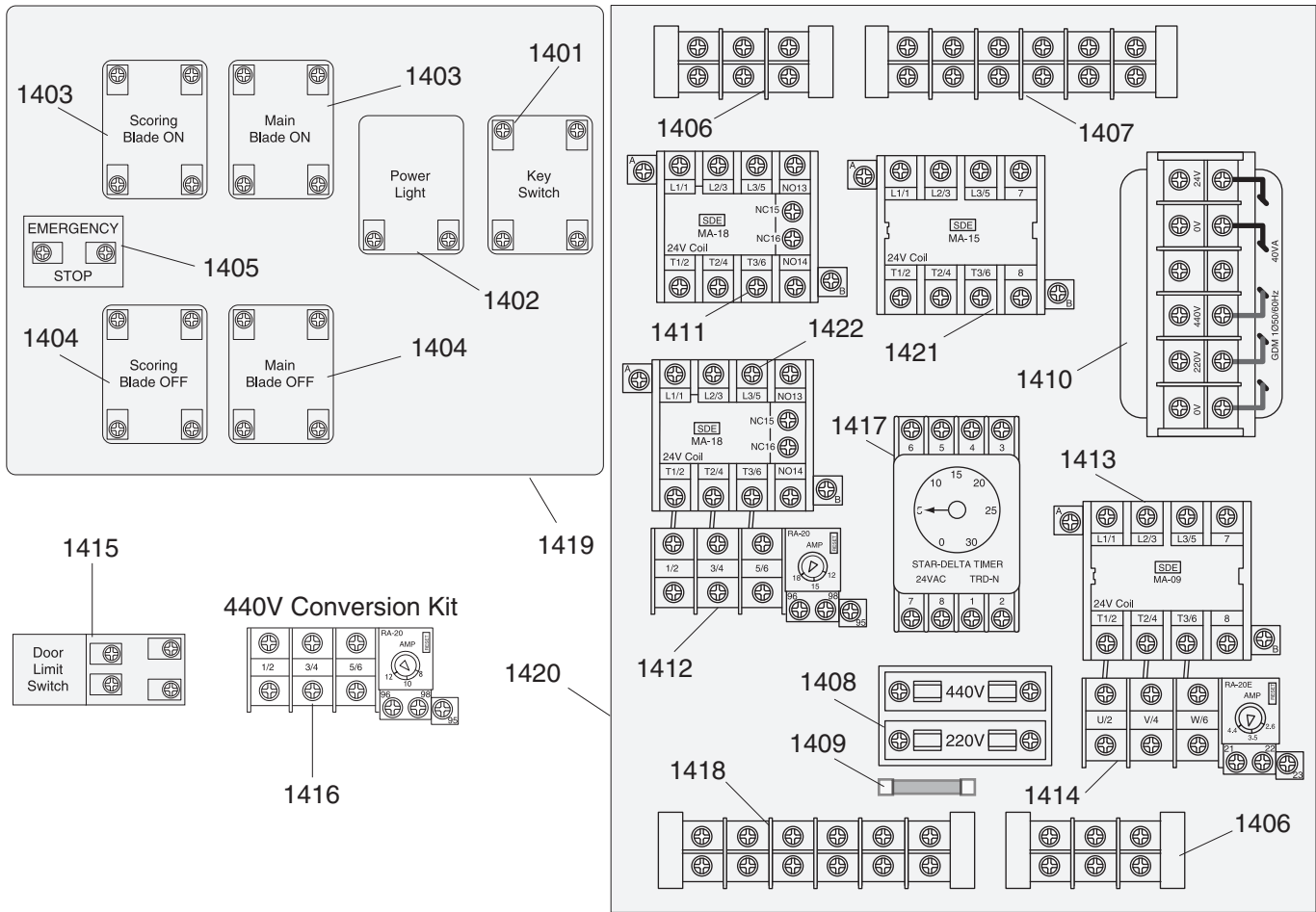


REF	PART #	DESCRIPTION
1221	P04931221	HEX NUT M12-1.75
1222	P04931222	LOCK WASHER 12MM
1223	P04931223	FLAT WASHER 12MM
1224	P04931224	T-BOLT M12-1.75 X 40
1225V3	P04931225V3	BOTTOM BASE 3200MM V3.07.10
1226V3	P04931226V3	COVER V3.07.10
1227	P04931227	FLAT HD SCR M6-1 X 30
1228V3	P04931228V3	RUBBER BLOCK V3.07.10
1229V3	P04931229V3	LOCATE BLOCK V3.07.10
1230V3	P04931230V3	PLATE V3.07.10
1231V3	P04931231V3	COVER V3.07.10
1232V3	P04931232V3	TOP BASE 3200MM V3.07.10
1233V3	P04931233V3	LOCATE ROD V3.07.10
1234	P04931234	FLAT HD SCR M6-1 X 10
1235V3	P04931235V3	STEEL RAIL V3.07.10
1239	P04931239	CAP SCREW M8-1.25 X 12

REF	PART #	DESCRIPTION
1240	P04931240	HANDLE
1241V3	P04931241V3	LOCK HANDLE V3.07.10
1243V3	P04931243V3	LOCATE BLOCK V3.07.10
1244V3	P04931244V3	FLAT HD SCR M5-.8 X 10
1245V3	P04931245V3	RIGHT END PLATE V3.07.10
1246V3	P04931246V3	BUTTON HD CAP SCR M6-1 X 12
1247V3	P04931247V3	BUTTON HD CAP SCR M6-1 X 16
1249V3	P04931249V3	TEETH LOCATE PLATE V3.07.10
1250	P04931250	TAP SCREW M5 X 16
1251V3	P04931251V3	COVER V3.07.10
1252V3	P04931252V3	STEEL BALL 16.6MM V3.07.10
1253V3	P04931253V3	SLIDING BOTTOM V3.07.10
1254V3	P04931254V3	WOOL PAD V3.07.10
1255V3	P04931255V3	BUTTON HD CAP SCR M6-1 X 20
1256	P04931256	ADHESIVE



Electrical Components

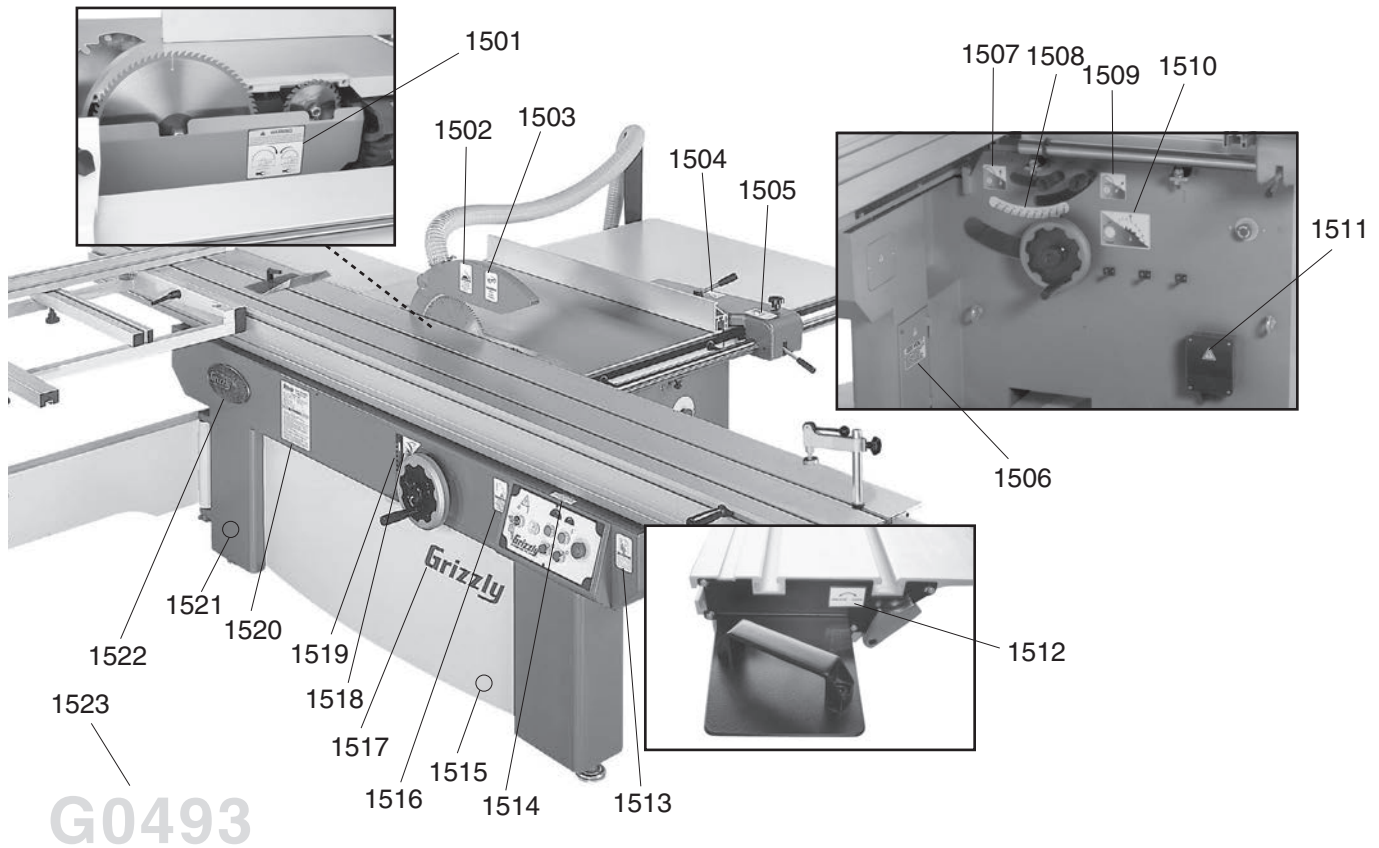


REF	PART #	DESCRIPTION
1401	P04510001	KEY SWITCH
1402	P04510002	POWER LAMP
1403	P04510003	ON SWITCH BUTTON
1404	P04510004	OFF SWITCH BUTTON
1405	P04510005	E-STOP BUTTON
1406	P04510006	TERMINAL 3 CIRCUIT (25A)
1407	P04510007	TERMINAL 6 CIRCUIT (15A)
1408	P04510008	FUSE BASE
1409	P04510009	FUSE 250V 10A
1410	P04510010A	TRANSFORMER
1411	P04510011A	MAG CONTACTOR MA-18 24V

REF	PART #	DESCRIPTION
1412	P04931412	OL RELAY RA-20 (12-18A)
1413	P04931413	MAG CONTACTOR MA-09 24V
1414	P04931414	OL RELAY RA-20E (2.6-4.4A)
1415	P04931415	LIMIT SWITCH
1416	P04931416	440V CONV. KIT (OLR RA-20 8-12A)
1417	P04931417	STAR-DELTA TIMER (24VAC)
1418	P04931418	TERMINAL 6 CIRCUIT (25A)
1419	P04931419	CONTROL PANEL ASSEMBLY
1420	P04931420	ELECTRICAL BOX ASSEMBLY
1421	P04931421	MAG CONTACTOR MA-15 24V
1422	P04931422	MAG CONTACTOR MA-18 24V



Parts List



REF	PART #	DESCRIPTION
1501	P04931501	LOWER BLADE GUARD LABEL
1502	P04931502	UPPER BLADE GUARD LABEL
1503	P04931503	SAFETY GLASSES LABEL
1504	P04931504	LOOSEN/TIGHTEN FENCE LABEL
1505	P04931505	KICKBACK WARNING LABEL
1506	P04931506	PREWIRED 220V LABEL
1507	P04931507	SCORING VERTICAL ADJUST LABEL
1508	P04931508	BLADE TILT SCALE LABEL
1509	P04931509	SCORING HORIZONTAL ADJUST LABEL
1510	P04931510	MAIN BLADE ELEVATION LABEL
1511	P04931511	ELECTRICITY LABEL
1512	P04931512	SLIDING TABLE LOCK LABEL

REF	PART #	DESCRIPTION
1513	P04931513	READ MANUAL LABEL
1514	P04931514	TRAINED PERSONNEL ONLY LABEL
1515	P04931515	"PUTTY" COLOR TOUCH-UP PAINT
1516	P04931516	DISCONNECT POWER LABEL
1517	P04931517	GRIZZLY LABEL
1518	P04931518	BLADE TILT LABEL
1519	P04931519	MAIN BLADE ELEVATION SCALE
1520	P04931520	MACHINE ID LABEL
1521	P04931521	"GRIZZLY GREEN" TOUCH-UP PAINT
1522	P04931522	GRIZZLY NAMEPLATE-LARGE CAST
1523	P04931523	MODEL NUMBER 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.





WARRANTY CARD

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 Model # _____ Order # _____ Serial # _____

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

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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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