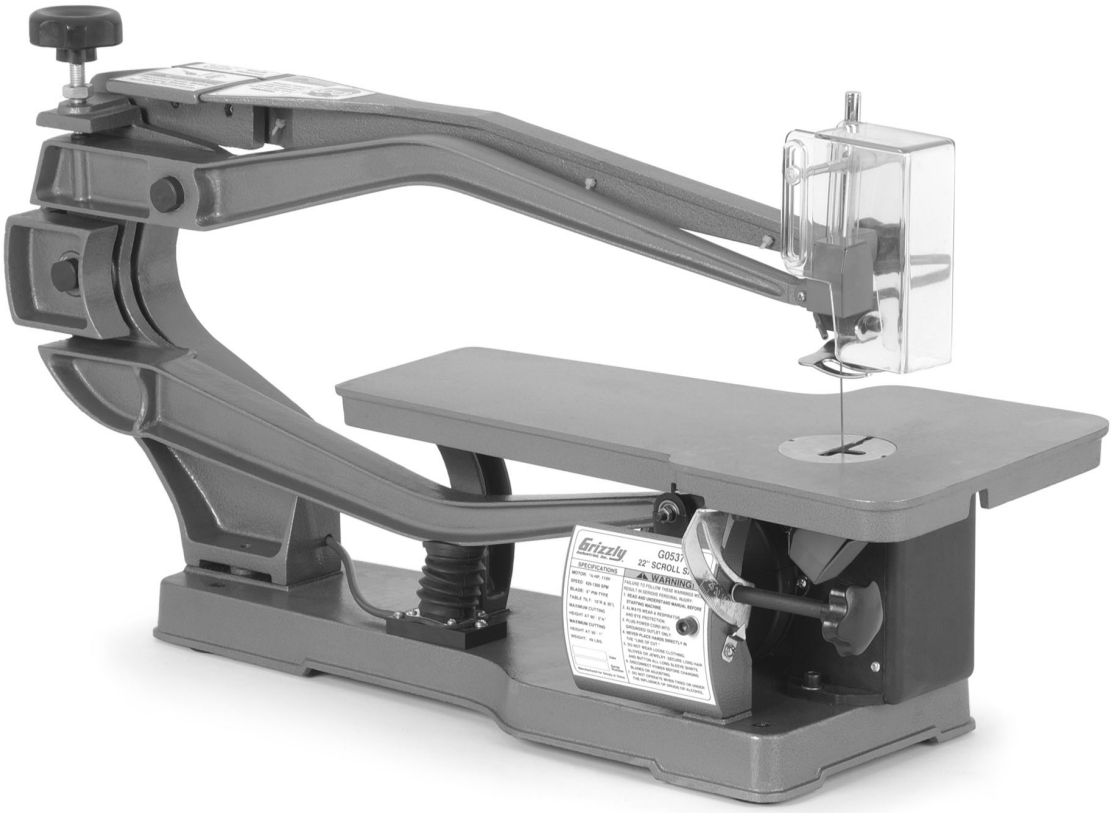
MODEL G0537
22" SCROLL SAW
INSTRUCTION MANUAL



#5813 PRINTED IN CHINA

ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE. CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

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.

Table Of Contents

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are 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.

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

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

⚠CAUTION — **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 equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
4. **NEVER USE IN DANGEROUS ENVIRONMENT**. DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **NEVER FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

⚠WARNING
Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

   Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DO NOT OVER-REACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING**. On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

18. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** DO NOT leave tool until it comes to a complete stop.

19. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

20. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE**. Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

21. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

Additional Safety Instructions For Scroll Saws

1. **SCROLL SAW SAFETY BEGINS** with your lumber. Inspect your stock carefully before you begin a cut. If you have any doubts about the stability or structural integrity of your stock, **DO NOT CUT!**

2. **KEEP HANDS AWAY FROM BLADE.** DO NOT hold pieces so small that your fingers go under the blade guard. DO NOT reach underneath work or in blade cutting path with your hands or fingers for any reason.

3. **AVOID POSITIONS** where a slip could cause your hand to go into the blade.

4. **NEVER USE YOUR SCROLL SAW WITH THE BLADE GUARD REMOVED.**

5. **WAIT UNTIL BLADE IS STOPPED** before clearing away cut-off pieces.

6. **UNPLUG YOUR SCROLL SAW** and remove the safety switch key before changing blades, adjustments, or performing maintenance.

7. **USE BLADES APPROPRIATE FOR YOUR MACHINE,** material being cut, and the type of cut that you are performing.

8. **DO NOT START THE SAW WITH THE BLADE IN CONTACT WITH THE WORKPIECE.**

9. **SUPPORT LARGE WORKPIECES** to reduce blade breakage and pinching.

10. **FIRMLY SECURE YOUR SCROLL SAW** to a stable, level table or workbench using clamps or bolts. The saw may move when cutting large workpieces if not secured.

11. **HABITS — GOOD AND BAD — ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.

12. **PROLONGED EXPOSURE TO WOOD DUST IS KNOWN TO CAUSE CANCER IN HUMANS.** Always wear an OSHA-approved respirator when working in an environment that could contain wood dust.

⚠WARNING

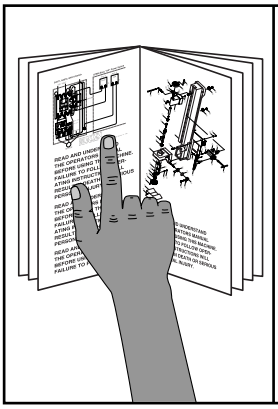
Like all machines there is danger associated with the Model G0537 Scroll Saw. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

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

SECTION 2: INTRODUCTION

Commentary



⚠WARNING

Lack of familiarity with this manual could cause serious personal injury. Become familiar with the contents of this manual, including all the safety warnings.

We are proud to offer the Model G0537 Scroll Saw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0537. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

The specifications, drawings, and photographs illustrated in this manual represent the Model G0537 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

SECTION 3: CIRCUIT REQUIREMENTS

110 Volt

Amperage Draw
The Model G0537 motor is wired to operate at 110V and draw the following load:

Motor Load .....1.4 Amps

Plug Type
The Model G0537 is supplied with a NEMA 5-15 plug. DO NOT modify the plug or power cord in any way. See **Figure 1** for a NEMA 5-15 plug and grounded outlet.

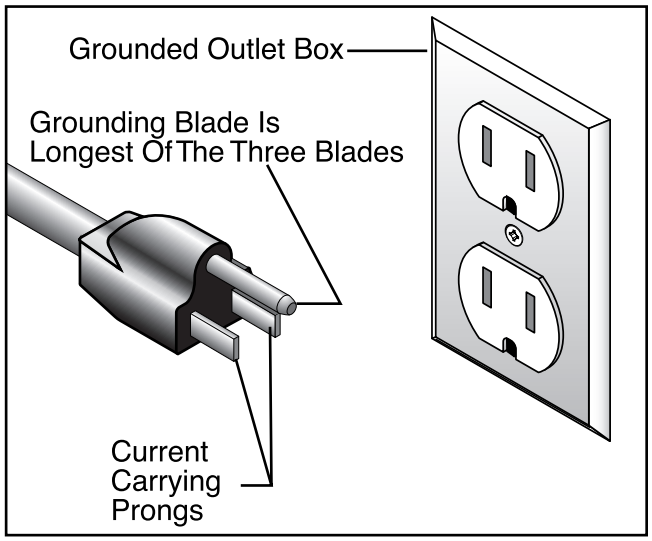


Figure 1. NEMA 5-15 plug and grounded outlet.

Circuit Breaker Requirements
Use the following guidelines when choosing a circuit breaker for your machine:

Recommended Circuit Breaker .....5 Amp

Your Circuit Capacity
Always check to see if the wires in your circuit are capable of handling the amperage load from your machine. If you are unsure, consult a qualified electrician.

If you operate this machine on any circuit that is already close to its capacity, it might blow a fuse or trip a circuit breaker. However, if an unusual load does not exist and a power failure still occurs, contact a qualified electrician or our Service Department at (570) 546-9663.

⚠WARNING

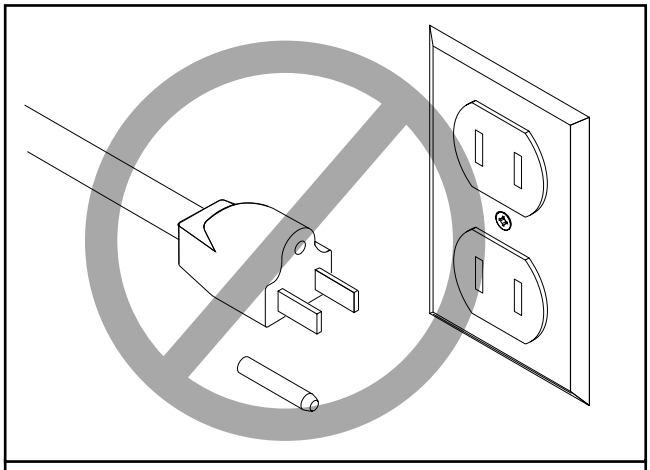
Serious personal injury could occur if you connect your machine to the power source before you have completed the assembly process. DO NOT connect the machine to the power source until instructed to do so.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with a power cord that has an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.

⚠WARNING

Electrocution or a fire can result if the machine is not grounded correctly. Make sure all electrical circuits are grounded. DO NOT use the machine if it is not grounded.



⚠CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. DO NOT remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

NOTICE

The wire on the power cord with green or green and yellow striped insulation is the grounding conductor.

Extension Cords

Operation
If you find it necessary to use an extension cord :

- Make sure the cord is rated Standard Service (grade S) or better.
- The extension cord must also contain a ground wire and plug pin.
- Use at least a 16 gauge cord.
- DO NOT use a cord longer that 100 feet!

⚠CAUTION

No single list of electrical guidelines can be comprehensive for all shop environments. Operating this machinery may require additional electrical upgrades specific to your machine and shop environment. It is your responsibility to make sure your electrical systems comply with all local electrical codes and ordinances.

SECTION 4: MACHINE FEATURES

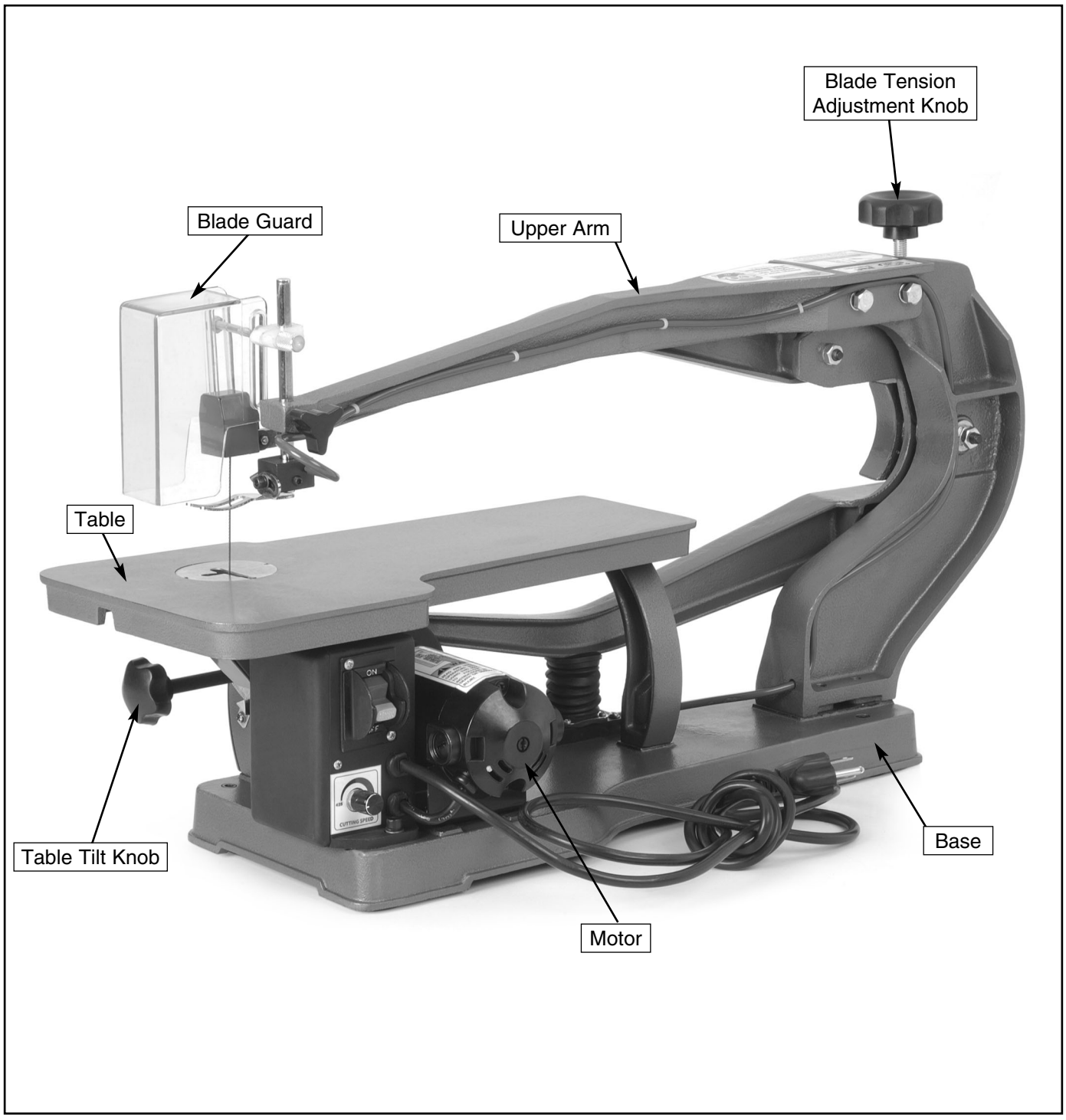


Figure 2. General machine features.

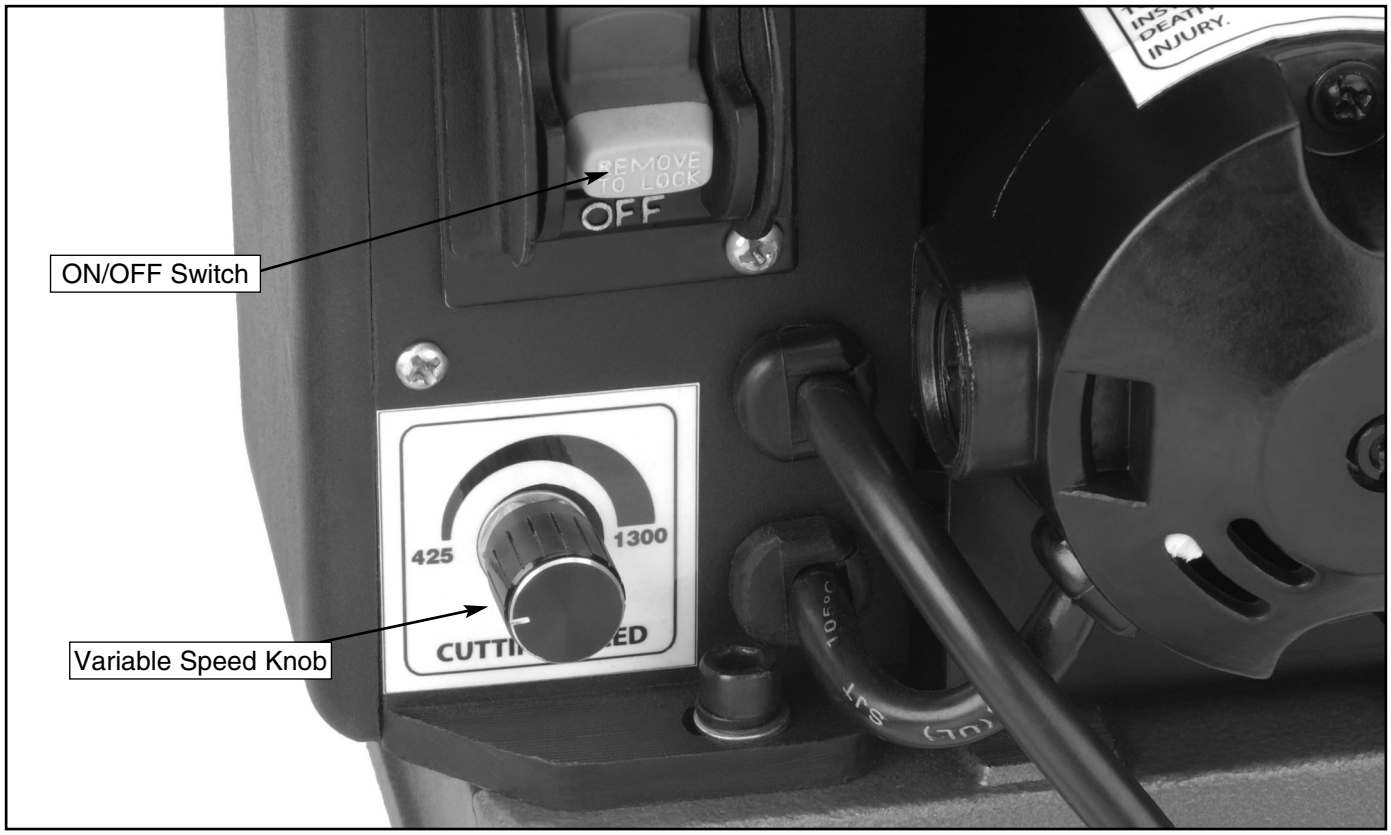


Figure 3. Controls.

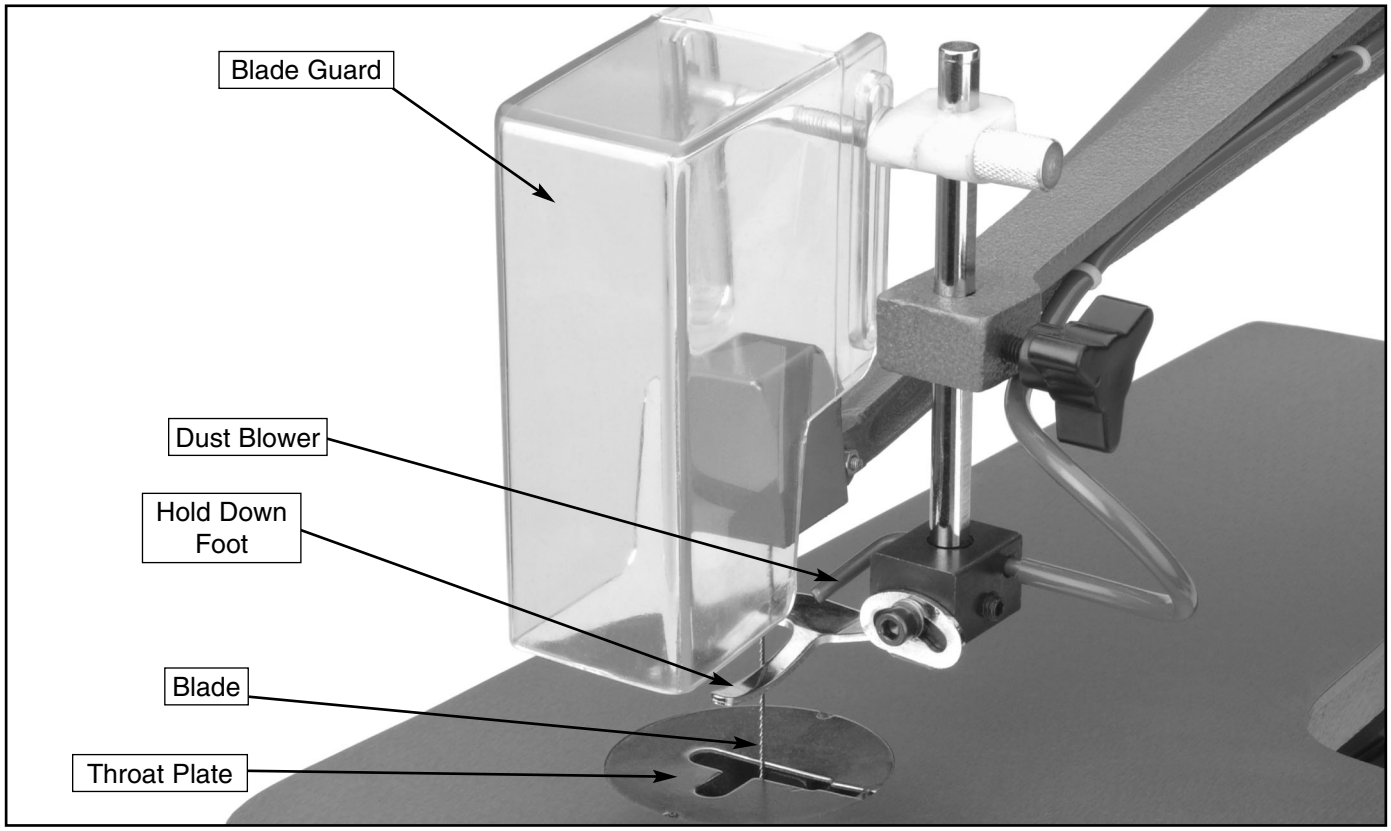


Figure 4. Cutting features.

SECTION 5: SET UP

Unpacking

The machine was carefully packed when it left the Grizzly warehouse. If you discover the machine is damaged after you have signed for delivery, and the truck and driver are gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for possible inspection by the carrier or its agent. Without the packing materials, filing a freight claim can be difficult. If you need assistance determining whether you need to file a freight claim, or with the procedure to file one, please contact our Customer Service.

⚠CAUTION

Sharp edges on metal parts may cause personal injury. Examine the edges of all metal parts before handling.

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

G0537 Inventory

- Blade Guard Assembly 1
- Blade 1

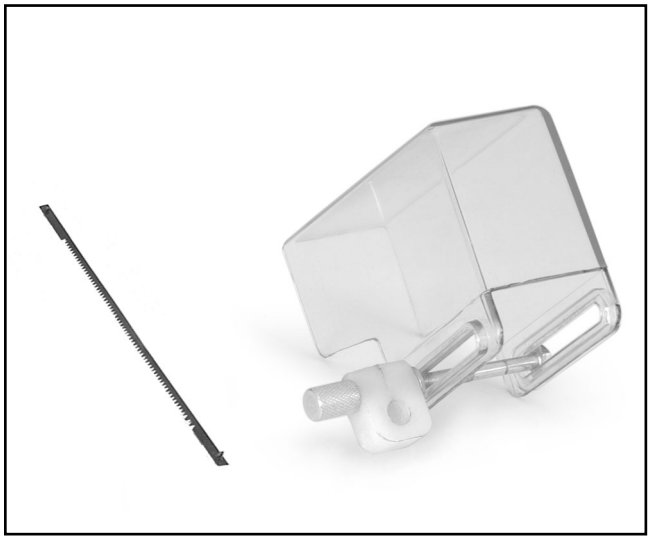


Figure 5. G0537 Inventory.

Clean Up

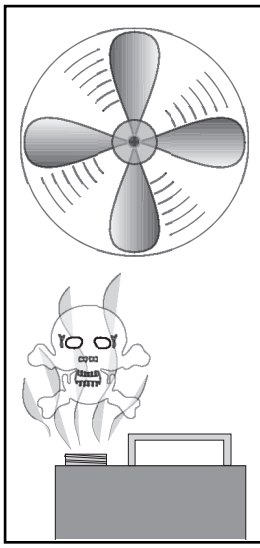
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.

⚠WARNING

Gasoline and petroleum products have low flash points and could explode if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.

⚠WARNING

Smoking near solvents could ignite an explosion or fire and cause serious injury. DO NOT smoke while using solvents.



⚠WARNING

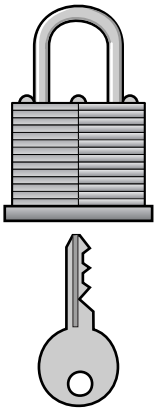
Lack of ventilation while using solvents could cause serious personal health risks, fire, or environmental hazards. Always work in a well ventilated area to prevent the accumulation of dangerous fumes. Supply the work area with a constant source of fresh air.

Site Considerations

Weight Load
The Model G0537 Scroll Saw is a small weight load with a small footprint. Most workbenches should be sufficient to carry the weight of the machine. Reinforce the workbench if you question its ability to support the weight.

Working Clearance
Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands or work tables. Also consider the relative position of each machine to one another for efficient material handling.

Lighting And Outlets Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle the amperage draw. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.



⚠WARNING

Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.

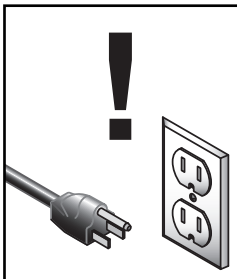
Beginning Assembly

This section covers the basic assembly and adjustment instructions needed to begin operation. Complete the assembly in the order provided in this manual and then read the remaining portion of the manual before attempting any type of operation.

Your safety is important! Please follow the warnings below during this entire section:

⚠CAUTION

Sharp edges on metal parts may cause personal injury. Examine the edges of all metal parts before handling.



⚠WARNING

Disconnect power to the machine during the entire assembly process. Failure to do this may result in serious personal injury.

Mount Scroll Saw

To attach the scroll saw to a solid surface:

1. Locate a rectangular piece of ¾" plywood that is at least 21"W and at least 20"D.
2. Remove the rubber feet from the scroll saw.
3. Mount the base of the scroll saw to the center of the plywood with ¼" x 2" lag bolts and ¼" washers.
4. Clamp the plywood securely to a workbench.
5. To permanently mount the scroll saw to the workbench, screw ¼" x 2" (or longer) lag bolts with ¼" washers directly to the workbench.

Attach Blade Guard

To attach the blade guard:

1. Thread the bolt through the blade guard components as shown in **Figure 6,** and screw it into the knurled nut.

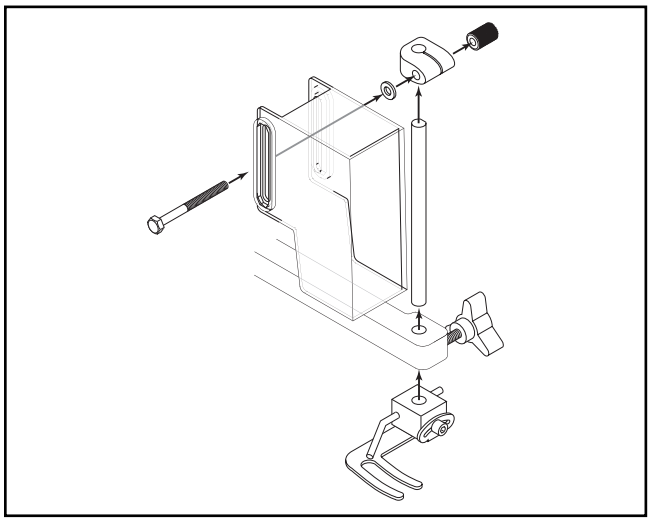


Figure 6. Blade guard assembly.

2. Slide the supporting rod through the upper arm and into the hold down block, and tighten the set screw.
3. Attach the guard assembly to the supporting rod and tighten the knurled nut.
4. Adjust the blade guard so that it rides just above the workpiece, and tighten the lock knob shown in **Figure 7.**

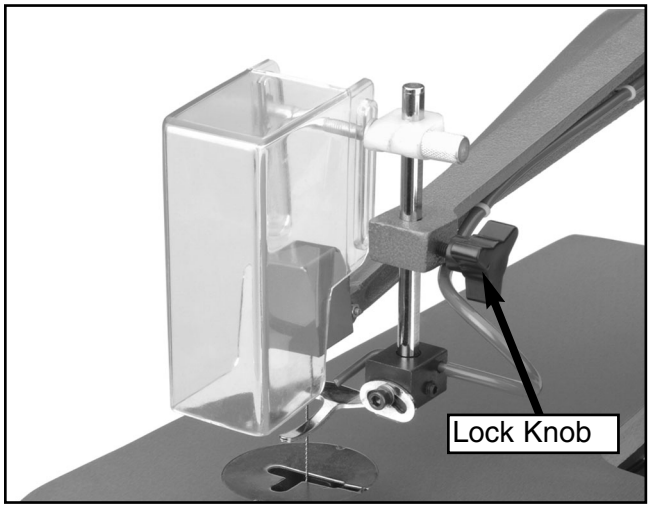


Figure 7. Blade guard adjustment.

Installing Blades

To install the blade:

1. **Disconnect the machine from the power source.**

2. Feed the blade through the table and hook it into the lower blade holder as shown in **Figure 8**. The blade teeth should face forward and down.

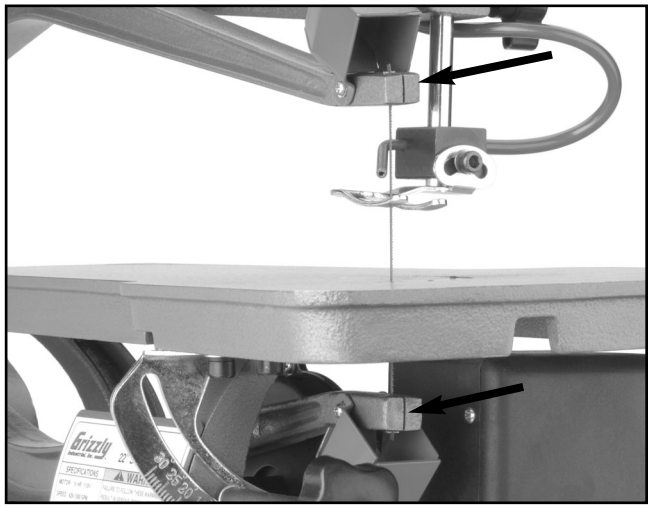


Figure 8. Blade attached to both holders.

3. Push down on the upper arm and slide the upper end of the blade into the holder. Make sure that the pins are seated into the grooves in both arms.

4. Increase the tension on the blade until the blade gives a musical sound when plucked.

   Note—*Determining correct blade tension is subjective and is learned through experience. If the blade is not tensioned enough the blade will drift off the layout line when cutting. The scroll saw will also have excessive noise and vibration. If the blade is too tight the blade could break, causing serious injury. Blades that are tensioned correctly will last longer and are less likely to break.*

5. Replace the throat plate and lower the blade guards into position.

Test Run

Once the assembly is complete, the machine needs to be tested. The purpose of the test run is to ensure that there are no problems.

To test run the scroll saw:

1. Remove all tools from the scroll saw.

2. Turn the variable speed setting down to 425 SPM.

3. Plug the saw into the power source. Flip the switch *ON*. Keep your finger ready to turn the scroll saw *OFF*.

4. Listen for any unusual noises, vibrations or rubbing. If anything sounds unusual, stop the saw immediately.

5. Disconnect the machine from the power source and find the source of the problem before operating further.

   NOTE—*If you cannot locate the source of an unusual noise or vibration, feel free to contact our service department for help.*

⚠WARNING

Before starting the saw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury.

SECTION 6: OPERATIONS

General

This section will cover basic scroll sawing operations. Please read the remaining portion of the manual before attempting any type of operation.

Your safety is important! Please follow the warnings below during this entire section:

⚠WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a respirator, and hearing protection while using this machine.

⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

Blade Speed

It is important to adjust the blade speed for the type of material being cut. Generally harder materials require a slower blade speed.

To adjust the blade speed:

Rotate the knob, shown in **Figure 9,** clockwise to increase the blade speed, and counterclockwise to reduce the speed.

Figure 9. Variable speed knob.

Feed Rate

The feed rate is the speed an operator moves the workpiece through the saw blade. The correct feed rate depends on the type of material, and its thickness. When using the correct feed rate the workpiece will move easily and the motor will run smoothly. When feeding the work too quickly the motor may bog down and the blade can break causing serious injury.

Changing Blades

A typical scroll saw blade will wear out in ½ to 2 hours, depending on the material cut. Blades become dull quicker when cutting thick material, plywood, laminates, hardwoods and metal.

To change the blade:

1. **Disconnect the machine from the power source.**

2. Loosen the blade tension adjustment knob.

3. Remove the throat plate and move the blade guards up.

4. Push down on the upper arm shown in **Figure 10**, pull the upper end of blade out of the holder, push down on the blade to free the lower end of the blade, and pull the blade up to remove.

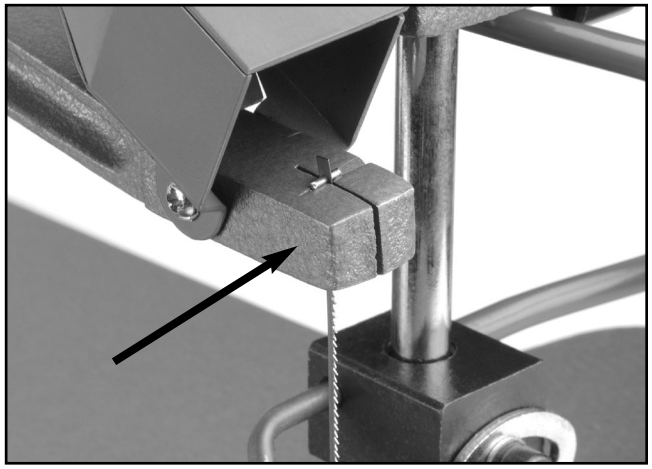


Figure 10. Upper Arm.

5. Feed the new blade through the table and hook it into the lower blade holder as shown in **Figure 11**. The teeth should face forward and down.

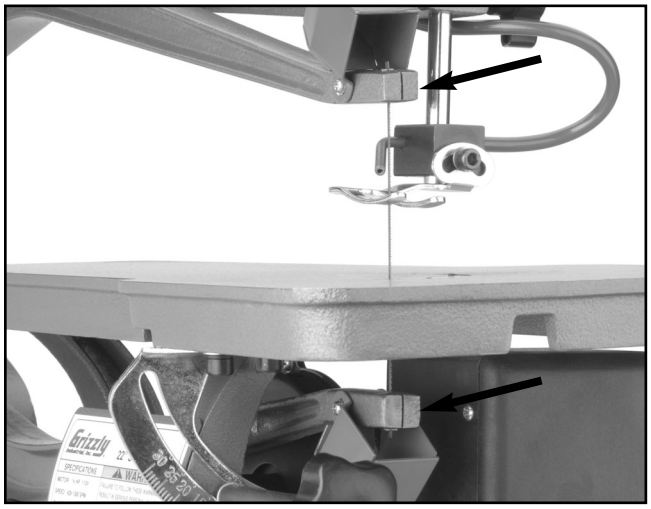


Figure 11. Blade attached to both holders.

6. Push down on the upper blade holder and slide the upper end of the blade into the holder. Make sure that the pins are seated into the grooves in both holders.

7. Increase the tension on the blade until the blade gives a musical sound when plucked.

   Note—*Determining correct blade tension is subjective and is learned through experience. If the blade is not tensioned enough the blade will drift off the layout line when cutting. The scroll saw will also have excessive noise and vibration. If the blade is too tight the blade could break, causing serious injury. Blades that are tensioned correctly will last longer and are less likely to break.*

8. Replace the throat plate and lower the blade guards into position.

Straight Cuts

Miter gauges and fences are not effective on scroll saws because most scroll saw blades are narrow and tend to follow the grain of the wood. Freehand cutting allows the operator to compensate for blade drift.

To make a straight cut:

1. Draw a straight line on your workpiece.

2. Turn the power *ON* and allow the motor to reach full speed.

3. Feed the workpiece slowly and steadily into the blade, keeping your hands to either side of the cutting line while pushing down. Make sure the blade is cutting on the waste side of the line (**Figure 12).**

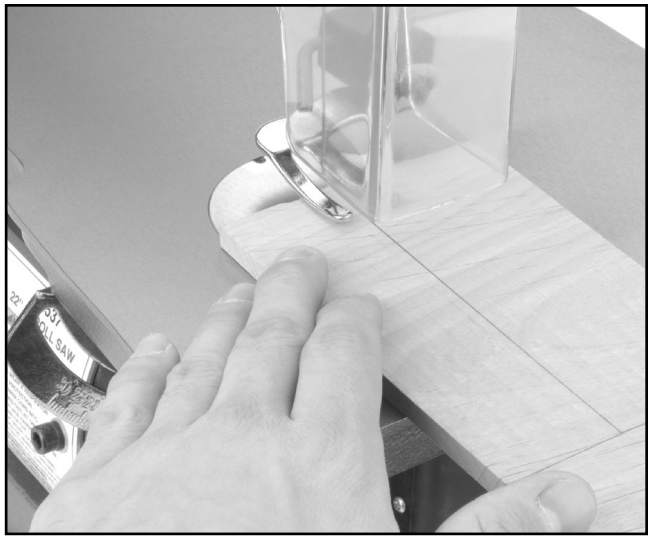


Figure 12. Straight cut.

4. Scroll saw blades will have a tendency to drift. Compensate by adjusting the feed direction.

Note—*The variation of hard and soft grain in wood will cause the scroll saw blade to deflect. If you are approaching hard grain at an angle, the feed rate must be slowed and pressure should be applied toward the side with the hard grain.*

Curved Cuts

When cutting curves, preplan your cuts and leave tight inside curves for a second pass to minimize backing out. Cut sharp outside curves by cutting past the curve and looping around to cut from a different angle.

To make a curved cut:

1. Draw a pattern on your workpiece.

2. Choose a blade size based on the tightest curve in the workpiece. Smaller blades can cut tighter curves.

3. Rough cut the board down to a workable size.

4. Feed the workpiece into the blade with a slow and even pressure. Use your fingers to hold it down and thumbs to steer as shown in **Figure 13**.

Figure 13. Making a curved cut.

Note—*When approaching a tight radius, slow down your feed rate, but do not stop. Give the teeth time to make the cut. Forcing the workpiece through the curve will cause the blade to twist or break. If your cut produces waste in the curve's interior, turn the power off and wait until all motion stops before removing the waste.*

Inside Cuts

Inside cuts such as circles or the insides of closed letters can be easily cut with your scroll saw by threading the blade through a hole drilled in the workpiece.

To make an inside cut:

1. **Disconnect the machine from the power source.**

2. Remove blade and throat plate.

3. Drill a hole in the waste portion of the workpiece that is large enough for the pins to fit through.

4. Thread the blade through the hole in the workpiece as shown in **Figure 14**.

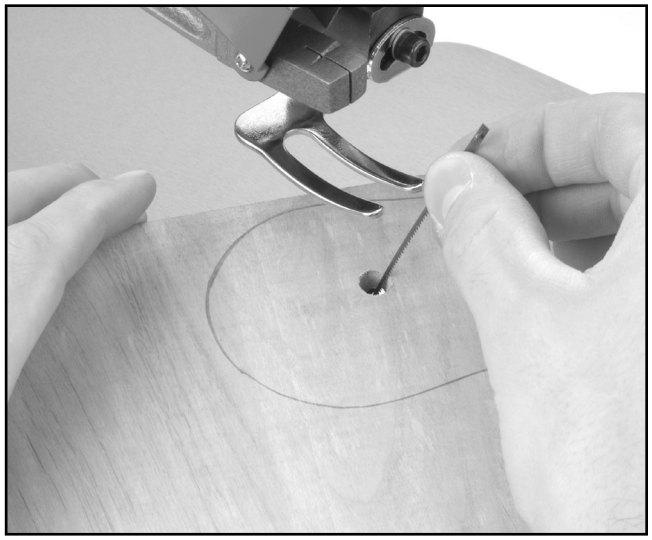


Figure 14. Installing the blade for an inside cut.

5. Replace the throat plate, mount the blade and tension it.

6. Make the inside cut and go back to **step 1** for the next inside cut.

Bevel Cuts

Bevel cuts can be used for miters, cope joints, and making relief or recessed projects.

To make a bevel cut:

1. Draw your pattern as described in the previous sections.

2. Adjust the table to the desired angle.

3. Using the same principles as in the previous sections, feed the work slowly and evenly into the blade, remembering not to force the workpiece (**Figure 15**).

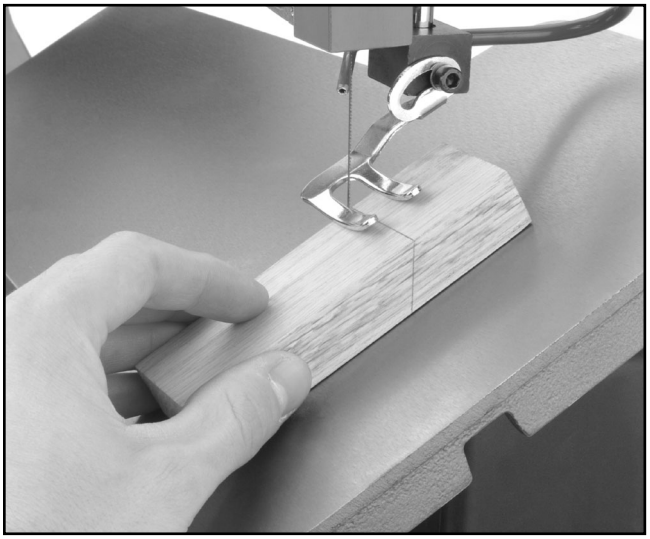


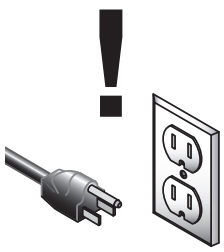
Figure 15. Making a bevel cut.
(Guard removed for clarity)

4. Wait until all motion has stopped before removing waste near the blade.

SECTION 7: MAINTENANCE

Maintenance Safety

Your safety is important! Please follow the warnings below during this entire section:



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

⚠WARNING

Projectiles from the machine could cause serious eye injury. Wear safety glasses at all times.

General

Regular periodic maintenance on the Model G0537 will ensure optimum performance. Make a habit of inspecting the machine each time you use it.

Before each use, look for the following conditions:

1. Loose bolts.
2. Damaged blades.
3. Worn switch.
4. Worn or damaged cords and plugs.
5. Any other condition that could hamper the safe operation of this machine.

Working Table

The table and other non-painted surfaces on your machine should be protected against rust and pitting. Wiping the table clean after every use ensures that moisture from wood dust does not remain on bare metal surfaces.

Tables can be kept rust-free with regular applications of products like SLIPIT® or Boeshield® T-9. For long term storage you may want to consider products like Kleen Bore's Rust Guardit™.

Lubrication

Lubricate the upper and lower arm bushings with light machine oil once a month or every 50 hours of use.

To lubricate the bushings:

1. **Disconnect the machine from the power source.**

2. Lay the machine on its side as shown in **Figure 16.**

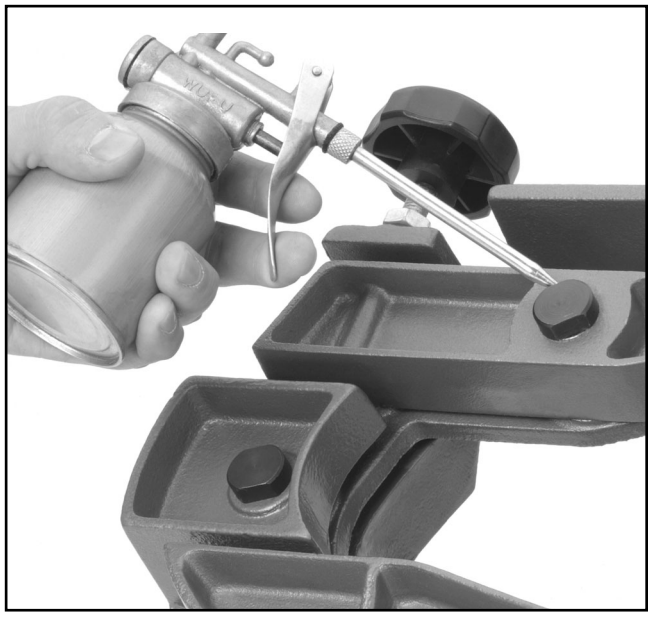


Figure 16. Lubricating bushings.

3. Apply a generous amount of machine oil to the end of the bolts that hold the bushings in place.

4. Leave the scroll saw on its side and allow the machine oil to soak in overnight.

Replacing Brushes

Replacing the motor brushes is a simple job that may be necessary after extended use.

To replace the motor brushes:

1. **Disconnect the machine from the power source.**

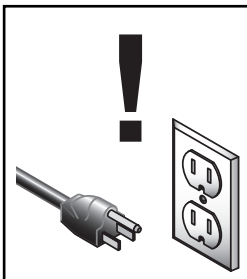
2. Remove the motor brush caps with a flat-head screwdriver. One of the brushes is shown in **Figure 17**. The other is on the opposite side of the motor.

Figure 17. Motor brush.

3. Remove the brushes and check for black carbon build-up or damage. If necessary, replace the brushes.

4. Slide brushes back into the slot and replace the brush caps.

SECTION 8: SERVICE ADJUSTMENTS



⚠WARNING

Always disconnect power to the machine before performing service adjustments. Failure to do this may result in serious personal injury.

About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Squaring Table

To ensure that the table is square:

1. **Disconnect the machine from the power source.**

2. Loosen the table tilt knob shown in **Figure 18**.

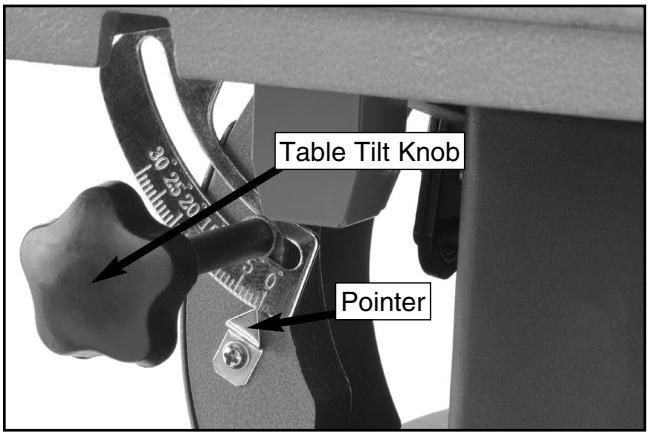


Figure 18. Pointer and table tilt knob.

3. Place a square on the table and against the blade as shown in **Figure 19**.

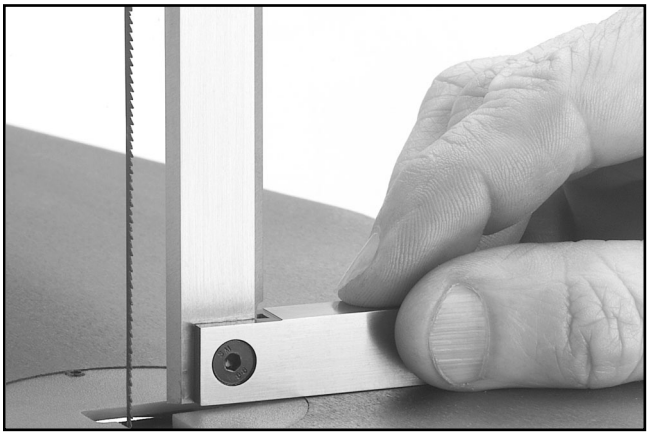


Figure 19. Check the angle with a square.

4. Adjust the table until the square and the blade are parallel.

5. Tighten the table tilt knob, loosen the pointer shown in **Figure 18** and adjust it to 0˚.

SECTION 9: REFERENCE INFO

General

This section contains the following subsections for the Model G0537: aftermarket accessories, data sheets, parts diagrams and list, troubleshooting, and warranty/return information.

If you need parts or help in assembling your machine, or if you need operational information, call the service department at (570) 546-9663. Trained service technicians will be glad to help you.

If you have any comments regarding this manual, please write to Grizzly at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com.

Aftermarket Accessories

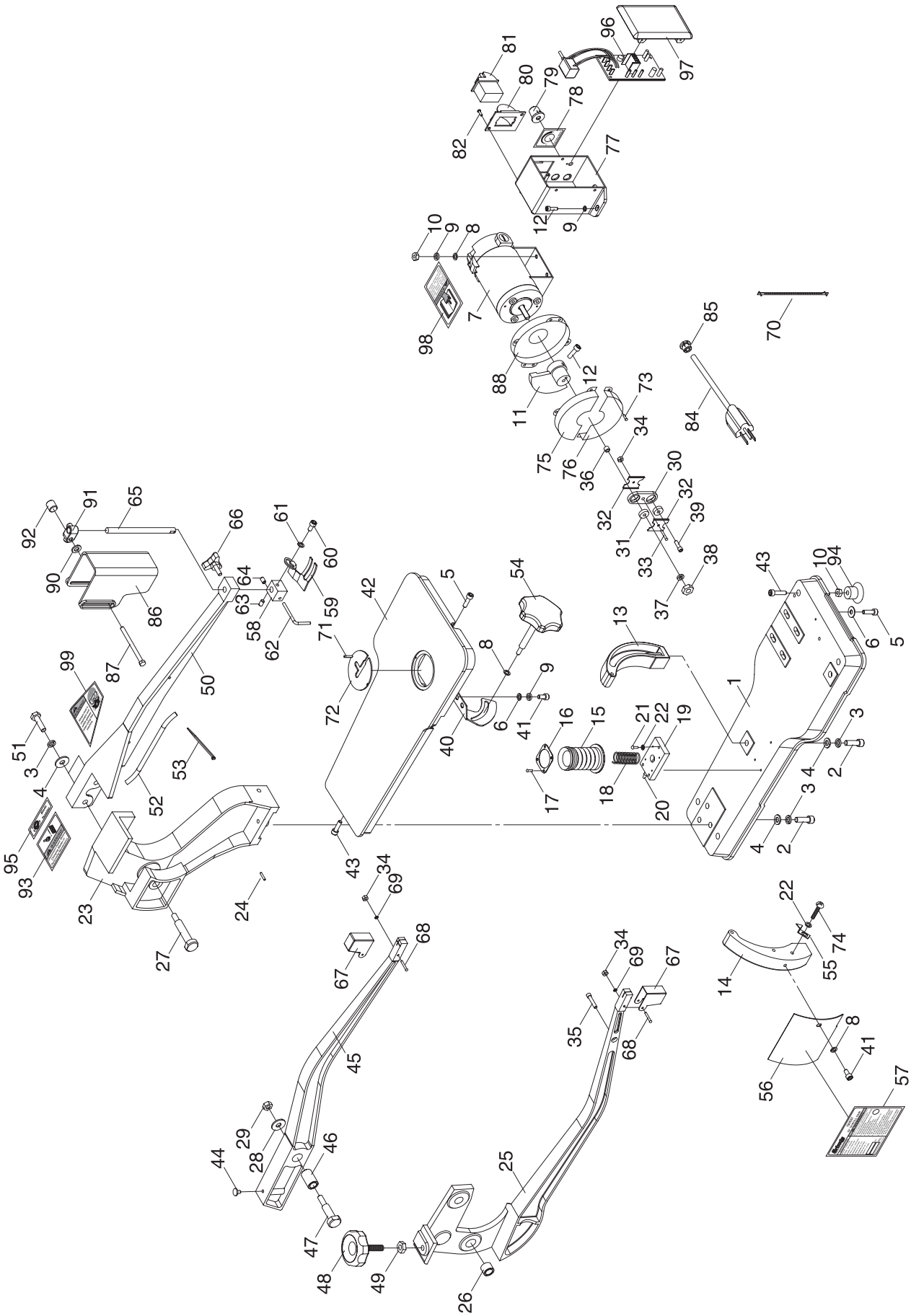
To order any of the aftermarket accessories below, find the model number in bold and call our customer service line 24 hours a day at 1-800-523-4777.

Replacement Blades:

MODEL	#	WIDTH	TPI	TOOTH
G6670	0.008	0.078"	25	Skip
G6671	0.019	0.125"	10	Skip
G6672	0.018	0.110"	15	Skip

Scroll Saw Abrasive Packs:
Quickly smooths edges of wood, plastic, metal and composite scroll saw projects. Eliminate hand sanding. ½" grits are 80, 120, 180 & 220. ¼" grits are 120, 180, 220 & 320. Packs of 4.

MODEL	TYPE	WIDTH
H5323	Pin	½"
H5324	Pin	¼"



REF	PART #	DESCRIPTION
1	P0537001	Base
2	PSB31M	Cap Screw M8-1.25 x 25
3	PLW04M	Lock Washer 8mm
4	PW01M	Flat Washer 8mm
5	PSB02M	Cap Screw M6-1 x 20
6	PW03M	Flat Washer 6mm
7	P0537007	Motor
8	PW03M	Flat Washer 6mm
9	PLW03M	Lock Washer 6mm
10	PN01M	Hex Nut M6-1
11	P0537011	Rocker Arm
12	PSB28M	Cap Screw M6-1 x 15
13	P0537013	Rear Strut
14	P0537014	Front Strut
15	P0537015	Air Bellows
16	P0537016	Pressure Plate
17	PHTEK3M	Tap Screw M3-.5 x 8
18	P0537018	Spring
19	P0537019	Anchor Plate
20	P0537020	Air-intake Opening
21	PS56M	Phlp Hd Scr M4-.7 x 16
22	PW05M	Flat Washer 4mm
23	P0537023	Pillar
24	PRP42M	Roll Pin 3 x 20mm
25	P0537025	Lower Arm
26	P0537026	Bushing
27	P0537027	Fulcrum Bolt
28	PW01M	Flat Washer 8mm
29	PN03M	Hex Nut M8-1.25
30	P0537030	Connecting Link
31	P625	Bearing 625ZZ
32	P0537032	Connecting Link Plate
33	PS50M	Phlp Hd Scr M3-.5 x 12
34	PN07M	Hex Nut M3-.5
35	PSB95M	Cap Screw M5-.8 x 30
36	P0537036	Sleeve
37	PLW01M	Lock Washer 5mm
38	PN06M	Hex Nut M5-.8
39	PSB53M	Cap Screw M5-.8 x 18
40	P0537040	Table Tilt Scale
41	PB02M	Hex Bolt M6-1 x 12
42	P0537042	Table
43	PB29M	Hex Bolt M6-1 x 30
44	P0537044	Pressure Plate
45	P0537045	Upper Arm
46	P0537046	Bushing
47	P0537047	Fulcrum Bolt
48	P0537048	Adjustment Knob (Male)
49	PN02M	Hex Nut M10-1.5

REF	PART #	DESCRIPTION
50	P0537050	Arm
51	PB07M	Hex Bolt M8-1.25 x 25
52	P0537052	Plastic Tube
53	P0537053	Cable Tie
54	P0537054	Tilting Locking Knob M6
55	P0537055	Pointer
56	P0537056	Rocker Arm Guard
57	P0537057	Main Label
58	P0537058	Lower Connecting Block
59	P0537059	Hold-Down Foot
60	PSB86M	Cap Screw M5-.8 x 10
61	PW02M	Flat Washer 5mm
62	P0537062	Dust Blower
63	PSS01M	Set Screw M6-1 x 10
64	PSS16M	Set Screw M8-1.25 x 10
65	P0537065	Support Post
66	P0537066	Locking Knob M6-1 x 17
67	P0537067	Chuck Guard
68	P0537068	Hex Bolt M3-.5 x 22
69	PLW09M	Lock Washer 3mm
70	P0537070	Blade
71	PRP14M	Roll Pin 3 x 6mm
72	P0537072	Table Insert
73	PS17M	Phlp Hd Scr M4-.7 x 6
74	PS07M	Phlp Hd Scr M4-.7 x 8
75	P0537075	Upper Rocker Arm Guard
76	P0537076	Lower Rocker Arm Guard
77	P0537077	Switch Box
78	P0537078	Speed-Adjustment Label
79	P0537079	Speed-Adjustment Knob
80	P0537080	Switch Plate
81	P0537081	Switch
82	PHTEK10M	Tap Screw M4-.7 x 11
84	P0537084	Plug
85	P0537085	Strain Relief
86	P0537086	Blade Guard
87	P0537087	Hex Bolt M6-1 x 80
88	P0537088	Back Rocker Arm Guard
90	PW03M	Flat Washer 6mm
91	P0537091	Upper Connecting Block
92	P0537092	Knurled Nut M6
93	P0537093	Disconnect Power Label
94	P0537094	Rubber Foot
95	P0537095	Blade Tensioning Label
96	P0537096	Circuit Board
97	P0537097	Switch Box Cover
98	P0537098	Read Manual Warning
99	P0537099	Respirator/Safety Glasses Warning

MACHINE DATA SHEET

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

GRIZZLY MODEL G0537 22" SCROLL SAW

Design Type ..... Bench Model

Overall Dimensions:
- Table .....9" x 16¾"
- Overall Height .....15¼"
- Width .....28⅝"
- Depth .....10"
- Box Size .....16" x 13" x 30½"
- Shipping Weight .....54 lbs.
- Net Weight .....48.5 lbs.
- Footprint .....20" x 8¼"

Capacities:
- Depth of Throat .....21⅞"
- Maximum Cutting Height @90° .....2⅛"
- Maximum Cutting Height @30° .....1"
- Table Tilt .....10 – 30°

Blade and Movement:
- Blade .....5" Pin-Type or Plain End
- Strokes per minute .....425 – 1300
- Stroke .....½"

Construction:
- Base .....Cast Iron
- Table .....Cast Iron
- Arms .....Die Cast Aluminum

Motor:
- Type .....TEFC Brush Type
- Horse Power ..... ⅕ HP
- Amps 1.4
- Phase / Voltage .....Single Phase / 110V
- Cycle / RPM .....60 Hertz / 425 – 1300 RPM
- Switch .....Toggle ON/OFF w/ Safety Lock Tab
- Power Transfer .....Direct Drive, Counterbalanced Flywheel
- Bearings .....Shielded & Lubricated Ball Bearings

Features:
- .....Blade Tension Adjustment Knob
- .....Adjustable Hold Down Foot
- .....Blower Bellows System

Specifications, while deemed accurate, are not guaranteed.

Troubleshooting Guide

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Blade won't stay on layout line.	1. Blade not tensioned enough.	1. Increase tension on blade.
Excessive blade breakage.	1. Blade tensioned too much. 2. Upper and lower blade guides are not perfectly in line.	1. Loosen blade tension. 2. Loosen guides and line them up.
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.	1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2 Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows or stalls when operating.	1. Applying too much pressure to workpiece. 2. Badly worn motor brushes.	1. Feed workpiece slower. 2. Replace motor brushes.

Warranty & Returns

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

Name _____

Street _____

City _____State_____Zip_____

Phone Number_____E-Mail_____FAX_____

MODEL #_____**Serial #** _____ Order #_____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?

___Advertisement
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other_____

2. Which of the following magazines do you subscribe to.

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other_____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Bandsaw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___jointer
___Vacuum Veneer Press
___Wide Belt Sander

___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" jointer
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
_✓_Scroll Saw
___Spindle/Belt Sander

___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other_____

13. What machines/supplies would you like Grizzly Industrial to carry?

_____

_____

14. What new accessories would you like Grizzly Industrial to carry?

_____

_____

15. What other companies do you purchase your tools and supplies from?

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes ___No

19. Comments:_____

_____

_____

_____

_____

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P.O. BOX 2069
BELLINGHAM, WA 98227-2069

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Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE