



MODEL G0513X2B 17" BANDSAW w/MOTOR BRAKE MANUAL INSERT

The Model G0513X2B is the same as the Model G0513X, except it has a cast iron trunnion, key switch, and a magnetic brake motor. Besides the data sheet, circuit requirements, certain setup and operation procedures, the wiring diagram, and parts in this insert, the content in the Model G0513X owner's manual is the same for both machines. On the following pages, the header indicates which page it replaces in the Model G0513X manual, if applicable.

Before operating your new machine, you **MUST** read and understand this insert and the entire Model G0513X manual to reduce the risk of injury from improper use or setup.

If you have any questions about this manual insert or the differences between the Model G0513X2B and the Model G0513X, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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(FOR MODELS MANUFACTURED SINCE 5/11) #BL10777 PRINTED IN TAIWAN



MACHINE DATA SHEET

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

MODEL G0513X2B 17" 2 HP EXTREME-SERIES® BANDSAW W/ CAST IRON TRUNNION & BRAKE.

Product Dimensions:

Weight..... 352 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 32 x 32 x 73 in.
 Footprint (Length x Width)..... 27 x 17-3/4 in.

Shipping Dimensions:

Type..... Wood Slat Crate
 Content..... Machine
 Weight..... 421 lbs.
 Length x Width x Height..... 31 x 20 x 81 in.

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 8.7A
 Minimum Circuit Size..... 15A
 Switch..... Magnetic with Thermal Overload Protection
 Switch Voltage..... 220V
 Recommended Power Cord..... 3-Wire, 14 AWG, 300VAC, "S"-Type
 Plug Included..... No
 Recommended Plug/Outlet Type..... NEMA 6-15

Motors:

Main

Type..... TEFC Capacitor Start Induction
 Horsepower..... 2 HP
 Voltage..... 220V
 Phase..... Single
 Amps..... 8.7A
 Speed..... 1725 RPM
 Cycle..... 60 Hz
 Number of Speeds..... 1
 Power Transfer..... Belt Drive
 Bearings..... Shielded and Permanently Lubricated

Main Specifications:

Operation

Blade Speeds..... 1700, 3500 FPM
 Table Tilt..... Left 5, Right 45 deg.

Cutting Capacities

Maximum Cutting Height..... 12 in.
 Max Capacity Left of Blade..... 16-1/4 in.



Blade Information

Standard Blade Length..... 131-1/2 in.
Blade Width Range..... 1/8-1 in.
Upper Blade Guides..... Ball Bearing
Lower Blade Guides..... Ball Bearing

Table Information

Table Length..... 23-5/8 in.
Table Width..... 17-1/4 in.
Table Thickness..... 1-1/2 in.
Floor to Table Height..... 37-1/2 in.

Fence Information

Locks in Front..... Yes
Locks in Rear..... No
Adjustable for Blade Lead..... Yes

Construction

Table..... Precision Ground Cast Iron
Rip Fence Cast Iron
Body..... One Piece Reinforced Steel
Upper Wheel..... Computer Balanced Cast Iron
Lower Wheel..... Computer Balanced Cast Iron
Tire..... Polyurethane
Wheel Cover Pre-Formed Steel
Paint..... Powder Coated

Other Related Information

Number of Dust Ports..... 2
Dust Port Size..... 4 in.

Other Specifications:

Country Of Origin Taiwan
Warranty 1 Year
Serial Number Location Table
Assembly Time 1 Hour

Features:

- Cast Iron Table Trunnion
- Ball Bearing Blade Guides
- Quick Change Blade Release/Tensioner
- Micro-Adjusting Gear Table Tilt
- Rack & Pinion Upper Blade Guide Height Adjustment
- Computer Balanced Cast Iron Wheels with Grizzly Bear Head Cut-Outs
- Blade Tension Indicator
- Height Scale for Upper Blade Guides
- Blade Tracking Window
- Hinged Wheel Covers
- Deluxe Cast Iron Fence with Extruded Aluminum Resaw Fence Attachment
- Included Miter Gauge
- Two 4 in. Dust Ports
- Motor Stops in Under 3 Seconds After Switch is Turned Off
- Included 1/2 in. Blade



(Replaces Section 1 on Page 11)

SECTION 1: SAFETY

WARNING

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

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



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



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



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

NOTICE

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

WARNING

Safety Instructions for Machinery

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

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.

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

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

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.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



WARNING

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well-lighted to minimize risk of injury.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify or alter machine for a purpose not intended by the manufacturer or serious injury may result!

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

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

REMOVE ADJUSTING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

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

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

NEVER STAND ON MACHINE. Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

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.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine may increase the risk of serious injury.

CHECK DAMAGED PARTS. Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

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



WARNING

Additional Safety for Bandsaws

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to perform the cut and increase the risk of kickback. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position fingers or hands in line with the blade. If the workpiece or your hands slip, serious personal injury could occur.

WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is NOT designed to cut metal, glass, stone, tile, etc.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure the blade teeth face down toward the table and the blade is properly tensioned and tracked before operating.

BLADE SPEED. Moving the workpiece against a blade that is not at full speed could cause the blade to grab the workpiece and draw the operator's hands into the blade. Always allow the blade to come to full speed before starting the cut.

GUARDS. The blade guard protects the operator from the moving bandsaw blade. ONLY operate this bandsaw with the blade guard in the proper position.

CUTTING TECHNIQUES. Plan your operation so the blade always cuts to the outside of the workpiece. DO NOT back the workpiece away from the blade while the bandsaw is running, which could cause kickback and personal injuries. If you need to back the workpiece out, turn the bandsaw OFF and wait for the blade to come to a complete stop. DO NOT twist or put excessive stress on the blade that could damage it.

LEAVING WORK AREA. Never leave a machine running unattended. Allow the bandsaw to come to a complete stop and use the padlock to disable the machine before you leave it unattended.

FEED RATE. To avoid the risk of the workpiece slipping and causing operator injury, always feed stock evenly and smoothly. DO NOT force or twist the blade while cutting, especially when sawing small curves.

SMALL WORKPIECE HANDLING. If your hands slip while holding small workpieces with your fingers during a cut, amputation or laceration injuries could occur. Always support/feed the workpiece with push sticks, jig, vise, or some type of clamping fixture.

BLADE CONTROL. To avoid serious personal injury, DO NOT attempt to stop or slow the blade with your hand or the workpiece. Allow the blade to stop on its own.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

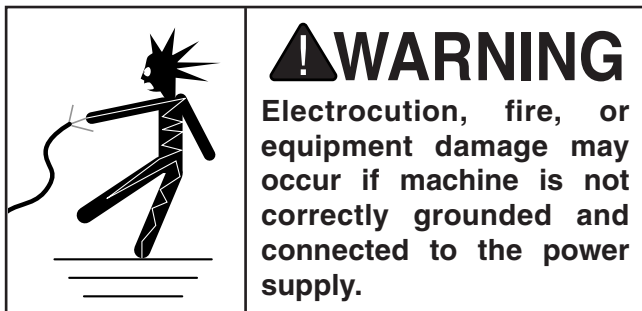


(Replaces Section 2 on Page 14)

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 a qualified electrician 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 8.7 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 requirements in the following section.

Circuit Requirements for 220V

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V/240V
Cycle.....60 Hz
Phase..... 1-Phase
Circuit Rating..... 15 Amps
Plug/Receptacle NEMA 6-15
Cord.....3-Wire, 14 AWG, 300VAC, “S”-Type

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 machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)



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



Grounding Instructions

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

The power cord and plug specified under “Circuit Requirements for 220V” on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

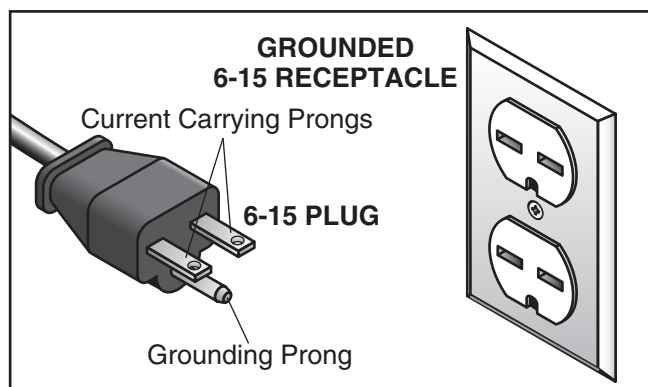
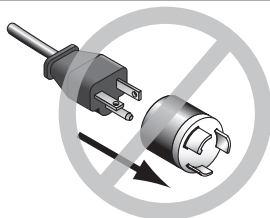


Figure 1. Typical 6-15 plug and receptacle.

⚠ CAUTION



No adapter should be used with the required plug. If the plug does not fit the available receptacle, or the machine must be reconnected for use on a different type of circuit, the reconnection must be made by a qualified electrician and comply with all local codes and ordinances.

⚠ WARNING

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

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size 14 AWG
Maximum Length (Shorter is Better).....50 ft.



(Replaces Inventory on Page 17)

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

If any non-proprietary 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.

Crate Contents (Figure 2):	Qty
A. Bandsaw (not shown)	1
B. Table w/Table Insert	1
C. Miter Gauge.....	1
D. Resaw Fence	1
E. Front Square Rail	1
F. Fence Assembly.....	1
G. Guide Post Handwheel.....	1

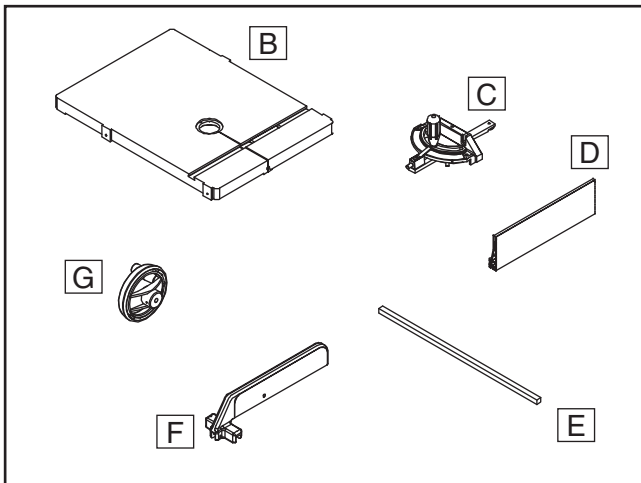


Figure 2. G0513X2B inventory.

Hardware and Tools: Qty

- Eye Bolt M10-1.5 (may be installed) 1
- Hex Bolts M8-1.25 x 25 (Table) 4
- Flat Washers 8mm (Table, Fence, Rail)..... 8
- Lock Washers 8mm (Table, Rail) 5
- Lock Washers 6mm (Rail) 3
- Flat Washers 6mm (Rail)..... 3
- Cap Screws M6-1 x 20 (Rail) 3
- Cap Screw M8-1.25 x 20 (Rail) 1
- Knobs M8-1.25 x 20 (Rail)..... 2
- Hex Bolt M8-1.25 x 90 (Pos. Stop) 1
- Hex Nuts M8-1.25 (Pos. Stop, Fence)..... 2
- Lock Handle M8-1.25 x 44 (Fence) 1
- Moving Plate (Fence)..... 1
- Table Pin..... 1
- Rail Plates 3
- Hex Wrench 5mm & 8mm 1 Ea
- Open End Wrench 10 x 13mm 1

NOTICE

If you cannot find an item on this list, check the mounting location on the machine or the packaging materials. Sometimes parts are pre-installed for shipping, or they become hidden by packaging materials.



(Replaces Table on Page 21)

Components and Hardware Needed: Qty
Hex Bolts M8-1.25 x 25 4

1. Follow **Steps 1-3** on **Page 21** in the G0513X Manual. If the table insert is pre-installed, remove it now.
2. With the help of another person, lift the table onto the trunnions.
3. Secure the table to the trunnions with the four M8-1.25 x 25 hex bolts, 8mm lock washers and 8mm flat washers.
4. Follow **Steps 6-9** in the G0513X Manual.

(Replaces Positive Stop on Page 23)

Components and Hardware Needed: Qty
Hex Bolts M8-1.25 x 90 1
Hex Nut M8-1.25..... 1

To install the positive stop:

1. Unlock the table tilt lock lever, tilt the table to access the positive stop bolt installation location, then lock the lever.
2. Thread the M8-1.25 hex nut halfway onto the M8-1.25 x 90 hex bolt (this is the positive stop bolt).
3. Thread the positive stop bolt into the threaded hole on the bandsaw body.
4. Lower the table onto the positive stop bolt.
5. Follow **To Set the Positive Stop** on G0513X Manual **Page 24**.

(Replaces Installing Fence on Page 25)

Components and Hardware Needed: Qty
Fence Assembly 1
Front Rail 1
Rail Plates 3
Cap Screws M6-1 x 20 3
Flat Washers 6mm 3
Lock Washers 6mm..... 3
Cap Screw M8-1.25 x 20 1
Knobs M8-1.25 x 20 2
Flat Washers 8mm 4
Lock Washer 8mm 1
Resaw Fence..... 1
Lock Handle M8-1.25 x 44 1
Moving Plate..... 1

To install the fence:

1. Attach the rail plates to the front rail with the three M6-1 x 20 cap screws, 6mm lock washers, and 6mm flat washers (see **Figure 3**).

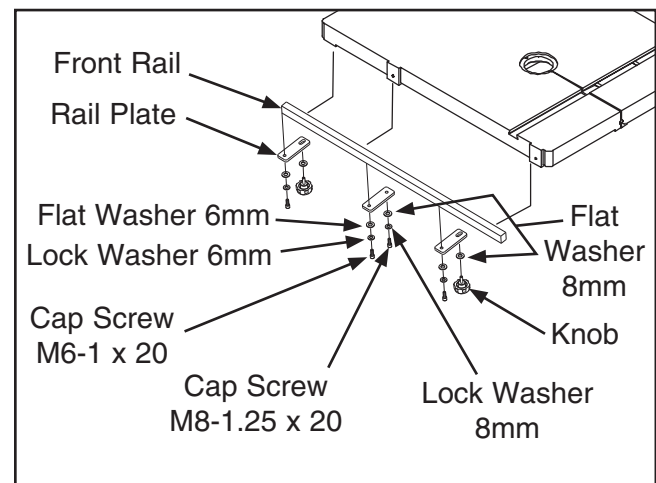


Figure 3. Installing front rail onto table.

2. Attach the outer two rail plates with the round and elongated mounting holes on the outer part of the table bottom with two M8-1.25 x 20 knobs and 8mm flat washers. Attach the remaining rail plate with the round mounting holes using an M8-1.25 x 20 cap screw, 8mm lock washer and 8mm flat washer (**Figure 3**).



3. Thread the fence handle into the fence, then tighten the hex nut against the fence pivot block (see **Figure 4**).

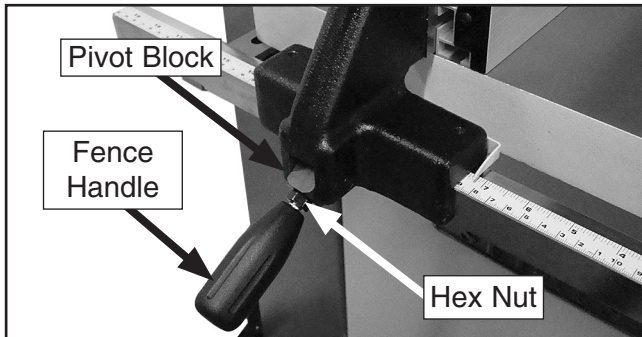


Figure 4. Fence handle components.

4. Install the resaw fence lock handle (with the washer and moving plate) onto the fence, then slide the resaw fence over the moving plate as shown in **Figure 5**.

Note: Leave the moving plate and lock handle loose enough to slide on the fence.

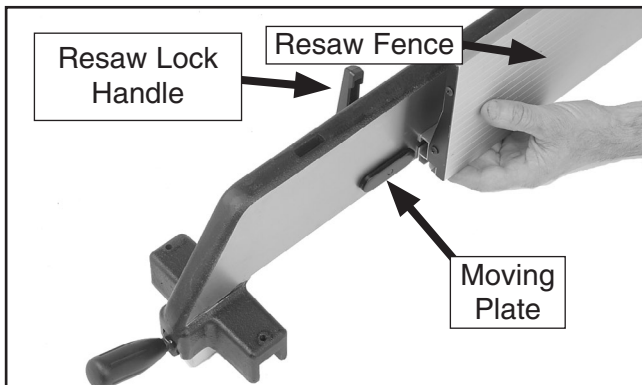


Figure 5. Attaching resaw fence to standard fence.

5. Tighten the resaw lock handle.
6. Pull the fence handle up and place the fence assembly on the rail.
7. Push the fence handle down to lock the fence assembly in place.

Guide Post Handwheel

Secure the guide post handwheel onto the flat part of the handwheel shaft with the M6-1 x 20 cap screw.

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Power Connection

After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine.

Connecting Power

1. Turn the machine power switch **OFF**.
2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

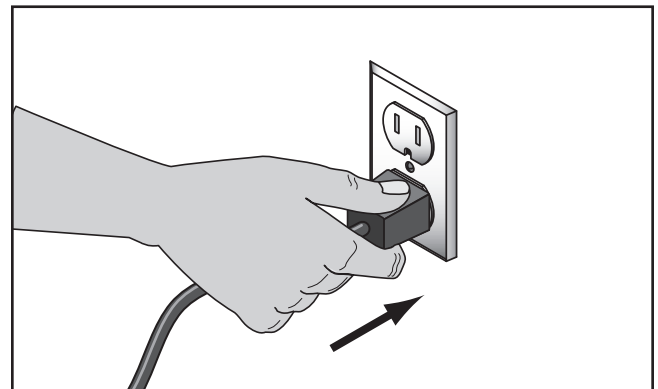


Figure 6. Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.
2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.

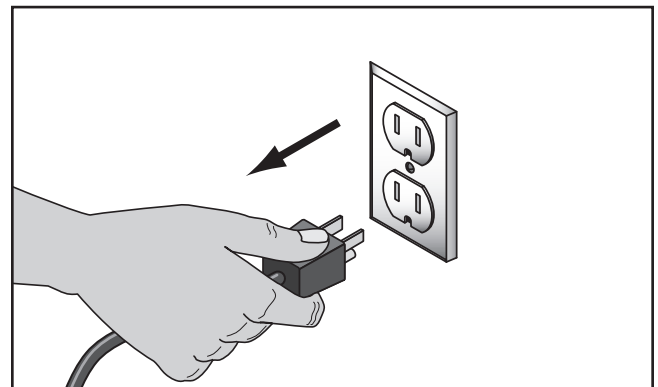


Figure 7. Disconnecting power.

(Replaces Test Run on Page 21)

To test run the machine:

1. Follow **Steps 1-5** on G0513X Manual **Page 26**.
2. Verify that the machine is operating correctly by turning the switch disabling key (**Figure 8**) to "1" and turning the machine **ON**.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.



Figure 8. G0513X2 switch disabling key and ON/OFF switch.

3. Press the OFF button to stop the machine.

4. WITHOUT resetting the OFF button, press the ON button. The machine should not start.

—If the machine does not start, the OFF button safety feature is working correctly.

—If the machine does start (with the stop button pushed in), immediately disconnect power to the machine. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

5. Twist the OFF button clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 9**).

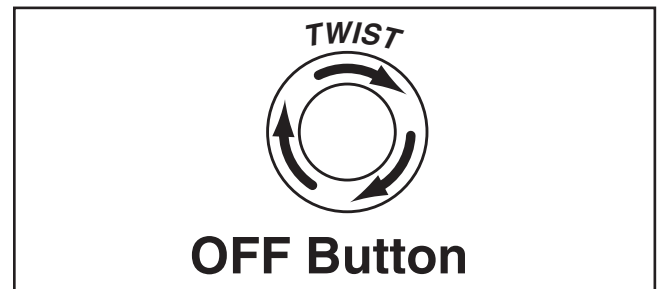


Figure 9. Resetting the switch.

6. Turn the switch disabling key to "0", as shown in **Figure 8**.
7. Try to turn the machine **ON**.

—If the bandsaw does not start, the switch disabling feature is working as designed. The Test Run is complete.

—If the bandsaw starts, immediately disconnect power. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Motor Brake

The motor brake is activated automatically when the OFF button is pushed.



(Replaces Aligning Fence on Page 31)

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

To align the fence parallel with the miter slot:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the miter slot is aligned with the bandsaw blade (refer to **Aligning Table** on G0513X Manual **Page 30**).
3. If the fence is mounted on the left-hand side of the blade, remove it and remount it next to the miter slot.
4. Loosen the knobs and cap screw that secure the fence rail to the table (see **Figure 3 on Page 10**).
5. Adjust the fence face parallel with the edge of the miter slot, as shown in **Figure 10**.



Figure 10. Example of fence square with miter slot.

6. Tighten the knobs and cap screw that secure the rail to the table, being careful not to move the fence.

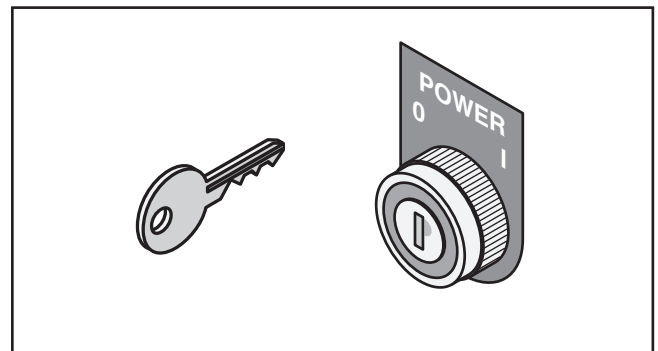
NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the "Aligning Table" instructions on G0513X Manual Page 30.

Disabling & Locking Switch

The power switch can be disabled and locked by removing the key, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

IMPORTANT: Locking the power switch with a key only restricts its function. It is not a substitute for disconnecting power from the machine when adjusting or servicing.



! WARNING

Children or untrained people can be killed or seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, remove the key from the switch before leaving machine unattended! Place key in a well-hidden or secure location.



Pointer Calibration

Your new bandsaw is equipped with a fence measurement system that includes a fence pointer, which must be calibrated when the bandsaw is first set up.

To calibrate the pointer:

1. If the fence is mounted on the right-hand side of the blade, remove it and re-install it on the left-hand side of the blade.
2. Place the fence flush against the bandsaw blade (Figure 11).



Figure 11. Fence flush with blade.

3. Loosen the pointer adjustment nut (Figure 12) and set the pointer in line with "0" and the measurement scale on the table.

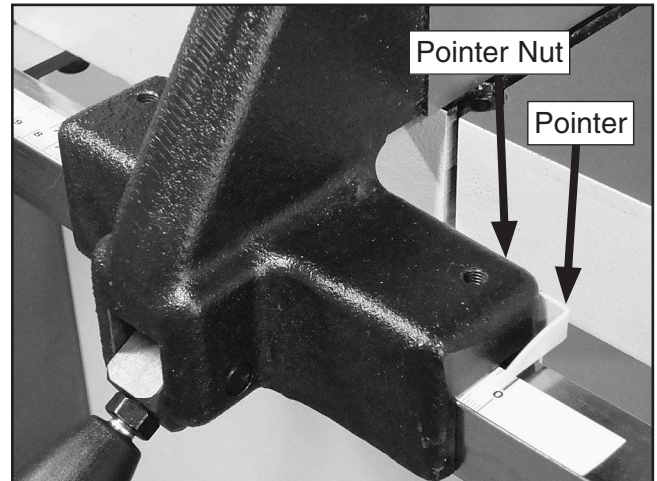


Figure 12. Calibrating fence pointer (screw out of view).

4. Re-tighten the pointer adjustment nut.



(Replaces Lubrication on Page 45)

To lubricate the blade guide rack and pinion:

1. DISCONNECT BANDSAW FROM POWER!
2. Lower the blade guide until it reaches the table.
3. Wipe off any existing grease and sawdust buildup on the rack (see **Figure 13**).

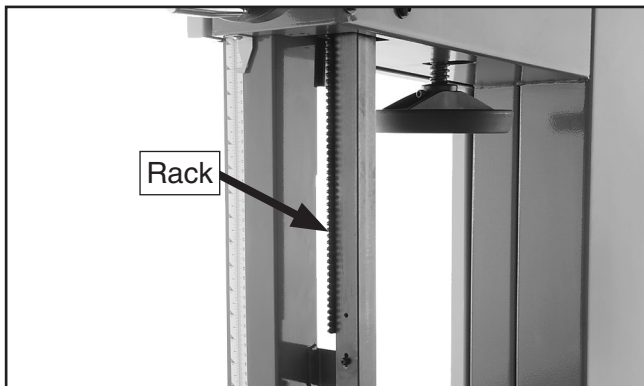


Figure 13. Rack lubrication location.

4. Apply a thin coat of light all-purpose grease to the rack.
5. Move the blade guide up and down several times to distribute the grease, then remove any excess grease to help prevent sawdust buildup.

To lubricate the blade tracking knob:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the blade tracking lock lever, then unscrew the blade tracking knob 5 turns.
3. Wipe off any existing grease and sawdust buildup on the threads.
4. Apply a few dabs of a light all-purpose grease to the threads.
5. Re-adjust tracking (see **Blade Tracking** on G0513X Manual **Page 22**).

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To lubricate the tension adjustment assembly:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the top wheel cover and look through the top of the wheel.
3. Wipe off any existing grease and sawdust buildup on the blade tension adjustment assembly and tension lever cam.
4. Apply a thin coat of grease to the tension adjustment assembly and tension lever cam (see **Figure 14**).

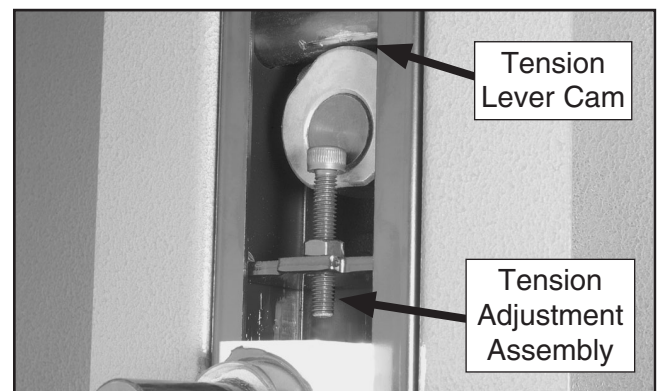


Figure 14. Tension adjustment assembly locations (top wheel removed for clarity).

To lubricate the trunnions:

1. DISCONNECT BANDSAW FROM POWER!
2. Move the table up until it reaches its maximum 45° angle and wipe off all excess grease and sawdust from the trunnions.
3. Apply a thin coat of light all purpose grease to the trunnions (see **Figure 15**).

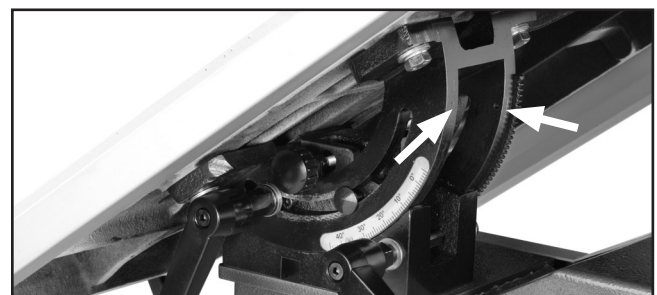


Figure 15. Trunnion lubrication location.

4. Move the table down and up to distribute the grease, then wipe off any excess grease.



Magnetic Brake Adjustment

The space between the magnetic motor brake and brake shoe is preset by the factory at 0.2mm. However, you should adjust this space every two to three years, or when it takes over five seconds for the brake to stop the motor.

Tools Needed

Phillips Head Screwdriver.....	1
US Dollar Bills	2
Hex Wrench 3mm.....	1
Hex Wrench 4mm.....	1

To adjust the space between the magnetic brake and brake shoe:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the motor fan cover, then loosen the cap screws securing the motor fan and brake shoe (see **Figure 16**).

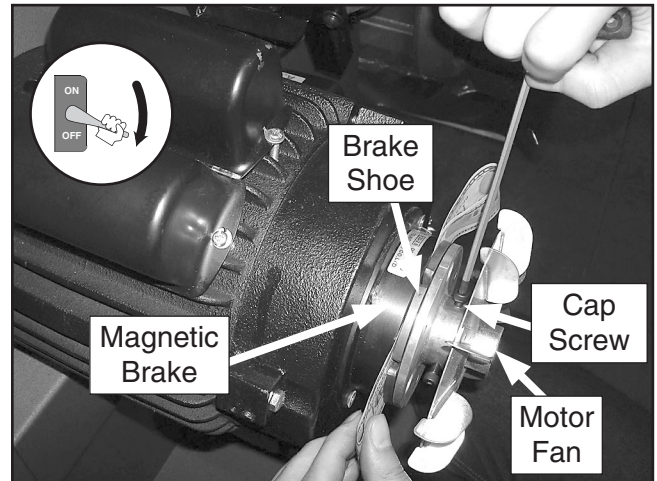


Figure 16. Adjusting distance between magnetic brake and brake shoe.

3. Fold two dollar bills in half and slide them between the brake shoe and magnetic brake on either side (see **Figure 16**). The space between the brake and shoe is correctly set when there is just enough tension to allow you to slide the dollar bills out.
4. Tighten the cap screws on the motor fan, then re-install the fan cover.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and 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. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

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

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



G0513X2B Electrical Components

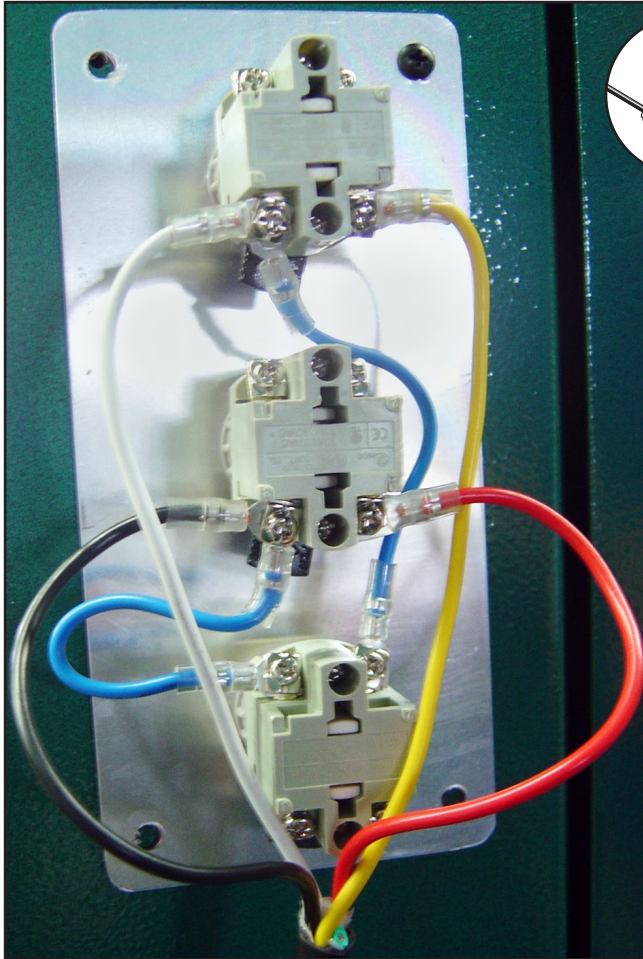


Figure 17. Control panel wiring.

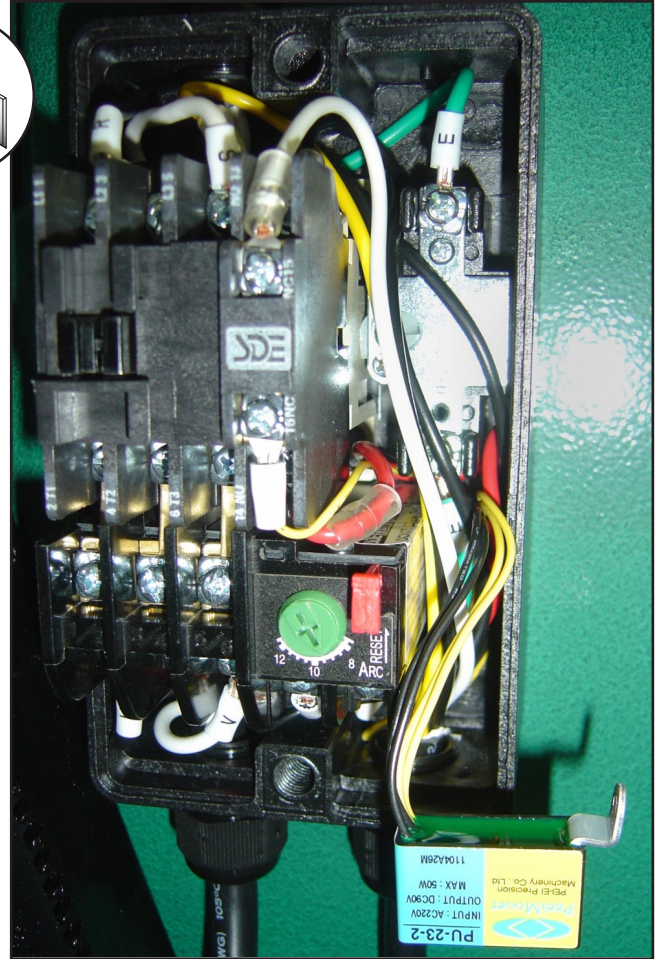


Figure 19. Magnetic switch.

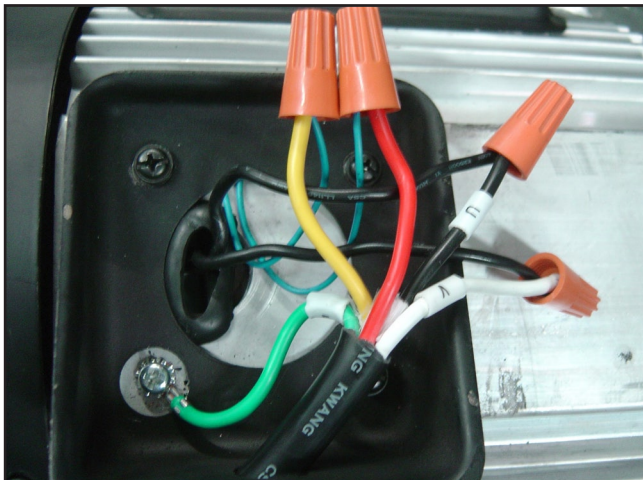


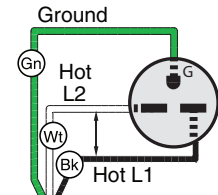
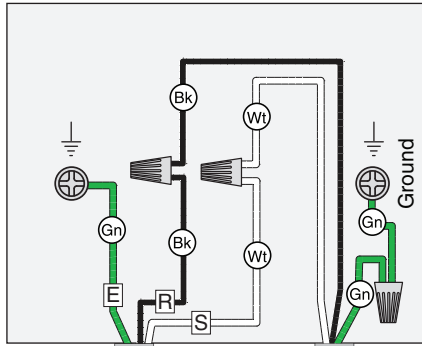
Figure 18. Motor wiring.



G0513X2B Wiring Diagram 220V, 1-Ph



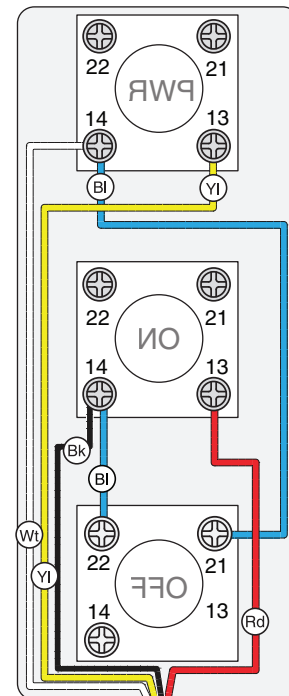
POWER SUPPLY JUNCTION BOX



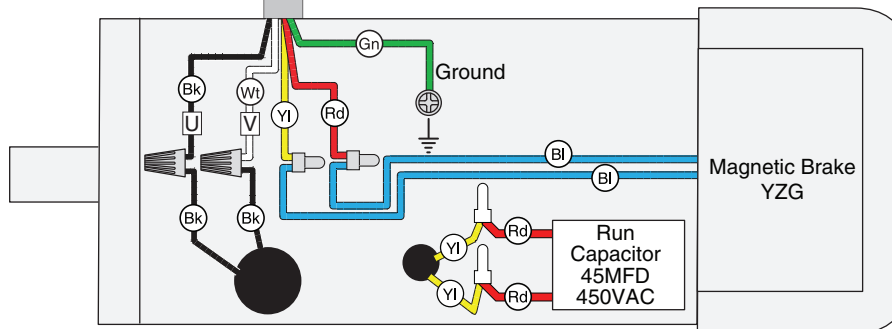
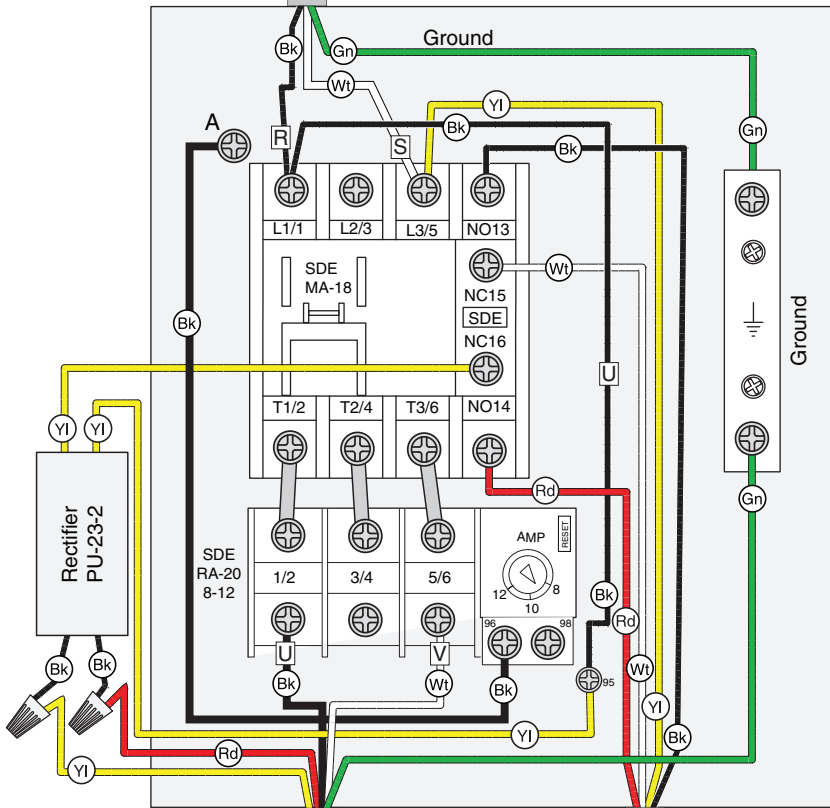
220 VAC

6-15 PLUG
(as recommended)

CONTROL PANEL
(viewed from behind)
See Figure 17



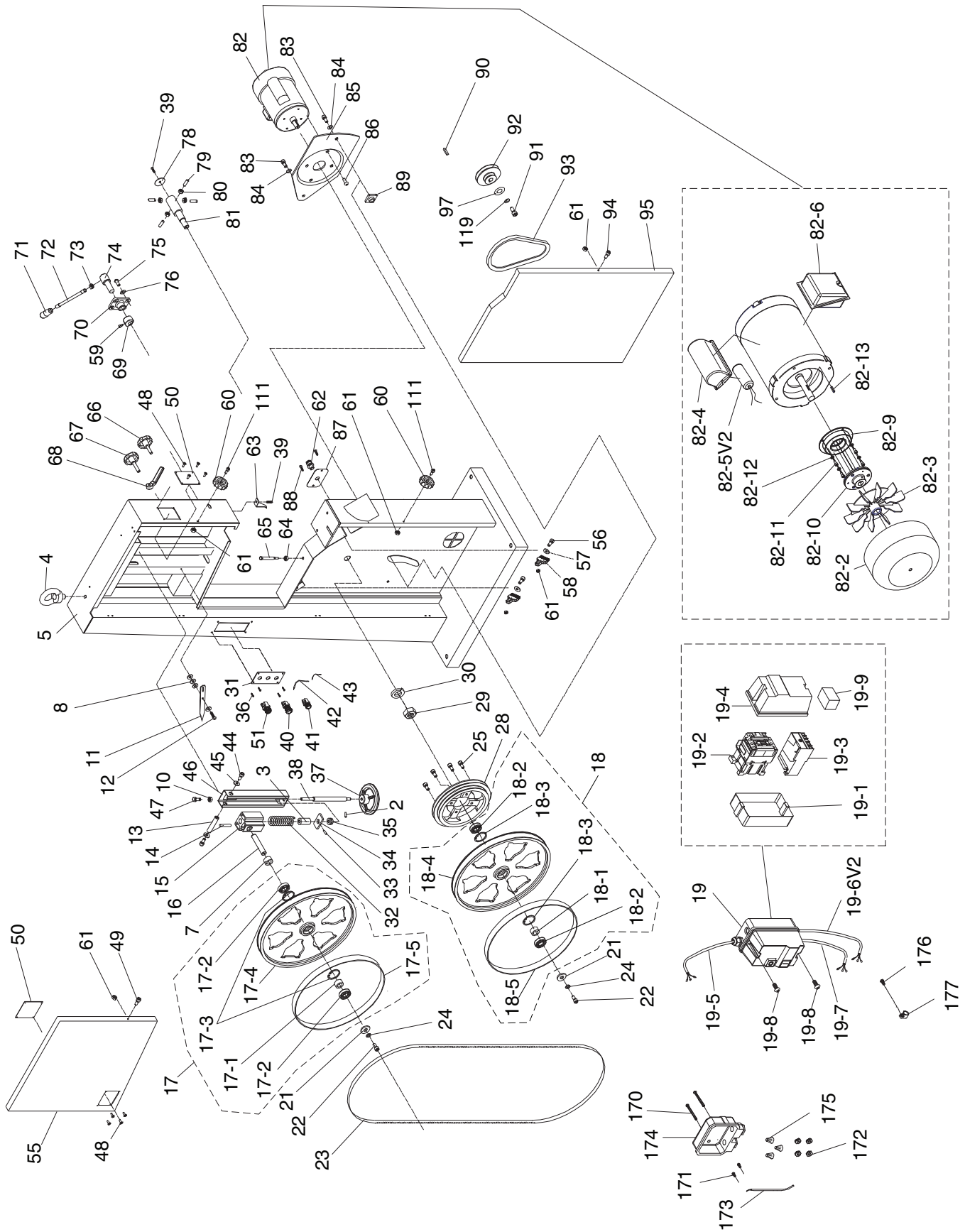
MAGNETIC SWITCH
See Figure 19



220V MOTOR
See Figure 18



Main Breakdown



Main Parts List

REF	PART #	DESCRIPTION
2	PSS01M	SET SCREW M6-1 X 10
3	P0513X003	BUSHING
4	P0513004	LIFTING EYE BOLT M10-1.5
5	P0513005	MACHINE BODY
7	P0513X007	BUSHING
8	PW03M	FLAT WASHER 6MM
10	PN01M	HEX NUT M6-1
11	P0513011	POINTER
12	P0513012	SHOULDER SCREW M4-.7 X 5
13	P0513013	UPPER SHAFT
14	PRP91M	ROLL PIN 5 X 35
15	P0513015	UPPER WHEEL SHAFT HINGE
16	P0513016	UPPER WHEEL SHAFT
17	P0513X2B017	UPPER WHEEL ASSEMBLY
17-1	P0513017	BUSHING
17-2	P6204LLU	BALL BEARING 6204LLU
17-3	PR25M	INT RETAINING RING 47MM
17-4	P0513X2B017-4	UPPER WHEEL 17"
17-5	T23071	UPPER TIRE
18	P0513X2B018	LOWER WHEEL ASSEMBLY
18-1	P0513017	BUSHING
18-2	P6204LLU	BALL BEARING 6204LLU
18-3	PR25M	INT RETAINING RING 47MM
18-4	P0513X2B018-4	LOWER WHEEL 17"
18-5	T23071	LOWER TIRE
19	P0513X2B019	MAG SWITCH ASSEMBLY MPE-18
19-1	P0513X2B019-1	MAG SWITCH BACK COVER
19-2	P0513X2B019-2	CONTACTOR SDE MA-18 220V
19-3	P0513X2B019-3	RELAY SDE RA-20 8-12
19-4	P0513X2B019-4	MAG SWITCH FRONT COVER
19-5	P0513X2B019-5	POWER CORD 14AWG X 3C
19-6V2	P0513X2B019-6V2	CONTROL CORD 16AWG X 5C V2.05.11
19-7	P0513X2B019-7	MOTOR CORD 14AWG X 5C
19-8	PS09M	PHLP HD SCR M5-.8 X 10
19-9	P0513X2B019-9	RECTIFIER (PU-23-2)
21	PW01M	FLAT WASHER 8MM
22	PSB11M	CAP SCREW M8-1.25 X 16
23	P0513023	SAW BLADE 1/2" X 131.5"
24	PLW04M	LOCK WASHER 8MM
25	PCAP14M	CAP SCREW M8-1.25 X 20
28	P0513X028	IDLE PULLEY
29	PN32	HEX NUT 1-14
30	PLW09	LOCK WASHER 1"
31	P0513X2B031	SWITCH PLATE
32	P0513032	COMPRESSION SPRING
33	PRP02M	ROLL PIN 3 X 16
34	P0513034	LOCATE BLOCK
35	P51201	THRUST BEARING 51201
36	PHTEK15M	TAP SCREW M4 X 10
37	P0513037	HANDWHEEL
38	P0513038	ADJUSTING BOLT
39	PFS07M	FLANGE SCREW M5-.8 X 10
40	P0513X2B040	STOP SWITCH
41	P0513X2B041	START SWITCH
42	P0513X2B042	SWITCH CORD
43	P0513043	SWITCH CORD
44	PCAP11M	CAP SCREW M8-1.25 X 16
45	PWF08M	FENDER WASHER 8MM
46	P0513046	UPPER WHEEL SLIDING BRACKET

REF	PART #	DESCRIPTION
47	PCAP06M	CAP SCREW M6-1 X 25
48	P0513048	RIVET 3.2 X 10
49	PCAP04M	CAP SCREW M6-1 X 10
50	P0513050	CLEAR WINDOW
51	P0513X2B051	KEY SWITCH
55	P0513055	UPPER WHEEL COVER
56	PB10M	HEX BOLT M6-1 X 25
57	PW03M	FLAT WASHER 6MM
58	P0513058	BRUSH
59	PCAP06M	CAP SCREW M6-1 X 25
60	P0513X060	STAR KNOB
61	PLN03M	LOCK NUT M6-1
62	P0513062	STRAIN RELIEF 16MM
63	P0513063	HEIGHT POINTER
64	PN03M	HEX NUT M8-1.25
65	PB124M	HEX BOLT M8-1.25 X 90
66	P0513066	KNOB SCREW M10-1.5 X 20
67	P0513067	KNOB SCREW M10-1.5 X 53
68	P0513068	THREADED HANDLE 10MM
69	P0513069	CAM
70	P0513070	PILLOW BLOCK
71	P0513071	HANDLE M10-1.5
72	P0513072	LEVER ROD
73	PN09M	HEX NUT M12-1.75
74	P0513074	SHAFT
75	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
76	PLW04M	LOCK WASHER 8MM
78	P0513078	COVER
79	PSS09M	SET SCREW M8-1.25 X 20
80	PN03M	HEX NUT M8-1.25
81	P0513081	LOWER WHEEL SHAFT
82	P0513X2B082	MOTOR 2HP W/BRAKE
82-2	P0513X2B082-2	MOTOR FAN COVER
82-3	P0513X2B082-3	MOTOR FAN
82-4	P0513X2B082-4	CAPACITOR COVER
82-5V2	P0513X2B082-5V2	R. CAPACITOR 45M 450VAC V2.05.11
82-6	P0513X2B082-6	JUNCTION BOX
82-9	P0513X2B082-9	MAGNETIC BRAKE
82-10	P0513X2B082-10	BRAKE SHOE
82-11	PCAP26M	CAP SCREW M6-1 X 12
82-12	PLW03M	LOCK WASHER 6MM
82-13	PK23M	KEY 5 X 5 X 25
83	PB32M	HEX BOLT M10-1.5 X 25
84	PLW06M	LOCK WASHER 10MM
85	P0513085	MOTOR BRACKET
86	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
87	P0513087	PLATE
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0513089	PILLOW BLOCK
90	PK15M	KEY 5 X 5 X 35
91	PB81M	HEX BOLT M8-1.25 X 20 LH
92	P0513092	MOTOR PULLEY
93	PVA42	V-BELT A-42 4L420
94	PCAP04M	CAP SCREW M6-1 X 10
95	P0513095	LOWER WHEEL COVER
97	PWF08M	FENDER WASHER 8MM
111	PCAP02M	CAP SCREW M6-1 X 20
119	PLW04M	LOCK WASHER 8MM



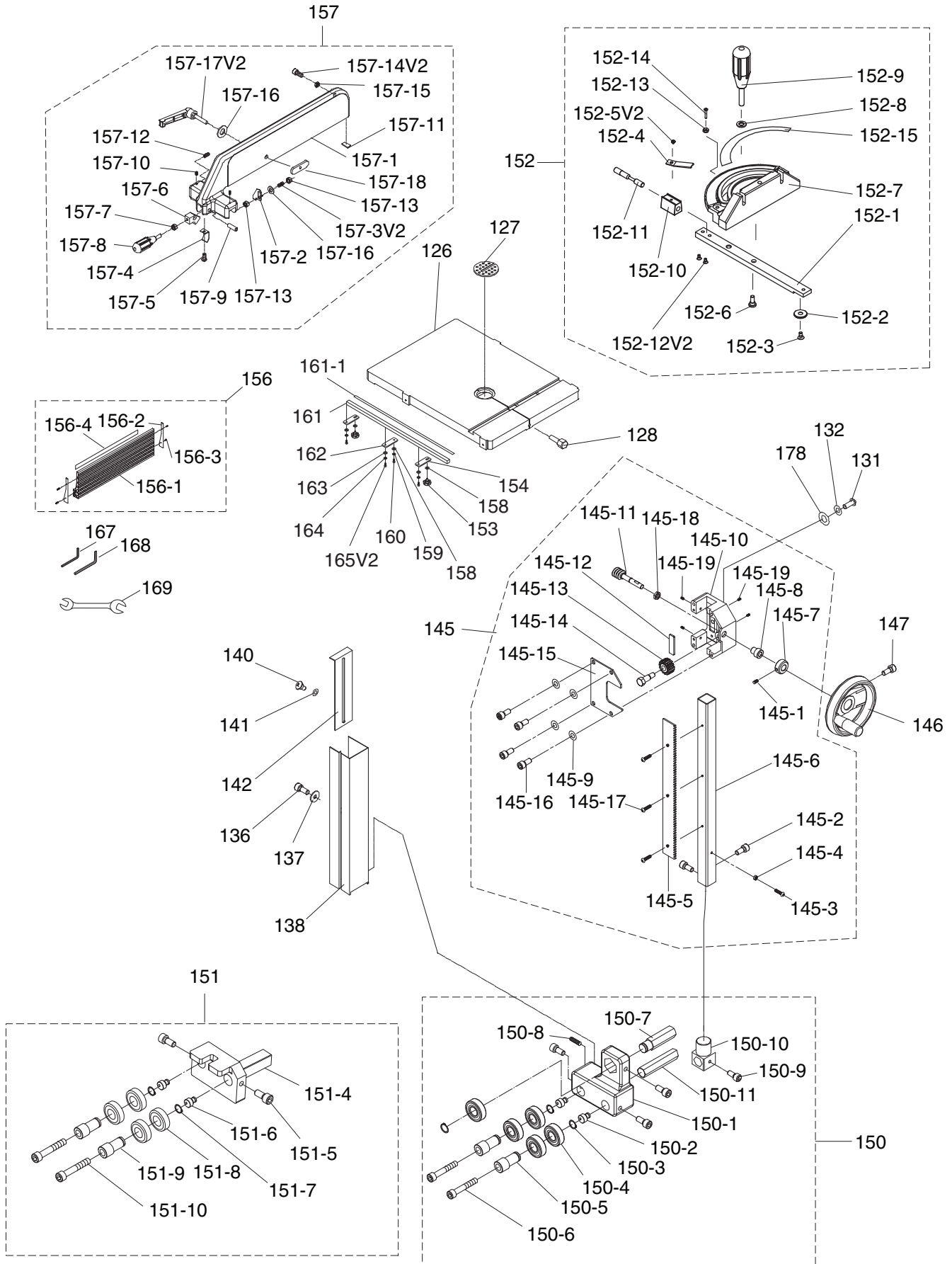
Main Parts List

REF	PART #	DESCRIPTION
170	PFS09M	FLANGE SCREW M5-.8 X 50
171	PS38M	PHLP HD SCR M4-.7 X 10
172	PTLW02M	EXT TOOTH WASHER 5MM
173	P0513X2B173	CONNECTING CORD

REF	PART #	DESCRIPTION
174	P0513X2B174	TERMINAL BOX
175	P0513X2B175	WIRE NUT P3
176	PFS07M	FLANGE SCREW M5-.8 X 10
177	P0513X2B177	STRAIN RELIEF 5/16"



Fence-Guides Breakdown



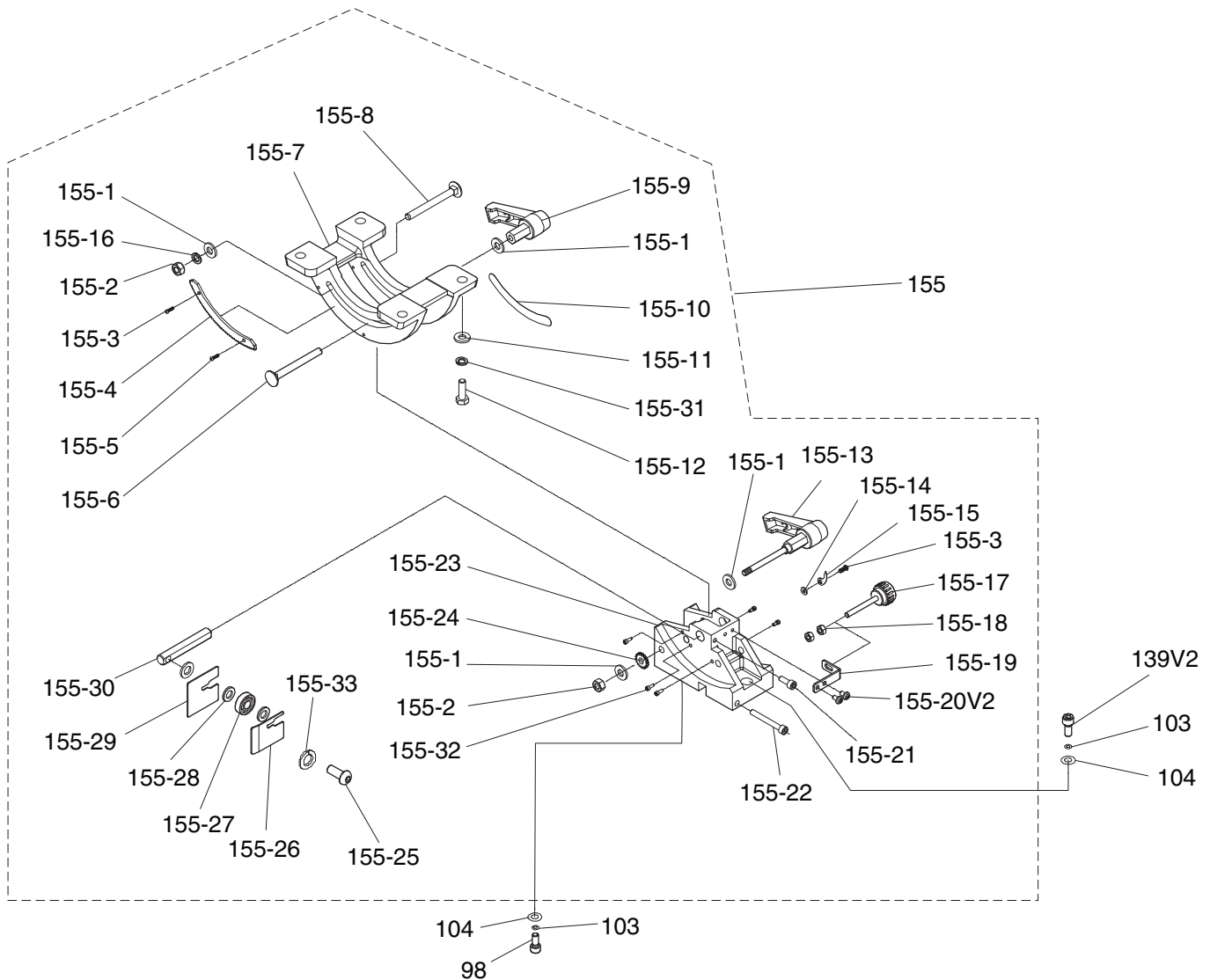
Fence-Guides Parts List

REF	PART #	DESCRIPTION
126	P0513X2B126	TABLE 17" X 24"
127	P0513X127	TABLE INSERT
128	P0513X128	TABLE PIN
131	PBHS22M	BUTTON HD CAP SCR M8-1.25 X 20
132	PLW04M	LOCK WASHER 8MM
136	PCAP50M	CAP SCREW M5-.8 X 10
137	PW02M	FLAT WASHER 5MM
138	P0513X138	PROTECTIVE COVER ASSY
140	P0513X140	SHOULDER SCREW
141	P0513X141	FIBER WASHER
142	P0513X142	SLIDING PLATE
145	P0513X2B145	GUIDE BRACKET ASSEMBLY
145-1	PSS07M	SET SCREW M5-.8 X 5
145-2	PCAP01M	CAP SCREW M6-1 X 16
145-3	PS38M	PHLP HD SCR M4-.7 X 10
145-4	PN04M	HEX NUT M4-.7
145-5	P0513X144	RACK
145-6	P0513X145	UPPER GUIDE TUBE
145-7	P0513X129	LOCATE BUSHING
145-8	P0513X130	BUSHING
145-9	PLW04M	LOCK WASHER 8MM
145-10	P0513X133	GUIDE BRACKET
145-11	P0513X134	WORM CYLINDER
145-12	P0513X135	FIXED PLATE
145-13	P0513X122	GEAR
145-14	P0513X123	FIXED BOLT
145-15	P0513X124	COVER
145-16	PCAP11M	CAP SCREW M8-1.25 X 16
145-17	PFH31M	FLAT HD SCR M4-.7 X 8
145-18	PN05M	HEX NUT M16-1.5
145-19	P0513X2B145-19	GUIDE BRACKET SET SCREW
146	P0513X146	HANDWHEEL
147	PCAP02M	CAP SCREW M6-1 X 20
150	P0513X150	BLADE ADJUSTMENT ASSY
150-1	P0513X150-5	UPPER BLADE GUIDE SUPPORT
150-2	P0513X150-6	BIAS SHAFT
150-3	PR05M	EXT RETAINING RING 15MM
150-4	P6202ZZ	BALL BEARING 6202ZZ
150-5	P0513X150-9	HANDLE BUSHING
150-6	PCAP48M	CAP SCREW M6-1 X 35
150-7	P0513X150-11	UPPER SPACING SLEEVE
150-8	PSS01M	SET SCREW M6-1 X 10
150-9	PCAP01M	CAP SCREW M6-1 X 16
150-10	P0513X150-2	UPPER GUIDE SUPPORT BLOCK
150-11	P0513X2B150-11	ADJUST BAR
151	P0513X151	BLADE ADJUSTMENT ASSY
151-4	P0513X151-5	LOWER BLADE GUIDE SUPPORT
151-5	PCAP01M	CAP SCREW M6-1 X 16
151-6	P0513X151-7	BIAS SHAFT
151-7	PR05M	EXT RETAINING RING 15MM
151-8	P6202ZZ	BALL BEARING 6202ZZ
151-9	P0513X151-10	HANDLE BUSHING
151-10	PCAP48M	CAP SCREW M6-1 X 35
152	P0513X152	MITER GAUGE ASSY

REF	PART #	DESCRIPTION
152-1	P0513X2B152	GUIDE BAR
152-2	P0513X2B152-2	GUIDE PIECE
152-3	PFH04M	FLAT HD SCR M6-1 X 8
152-4	P0513X2B152	POINTER
152-5V2	P0513X2B152-5V2	PHLP HD SCR 10-24 X 3/16
152-6	P0513X2B152-6	SHOULDER SCREW
152-7	P0513X2B152	MITER GAUGE BODY
152-8	PW01M	FLAT WASHER 8MM
152-9	P0513X2B152	HANDLE
152-10	P0513X2B152	FIXED BLOCK
152-11	P0513X2B152	LOCKING SHAFT
152-12V2	P0513X2B152-5V2	PHLP HD SCR 10-24 X 3/16
152-13	PN04M	HEX NUT M4-.7
152-14	PS56M	PHLP HD SCR M4-.7 X 16
152-15	P0513X2B152-15	SCALE
153	P0513X2B153	KNOB SCREW M8-1.25 X 20
154	P0513X2B154	OUTER RAIL PLATE
156	P0513X2B156	RESAW FENCE ASSEMBLY
156-1	P0513X2B156-1	RESAW FENCE (AL) L=590
156-2	P0636X122	TAP SCREW 3.5 X 8
156-3	P0513X2B156-3	FENCE PIECE 148 X 22 X 1
156-4	P0513X2B156-4	RESAW FENCE SCALE
157	P0513X2B157	FENCE ASSMBLY
157-1	P0513X2B157-1	FENCE
157-2	P0513X2B157-2	POINTER
157-3V2	PSS21M	SET SCREW M8-1.25 X 25
157-4	P0513X2B157-4	SPRING PIECE
157-5	PFS17M	FLANGE SCREW M4-.7 X 8
157-6	P0513X2B157-6	PIVOT BLOCK
157-7	PN03M	HEX NUT M8-1.25
157-8	P0513X2B157-8	HANDLE
157-9	P0513X2B157-9	SHAFT
157-10	P0513X2B157-10	FENCE PLASTIC SET SCREW
157-11	P0513X2B157-11	NYLON PAD
157-12	PSS14M	SET SCREW M8-1.25 X 12
157-13	PN03M	HEX NUT M8-1.25
157-14V2	PB09M	HEX BOLT M8-1.25 X 20
157-15	PN03M	HEX NUT M8-1.25
157-16	PW01M	FLAT WASHER 8MM
157-17V2	P0513X2B157-17V2	LOCK HANDLE M8-1.25 X 45 V2.05.11
157-18	P0513X2B157-18	MOVING PLATE
158	PW01M	FLAT WASHER 8MM
159	PLW04M	LOCK WASHER 8MM
160	PCAP14M	CAP SCREW M8-1.25 X 20
161	P0513X2B161	GUARD RAIL
161-1	P0513X2B161-1	FENCE SCALE
162	P0513X2B162	INNER RAIL PLATE
163	PW03M	FLAT WASHER 6MM
164	PLW03M	LOCK WASHER 6MM
165V2	PCAP02M	CAP SCREW M6-1 X 20
167	PAW05M	HEX WRENCH 5MM
168	PAW08M	HEX WRENCH 8MM
169	PWR1013	WRENCH 10 X 13
178	PW01M	FLAT WASHER 8MM



Trunnion Breakdown

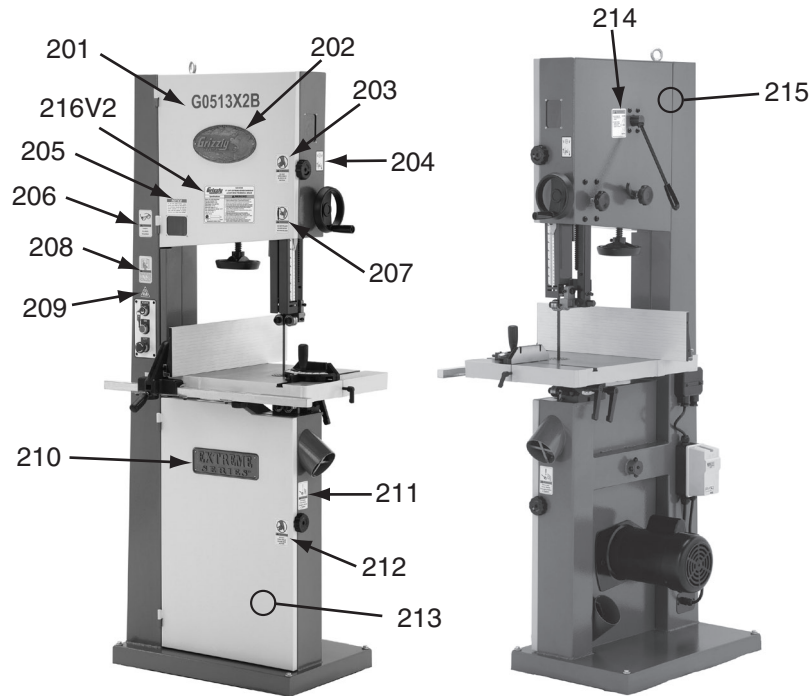


REF	PART #	DESCRIPTION
98	PCAP84M	CAP SCREW M10-1.5 X 35
103	PLW06M	LOCK WASHER 10MM
104	PW04M	FLAT WASHER 10MM
139V2	PCAP84M	CAP SCREW M10-1.5 X 35
155	P0513X2155	CAST IRON TRUNNION ASSEMBLY
155-1	PW01M	FLAT WASHER 8MM
155-2	PLN04M	LOCK NUT M8-1.25
155-3	PS17M	PHLP HD SCR M4-.7 x 6
155-4	P0513115	GEAR PLATE
155-5	PFH27M	FLAT HD SCR M4-.7 X 6
155-6	PCB10M	CARRIAGE BOLT M8-1.25 X 85
155-7	P0513X2162	UPPER TRUNNION
155-8	PCB23M	CARRIAGE BOLT M8-1.25 X 80
155-9	P0513118	LOCK HANDLE M8-1.25
155-10	P0513X2165	ANGLE LABEL
155-11	PW01M	FLAT WASHER 8MM
155-12	PB07M	HEX BOLT M8-1.25 X 25
155-13	P0513X101	LOCK HANDLE M8-1.25
155-14	PW05M	FLAT WASHER 4MM

REF	PART #	DESCRIPTION
155-15	P0513120	POINTER
155-16	PLW04M	LOCK WASHER 8MM
155-17	P0513109	ADJUST BOLT M6-1
155-18	PN01M	HEX NUT M6-1
155-19	P0513X2174	ADJUST PLATE
155-20V2	PFH30M	FLAT HD SCR M5-.8 X 8
155-21	PSB01M	CAP SCREW M6-1 X 16
155-22	PSB37M	CAP SCREW M6-1 X 50
155-23	P0513X2178	TRUNNION SUPPORT BRACKET
155-24	P0513100	SMALL GEAR
155-25	PBHS19M	BUTTON HD CAP SCR M10-1.5 X 30
155-26	P0513X2181	RIGHT COVER
155-27	P6000	BALL BEARING 6000ZZ
155-28	PW04M	FLAT WASHER 10MM
155-29	P0513X2184	LEFT COVER
155-30	P0513X2185	ADJUST BLOCK
155-31	PW01M	FLAT WASHER 8MM
155-32	PCAP97M	CAP SCREW M5-.8 X 6
155-33	PLW06M	LOCK WASHER 10MM



Labels Breakdown



REF	PART #	DESCRIPTION
201	P0513X2B201	G0513X2B MODEL # LABEL
202	G8588	GRIZZLY LOGO PLATE
203	PLABEL-20	OPEN DOOR LABEL
204	P0513X204	GUARD ADJ LABEL
205	P0513X205	SCALE DIRECTIONS LABEL
206	PLABEL-11	SAFETY GLASSES LABEL
207	PLABEL-19	HANDS/BLADE LABEL
208	PLABEL-12	READ MANUAL LABEL

REF	PART #	DESCRIPTION
209	PLABEL-14	ELECTRICITY LABEL
210	P0513X210	EXTREME SERIES PLATE
211	PLABEL-18	DISCONNECT POWER LABEL
212	PLABEL-20	OPEN DOOR LABEL
213	PPAINT-11	"PUTTY" PAINT
214	P0513X214	TENSION ADJ LABEL
215	PPAINT-1	"GRIZZLY GREEN" PAINT
216V2	P0513X2B216V2	MACHINE ID LABEL CSA V2.05.11

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.



Accessories

⚠️ 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

Replacement Blades

These replacement blades are milled for exact tooth set and are made with high quality tool steel.

131½" Carbon Steel Replacement Blades for the Model G0513X2B

MODEL	WIDTH	TPI
H4803	⅛"	14 RAKER
H4804	¼"	6 HOOK
H4805	¼"	18 RAKER
H4806	⅜"	10 RAKER
H4807	½"	6 HOOK
H4808	½"	10 RAKER
H4809	¾"	3 HOOK
H4810	1"	6 HOOK
H4811	1"	2 HOOK

- 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 20. Eye protection assortment.

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



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