



MODEL G0732

CONTRACTOR STYLE SAW

OWNER'S MANUAL

(For models manufactured since 11/11)



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WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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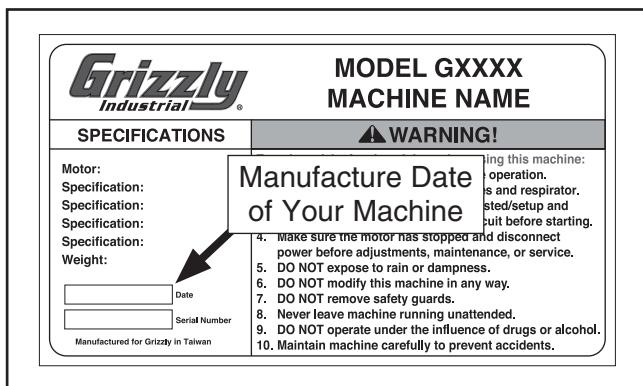
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

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

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

Machine Description

This contractor-style table saw has an open stand, which makes it easy to move around in the shop or transport to different locations.

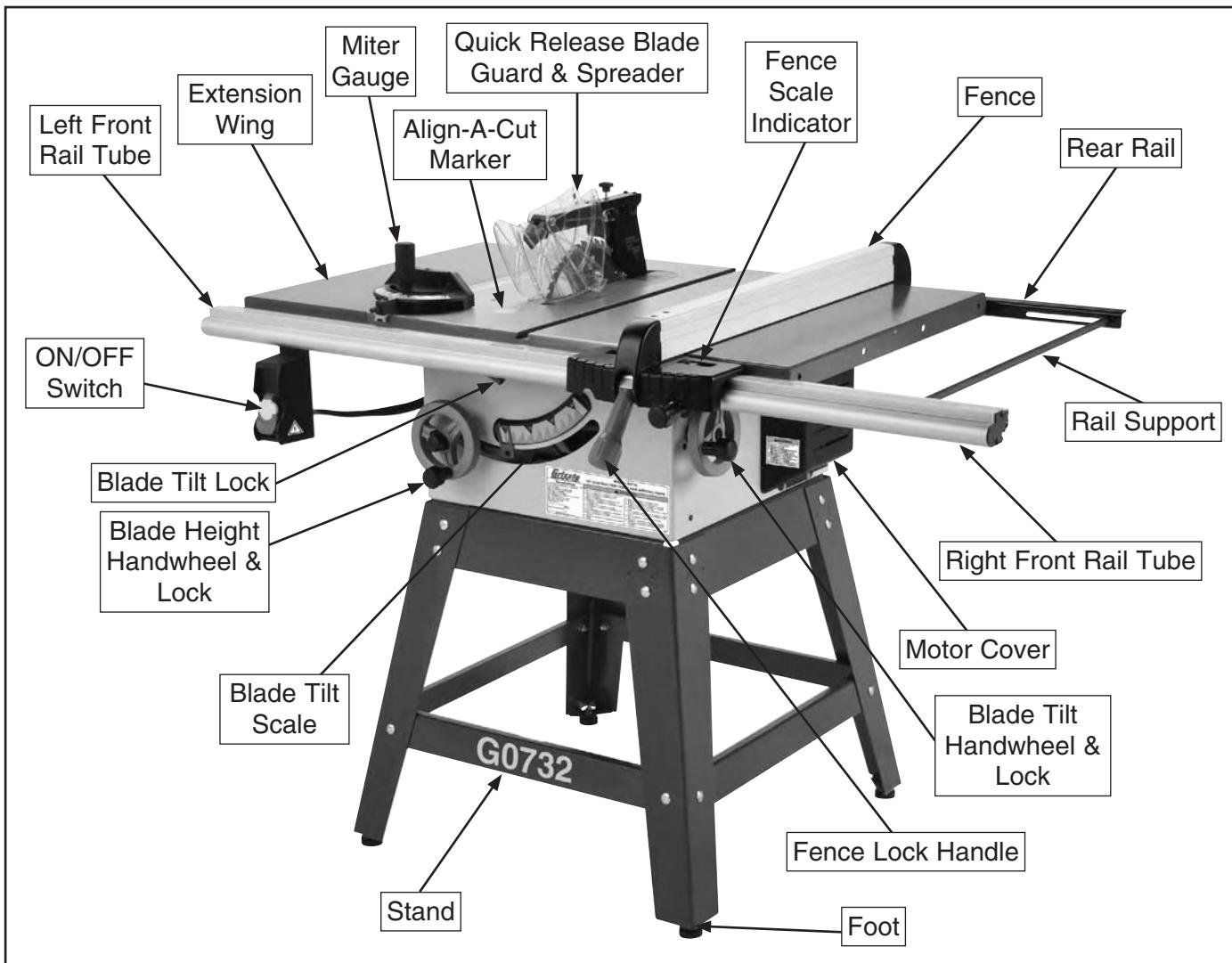
The Model G0732 1½ HP motor is prewired for 110V but will run on a 220V power supply if rewired.

This saw features an internal dust shroud that encapsulates the blade for highly effective dust removal, and a blade housing that moves using worm gears for solid and precise control.

Also, includes a left/right reading T-shape aluminum fence, a miter gauge, a quick-release blade guard and riving knife, a table insert for standard blades, a safety paddle switch, Align-A-Cut marker, and a micro-adjustable fence knob.



Identification



⚠️WARNING

For Your Own Safety Read Instruction Manual Before Operating Saw

- a) Wear eye protection.
- b) Use saw-blade guard and riving knife for every operation for which it can be used, including all through sawing.
- c) Keep hands out of the line of saw blade.
- d) Use a push-stick when required.
- e) Pay particular attention to instructions on reducing risk of kickback.
- f) Do not perform any operation freehand.
- g) Never reach around or over saw blade.





MACHINE DATA SHEET

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

MODEL G0732 CONTRACTOR STYLE SAW

Product Dimensions:

Weight.....	198 lbs
Width (side-to-side) x Depth (front-to-back) x Height.....	54-3/4 x 38-1/4 x 43 in.
Footprint (Length x Width).....	28 x 28 in.

Shipping Dimensions:

Type.....	Cardboard
Content.....	Machine
Weight.....	221 lbs
Length x Width x Height.....	36 x 29 x 19 in.

Electrical:

Power Requirement.....	110V or 220V, Single-Phase, 60 Hz
Prewired Voltage.....	110V
Minimum Circuit Size.....	15A@110V, 15A@220V
Switch.....	ON/OFF Toggle with Safety Lock Tab
Switch Voltage.....	110V/220V
Cord Length.....	6 ft.
Cord Gauge.....	14 AWG
Plug Included.....	Yes
Included Plug Type.....	NEMA 5-15 for 110V
Recommended Plug/Outlet Type.....	NEMA 6-15 for 220V

Motors:

Main

Type.....	TEFC Capacitor Start
Horsepower.....	1-1/2 HP
Voltage.....	110V/220V
Prewired.....	110V
Phase.....	Single-Phase
Amps.....	11.5A at 110V, 5.7A at 220V
Speed.....	3600 RPM
Cycle.....	60 Hz
Number of Speeds.....	1
Power Transfer	Belt Drive
Bearings.....	Shielded and Permanently Lubricated

Main Specifications:

Blade Information

Maximum Blade Diameter.....	10 in.
Riving Knife/Spreader Thickness.....	0.09 in. (2.3mm)
Required Blade Body Thickness.....	0.078 in. (2mm)
Required Blade Kerf Thickness.....	0.118 in. (3mm)
Maximum Width of Dado.....	13/16 in.
Blade Tilt.....	Left 0-45 Deg.
Arbor Size.....	5/8 in.
Arbor Speed.....	4000 RPM
Arbor Bearings.....	Sealed and Permanently Lubricated
Included Blade Information.....	10" 40T



Cutting Capacities

Maximum Depth of Cut At 90 Degrees.....	3-1/8 in.
Maximum Depth of Cut At 45 Degrees.....	2-1/4 in.
Maximum Rip To Right of Blade-Standard.....	30 in.
Maximum Rip To Left of Blade.....	12 in.

Table Information

Floor To Table Height.....	36-1/2 in.
Table Size Width.....	40 in.
Table Size Depth.....	25-1/4 in.
Table Size Thickness.....	1-1/2 in.
Distance Front of Table To Center Of Blade.....	13-1/2 in.
Distance Front of Table To Blade At Maximum Cut.....	8-7/8 in.

Fence Information

Fence Size Length.....	28 in.
Fence Size Width.....	1-5/8 in.
Fence Size Height.....	2-1/4 in.
Fence Rail Type.....	Extruded Aluminum
Fence Rail Length.....	54-3/4 in.
Fence Rail Width.....	2-3/4 in.
Fence Rail Height.....	1-3/4 in.

Miter Gauge Information

Miter Gauge Slot Type.....	T-Slot
Miter Gauge Slot Size Width.....	3/4 in.
Miter Gauge Slot Size Height.....	3/8 in.

Construction

Type.....	Contractor
Table.....	Precision Ground Cast Iron
Wings.....	Sheet Metal
Trunnions.....	Cast Iron
Base.....	Sheet Metal
Body Assembly.....	Pre-Formed Steel
Fence Assembly.....	Steel and Aluminum
Rails.....	Extruded Aluminum
Miter Gauge.....	Aluminum
Guard.....	Steel and Clear Plastic

Other Related Information

Paint.....	Powder Coated
Number of Dust Ports.....	1
Dust Port Size.....	2-1/2 in.
Motor Cover.....	Yes
Mobile Base.....	G7314Z

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Front of Cabinet
Assembly Time	1 Hour
Sound Rating	95 dB



Glossary of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is **VERY** important to us at Grizzly!

Arbor: A metal shaft extending from the drive mechanism that is the mounting location for the saw blade.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece. Refer to **Page 42** for more details.

Blade Guard Assembly: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade during operation. Refer to **Page 34** for more details.

Crosscut: Cutting operation in which the miter gauge is used to hold the workpiece while it is cut across its shortest width. Refer to **Page 41** for more details.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that uses a dado blade to cut a flat bottomed groove into the face of the workpiece. Refer to **Page 42** for more details.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface. Refer to **Page 51** for more details.

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

Kickback: An event in which the workpiece is propelled back towards the operator at a high rate of speed.

Non-Through Cut: A cut in which the blade does not cut through the top of the workpiece. Refer to **Page 30** for more details.

Parallel: Being an equal distance apart at every point along two given lines or planes (e.g. the rip fence face is parallel to the face of the saw blade).

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

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces. Refer to **Page 55** for more details.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece. Refer to **Page 45** for more details.

Rip Cut: Cutting operation in which the rip fence is used to cut across the widest width of the workpiece. Refer to **Page 40** for more details.

Riving Knife: Curving metal plate located behind the blade. It maintains the kerf opening in the wood when performing a cutting operation. Refer to **Page 37** for more details.

Spreader: Straight metal plate located behind the blade. Maintains kerf opening in wood when performing a cutting operation. Acts as a barrier behind blade to shield hands from being pulled into the blade if a kickback occurs.

Straightedge: A tool used to check the flatness, parallelism, or consistency of a surface(s).

Thin Kerf Blade: A blade with a kerf or thickness that is thinner than a standard blade cannot be used on this saw.

Through Cut: A cut in which the blade cuts completely through the workpiece (refer to **Page 30**).



Preventing Kickback

Take the precautions below to avoid the most common causes of kickback:

- Only cut workpieces with at least one smooth and straight edge. DO NOT cut warped, cupped or twisted wood.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, kickback will likely occur. Always use the rip fence or miter gauge to support the workpiece.
- Make sure the spreader or riving knife is aligned with the blade. A misaligned spreader or riving knife can cause the workpiece to catch or bind, increasing the chance of kickback. If you think that your spreader or riving knife is not aligned with the blade, check it immediately!
- Take the time to check and adjust the rip fence parallel with the blade; otherwise, the chances of kickback are extreme.
- The spreader or riving knife maintains the kerf in the workpiece, reducing the chance of kickback. Always use the riving knife for all non-through operations, unless a dado blade is installed. Always use the spreader with the blade guard for all through cuts.
- Feed cuts through to completion. Anytime you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.
- Keep the blade guard installed and in good working order. Only remove it when performing non-through cuts and immediately re-install the blade guard when finished. Remember, always use the riving knife for all non-through operations, unless a dado blade with a diameter smaller than 10" is installed.
- Make multiple, shallow passes when performing a non-through cut. Making a deep non-through cut will greatly increase the chance of kickback.

- Never move the workpiece backwards or try to back it out of a cut while the blade is moving. If you cannot complete a cut for some reason, stop the saw motor and allow the blade to completely stop before backing the workpiece out. Promptly fix the condition that prevented you from completing the cut before starting the saw again.

WARNING

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

Protecting Yourself from Kickback

Even if you know how to prevent kickback, it may still happen. Take these precautions to protect yourself if kickback DOES occur:

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



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.

⚠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 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 work-piece 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 dark areas. Keep work area clean, dry, and well-lighted.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify machine for a purpose not intended by the manufacturer!

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 risk of injury or loss of control. Before starting, verify machines are stable and mobile base (if used) is locked.

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 increases risk of 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.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

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



Additional Safety for Table Saws

WARNING

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

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

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

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

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

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

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

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

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

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

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

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

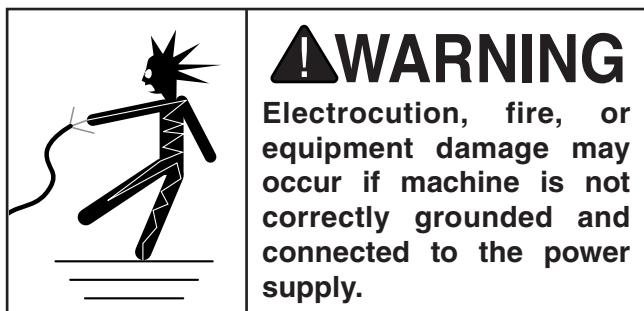
CUTTING CORRECT MATERIAL. Never cut materials not intended for this saw; only cut natural and man-made wood products, laminate covered wood products, and some plastics. Cutting metal, glass, stone, tile, etc. increases the risk of operator injury due to kickback or flying particles.



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 110V... 11.5 Amps

Full-Load Current Rating at 220V 5.7 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 Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

CAUTION

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

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.

Circuit Requirements for 110V

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage	110V/120V
Cycle	60 Hz
Phase	Single-Phase
Power Supply Circuit	15 Amps
Plug/Receptacle	NEMA 5-15

Circuit Requirements for 220V

This machine can be converted to operate on a 220V power supply (refer to **Voltage Conversion** instructions). This power supply must have a verified ground and meet the following requirements:

Nominal Voltage	220V/240V
Cycle	60 Hz
Phase	Single-Phase
Power Supply Circuit	15 Amps
Plug/Receptacle	NEMA 6-15



Grounding Requirements

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.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). 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.

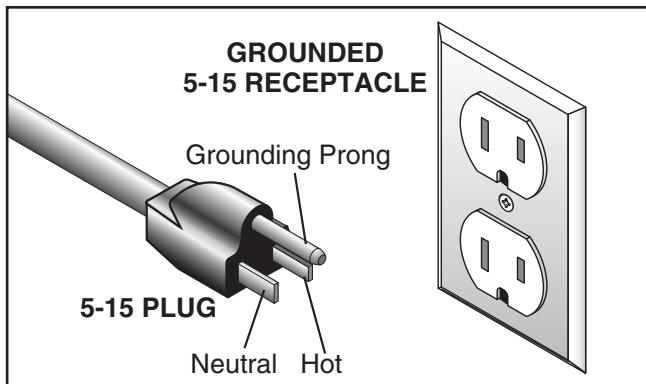
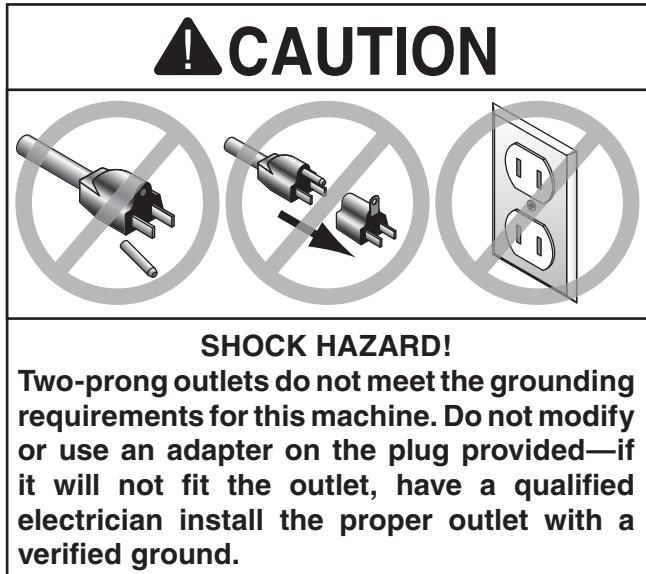


Figure 1. Typical 5-15 plug and receptacle.



For 220V operation: The plug specified under "Circuit Requirements for 220V" on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

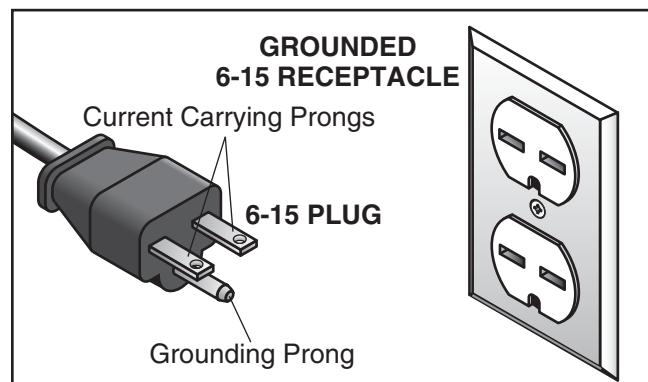


Figure 2. Typical 6-15 plug and receptacle.

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.



Voltage Conversion to 220V

The voltage conversion MUST be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the motor and installing the correct plug. A wiring diagram is provided on **Page 75** for your reference.

IMPORTANT: If the diagram included on the motor conflicts with the one on **Page 75**, the motor may have changed since the manual was printed. Use the diagram included on the motor instead.

Items Needed	Qty
• Phillips Head Screwdriver #2	1
• Electrical Tape	As Needed
• Wire Nut (14 AWG x 3)	1
• Plug 6-15	1

To convert the Model G0732 to 220V:

1. DISCONNECT SAW FROM POWER!
2. Remove the existing 5-15 plug.
3. Open the motor junction box, then loosen the two wire nuts indicated in **Figure 3**.

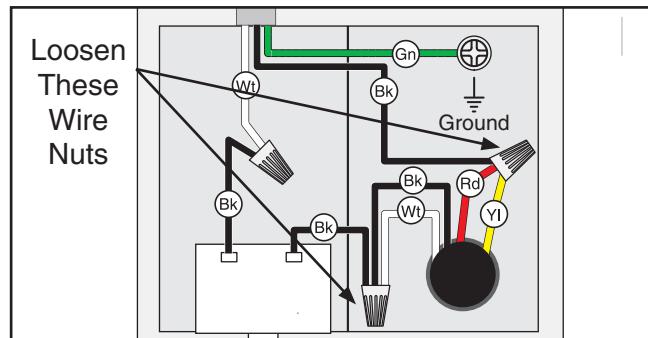


Figure 3. Location of wire nuts to be loosened.

4. Use wire nuts to connect the wires as indicated in **Figure 4**. Twist the wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose.

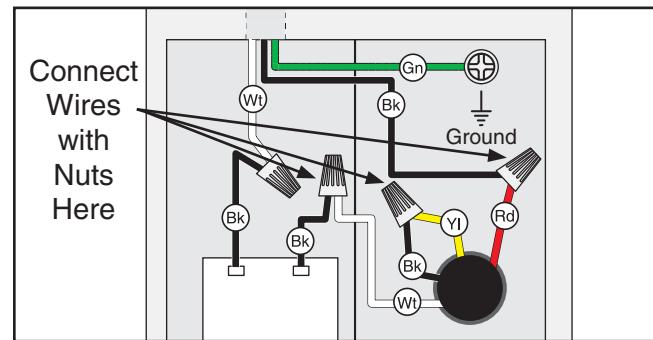
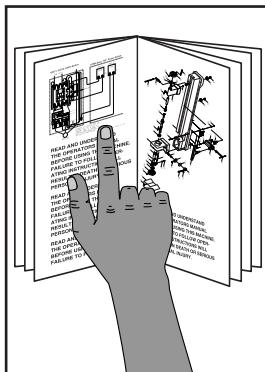


Figure 4. Saw rewired to 220V.

5. Close and secure the motor junction box.
6. Install a 6-15 plug on the power cord, according to the plug manufacturer's instructions. If the plug manufacturer's instructions are not available, NEMA standard 6-15 plug wiring is provided on **Page 75**.



SECTION 3: SETUP



⚠️WARNING

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



⚠️WARNING

Wear safety glasses during the entire setup process!



⚠️WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

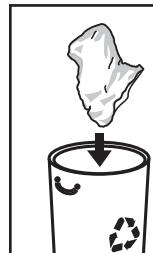
Description	Qty
• Additional People	1
• Safety Glasses	1
• Degreaser or Solvent for Cleaning.....	Varies
• Shop Rags for Cleaning	Varies
• Straightedge 4'	1
• Screwdriver Phillips #2	1
• Dust Collection System	1
• Dust Hose 4"	1
• Hose Clamps 4"	2

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

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

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



⚠️WARNING

SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.



Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

○ #10

○ 1/4"

○ 5/16"

○ 3/8"

○ 7/16"

○ 1/2"

○ 4mm

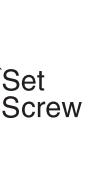
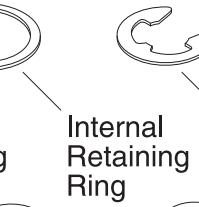
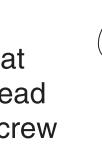
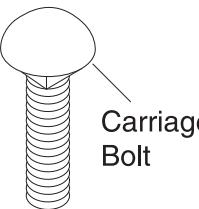
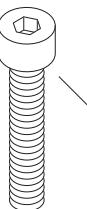
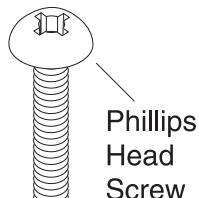
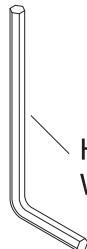
○ 6mm

○ 8mm

○ 10mm

○ 12mm

○ 16mm

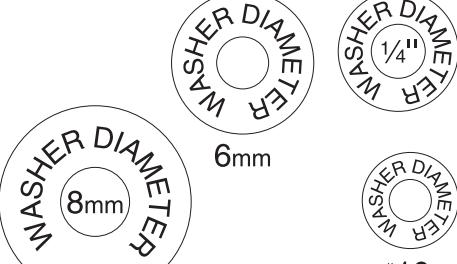
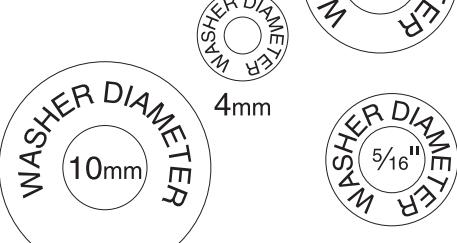
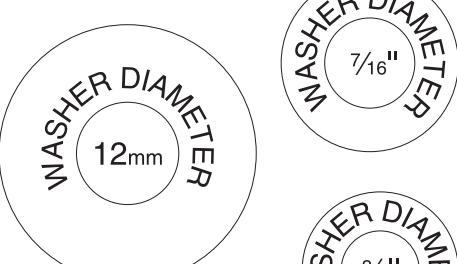
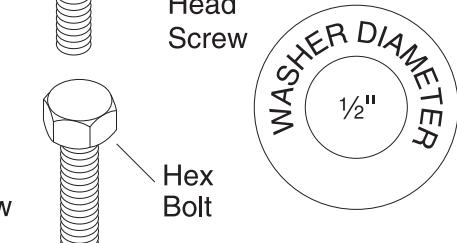
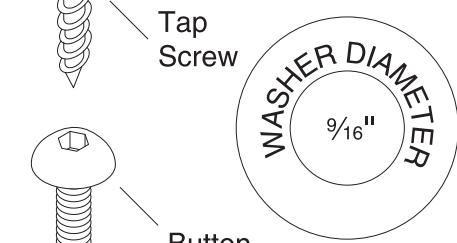
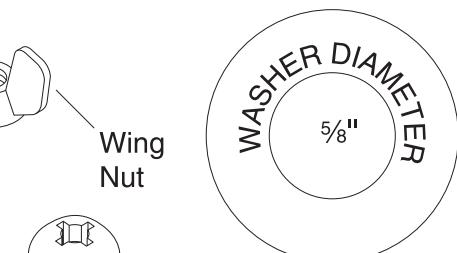


LINES ARE 1MM APART

5mm
10mm
15mm
20mm
25mm
30mm
35mm
40mm
45mm
50mm
55mm
60mm
65mm
70mm
75mm

1/4"
3/8"
1/2"
5/8"
1"
1 1/4"
1 1/2"
1 3/4"
2
2 1/4"
2 1/2"
2 3/4"
3

WASHERS ARE MEASURED BY THE INSIDE DIAMETER



#10



Inventory

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.

NOTICE

If you cannot find an item on this list, carefully check the machine and the packaging materials. Some of these items may be pre-installed for shipping or become misplaced during unpacking.

Box Components: (Figures 5– 7)		Qty
A.	Table Saw (Not Shown)	1
B.	Stand Legs	4
C.	Extension Wings	2
D.	Long Upper Stand Braces	2
E.	Short Upper Stand Braces	2
F.	Short Lower Stand Braces	2
G.	Long Lower Stand Braces	2
H.	Rubber Feet	4
I.	Miter Gauge Assembly	1
J.	Spreader/Blade Guard Assembly	1
K.	Blade Tilt Handwheel	1
L.	Blade Height Handwheel	1
M.	Hex Wrench 2.5, 4, 6 mm	1 Each
N.	Wrench 11 x 13	1
O.	Blade Height Lock Knob	1
P.	Height Handwheel Bushing	1
Q.	Arbor Wrenches	2
R.	Push Stick	1
S.	Fence Handle	1
T.	Fence Assembly	1
U.	Right Front Rail	1
V.	Left Front Rail	1
W.	Right Rear Rail	1
X.	Left Rear Rail	1
Y.	Rail Support Shaft	1
Z.	Push Stick Holder	1
AA.	Front Rail Caps	2

Hardware (Not Shown):		Qty
Carriage Bolts M8-1.25 x 20 (Stand)		24
Flat Washers 8mm (Stand, Feet)		40
Hex Nuts M8-1.25 (Stand, Feet, Rails)		48

Lock Washers 8mm (Wings, Rails)	20
Hex Bolts M8-1.25 x 20	
(Stand, Wings, Rear Rails)	18
T-Bolts M8-1.25 x 20 (Front Rails)	6
Tap Screws M4 x 10 (Front Rails)	4
Phillip Head Screws M6-1 x 12 (Switch)	2
Square Nuts M6 x 1 (Switch)	2
Flat Washers 6mm (Switch, Support Shaft)	3
Knob M6-1 x 12 (Support Shaft)	1
Rail Sliding Plate (Support Shaft)	1
Flat Head Screw M4-.7 x 12 (Support Shaft)	1
Hex Bolt M8-1.25 x 10 w/Flat Washer	
(Push Stick Holder)	1

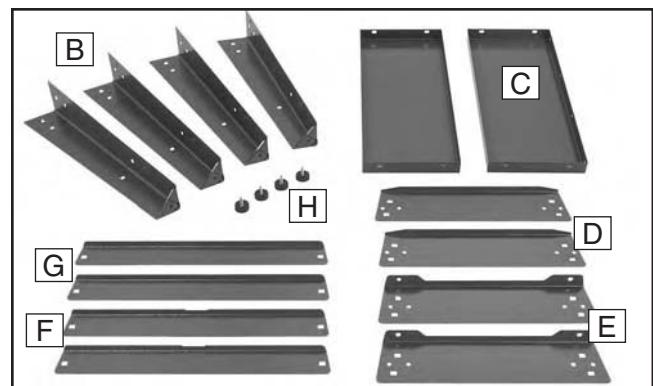


Figure 5. Inventory contents B–H.

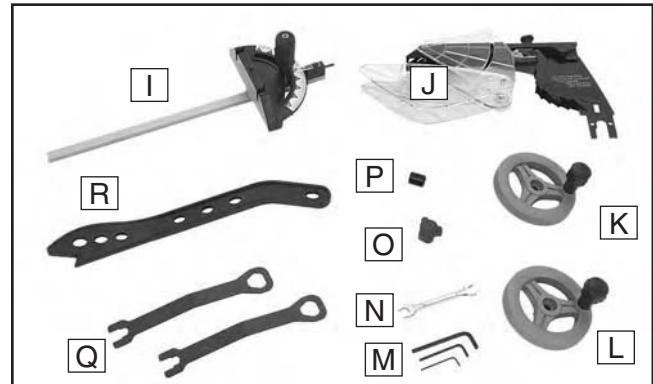


Figure 6. Inventory contents I–R.

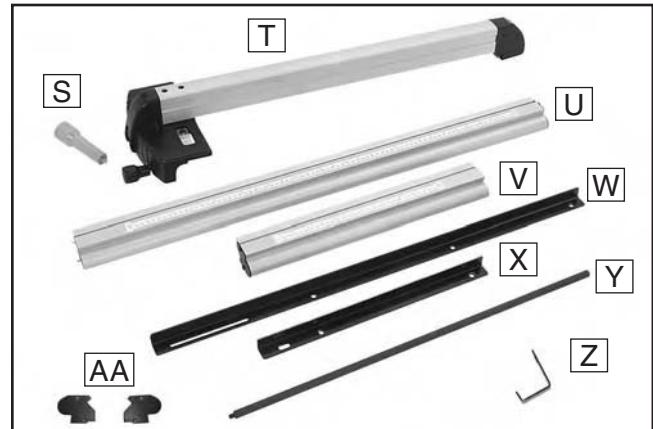


Figure 7. Inventory contents S–Z.



Cleanup

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

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

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

Before cleaning, gather the following:

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

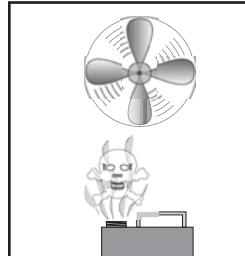
Basic steps for removing rust preventative:

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



WARNING

Gasoline or products with low flash points can explode or cause fire if used to clean machinery. Avoid cleaning with these products.



CAUTION

Many cleaning solvents are toxic if concentrated amounts are inhaled. Only work in a well-ventilated area.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces. Test all cleaners in an inconspicuous area before using to make sure they will not damage paint.

T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.



Figure 8. T23692 Orange Power Degreaser.



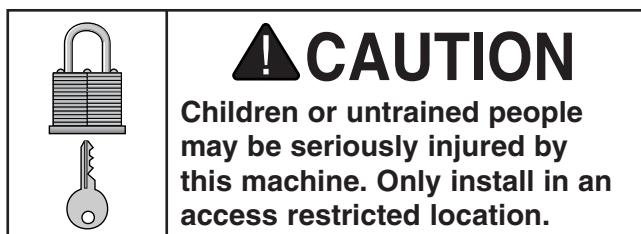
Site Considerations

Weight Load

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

Space Allocation

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



Physical Environment

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

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device, if required.

Lighting

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

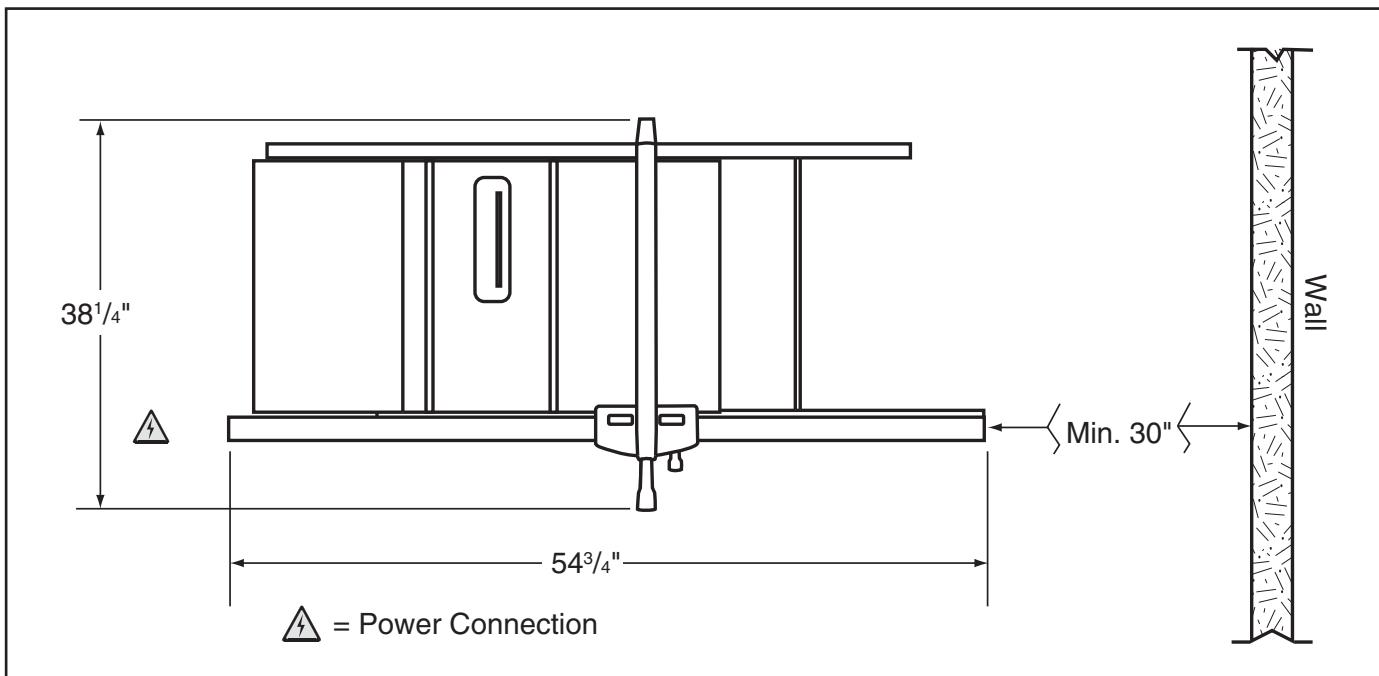


Figure 9. Minimum working clearances.



Assembly

To assemble the table saw:

1. Attach each short upper stand brace to two stand legs, as shown in **Figure 10**, using (4) M8-1.25 x 16 carriage bolts, (4) 8mm flat washers, and (4) M8-1.25 hex nuts.

Note: The short stand braces can be distinguished from the long braces by the notches in the upper part of the braces.

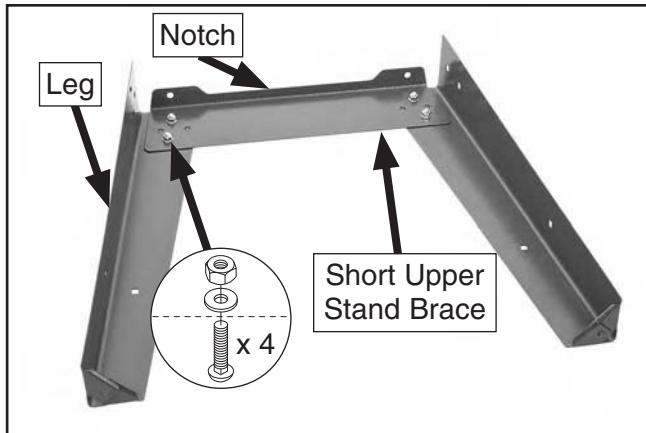


Figure 10. Short upper stand brace attached to legs.

2. Attach each of the short lower stand braces to one of the assemblies from **Step 1**, as shown in **Figure 11**, with (2) M8-1.25 x 16 carriage bolts, (2) 8mm flat washers, and (2) M8-1.25 hex nuts.

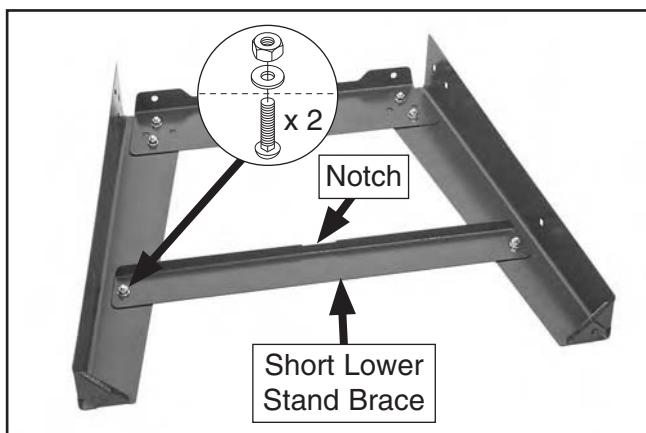


Figure 11. Short lower stand brace attached to legs.

Note: Make sure the upper stand brace with the Grizzly logo is on the same side as the lower stand brace with the model number label.

3. Attach the leg assemblies with the remaining long upper and lower braces, using (12) M8-1.25 x 16 carriage bolts, (12) 8mm flat washers, and (12) M8-1.25 hex nuts, as shown in **Figure 12**. Hand tighten the fasteners for now.

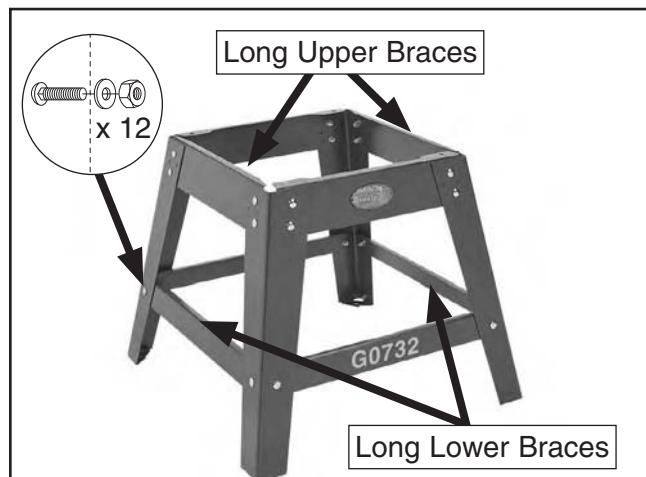


Figure 12. Stand assembly completed.

4. Attach each of the feet to the bottom of the stand legs, as shown in **Figure 13**, using (2) M8-1.25 hex nuts and (2) 8mm flat washers.

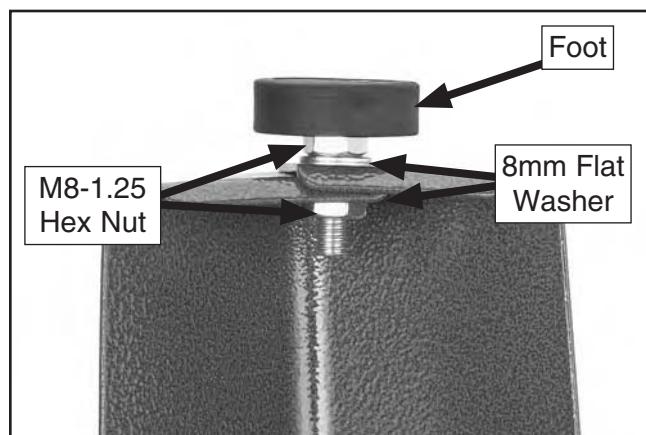


Figure 13. Foot installed with flat washers and hex nuts.



- Insert the bushing onto the front handwheel shaft (see **Figure 14**), slide the flat on the blade height handwheel onto the flat of the shaft, then thread the lock knob on until you feel slight resistance.

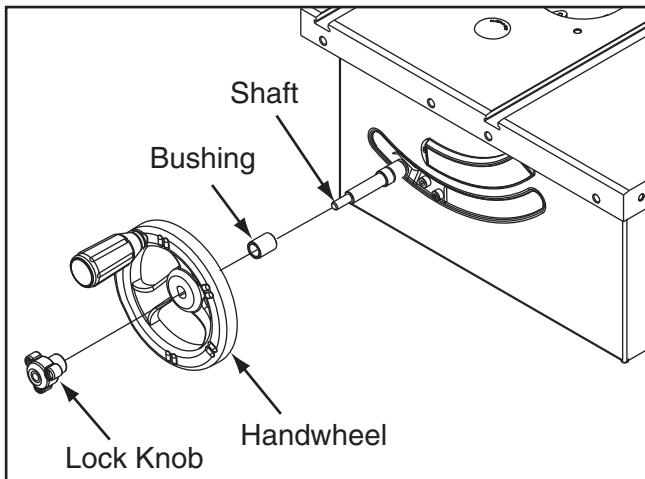


Figure 14. Installing blade height handwheel components.

- Use the blade height handwheel to lower the blade all the way into the saw.
- With the help of two other people, place the saw upside down (we recommend putting it on a piece of cardboard to prevent scratching the cast iron table top), then place the stand on the saw so the Grizzly logo and model number face the same direction as the front of the saw, as shown in **Figure 15**.

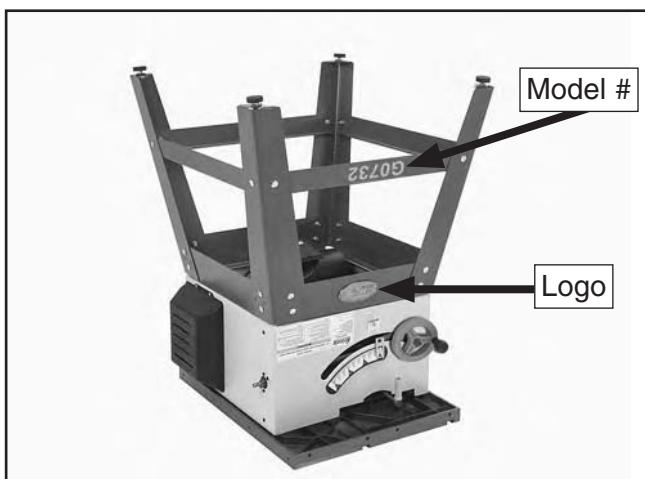


Figure 15. Stand assembly positioned on saw.

- Secure the stand to the table saw body with (4) M8-1.25 x 20 hex bolts, (8) 8mm flat washers, and (4) M8-1.25 hex nuts, as shown in **Figure 16**.

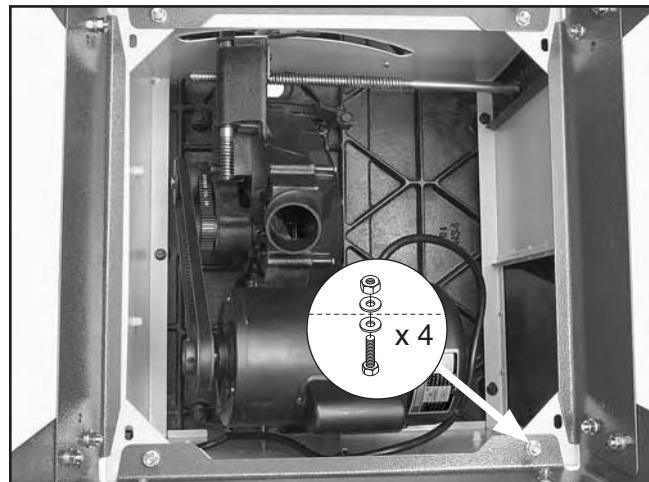


Figure 16. Stand secured to saw body.

- With the assistance of two other people, turn the saw upright on its feet. **DO NOT ATTEMPT THIS BY YOURSELF!**
- Place a level on the saw table, level the saw from side-to-side and front-to-back by adjusting the feet, then fully tighten all the stand fasteners with a 13mm wrench (or socket).
- Remove the cap screw, lock washer, and flat washer from the blade tilt shaft.
- Slide the flat of the blade tilt handwheel onto the flat of the blade tilt shaft, then secure, as shown in **Figure 17**.

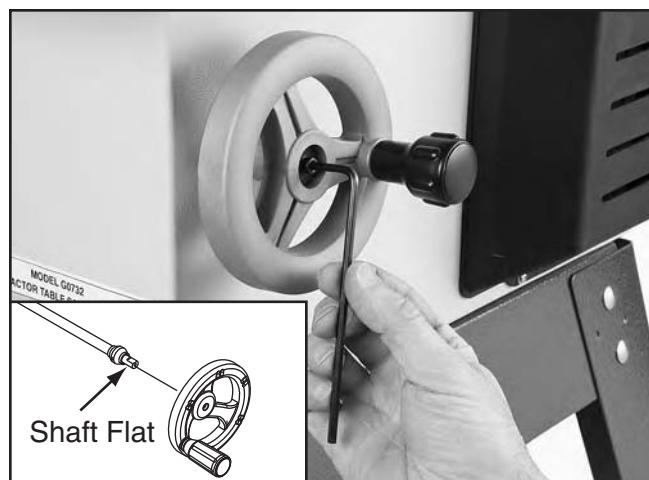


Figure 17. Securing blade tilt handwheel.



13. Inspect the cast iron table for burrs or foreign material that may inhibit installation of the extension wings.

The mating edges of the table must be clean, smooth, and flat. Use a wire brush or file if necessary to clean up the edges. This step will ensure that the wings will mount properly to the main table.

14. With another person to hold the wings in place, attach each extension wing to the main table with (4) M8-1.25 x 20 hex bolts and (4) 8mm lock washers, as shown in **Figure 18**.

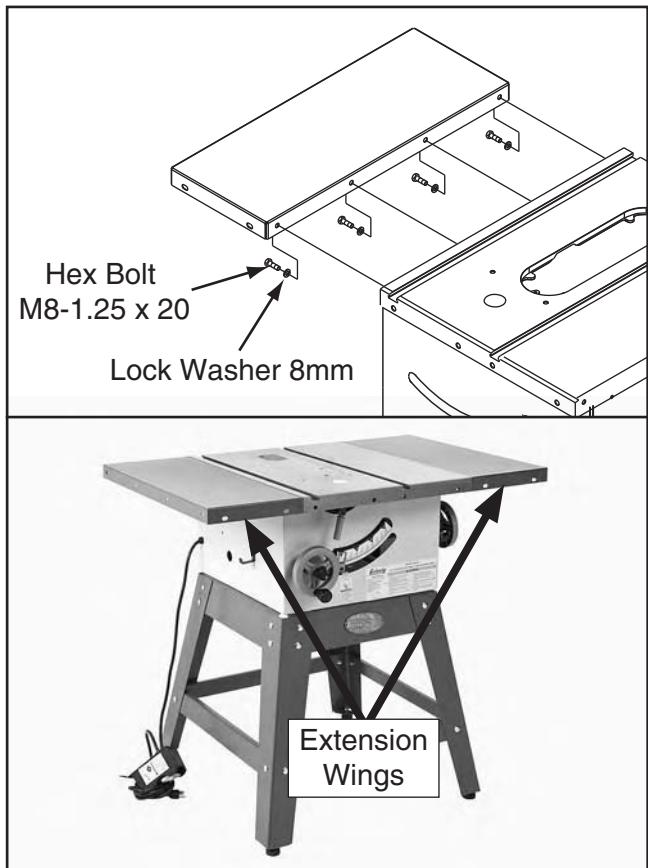


Figure 18. Extension wings installed on saw.

15. Place the straightedge across the extension wings and main table to make sure that the combined table surface is flat.

- If the combined table surface is flat, proceed to the next step.
- If the outside end of the extension wing tilts up or down, you will have to adjust the wings evenly with the table when instructed later in the assembly process.

16. Install the left rear rail onto the table and left extension wing with (3) M8-1.25 x 20 hex bolts, (3) 8mm lock washers, and (3) M8-1.25 hex nuts, as shown in **Figure 19**. Do not fully tighten at this time.

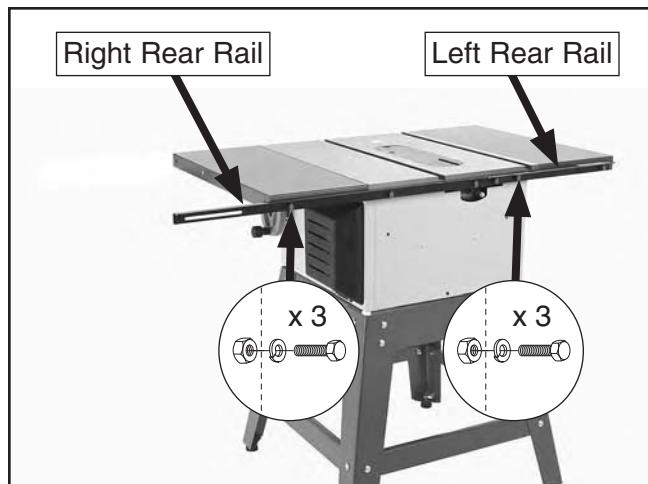


Figure 19. Rear rail installed.

17. Install the right rear rail onto the table and right extension wing with (3) M8-1.25 x 20 hex bolts, (3) 8mm lock washers, and (3) M8-1.25 hex nuts. Do not fully tighten at this time.

18. Align the bottom of the rails with the bottom edges of the cast iron table, so the top of the rails are flush with each other and parallel with the table and extension wings. Completely tighten the fasteners on the rear rails that mount it to the cast iron table.

19. Turn the lock knob that secures the table insert so it is parallel to the inner slot, as shown in **Figure 20**, remove the insert and set it aside, then raise the blade up all the way

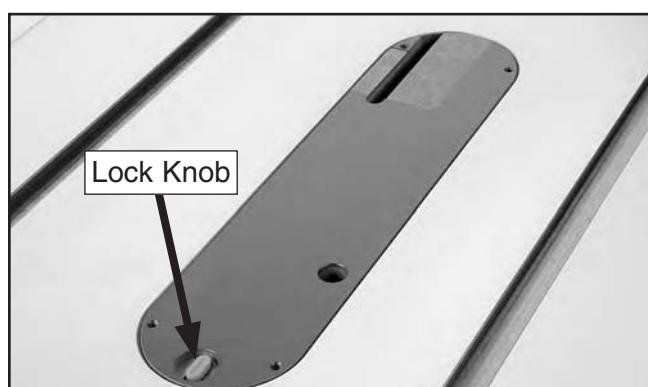


Figure 20. Insert lock knob unlocked.



20. Slide (2) M8-1.25 x 20 T-slot bolts into the slot on the left front rail tube, as illustrated in **Figure 21**.

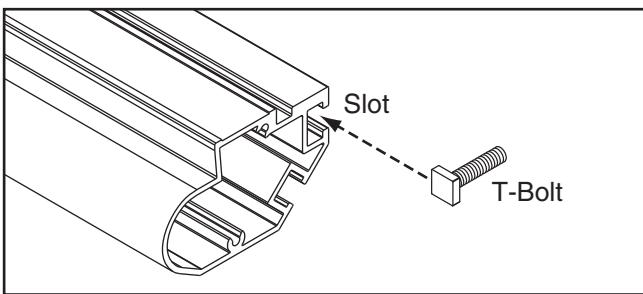


Figure 21. Inserting T-bolt into left rail tube slot.

21. Insert the bolts into the corresponding holes on the extension wing and main table, then align the right edge of the left front rail (see **Figure 22**) with the saw blade.

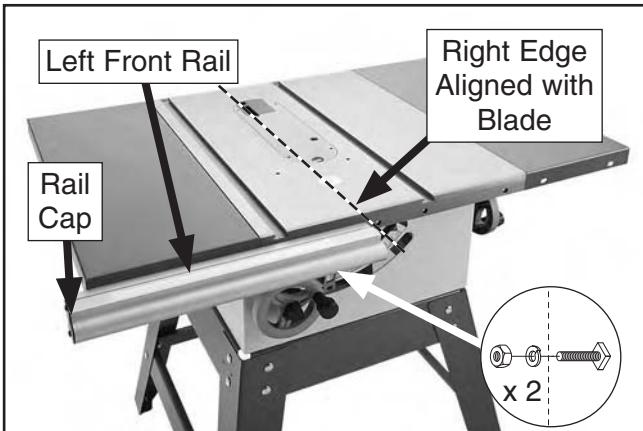


Figure 22. Left front rail installed.

Note: A straightedge can be used to align the right edge of the left front rail with the blade.

22. Secure the front left rail with (2) 8mm lock washers and (2) M8-1.25 hex nuts, as shown in **Figure 22**. Do not fully tighten the fasteners yet. Also install the left rail cap with two M4 x 10 tap screws.

23. Slide (4) M8-1.25 x 20 T-slot bolts into the slot in the right front rail, then insert the bolts into the mounting holes in the extension wing and main table.

24. Slide the two pins on the end of the right front rail (**Figure 23**) into the holes in the left rail.

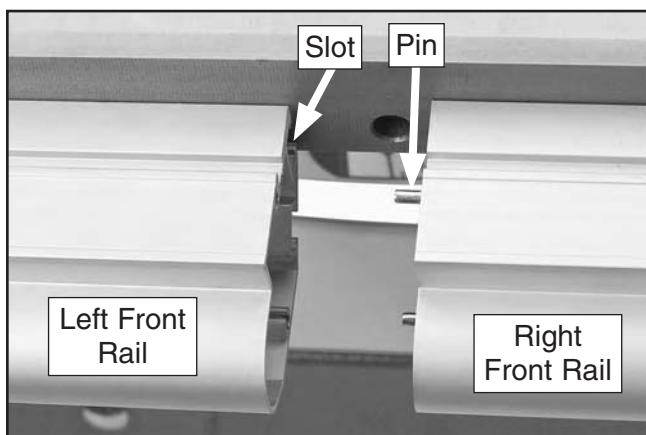


Figure 23. Front rail pins and slots.

25. Secure the right front rail with the (4) 8mm lock washers and (4) M8-1.25 hex nuts, as shown in **Figure 24**. Do not fully tighten the fasteners yet. Also install the right rail cap with two M4 x 10 tap screws.

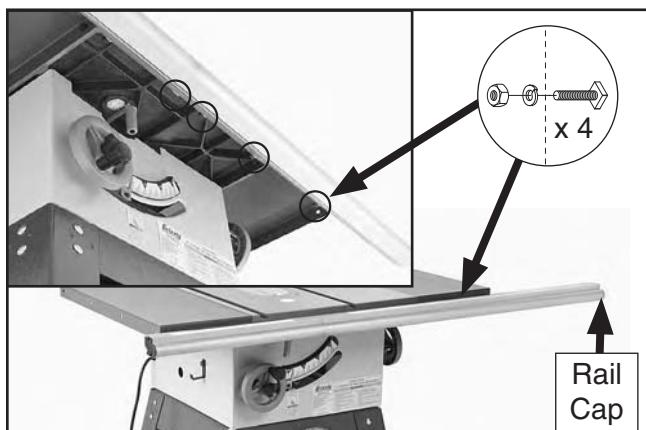


Figure 24. Right front rail installed.

—If the wings were not even with the table top in **Step 15 on Page 22**, loosen the wing mounting fasteners. Place a straightedge across the front of the table and front of the extension wings. Gently lift up or push down on the wings. When the front of the table and wings are even, tighten the fasteners that mount the front of the wings to the table.

Repeat the process above in similar manner for the table and back of the extension wings. When the back of the wings are even with the back of the table, tighten the rear wing mounting fasteners.



26. Thread the fence handle into the fence (see **Figure 25**), then mount the fence on the front and rear rails and to the right of the blade.

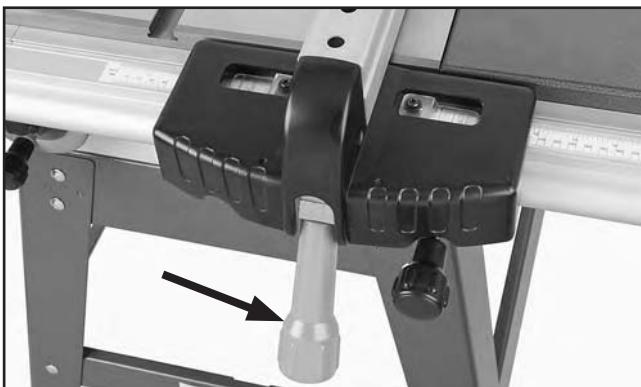


Figure 25. Fence lock handle installed on fence.

Note: The bracket on the back of the fence must be seated below the rear rail for the fence to function correctly (see **Figure 26**).

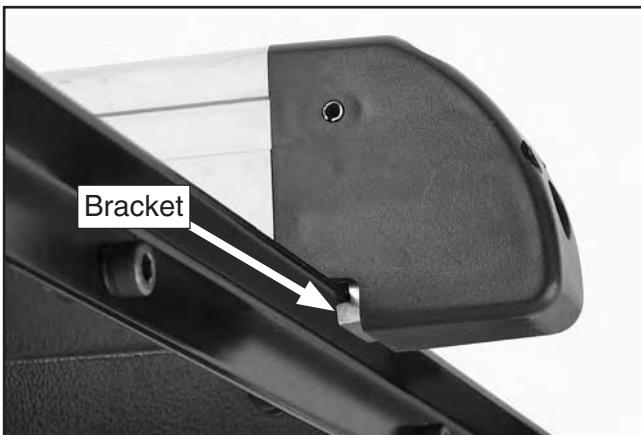


Figure 26. Rear fence bracket positioned correctly.

27. Move the left face of the fence against the blade.

28. While holding the fence stationary, adjust the front rail until the right fence scale zero mark aligns with the centerline on the right fence indicator window.

29. Tighten the front rail fasteners, then verify that the front rail is parallel with the cast iron table and extension wings.

Tip: Use a straightedge to level the right and left rail pieces.

30. Secure the sliding rail plate to the support shaft with an M4-.7 x 12 flat head screw, slide the plate into rear slot on the front rail, then secure the opposite end of the shaft with (1) M6-1 x 12 knob and (1) 6mm flat washer, as shown in **Figure 27**. Ensure that the shaft is parallel with the extension wing.

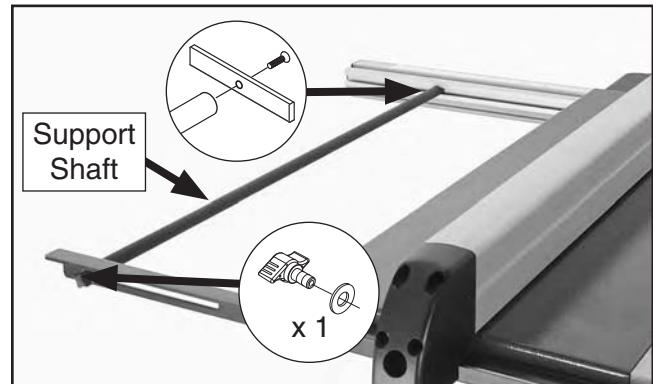


Figure 27. Support shaft installed.

31. Insert (2) M6-1 square nuts into the slot on the back of the left front rail, align the nuts with the switch bracket mounting holes, then secure the switch with (2) M6-1 x 12 Phillips head screws and (2) 6mm flat washers, as shown in **Figure 28**.

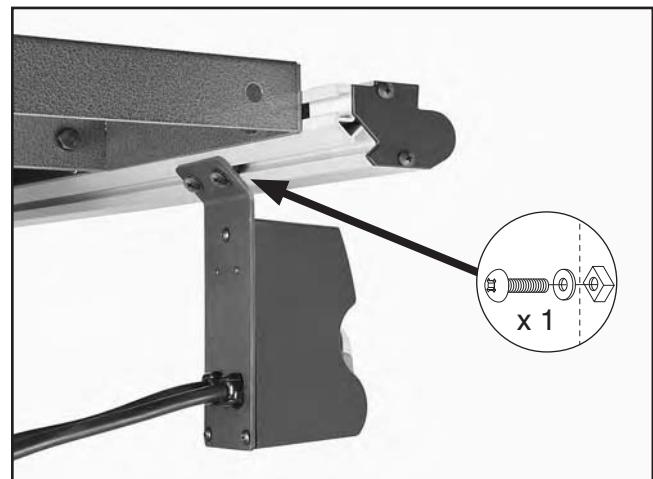


Figure 28. Switch installed onto front rail.



32. Install the push stick holder with (1) M8-1.25 x 10 hex bolt and flat washer, as shown in **Figure 29**.

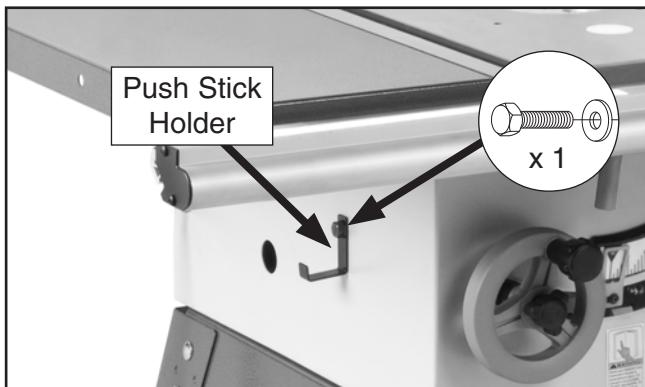


Figure 29. Push stick holder installed (switch and cords not shown for clarity).

33. Slide the fence out of the way.

34. Ensure the blade is raised all the way up and the blade angle is 0°.

35. Unthread the lock knob on the riving knife/blade guard mounting block (see **Figure 30**) several turns. Push the riving knife away from the knob, then lift the riving knife up to remove it.

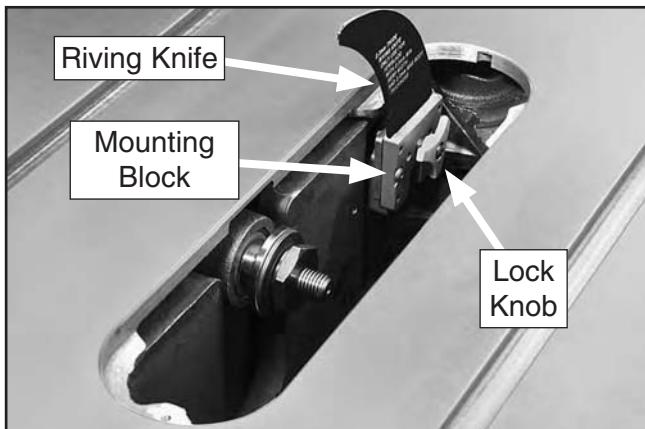


Figure 30. Example of riving knife installed.

The riving knife is installed for shipping purposes. Although it is possible to use the riving knife for through-cutting operations, the blade guard assembly offers far more injury protection and risk reduction than the riving knife. Therefore, **we strongly recommend** that you use the blade guard instead of the riving knife for through cuts.

Note: *The two pins in the mounting block fit into matching slots on the riving knife, keeping it secured.*

36. Lower the blade all the way down.

37. Follow instructions in **Dust Collection, Power Connection**, and **Test Run**, then proceed to **Final Setup** to complete the remaining assembly steps.



Dust Collection

! CAUTION

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

Components and Hardware Needed: Qty

Dust Hose 2½" (not included) 1
Hose Clamps 2½" (not included) 2
Dust Collection System (not included) 1

Recommended CFM at Dust Port: 250 CFM

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

To connect a dust collection hose:

1. Fit a 2½" dust hose over the dust port, as shown in **Figure 31**, and tightly secure in place with a hose clamp.
2. Tug the hose to make sure it does not come off. **Note:** A tight fit is necessary for proper performance.



Figure 31. Dust hose attached to dust port.

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.

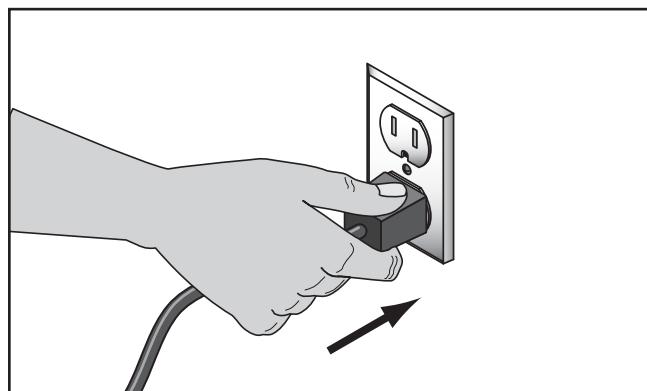


Figure 32. Connecting power.

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.

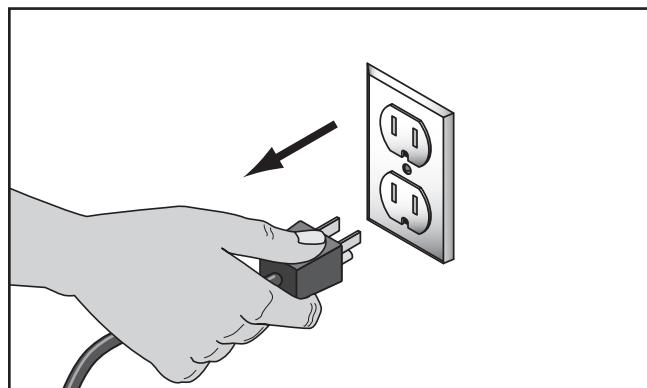


Figure 33. Disconnecting power.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following:
1) The motor powers up and runs correctly, and
2) the safety disabling mechanism on the switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting on Page 63**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
2. Lower the blade all the way down.
3. Connect the machine to the power source.
4. Verify that the machine is operating correctly by turning it **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.

5. Turn the machine **OFF**.
6. Remove the switch disabling key, as shown in **Figure 34**.

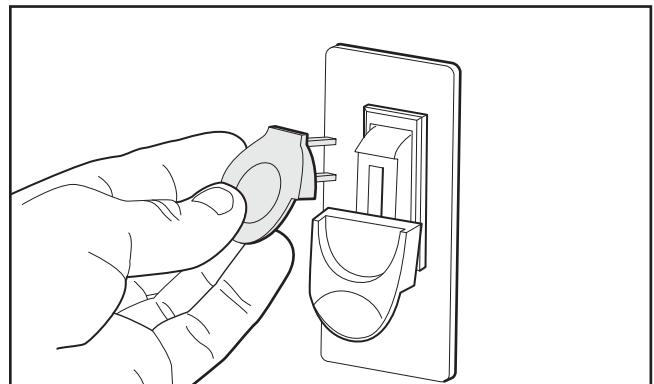


Figure 34. Removing switch key from paddle switch.

7. Try to start the machine with the paddle switch.
 - If the machine DOES NOT start, the switch disabling feature IS working as designed.
 - If the machine DOES start, immediately stop the machine. The switch disabling feature IS NOT working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Congratulations! The test run is complete.



Final Setup

The remaining tasks required for assembling the saw include the following steps: installing the table insert and cutting a slot for the blade, checking fence parallelism, and installing the blade guard.

To complete the remaining assembly steps:

1. DISCONNECT SAW FROM POWER!
2. Install and cut the table insert, as instructed in **Cutting a Zero Clearance Insert** on **Page 38**, then proceed to the next step.
3. Verify that the fence is parallel with the blade/ miter slot (refer to **Parallelism & Clamping Pressure** on **Page 69**). The blade was set parallel with the miter slot at the factory, which affects whether the fence is parallel when mounted to the table.

4. Install the blade guard as instructed in "Installing Blade Guard & Spreader" on **Page 34**.
5. Verify the blade tilt stop accuracy (refer to **Page 65**). This adjustment was performed at the factory. However, because of the many variables involved with shipping, we recommend that you verify this adjustment to ensure that this saw cuts safely and accurately.

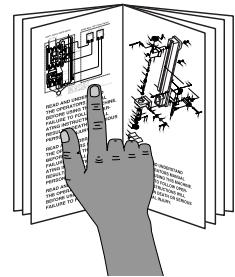
The table saw should now look like the one shown in **Figure 35**. Congratulations, you have successfully assembled the table saw!



Figure 35. Fully assembled table saw.



SECTION 4: OPERATIONS



!WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

!WARNING

Damage to your eyes, lungs, and hearing could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



!WARNING

For Your Own Safety Read Instruction Manual Before Operating Saw

- a) Wear eye protection.
- b) Use saw-blade guard and riving knife for every operation for which it can be used, including all through sawing.
- c) Keep hands out of the line of saw blade.
- d) Use a push-stick when required.
- e) Pay particular attention to instructions on reducing risk of kickback.
- f) Do not perform any operation freehand.
- g) Never reach around or over saw blade.

NOTICE

If you have never used this type of machine or equipment before, seek training from an experienced machine operator or read "how to" books before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

Refer to **Figure 36** and the descriptions below to better understand the basic controls.

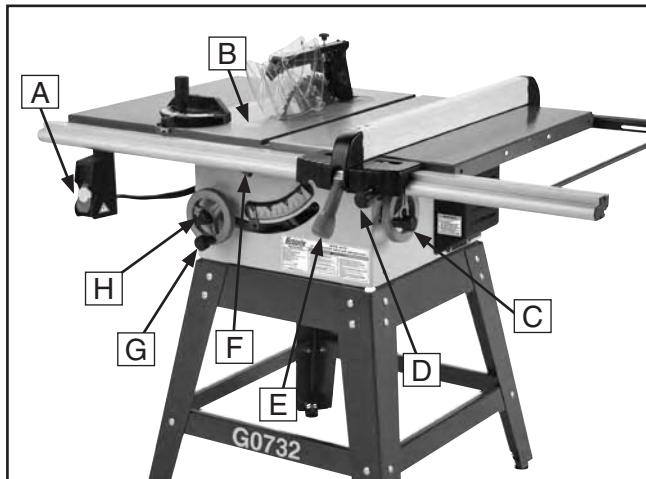


Figure 36. Basic table saw controls G0732.

- A. **ON/OFF Switch:** Starts and stops the motor. The switch can be disabled for safety by removing the key.
- B. **Align-A-Cut Marker:** Used to align the cutting mark on the workpiece with the blade kerf.
- C. **Blade Tilt Handwheel:** Adjusts the blade angle from 0°–45°.
- D. **Micro-Adjustment Knob:** Adjusts the fence-side-to-side in small increments.
- E. **Fence Lock:** Locks fence when pushed down, unlocks fence when pulled up.
- F. **Blade Tilt Lock:** Locks the blade tilt setting so it does not move during operations.
- G. **Blade Height Handwheel:** Adjusts blade height.
- H. **Blade Height Lock:** Locks the blade height.



Operation Overview

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

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

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

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the blade tilt, if necessary, to the correct angle of the desired cut.
3. Adjusts the blade height to no more than $\frac{1}{4}$ " higher than the thickness of the workpiece.
4. Adjusts the fence to the desired width of cut then locks it in place.
5. Checks the outfeed side of the machine for proper support and to make sure the workpiece can safely pass all the way through the blade without interference.
6. Puts on safety glasses and a respirator. Locates push sticks/blocks if needed.
7. Starts the saw.
8. Feeds the workpiece all the way through the blade while maintaining firm pressure on the workpiece against the table and fence, and keeping hands and fingers out of the blade path and away from the blade.
9. Stops the machine immediately after the cut is complete.

Non-Through & Through Cuts

Non-Through Cuts

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

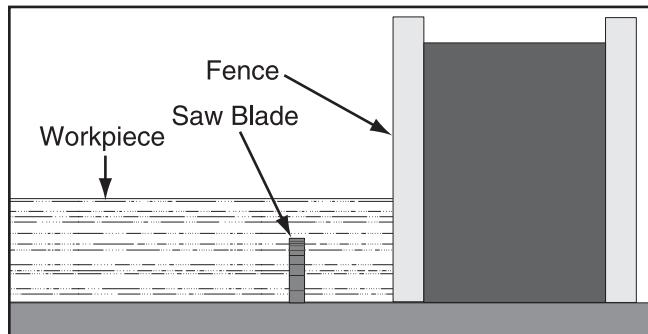


Figure 37. Example of a non-through cut.

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

Through Cuts

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

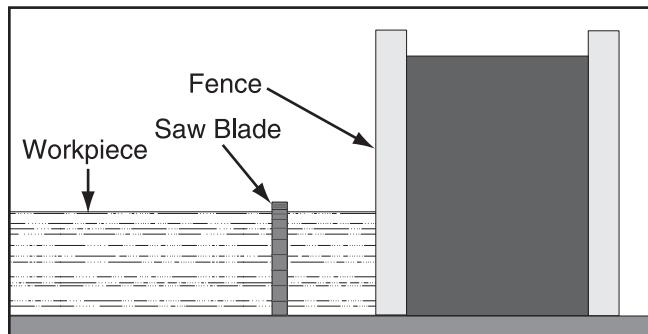


Figure 38. Example of a through cut (blade guard not shown for illustrative clarity).



Workpiece Inspection

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

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

Blade Requirements

To ensure that the spreader or riving knife works safely, the following requirements MUST be met when installing new blades:

- Blade Diameter: 10"
- Required Blade Body Thickness (excluding teeth): 0.078" (2mm)
- Required Blade Kerf Thickness: 0.118"– (3mm)

The spreader or riving knife MUST be aligned/adjusted to blade. These requirements DO NOT apply to dado blades.

Blade Selection

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

Ripping Blade Features:

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

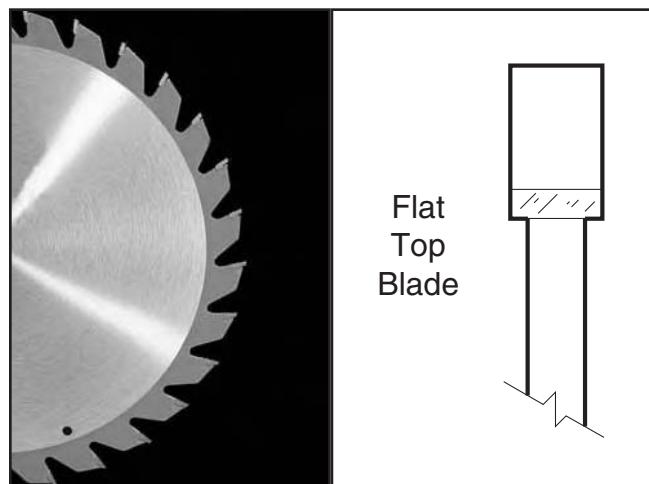


Figure 39. Ripping blade.



Crosscut blade features:

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

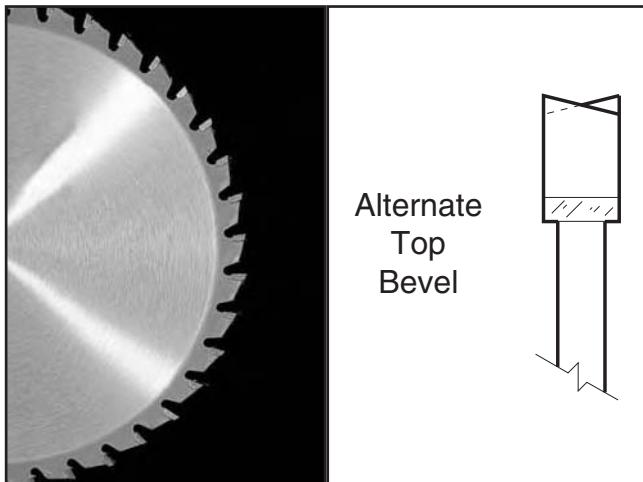


Figure 40. Crosscutting blade.

Combination blade features:

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

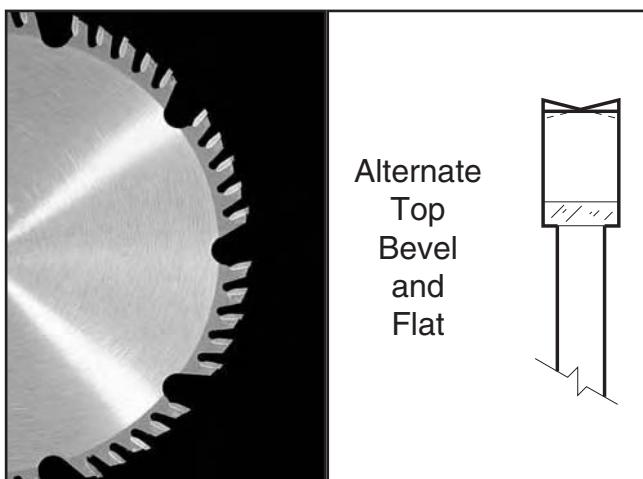


Figure 41. Combination blade.

Laminate blade features:

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

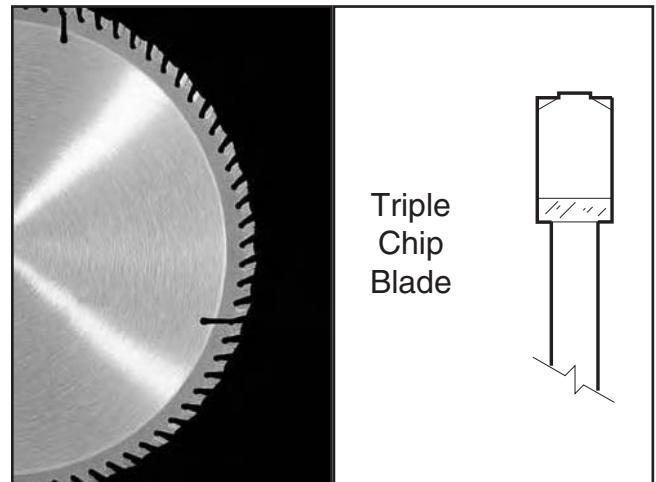


Figure 42. Laminate blade.

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

Dado Blades

Stacked Dado Blade (see below): Multiple blades are stacked together to control the cutting width. Stacked dado blades are more expensive than wobble blades, but typically produce higher quality results.

Wobble Dado Blade: A single blade mounted at a slight angle on an arbor hub. The blade angle is adjustable on the hub, and the width of the dado cut is controlled by the angle setting of the blade.



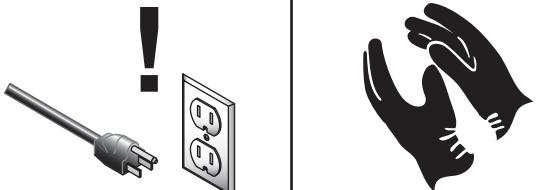
Figure 43. Stacked dado blade.



Blade Installation

! CAUTION

To reduce the risk of injury, always disconnect power to the saw before changing blades. Since the blade is sharp, use extra care and wear gloves when installing it.



To install a new blade:

1. DISCONNECT SAW FROM POWER!
2. Raise the arbor all the way up, and remove the table insert and blade guard/riving knife, depending on what is installed.
3. Use the arbor wrenches to loosen and remove the arbor nut, flange, and blade. The arbor nut has right hand threads; turn it counter-clockwise to loosen.
4. Install the new blade, flange and arbor nut on the arbor, as shown in **Figure 44**, with teeth facing the front of the saw.

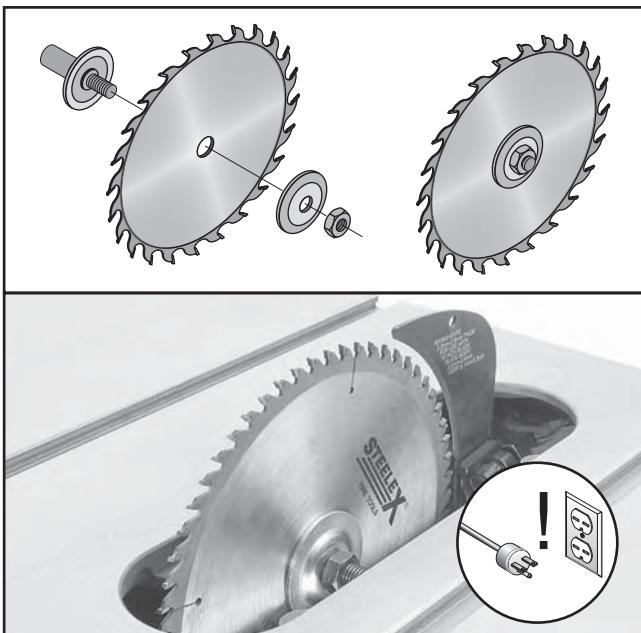


Figure 44. Blade order of installation and teeth facing the correct direction.

5. Securely tighten the arbor nut and the flange against the blade using the wrenches included with the saw, as shown in **Figure 45**. DO NOT overtighten.

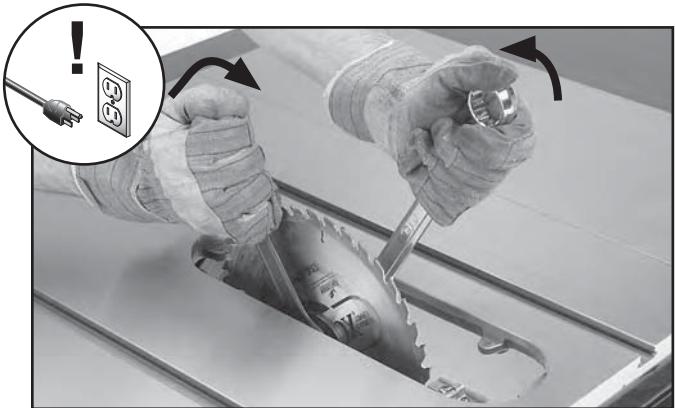


Figure 45. Example of securing blade.

6. Re-install the blade guard/riving knife and the table insert.



Blade Guard Assembly

The term "blade guard" refers to the assembly that consists of the clear polycarbonate shield, the spreader, and the anti-kickback pawls on each side of the spreader (**Figure 46**). Each of these components has important safety functions.

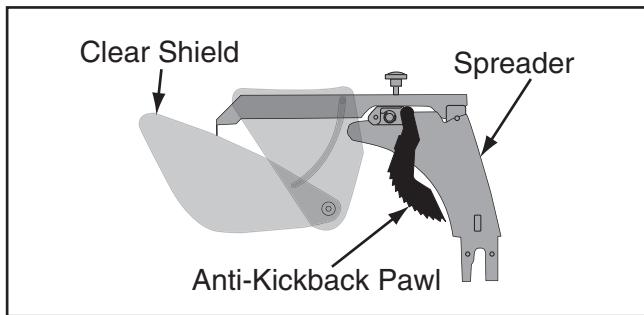


Figure 46. Blade guard assembly components.

Guard

The clear polycarbonate guard reduces injury risk by providing a barrier around the blade that prevents accidental contact and contains flying wood chips.

The guard allows the operator to see the blade cut the workpiece during operation. This guard is designed to lift as the workpiece is pushed into the blade and remain in contact with the workpiece throughout the entire cut.

To ensure that the guard does its job effectively, it must always be in the downward position against the table during idle operation, and the hinge mechanism must be maintained in good working condition so the guard can freely pivot up and down to accommodate the height of the workpiece and return to the table surface.

Spreader

The spreader is a metal plate that prevents the newly cut workpiece from pinching the backside of the blade and causing kickback.

The spreader also acts as a barrier behind the blade to shield hands from being pulled into the blade if a kickback occurs.

WARNING

In order to work properly, the spreader cannot be bent or misaligned with the blade. If the spreader gets accidentally bent, take the time to straighten it or just replace it. Using a bent or misaligned spreader will increase the risk of kickback! Refer to Page 67 to check or adjust alignment if necessary.

Installing Blade Guard & Spreader

1. DISCONNECT SAW FROM POWER!
2. Remove the table insert.
3. Insert the spreader into the bracket slot and tighten the lock knob shown in **Figure 47** to secure the spreader.

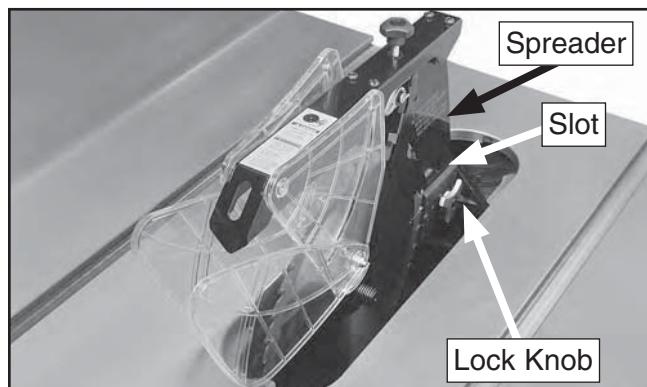


Figure 47. Example of location to secure blade guard.

4. Tug upward on the top of the spreader to verify it is locked.



5. Lift the blade guard cover just enough to slide the table insert into the table slot over the blade, then secure the insert in place with the lock knob.

The blade guard, when properly installed, should be setup similar to **Figure 48**. It should pivot freely up and down and return to the table in the resting position. It should also swing up high enough to accommodate the workpiece.



Figure 48. Blade guard and insert properly installed.

6. Swing one side of the blade guard up and out of the way.
7. While lifting up on the right spreader pawl, place a straightedge against the blade and the spreader, making sure the straightedge does not touch a blade tooth.

When properly aligned, the spreader/riving knife will be in the "Alignment Zone," shown in **Figure 49**, and will be parallel with the blade.

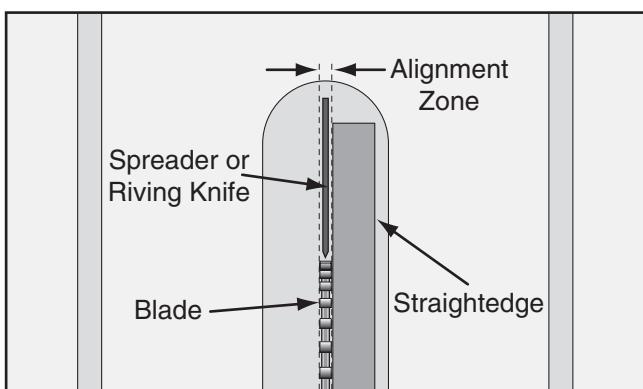


Figure 49. Spreader/riving knife alignment zone.

—If the spreader/riving knife is not properly aligned, then it needs to be adjusted. Proceed to "Adjusting Alignment" on **Page 68**.

Anti-Kickback Pawls

The anti-kickback pawls allow the workpiece to travel in only one direction. If the workpiece moves backwards, such as during a kickback, the pawls will dig into the workpiece to slow or stop it.

To work properly, the pawls must return to their resting position after pivoting, as shown in **Figure 50**.

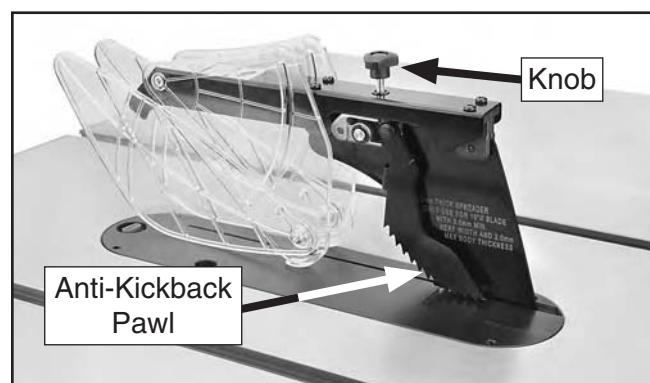


Figure 50. Example of pawls in resting position.

If the pawls fail to return to the resting position, the pivot spring may have been dislodged or broken and will need to be fixed/replaced.

Removing Pawls

You might remove the pawls if you are concerned about them scratching a delicate workpiece, or if you believe that they will obstruct a narrow workpiece and cause feeding difficulty or loss of control. Use your best judgment before removing the pawls, as they are provided for your safety.



WARNING

We do not recommend removing the pawls during normal operations unless absolutely necessary. In most situations, removing the pawls will increase your risk of serious personal injury in the event of a kickback.

To remove the pawls:

1. Loosen the knob on top of the spreader (see **Figure 50** on **Page 35**) several turns, then remove the blade guard assembly.
2. Press the button shown in **Figure 51** on the block that holds the pawls, then remove the pawls from the spreader.

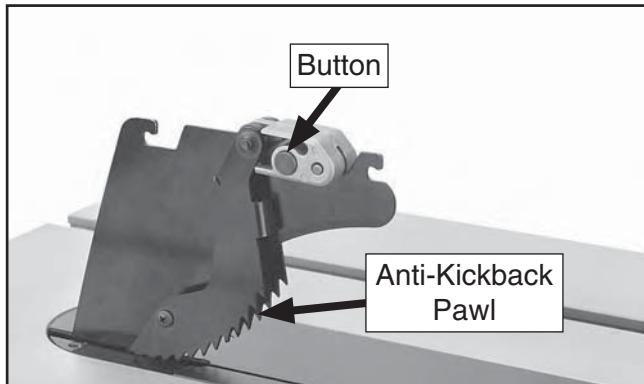


Figure 51. Button for removing pawls.

3. Re-install the blade guard onto the spreader, making sure the front and back pins on the blade guard slide all the way into the spreader slots (see **Figure 52**), then tighten the top knob to secure the guard.



Figure 52. Guard installed without pawls.

Re-installing Pawls

1. Loosen the knob on top of the spreader, then remove the blade guard.
2. Slide the pin in the pawl block into the second groove from the front of the spreader, as shown in **Figure 53**.

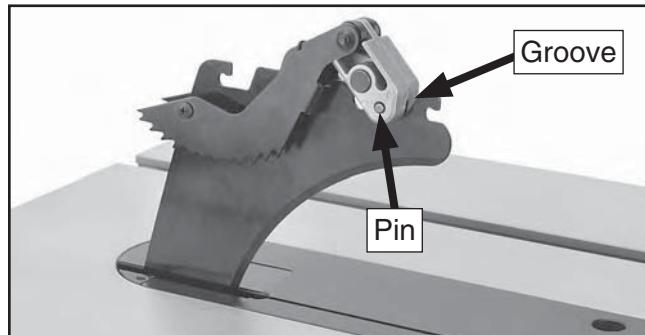


Figure 53. Re-installing pawls.

3. Press the button on the pawl block, shown in **Figure 51**, then pivot the pawls down until they lock into place.
4. Re-install the blade guard onto the spreader and secure with the top knob.

When to Use Blade Guard

The blade guard assembly MUST always be installed on the saw for all normal through cuts (those where the blade cuts all the way through the thickness of the workpiece). Operating the saw without the guard increases the risk of kickback or blade contact. If the blade guard is removed for specific operations, immediately replace it after those operations are complete.

When Not to Use Blade Guard

The blade guard cannot be used for any non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

IMPORTANT: Whenever the blade guard cannot be used, the riving knife must be installed.

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



Riving Knife

The riving knife works in the same manner as the spreader on the blade guard assembly. It is a metal plate that prevents the newly cut workpiece from pinching the backside of the blade and causing kickback.

The key difference between the spreader and the riving knife is that the riving knife mounts below the blade's highest point of rotation, as shown in **Figure 54**, so that it can remain installed for non-through cuts.

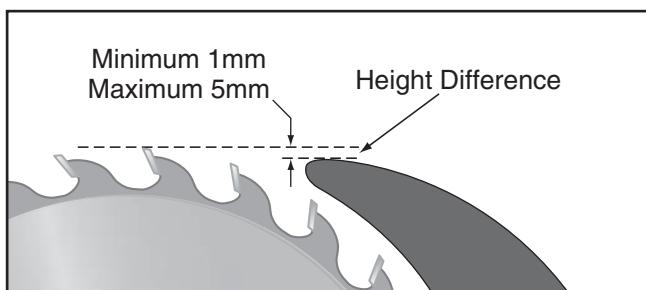


Figure 54. Height difference between riving knife and blade.

Similar to the spreader, the riving knife acts as a barrier behind the blade to reduce the risk of hands being pulled into the blade if kickback occurs.

The riving knife must be kept within the range shown in **Figure 55**. For that reason, a 10" blade is required for operations that use a riving knife.

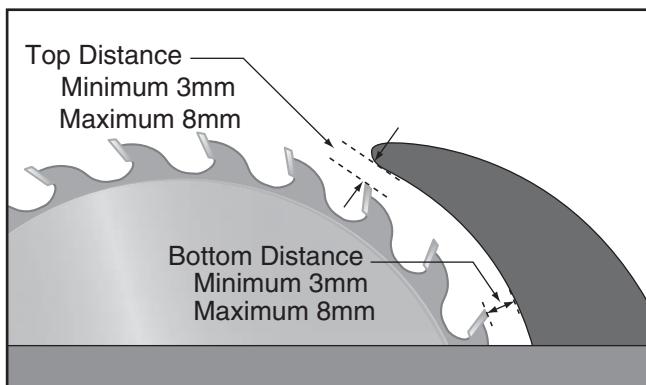


Figure 55. Allowable top and bottom distances between riving knife and blade.

WARNING

To ensure that the riving knife works safely, it **MUST** be aligned with and correctly adjusted to the blade. Refer to Page 67 to check or adjust the riving knife alignment.

How to Install the Riving Knife

Install the riving knife in the same manner as the blade guard and spreader. Refer to **Blade Guard Assembly** on **Page 34** for installation instructions.

When to Use the Riving Knife

Use the riving knife for all non-through cuts made with a standard table saw blade (i.e., dadoes or rabbet cuts, and when using a tenoning jig), or when using a 10" diameter dado blade.

Also, use the riving knife for those special operations where the blade guard or its components get in the way of safe operation, such as with very narrow cuts.

When Not to Use the Riving Knife

Do not use the riving knife with a dado blade that has a diameter smaller than 10" in diameter. Otherwise, the riving knife height will exceed the blade height and the workpiece will hit the riving knife during the cut, forcing the operator into a dangerous situation of trying to turn the saw off with the workpiece stuck halfway through the cut.

In addition, although it is possible to use the riving knife for through cutting operations, the blade guard assembly offers far more injury protection and risk reduction than the riving knife. Therefore, **we strongly recommend** that you use the blade guard assembly instead of the riving knife for through cuts.



Cutting a Zero Clearance Insert

A zero clearance insert is provided with the table saw to reduce workpiece tear out and increase user safety. The insert can be customized to fit a specific blade height or blade angle for the applicable cutting operation.

To install the zero clearance insert:

1. DISCONNECT SAW FROM POWER!
2. Check to make sure the blade is properly installed (refer to the instructions in **Blade Installation on Page 33**).
3. Install the table insert, as shown in **Figure 56**.

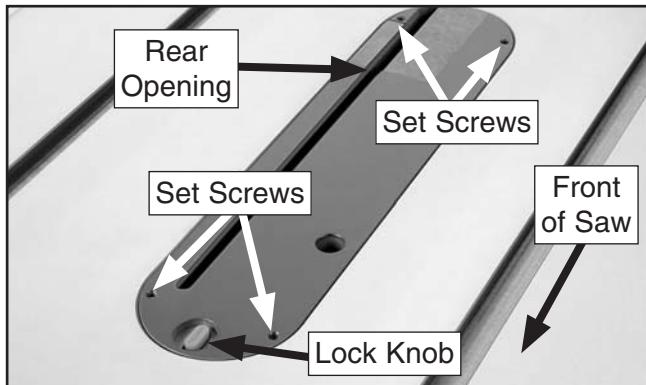


Figure 56. Insert knob in lock position.

4. Adjust the table insert set screws with a 2.5mm hex wrench to make sure the insert is flush with the table (use a straightedge as a guide), then turn the lock knob to secure the insert.
5. Center a board at least 2" thick and equal to the length of the table over the rear opening of the insert, then secure it with clamps at both ends, as shown in **Figure 57**. This will provide extra support for the insert and reduce tear out when cutting.

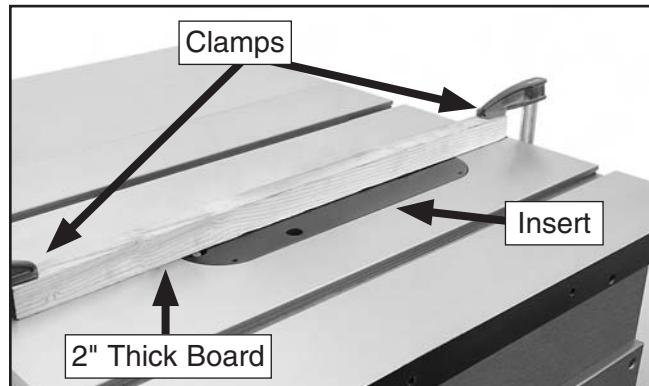


Figure 57. Securing insert with board and clamps.

6. Set the blade angle at 0°.

Suggestion: To retain the zero clearance ability of the insert included with this saw, we recommend only raising the blade into the insert at 90° during the following step.

—If you need a zero clearance insert for compound cuts, install an optional phenolic zero clearance table insert, Model T21876 (refer to **Page 59** for each angled cut, then follow **Step 7**).

—If you plan to use a dado blade to cut rabbits or dados, install an optional Model T23748 dado blade insert (refer to **Page 59**).

—If you do not require your insert to have a zero clearance fit, especially if you need to make a range of compound cuts, you can modify the insert included with this saw. Follow **Step 7**, then route the underside of the blade-cut slot to the same width as the rear opening (see **Figure 56**).

7. Connect the saw to power. Keep hands off of table top, do not stand directly behind the blade path, and wear eye protection.
8. Turn the saw **ON**, then slowly raise the blade to the maximum height that will be used during normal operations.
9. Turn the saw **OFF**, lower the blade completely, then remove the board and clamps.
10. Install the blade guard (refer to "Installing Blade Guard & Spreader" on **Page 34**).



Align-A-Cut

This table saw features the Align-A-Cut marker, which aligns the cutting line on a workpiece with the blade kerf without the need to touch a blade tooth.

Use the miter gauge to perform a cut on the right and left sides of the workpiece, slide it back, then use a pencil to mark the ends of the workpiece onto the center of the marker, as shown in **Figure 58**.

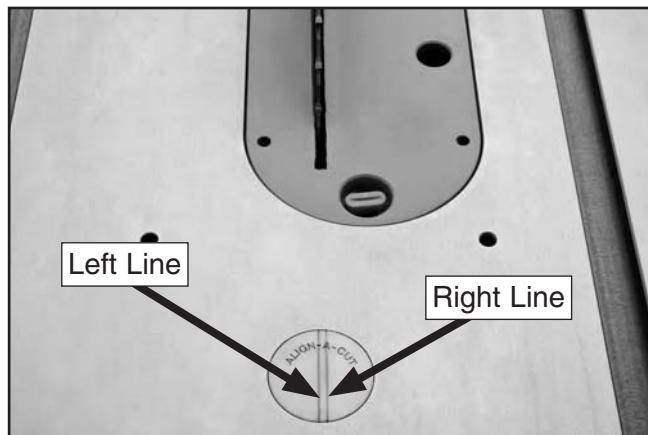


Figure 58. Align-A-Cut marker with kerf lines.

If you install another blade, remove the pencil marks with a clean shop rag and re-mark new kerf lines.

To set up the Align-A-Cut marker:

1. DISCONNECT SAW FROM POWER!
2. Remove the fence, or slide it out of the way.
3. Mark the cutting line on the workpiece.
4. Place the miter gauge in the *right* miter slot with the workpiece.
5. Align the blade with the cutting line on the workpiece, then perform the cut (refer to **Miter Cuts** on Page 41 for more details).
6. Turn the saw **OFF**.
7. Slide the miter gauge and workpiece back, making sure the workpiece does not move side-to-side, then mark the end of the workpiece (the right kerf line) onto the marker.
8. Place the miter gauge and workpiece on the left miter slot.
9. Repeat **Steps 5–7**, then mark the end of the board (the left kerf line) onto the marker.



Ripping

"Ripping" means cutting with the grain of a natural wood workpiece. In man-made materials such as MDF or plywood, ripping simply means cutting lengthwise.

WARNING

Serious injury can be caused by kickback. Kickback is a high-speed ejection of stock from the table saw toward an operator. The operator or bystanders may be struck by flying stock, or the operator's hands can be pulled into the blade during the kickback.

To make a rip cut:

1. Review **Preventing Kickback** on **Page 8**, and take the necessary precautions to reduce the likelihood of kickback.
2. If using natural wood, joint one long edge of the workpiece on a jointer. This provides a flat, consistent surface that can slide along the fence, which minimizes chances of the workpiece moving during the cut, and reduces the risk of kickback.
3. **DISCONNECT SAW FROM POWER!**
4. Ensure that the blade guard and spreader are installed.
5. Set the fence to the desired width of cut on the scale.
6. Adjust the blade height so the highest saw tooth protrudes no more than $\frac{1}{4}$ " above the workpiece.
7. Set up safety devices such as featherboards or other anti-kickback devices.
8. Rotate the blade to make sure it does not come into contact with any of the safety devices.
9. Connect the saw to the power source, turn it **ON**, and allow it to reach full speed.

Note: The jointed edge of the workpiece must slide against the fence during the cutting operation.

10. Use a push stick to feed the workpiece through the saw blade, as shown in **Figure 59**, until the workpiece is completely beyond the saw blade.

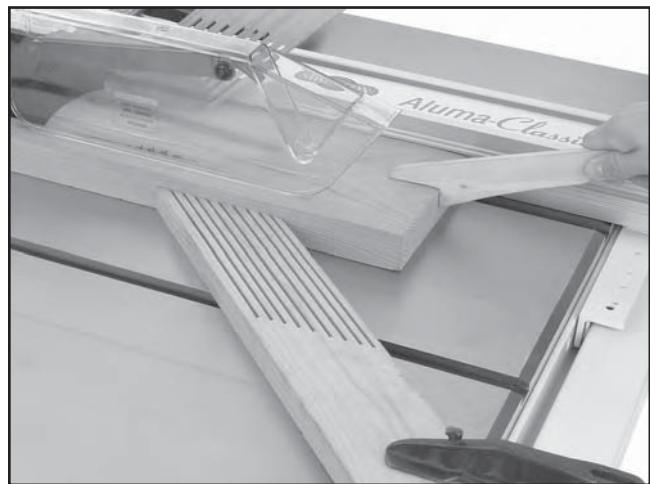
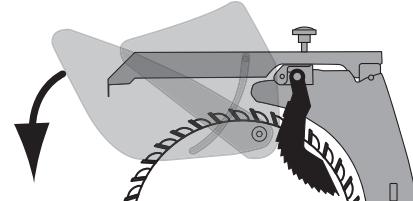


Figure 59. Typical ripping operation.

WARNING

Turn *OFF* the saw and allow the blade to come to a complete stop before removing the cut-off piece. Failure to follow this warning could result in accidental contact with rotating blade, causing lacerations or amputation.

WARNING



Keep the blade guard installed and in the down position. Failure to do this could result in serious personal injury or death.



Crosscutting

"Crosscutting" means cutting across the grain of a natural wood workpiece. In man-made materials, such as MDF or plywood, crosscutting means cutting across the width of the workpiece.

To make a crosscut using the miter gauge:

1. DISCONNECT SAW FROM POWER!
2. Ensure that the blade guard/spreader is installed.
3. Move the rip fence aside and position the miter gauge, adjusted to 90°, in a miter slot.
4. Adjust the blade height so the teeth protrude no more than $\frac{1}{4}$ " above the workpiece.
5. Slide the miter gauge near the blade, and adjust the workpiece so the blade will cut on the waste side of the line.
6. Plug in the table saw, turn it **ON**, and allow it to reach full speed.
7. Hold the workpiece firmly against the face of the miter gauge (see **Figure 60**), and ease it through the blade until the workpiece is completely past the saw blade.

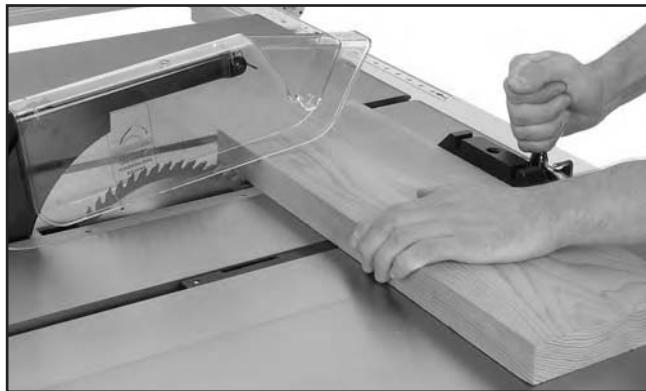


Figure 60. Example of crosscutting operation.

WARNING

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

Miter Cuts

A miter is an angled crosscut. Mitters are usually cut in the same manner as crosscuts, using the miter gauge and a predetermined mark on the workpiece.

To perform a miter cut:

1. DISCONNECT SAW FROM POWER!
2. Ensure that the blade guard/spreader is installed.
3. Determine the angle of your cut. If the angle needs to be very precise, use a protractor to set the miter gauge to the blade.
4. Place the face of the miter gauge against the edge of the workpiece and place the bar across the face of the workpiece. Use the bar as a guide to mark your cut, as shown in **Figure 61**.



Figure 61. Example of marking miter line.

5. Place the miter gauge back into the slot and hold the workpiece firmly against the miter gauge body. Slide the miter gauge near the blade and adjust the workpiece so the blade will cut on the waste side of the line.
6. Proceed to make the cut in the same manner as described in the **Crosscutting** instructions.



Blade Tilt/Bevel Cuts

When the blade tilt stop bolts are properly adjusted (as described on **Page 65**), the blade tilt handwheel allows the operator to tilt the blade to the left, between 0° and 45°. This is used most often when cutting bevels, compound miters or chamfers. **Figure 62** shows an example of the blade when tilted to 45°.



Figure 62. Blade tilted to 45° for bevel cutting on a typical table saw.

Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece. Dadoes are "non-through" cuts that can be made with a dado blade or a standard saw blade. The **Figure** below shows a cutaway view of a dado cut being made with a dado blade.

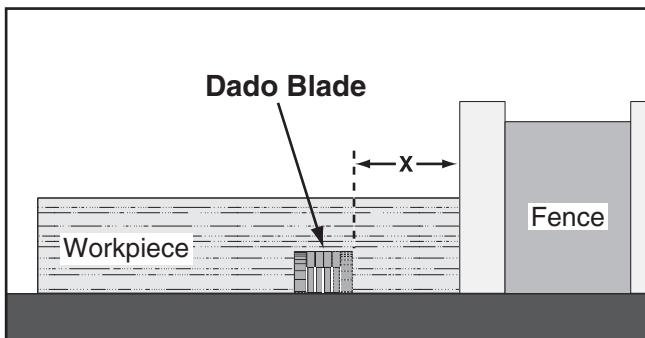


Figure 63. Example of a dado being cut with a dado blade.

The optional dado blade insert, Model T23748 (**Page 59**), must be installed when using a dado blade. The insert included with the saw or the Model T21876 (**Page 59**) must be installed when using a standard saw blade.

The Model G0732 can accommodate dado blades up to 10" in diameter. However, you **MUST** install the included riving knife while using a 10" diameter dado blade, as it reduces the risk of hands being pulled into the blade if kickback occurs.

DO NOT use the riving knife if you install a dado blade smaller than 10" in diameter. Otherwise, the riving knife height will exceed the blade height and the workpiece will hit the riving knife during the cut, forcing the operator into a dangerous situation of trying to turn the saw off with the workpiece stuck halfway through the cut.

Installing a Dado Blade

1. **DISCONNECT SAW FROM POWER!**
2. Remove the table insert, the blade guard assembly or riving knife, and the saw blade.
3. Attach and adjust the dado blade system according to the dado blade manufacturer's instructions.
4. Install the dado table insert.

WARNING

DO NOT make through cuts with a dado blade. Dado blades are only intended for non-through cuts. Failure to heed this warning could result in serious injury.

WARNING

Never try to dado a warped board by holding it down against the table. If kickback occurs, your hand could be pulled into the blade, resulting in accidental contact with the rotating blade, causing lacerations or amputation.



Cutting Dadoes with a Dado Blade

Because dado blades are much wider than standard blades, they place a greater amount of force against the workpiece when cutting. This additional force increases the risk of kickback, requiring the operator to take additional steps when cutting to keep their injury risk at an acceptable level.

WARNING

Dado blades have a higher risk of kickback than normal blades because their larger size applies stronger forces to the workpiece. This risk increases relative to the depth and width of the cut. To minimize your risk of serious personal injury, ensure that stock is flat and straight, and make multiple light cuts (rather than one deep cut) to achieve the desired cutting depth.

The **Figure** below demonstrates the sequential process of making multiple, light cuts that get progressively deeper. The actual number of cuts used should be determined by workpiece hardness, total dado depth, and feed rate. In general, if you hear the motor slow down during the cut, you are cutting too deep or feeding too fast.

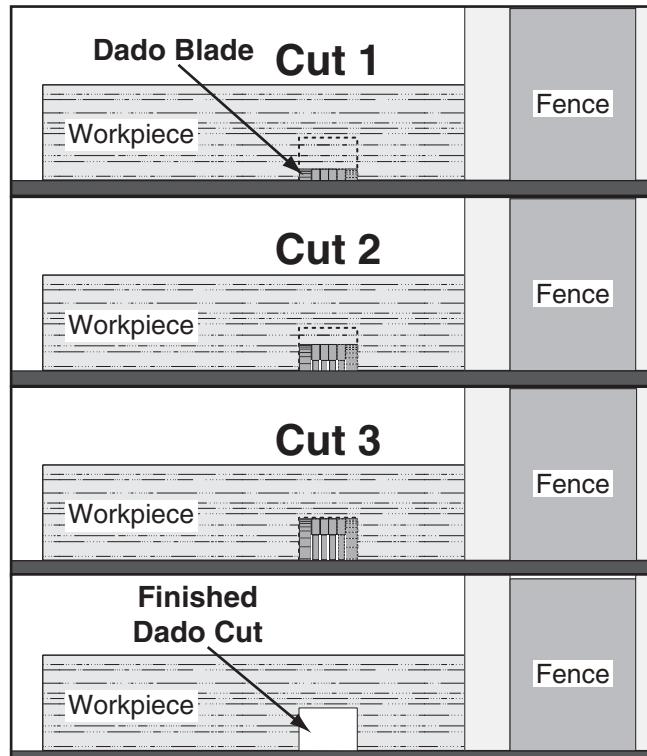


Figure 64. Example of dado being cut with multiple light cuts, instead of one deep cut.

To cut a dado with a dado blade:

1. Adjust the dado blade to the desired depth of cut.
2. Adjust the distance between the fence and the inside edge of the blade, as shown in **Figure 63 on Page 42**, to dado the length of a workpiece.
 - If dadoing across the workpiece, use the miter gauge and carefully line up the desired cut with the dado blade. DO NOT use the fence in combination with the miter gauge, to prevent binding with the workpiece.
3. Reconnect the saw to the power source.
4. Turn the saw **ON**. The blade should run smoothly, with no vibrations.
5. When the blade has reached full speed, perform a test cut with a scrap piece of wood.
6. If the cut is satisfactory, repeat the cut with the actual workpiece.



Cutting Dadoes with a Standard Blade

A ripping blade (described on [Page 31](#)) is typically the best blade to use when cutting dadoes with a standard blade because it removes sawdust very efficiently.

To use a standard saw blade to cut dadoes:

1. DISCONNECT SAW FROM POWER!
2. Ensure that the riving knife and included table insert are installed and properly adjusted. Do not use the included insert if it has lost the zero clearance feature by modification; if so, you must install the optional Model T21876.
3. Mark the width of the dado cut on the workpiece. Include marks on the edge of the workpiece so the cut path can be aligned when the workpiece is lying on the table.
4. Raise the blade up to the desired depth of cut (depth of dado channel desired).
5. Set the saw up for the type of cut you need to make, depending on if it is a rip cut ([Page 40](#)) or crosscut ([Page 41](#)).
6. Align the blade to cut one of the dado sides, as shown in [Figure 65](#).

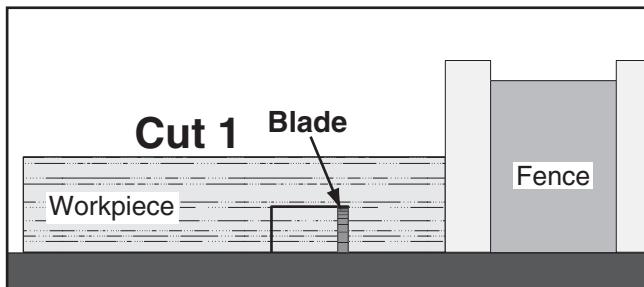


Figure 65. First cut for a single-blade dado.

7. Reconnect the saw to the power source and turn the saw **ON**. Allow the blade to reach full speed, then perform the cutting operation.
8. Repeat the cutting operation on the other side of the dado channel, as shown in [Figure 66](#).

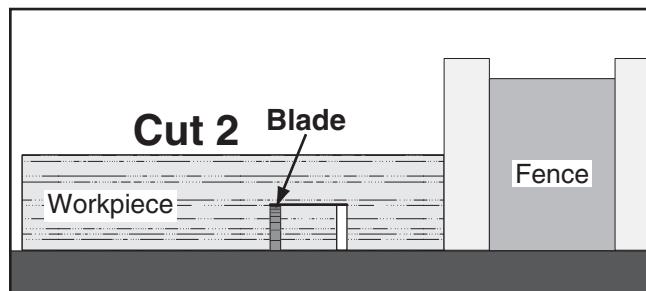


Figure 66. Second cut for a single blade dado.

9. Make additional cuts (see [Figure 67](#)) in the center of the dado to clear out the necessary material. The dado is complete when the channel is completely cleared out.

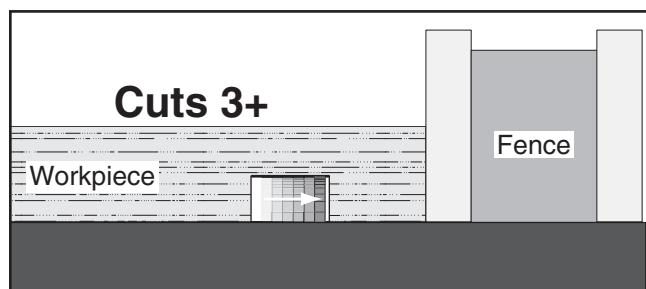


Figure 67. Additional single blade dado cuts.

Rabbet Cutting

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece. Rabbets can be cut with either a dado blade or a standard saw blade.

Rabbet cutting on the edge of the workpiece with a dado blade requires a sacrificial fence (**Figure 68**). Make the sacrificial fence the same length as the fence and $\frac{3}{4}$ " thick. Attach it to the fence with screws or clamps, making sure they are all secure and tight. Raise the blade into the sacrificial fence to the height needed.

When using a dado blade, the optional dado insert, Model T23748 (see **Page 59**), must be installed and used during rabbeting operations.

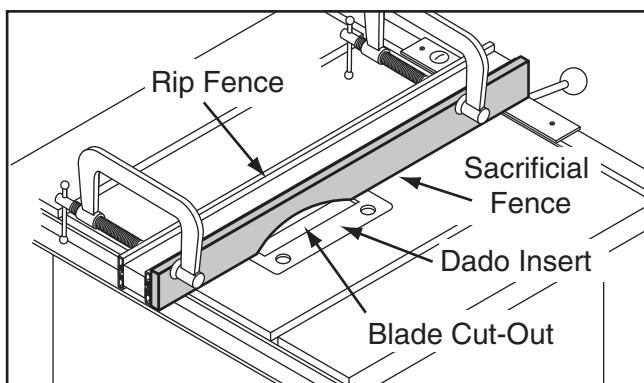


Figure 68. Example of sacrificial fence.

WARNING

Dado blades have a higher risk of kickback than normal blades because their larger size applies stronger forces to the workpiece. This risk increases relative to the depth and width of the cut. To minimize your risk of serious personal injury, ensure that stock is flat and straight, and make multiple light cuts (rather than one deep cut) to achieve the desired cutting depth.

CAUTION

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

Cutting Rabbets with a Dado Blade

1. DISCONNECT SAW FROM POWER!
2. Adjust the dado blade to the height needed for the rabbeting operation. When cutting deep rabbets, take more than one pass to reduce the risk of kickback.
3. Adjust the fence and align the workpiece to perform the cutting operation, as shown in **Figure 69**.

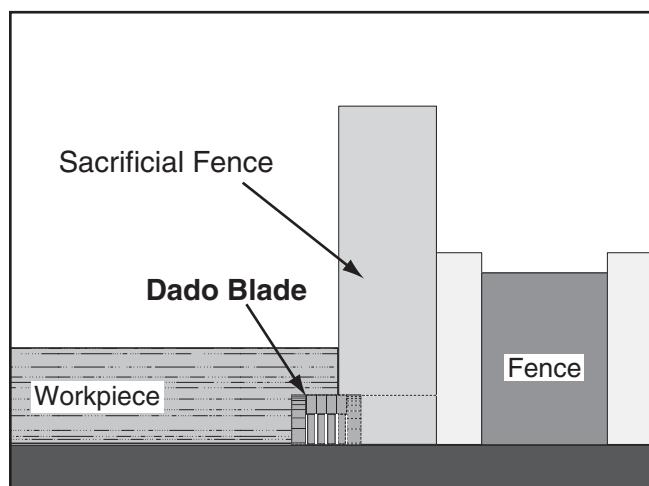


Figure 69. Rabbet cutting.

4. Reconnect the saw to the power source and turn the saw **ON**. When the blade has reached full speed, perform a test cut with a scrap piece of wood.
 - If the cut is satisfactory, repeat the cut with the final workpiece.



Cutting Rabbets with a Standard Blade

A ripping blade is typically the best blade to use for cutting rabbets when using a standard blade because it removes sawdust very efficiently. (See **Page 31** for blade details.) Also, a sacrificial fence is not required when cutting rabbets with a standard blade.

To cut rabbets with the standard blade:

1. DISCONNECT SAW FROM POWER!
2. Ensure that the riving knife and included zero clearance table insert are installed. Do not use the insert if it has lost the zero clearance feature by modification; if so you must install the optional Model T21876.
3. Mark the width of the rabbet cut on the edge of the workpiece, so you can clearly identify the intended cut while it is laying flat on the saw table.
4. Raise the blade up to the desired depth of cut (depth of rabbet channel desired).
5. Stand the workpiece on edge, as shown in **Figure 70**, then adjust the fence so the blade is aligned with the inside of your rabbet channel.

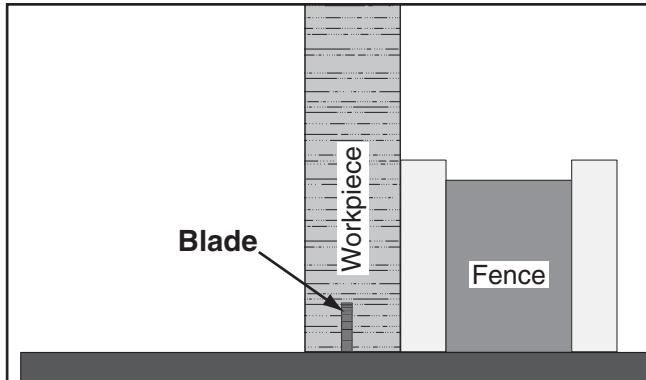
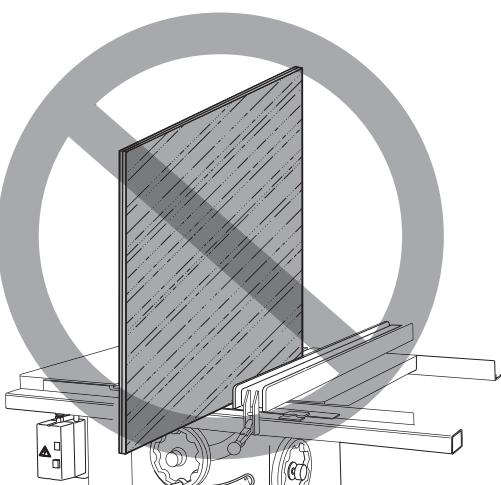


Figure 70. Example of rabbet cutting with a standard blade.

—If the workpiece is very tall, or is unstable when placed against the fence, lay it flat on the table and use a dado blade to perform the rabbet cut.

WARNING



DO NOT place a tall board on edge to perform a rabbet cut with a standard blade. Workpieces that are too tall to properly support with the fence can easily shift during operation and cause kickback. Instead, place the stock flat on the saw and perform the rabbet cut with a dado blade, as instructed on **Page 45**.

6. Reconnect the saw to the power source, then perform the cut.
7. Lay the workpiece flat on the table, as shown in **Figure 71**, adjust the saw blade height to intersect with the first cut, then perform the second cut to complete the rabbet.

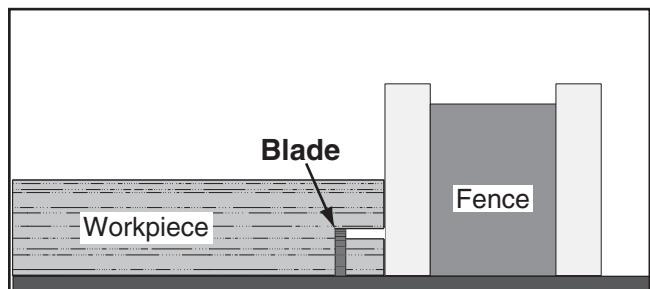


Figure 71. Example of second cut to create a rabbet.



Resawing

WARNING

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

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

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

If you insist on resawing with a table saw, DO NOT do so without using a resaw barrier and wearing a full face shield. The following instructions describe how to build a resaw barrier and add an auxiliary fence to your standard fence, to reduce the risk of injury from resawing on a table saw.

Note: To determine the maximum resaw height for this table saw, find the maximum blade height, then double it and subtract $\frac{1}{8}$ ".

Making Resaw Barrier

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

Tools Needed:	Qty
Table Saw	1
Jointer and Planer	Recommended
Clamps	2 Minimum
Drill and Drill Bits	1

Components Needed for Resaw Barrier:

Wood* $\frac{3}{4}$ " x $5\frac{1}{2}$ " x Length of Fence	1
Wood* $\frac{3}{4}$ " x 3" x Length of Fence	1
Wood Screws #8 x 2"	4
Wood Glue	As Needed

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

To build the resaw barrier:

1. Cut your wood pieces to the size specified above. If you are using hardwood, cut the pieces oversize, then joint and plane them to the correct size to make sure they are square and flat.
2. Pre-drill and countersink four holes approximately $\frac{3}{8}$ " from the bottom of the $5\frac{1}{2}$ " tall wood piece.
3. Glue the end of the 3" board, clamp the boards at a 90° angle with the larger board in the vertical position, as shown in **Figure 72**, then fasten together with the wood screws.

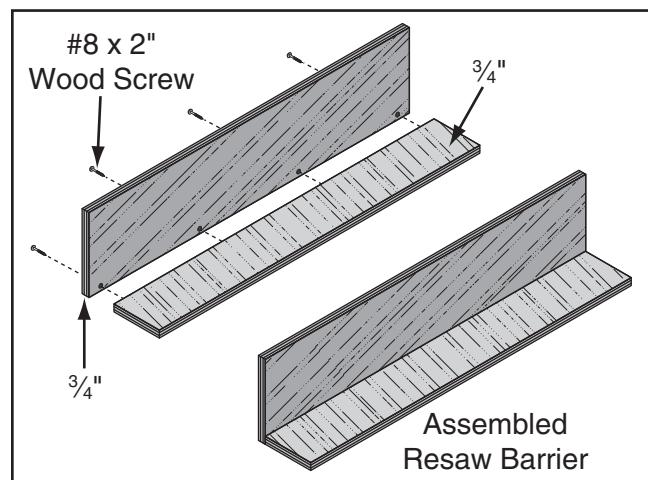


Figure 72. Resaw barrier.



Making Auxiliary Fence

The auxiliary fence is necessary if you are resawing a workpiece that is taller than it is wide. It should be no less than $\frac{1}{2}$ " shorter than the board to be resawn.

IMPORTANT: Installation requires permanent modification to the Model G0732 table saw fence—specifically drilling mounting holes.

The fence should be similar to the one in **Figure 73** when installed.

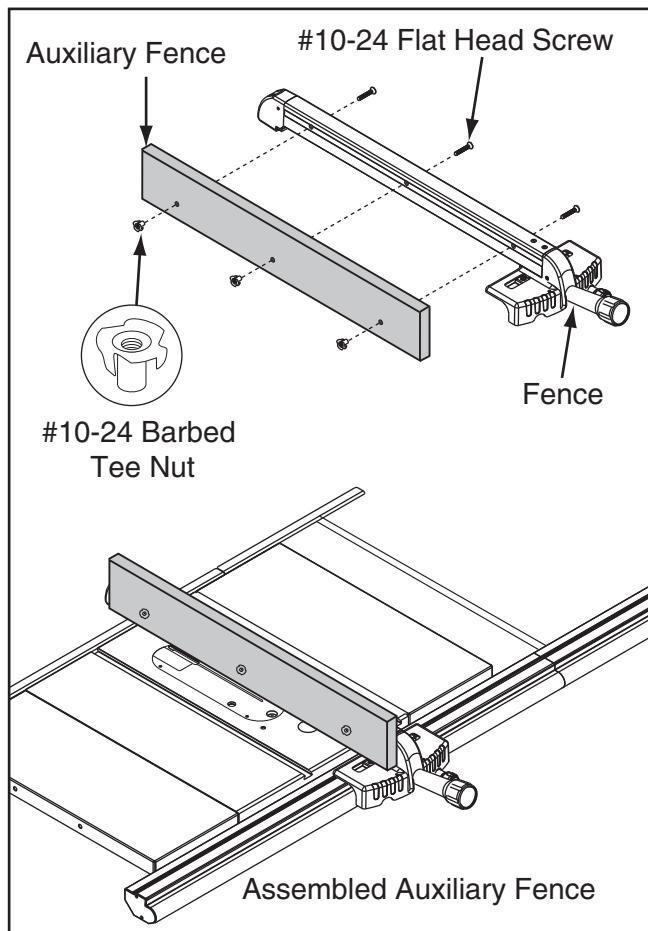


Figure 73. Example of auxiliary fence installed on standard fence.

Tools Needed:

	Qty
Clamps	2 Minimum
Drill	1
Drill Bits $\frac{1}{8}$ ", $\frac{3}{16}$ ", $\frac{1}{4}$ "	1 Each
Countersink Drill Bit	1
Forstner Bit $\frac{3}{4}$ "	1
Mallet	1
Phillips Head Screwdriver	1
Ruler	1

Components Needed for Auxiliary Fence:

Barbed Tee Nuts #10-24	3
Flat Head Screws #10-24	3
Wood* $\frac{3}{4}$ " x 4" x Length of Fence	1
Scrap Board	1

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

To build the auxiliary fence:

1. Remove the fence from the table, and mark three holes on both sides of the aluminum fence body, as indicated in **Figure 74**.

Note: Make sure the holes are located exactly $\frac{5}{32}$ " below the top edge of the channel. If you place the hole in the center of the channel, the drill bit will run into a support wall.

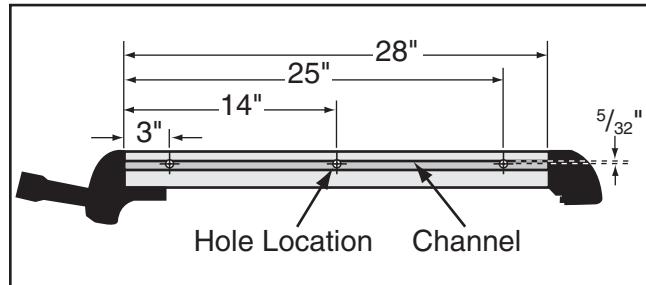


Figure 74. Location to mark holes in fence.

2. Using a $\frac{1}{8}$ " drill bit, drill a pilot hole into each hole location, then use a $\frac{3}{16}$ " bit to drill through the fence and connect each pair of holes. Do not drill the holes larger than necessary or the mounting screws will not pull out.
3. Countersink the six holes drilled into the aluminum fence, then insert the flat head screws through the holes. Adjust the depth of the countersink holes as needed so that the heads of the flat head screws sit below the surface of the channel, as illustrated in **Figure 75**.

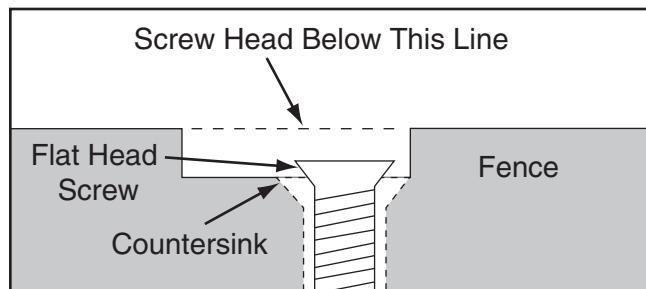


Figure 75. Flat head screw below fence channel.



4. Shake the aluminum shavings out of the fence.
5. Place a thin metal shim (such as a ruler) between the table and the bottom of the auxiliary fence board, so the fence will not catch on the table when moved.
6. Place a scrap board adjacent to the auxiliary fence to reduce tear out, then clamp the scrap board and auxiliary fence onto the fence, as shown in **Figure 76**.

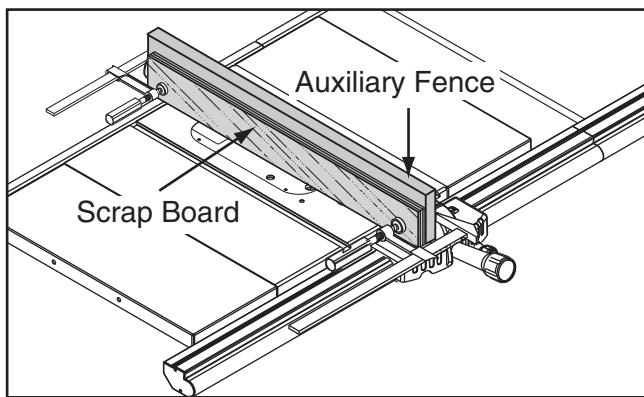


Figure 76. Scrap board and auxiliary fence clamped to fence to reduce tearout.

7. Using the $\frac{3}{16}$ " bit, drill through the holes in the fence into the auxiliary fence board, then remove the clamps, scrap board and auxiliary fence.
8. Use a $\frac{3}{4}$ " forstner bit to countersink the three holes in the auxiliary fence $\frac{1}{16}$ " deep so the tee nuts will be flush with the auxiliary fence-face in **Step 10**.
9. Clamp the scrap board to the auxiliary fence, then use a $\frac{1}{4}$ " drill bit to drill into the auxiliary fence for the shaft of the tee nuts.
10. Using a mallet, tap each tee nut into one of the holes in the auxiliary fence.
11. Insert a flat head screw through each hole in the fence, then thread them into the tee nuts. The end result should appear similar to **Figure 73** on **Page 48**.
12. Slide a flat piece of wood across the auxiliary fence and fence to verify the mounting hardware is correctly installed. Adjust the fasteners so they do not catch on workpieces.

Resawing Operations

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

Components Needed for Resawing:

Zero-clearance Insert	1
Ripping Blade 10".....	1
Clamps	2
Shop Made Auxiliary Fence	1
Shop Made Resaw Barrier	1

WARNING

You may experience kickback during this procedure. Stand to the side of the blade and wear a full face shield to prevent injury when resawing.

To perform resawing operations:

1. DISCONNECT SAW FROM POWER!
2. Remove the standard table insert and the blade guard assembly.
3. Install a ripping blade, install the riving knife, lower the blade below the table, then install the included zero clearance table insert.
4. Attach the auxiliary fence and set it to the desired width.

Note: When figuring out the correct width, don't forget to account for blade kerf and the inaccuracy of the fence scale while the auxiliary fence is installed.



5. Place the workpiece against the auxiliary fence and slide the resaw barrier against the workpiece, as shown in **Figure 77**. Now clamp the resaw barrier to the top of the table saw at both ends.

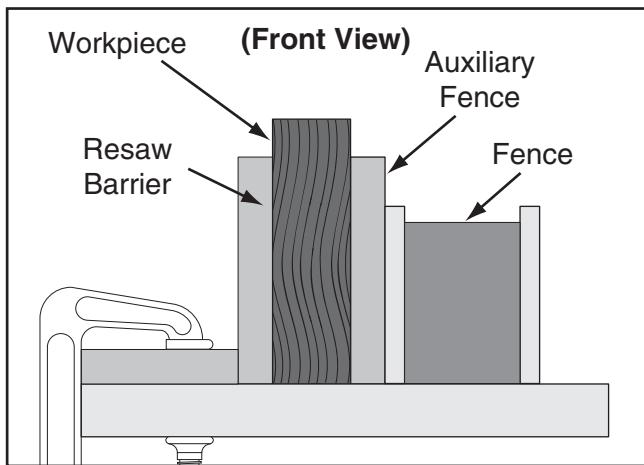


Figure 77. Ideal resaw workpiece setup.

6. Lower the blade completely below the table, and slide the workpiece over the blade to make sure it moves smoothly and fits between the resaw barrier and fence.
7. Raise the blade approximately an inch, or close to half the height of the workpiece (**Figure 78**), whichever is less.

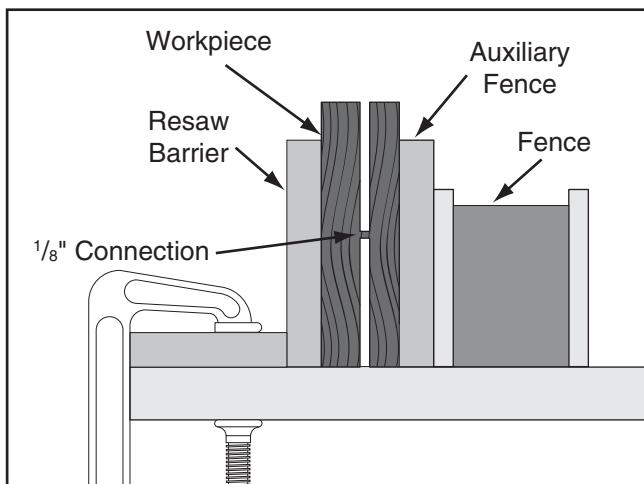


Figure 78. Ideal completed resaw cut.

WARNING

The danger of kickback increases relative to the depth of a cut. Reduce the risk of kickback by making multiple passes to achieve the desired depth of cut. Failure to follow these warnings could result in serious personal injury.

WARNING

Always use push sticks or push paddles to increase safety and control during operations which require that the blade guard and spreader must be removed from the saw. **ALWAYS** replace the blade guard after resawing is complete.

8. Plug in the table saw, turn it **ON**, and use a push stick or push block to feed the workpiece through the blade, using a slow and steady feed rate.

Note: We recommend making a series of light cuts that get progressively deeper, to reduce the chance of stalling the motor.

9. Flip the workpiece end for end, keeping the same side against the fence, and run the workpiece through the blade.
10. Repeat **Steps 7–9** until the blade is close to half of the height of the board to be resawn. The ideal completed resaw cut will leave an $\frac{1}{8}$ " connection when the resawing is complete as shown in **Figure 78**. Leaving an $\frac{1}{8}$ " connection will reduce the risk of kickback.
11. Turn **OFF** the table saw, then separate the parts of the workpiece and hand plane the remaining ridge to remove it.
12. When finished resawing, remove the resaw barrier and auxiliary fence, then re-install the blade guard/spreader or riving knife and standard table insert.



SECTION 5: SHOP MADE SAFETY ACCESSORIES

Featherboards

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

Making a Featherboard

This sub-section covers the two basic types of featherboards: 1) Those secured by clamps, or 2) those secured with the miter slot.

Material Needed for Featherboard

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

Additional Material Needed for Mounting Featherboard in Miter Slot

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

To make a featherboard:

1. Cut a hardwood board approximately $\frac{3}{4}$ " thick to size. The length and width of the board can vary according to your design. Most featherboards are 10"-28" long and 3"-6" wide. Make sure the wood grain runs parallel with the length of the featherboard, so the fingers you will create in **Step 3** will bend without breaking.
2. Cut a 30° angle at one end of the board.

CAUTION

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

3. Make a series of end cuts with the grain $\frac{3}{8}$ "- $\frac{1}{4}$ " apart and 2"-3" long, as shown in **Figure 79 (A)**. Alternatively, start cuts at 2"-3" deep, then make them progressively deeper, as shown in **Figure 79 (B)**.

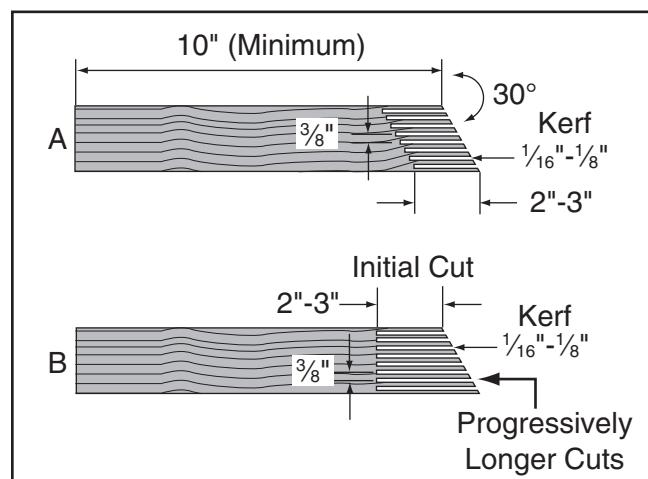


Figure 79. Patterns for featherboards (top view shown).

IMPORTANT: Cuts made across the grain result in weak fingers that easily break when flexed. When made correctly, the fingers should withstand flexing from moderate pressure. To test the finger flexibility, push firmly on the ends with your thumb. If the fingers do not flex, they are likely too thick (the cuts are too far apart).

NOTICE

Only Steps 1-3 are required to make a clamp-mounted featherboard. Refer to Page 53 for instructions on clamping.



4. Rout a $\frac{1}{4}$ "– $\frac{3}{8}$ " wide slot 4"–5" long in the workpiece and 1"–2" from the short end of the featherboard (see **Figure 80**).

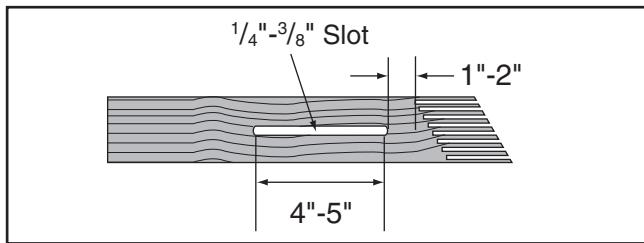


Figure 80. Slot routed in featherboard.

5. Cut a miter bar that will fit in the table miter slot approximately 5" long, as shown in **Figure 81**.

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

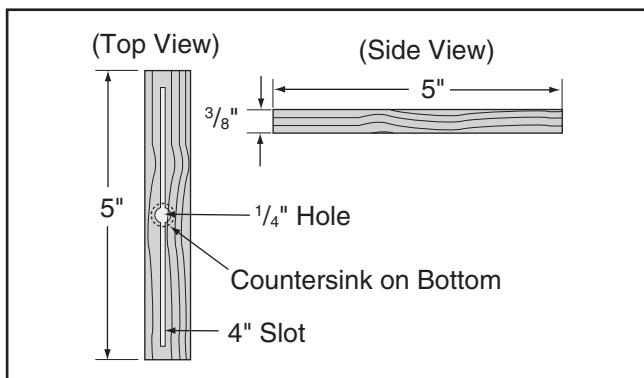


Figure 81. Miter bar pattern.

6. Drill a $\frac{1}{4}$ " hole in the center of the bar, then countersink the bottom to fit a $\frac{1}{4}$ "-20 flat head screw.

7. Mark a 4" line through the center of the countersunk hole in the center, then use a jig saw with a narrow blade to cut it out.

8. Assemble the miter bar and featherboard with a $\frac{1}{4}$ "-20 x flat head screw, flat washer, and a wing nut or a star knob (see **Figure 82**). Congratulations! Your featherboard is complete.

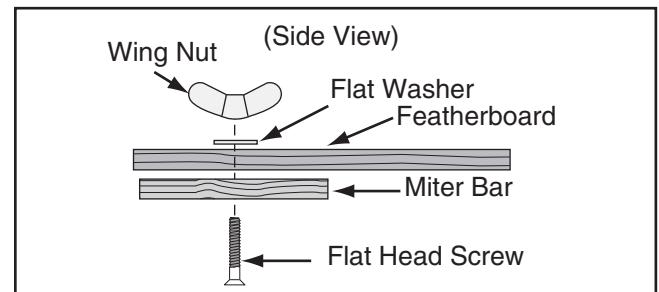


Figure 82. Assembling miter slot featherboard components.

Note: The routed slot, countersink hole, and the flat head screw are essential for the miter bar to clamp into the miter slot. When the wing nut is tightened, it will draw the flat head screw upward into the countersunk hole. This will spread the sides of the miter bar and force them into the walls of the miter slot, locking the featherboard in place.

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

Now, proceed to **Mounting Featherboard in Miter Slot on Page 53**.



Mounting Featherboards w/Clamps

1. Lower the saw blade, then adjust the fence to the desired width and secure it.
2. Place the workpiece against the fence, making sure it is 1" in front of the blade.
3. Place a featherboard on the table away from the blade so all fingers point forward and contact the workpiece (see **Figure 83**).

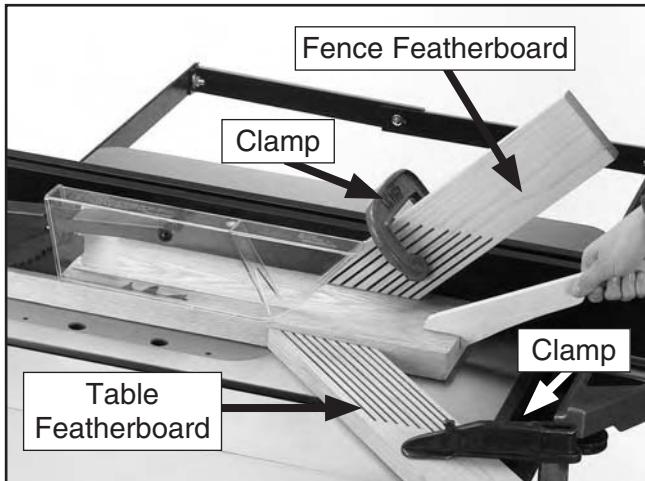


Figure 83. Example of featherboards secured with clamps.

4. Secure the featherboard to the table with a clamp.
5. Check the featherboard by pushing it with your thumb to ensure it is secure.
—If the featherboard moves, tighten the clamp more.
6. Optional: If cutting long workpieces, it may be beneficial to use another featherboard to keep the board firmly against the table while feeding.

Mounting Featherboard in Miter Slot

1. Lower the saw blade, then adjust the fence to the desired width and secure it.
2. Place the workpiece evenly against the fence, making sure it is 1" in front of the blade.
3. Slide the featherboard miter bar into the miter slot, making sure the fingers slant toward the blade, as shown in **Figure 84**.

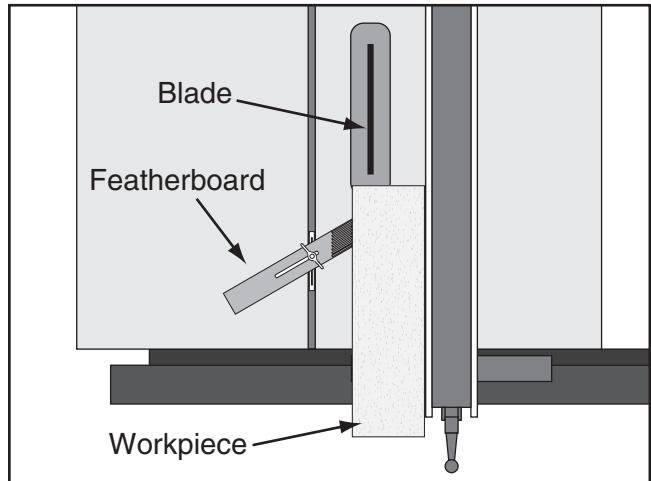


Figure 84. Featherboard installed in miter slot and supporting workpiece for ripping cut.

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

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



Push Sticks

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

Using a Push Stick

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

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

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

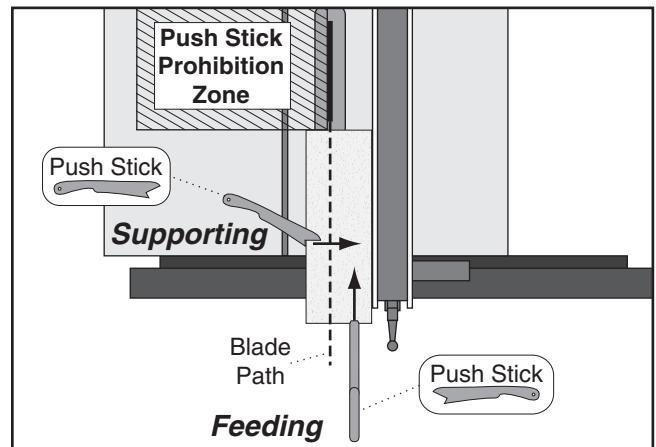


Figure 85. Using push sticks to rip narrow stock.

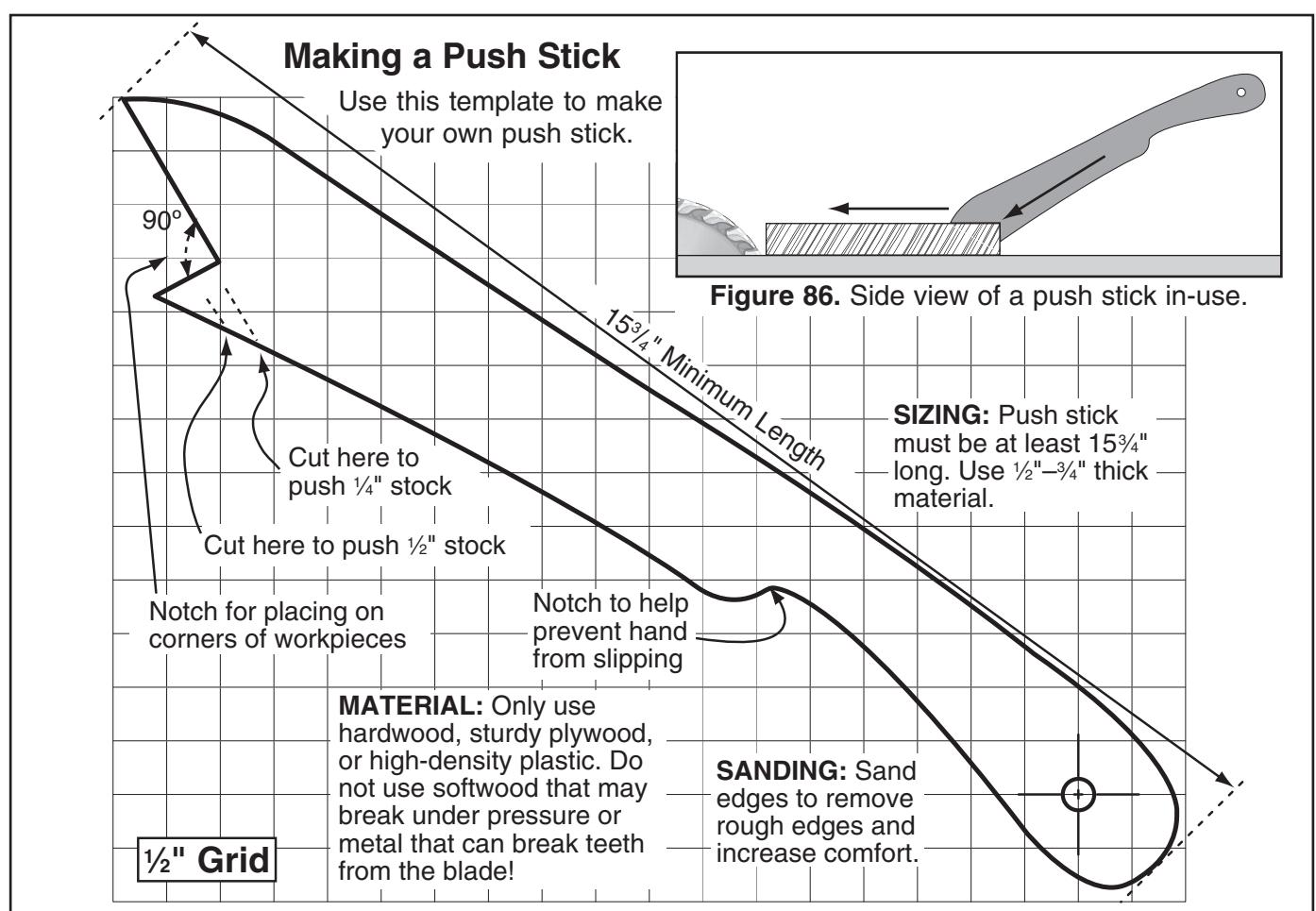


Figure 87. Template for a basic shop-made push stick (not shown at actual size).



Push Blocks

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

Using a Push Block

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

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

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

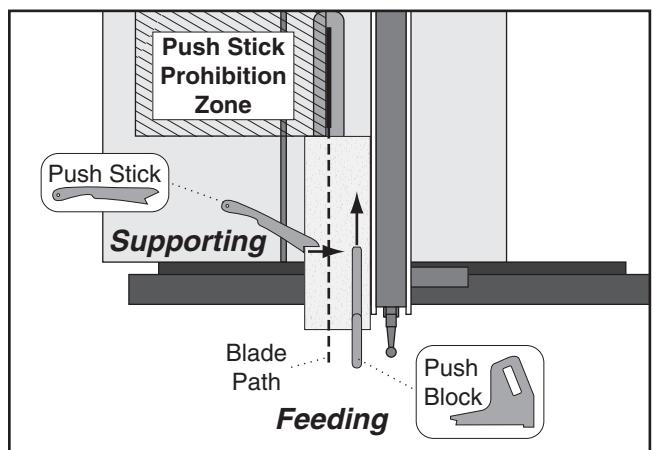


Figure 89. Using a push block and push stick to make a rip cut.

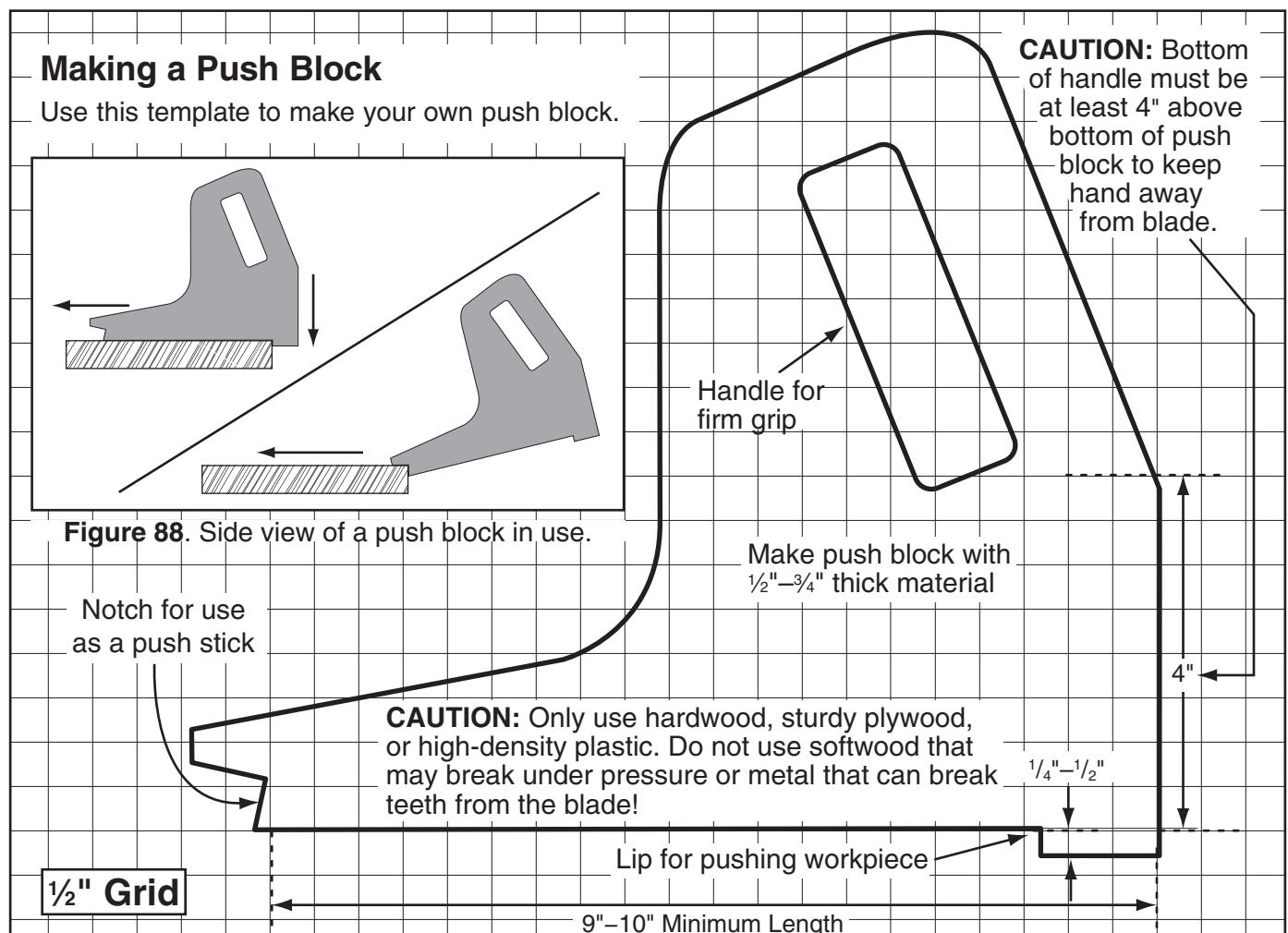


Figure 90. Template for a shop-made push block (shown at 50% of full size).



Narrow-Rip Auxiliary Fence & Push Block

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

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

Material Needed for Narrow Rip Auxiliary Fence & Push Block

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

Material Needed for Push Block

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

Making a Narrow-Rip Push Block for an Auxiliary Fence

1. Cut a piece of $\frac{3}{4}$ " thick plywood $5\frac{1}{4}$ " wide and as long as your table saw fence; cut a piece of $\frac{3}{4}$ " thick hardwood 3" wide and as long as your table saw fence, as shown in **Figure 91**.

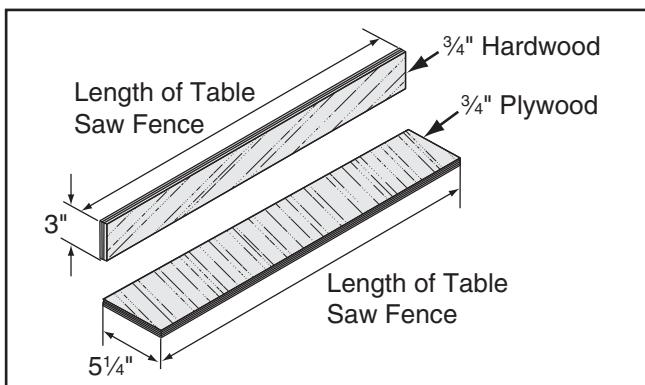


Figure 91. Auxiliary fence dimensions.

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

2. Pre-drill and countersink eight pilot holes $\frac{3}{8}$ " from the bottom of the 3" wide board, then secure the boards together with eight #8 x $1\frac{1}{2}$ " wood screws, as shown in **Figure 92**.

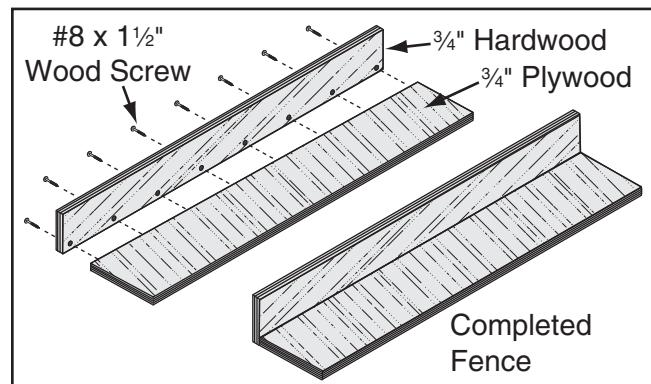


Figure 92. Location of pilot holes.

3. Using the $\frac{3}{4}$ " material you used in the previous steps, cut out pieces for the push block per the dimensions shown in **Figure 93**; for the handle, cut a piece 10" long by 5"-9" high and shape it as desired to fit your hand.

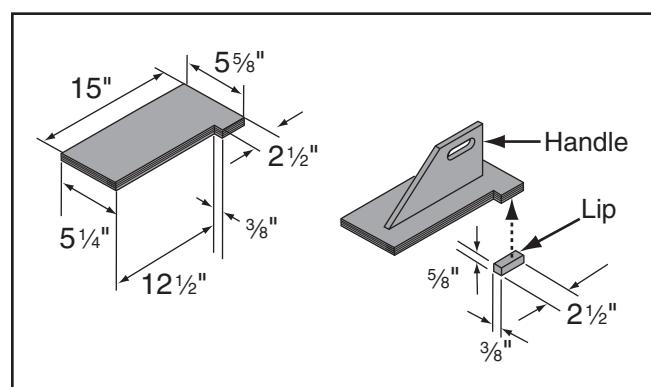


Figure 93. Push block dimensions and construction.

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



Using the Auxiliary Fence & Push Block

1. Place the auxiliary fence on the table and clamp it to the fence at both ends, then adjust the distance between the auxiliary fence and the blade—this determines how wide the workpiece will be ripped (see **Figure 94**).

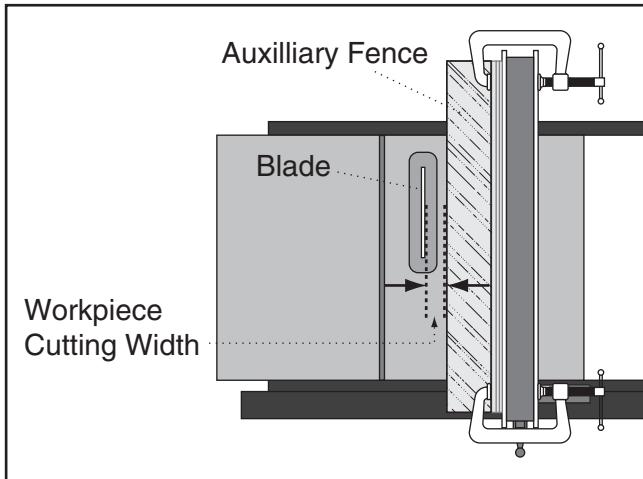
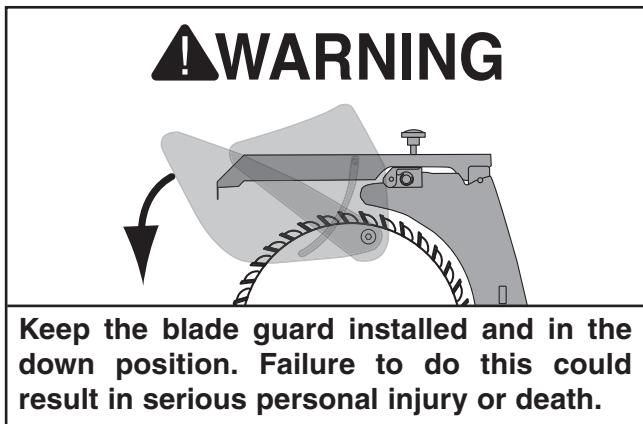


Figure 94. Adjusting ripping distance between blade and auxiliary fence.

2. Install the blade guard, then remove the spreader pawls, as explained on **Page 36**, so they do not interfere with the push block lip.



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

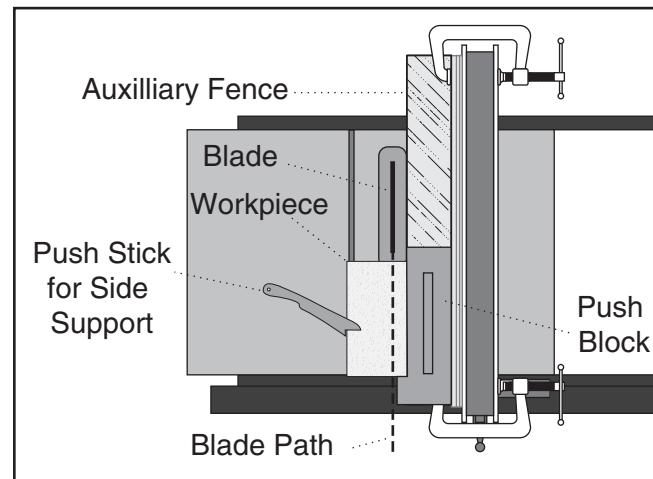


Figure 95. Push block in position to push workpiece through blade.

4. Turn the saw **ON**, then begin ripping the workpiece using a push stick for side support.
5. As the workpiece nears the end of the cut, place the push block on the auxiliary fence with the lip directly behind the workpiece, then release the push stick just before the blade.
6. Guide the workpiece the rest of the way through the cut with the push block, as shown in **Figure 96**.

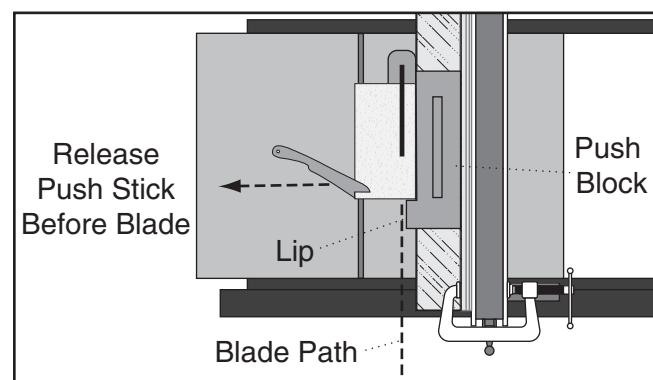


Figure 96. Ripping with push block.



7. Re-install the spreader pawls when finished using the auxiliary fence and push block.



Outfeed & Support Tables

One of the best accessories for improving the safety and ease of using a table saw is simply placing a large table (outfeed table) behind the saw to catch the workpiece (see **Figure 97**). Additionally, another table to the left of the saw (support table) can also help support large workpieces so they can be cut safely and accurately.



Figure 97. Example of outfeed & support tables.

Crosscut Sled

A crosscut sled (see **Figure 98**) is a fantastic way to improve the safety and accuracy of cross-cutting on the table saw. Most expert table saw operators use a crosscut sled when they have to crosscut a large volume of work, because the sled offers substantial protection against kickback when crosscutting.



Figure 98. Example of crosscut sled.



SECTION 6: 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

T21876—Zero Clearance Insert for G0732

Zero clearance table inserts are important accessories for eliminating the gap between the blade and the table, which results in tear-out free cuts and a reduced risk of kickback from cutting narrow stock. Perfectionist woodworkers have a different table insert for each type of cut!



Figure 99. T21876 Zero-Clearance Table Insert.

T23478—Dado Insert for G0732



Figure 100. T23478 Dado Insert.

G7314Z—Heavy-Duty SHOP FOX® Mobile Base

This patented base is the most stable on the market with outrigger type supports. Adjusts from 19" x 20½" to 29½" x 29½". 700 lb. capacity. Weighs 47 lbs.

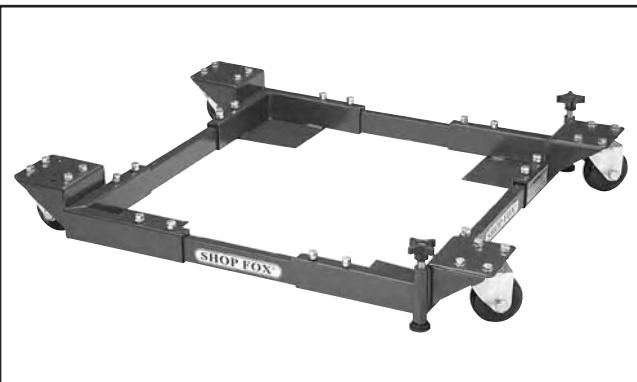


Figure 101. G7314Z SHOP FOX® Mobile Base.

G1163—1HP Floor Model Dust Collector

G0710—1HP Wall-Mount Dust Collector

G3591—30 Micron Replacement Bag

H4340—3.0 Micron Upgrade Bag

Excellent point-of-use dust collectors that can be used next to the machine with only a small amount of ducting. Specifications: 450 CFM, 7.2" static pressure, 2 cubic foot bag, and 30 micron filter. Motor is 1HP, 110V/220V, 14A/7A.



Figure 102. Point-of-use dust collectors.

T23412—Clear Flexible Hose 2½" x 10'
T23415—Clear Flexible Hose 4" x 10'
T23421—Black Flexible Hose 2½" x 10'
T23425—Black Flexible Hose 4" x 10'
G3124—Wire Hose Clamp 2½"
G2974—Wire Hose Clamp 4"
G3119—Dust Collection Adapter 2½" x 4"
G1843—Plastic Blast Gate 4"
G4679—Anti-Static Grounding Kit
G7938—Shop Vacuum Adapter 2½" x 2½"

We've hand picked a selection of dust collection components commonly needed to connect the Model G0732 to an existing dust collection system.



Figure 103. Dust collection accessories.

H9587—Table Saw Fundamentals Book

The table saw is the single tool that turns the hobbyist into a real woodworker, capable of handling a range of challenging jobs. With expert advice, color photos, drawings, and exploded diagrams, Popular Mechanics reveals exactly what this all-important piece of equipment can do. This invaluable and instructive manual covers it all.

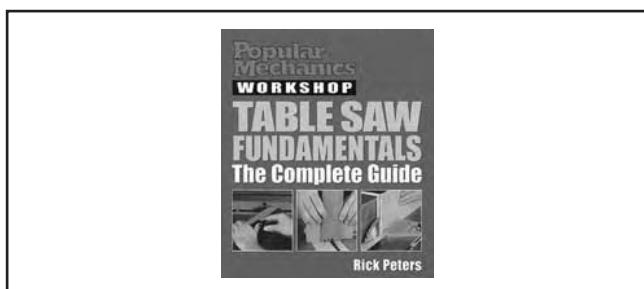


Figure 104. Model H9587.

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**
G4682—**Dry Coating Lubricant 9.5 oz. Spray**



Figure 105. Recommended products for protecting your cast iron table top.

H7583—Grizzly Tenoning Jig

Our fully adjustable tenoning jig handles stock up to 3¼" thick and features an adjustable bevel angle with a 90° to 75° range. The two large grip handles, adjustable guide bar, multi-position control levers, and extra large clamping handwheel will ensure accurate and repeatable results. A top seller!

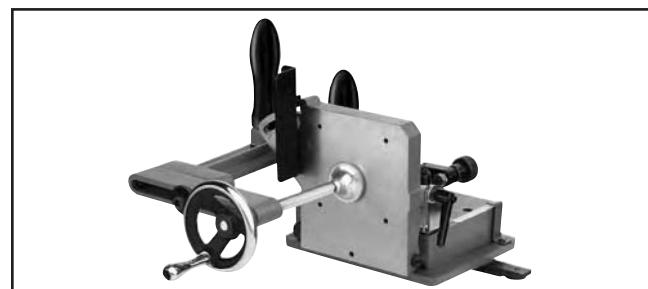
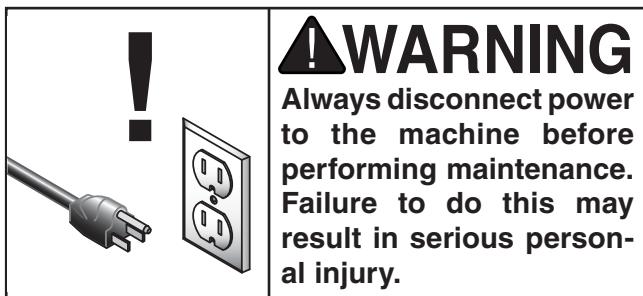


Figure 106. Model H7583 Tenoning Jig.

Call 1-800-523-4777 To Order



SECTION 7: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Inspect blades for damage or wear.
- Check for loose mounting bolts/arbor nut.
- Check cords, plugs, and switch for damage.
- Any other condition that could hamper the safe operation of this machine.
- Wipe the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.
- Verify that the anti-kickback pawls return to their bottom-most position after pivoting.
- Verify that the spreader/riving knife is aligned with the blade (refer to **Page 67** to perform a quick check.)
- Move the miter gauge off the table and the fence over the extension wings to minimize oxidation of the cast iron table.

Weekly Maintenance:

- Wipe down the table surface and grooves with a lubricant and rust preventive.
- Vacuum dust buildup from the motor housing and trunnions.
- Clean the pitch and resin from the saw blade with a cleaner like OxiSolv® Blade & Bit Cleaner.

Monthly Maintenance:

- Check/tighten the belt tension (**Page 72**).
- Check lubrication of trunnion slides, tilt leadcrew, bevel gear, and elevation leadscrew (**Page 62**).

Cleaning

Cleaning this machine is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Occasionally it will become necessary to clean the internal parts with more than a vacuum. To do this, remove the table top and clean the internal parts with resin/pitch dissolver or mineral spirits and a stiff wire brush or steel wool. **DO NOT USE WATER—WATER WILL CAUSE CAST IRON TO RUST.**

Make sure the internal workings are dry before using the saw again, so that wood dust will not accumulate. If any essential lubrication is removed during cleaning, re-lubricate those areas.



Lubrication

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more grease to them will not yield smooth moving components.

Clean the components in this section with an oil/grease soluble cleaner.

If you thoroughly clean the components in this section before lubricating them, the result will be silky smooth movement when turning the handwheels, which will result in much higher enjoyment on your part and a longer lasting machine!

The following components need to be lubricated:

- Trunnion Slides and Tilt Leadscrew
- Bevel Gear, Elevation Leadscrew

Trunnion Slides & Tilt Leadscrew

Check every month. The trunnion slides are the grooved portions of the trunnions where the cast iron components slide against each other as the blade is tilted (see **Figure 107**).

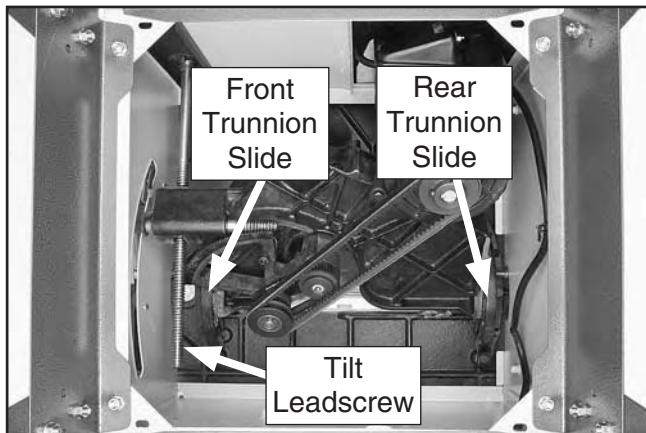


Figure 107. Trunnion slides and tilt leadscrew.

Clean the trunnion slides and tilt leadscrew with mineral spirits, and apply a dab of lithium grease into each groove and around the tilt leadscrew next to where it goes into the housing. Move the blade tilt back and forth to spread the grease.

Bevel Gear & Elevation Leadscrew

Check every month. The bevel gear is shown below in **Figure 108**. When the blade height handwheel is rotated, the bevel gear turns the elevation leadscrew to raise/lower the motor housing assembly.

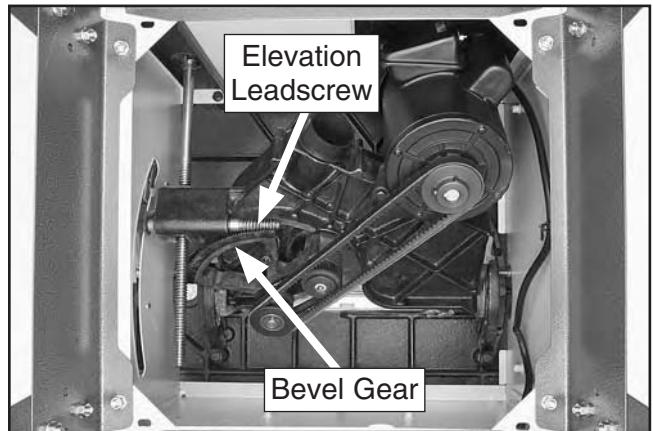


Figure 108. Bevel gear and elevation leadscrew.

Clean the bevel gear and elevation leadscrew with mineral spirits before lubricating.

Lubricate the bevel gear and elevation leadscrew with lithium grease. Apply a dab into the bevel gear teeth and around the elevation leadscrew right next to where it goes into the housing.



SECTION 8: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.
Note: Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting



Symptom	Possible Cause	Possible Solution
Motor does not start.	<ol style="list-style-type: none">1. Switch disabling key removed.2. Motor connection wired incorrectly.3. Break or short in wiring; or loose connections.4. Power supply switched off/has incorrect voltage.5. Start capacitor has blown.6. Centrifugal switch at fault.	<ol style="list-style-type: none">1. Install switch disabling key.2. Wire motor correctly (refer to inside junction box cover or manual).3. Trace/replace broken or corroded wires; fix loose connections.4. Switch power supply on/verify voltage.5. Test/replace if at fault.6. Adjust/replace centrifugal switch.
Machine stalls or is underpowered.	<ol style="list-style-type: none">1. Feed rate/cutting speed too fast.2. Workpiece material unsuitable for machine.3. Workpiece crooked; fence mis-adjusted.4. Machine undersized for task.5. Run capacitor at fault.6. Belt slipping.7. Motor wired incorrectly.8. Plug/receptacle at fault.9. Pulley/sprocket slipping on shaft.10. Motor bearings at fault.11. Contactor not energized/has poor contacts.12. Motor overheated.13. Motor at fault.	<ol style="list-style-type: none">1. Decrease feed rate/cutting speed.2. Only cut wood/ensure moisture is below 20%.3. Straighten or replace workpiece/adjust fence.4. Use correct blade/reduce feed rate or depth of cut.5. Test/repair/replace.6. Tension/replace belt (Page 72).7. Wire motor correctly.8. Test for good contacts/correct wiring.9. Replace loose pulley/shaft.10. Test/repair/replace.11. Test all legs for power/replace if faulty.12. Clean motor, let cool, and reduce workload.13. Test/repair/replace.
Machine has excessive vibration or noise.	<ol style="list-style-type: none">1. Slight blade wobble.2. Arbor nut is loose/obstructed by debris.3. Arbor pulley loose.4. Loose tilt handwheel.5. Casting at fault.6. Motor fan rubbing on fan cover.7. Motor mounting loose.8. Belt worn or damaged.9. Belt(s) slapping cover.10. Pulley loose or not in alignment; shaft bent.11. Arbor bearings at fault.12. Motor bearings worn or damaged.	<ol style="list-style-type: none">1. Use a blade stabilizer.2. Remove and clean, then tighten arbor nut.3. Retighten/replace arbor pulley with shaft and thread locking liquid.4. Tighten the tilt handwheel lock knob.5. Trunnion/geared bearing housing is loose or cracked; tighten or replace.6. Fix/replace fan cover; replace loose or damaged fan.7. Tighten mounting bolts/nuts; use thread locking fluid.8. Replace belt (refer to Page 73).9. Tighten belt(s).10. Replace worn pulley, key, and shaft, and realign.11. Replace arbor housing bearings; replace arbor.12. Replace motor bearings or replace motor.



Symptom	Possible Cause	Possible Solution
Handwheel binds or is difficult to move.	1. Lock knob is engaged. 2. Handwheel shaft pins are wedged.	1. Loosen lock knob. 2. Remove handwheel and adjust shaft pins.
Blade does not reach 90 degrees.	1. Pointer or scale calibrated incorrectly. 2. 90 Degree stop bolt is out of adjustment.	1. Calibrate pointer/scale at true 90 degrees (Page 65). 2. Adjust 90 degree stop bolt (Page 65).
Blade does not reach 45 degrees.	1. 45 Degree stop bolt is out of adjustment. 2. Sawdust is built up in front trunnion.	1. Adjust 45 degree stop bolt (Page 66). 2. Check for sawdust in trunnions, clean and re-lubricate as necessary.
Blade too close to insert.	1. Blade position on arbor is incorrect. 2. Table mounting position is not centered.	1. Verify that blade arbor washers are correct and in the required position. 2. Loosen table mounting bolts, adjust table position, then realign the blade.
Blade will not go beneath table surface.	1. Roll pin/set screw in worm gear contacting geared trunnion.	1. Tighten roll pins and set screws in the worm gear.
Blade will not move up or down.	1. Set screw on worm gear is loose/missing.	1. Tighten or replace set screw.
Workpiece burns or binds when feeding.	1. Riving knife not correctly aligned with blade. 2. Spreader not correctly aligned with blade. 3. Fence not parallel with blade (pressure at blade backside). 4. Blade is warped or damaged. 5. Too many teeth on blade for cutting type.	1. Adjust riving knife into alignment with blade (Page 68). 2. Adjust spreader into alignment with blade (Page 68). 3. Adjust fence parallel with blade (Page 69). 4. Replace blade (Page 33). 5. Change blade to one with fewer teeth.
Too much sawdust blown back toward operator.	1. Blade guard has been removed. 2. Too many air leaks in housing for proper dust collection. 3. Dust collection system clogged; too weak. 4. Fence not parallel with blade (pressure at blade backside). 5. Miter slot/fence not parallel with blade at 90°.	1. Re-install blade guard for maximum safety and dust control. 2. Seal leaks in housing or around dust chute. 3. Remove clog; revise ducting layout for improved suction; use a different dust collector. 4. Adjust fence parallel with blade (Page 69). 5. Adjust table so miter slot is parallel with blade at 90° (Page 66).



Blade Tilt Stops

The table saw features set screws that stop the blade at 45° and 90° when tilting it with the handwheel. The stops have been set at the factory and should require no adjustments, unless you notice that your cuts are not accurate.

If you do need to adjust the blade tilt stops, you can access the set screws from the top of the table, through the holes shown in **Figure 109**.

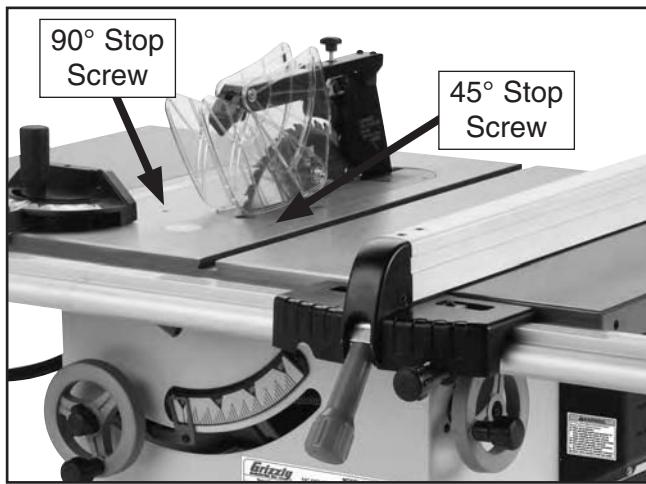


Figure 109. 90° stop bolt and jam nut.

Note: The tilt scale reads "0" when the blade is 90° to the table.

Tools Needed	Qty
90° Square	1
45° Square	1
Hex Wrench 4mm	1
Phillips Screwdriver	1

Setting 90° Stop Bolt

1. DISCONNECT SAW FROM POWER!
2. Raise the blade as high as it will go, then tilt it toward 0° until it stops and cannot be tilted any more.
3. Place a 90° square against the table and blade so it contacts the blade evenly from bottom to top, as shown in **Figure 110**. Make sure a blade tooth does not obstruct the placement of the square.

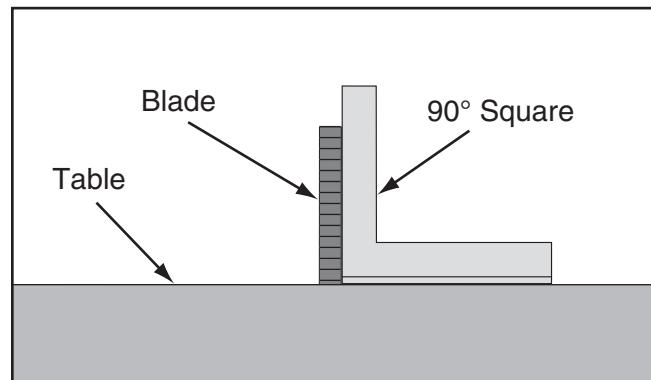


Figure 110. Checking blade at 90°.

—If the blade *is* 90° to the table, then adjustments do not need to be made. Make sure the tilt indicator arrow shown in **Figure 111** points to the 0° mark on the scale. Adjust the position by loosening the screw, moving the indicator with your fingers, then tightening the screw.

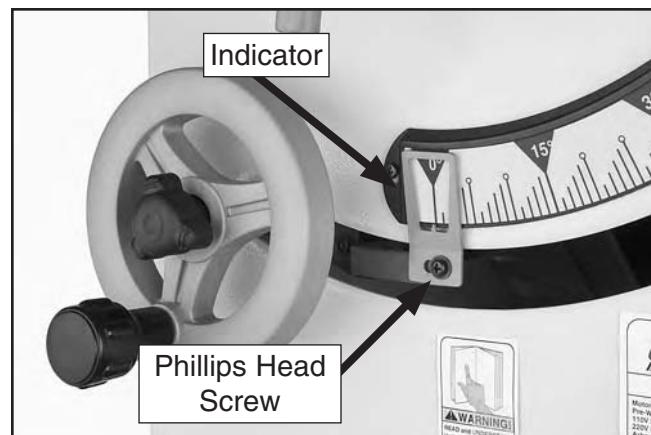


Figure 111. Tilt indicator arrow.

—If the blade *is not* 90° to the table, you will need to adjust the 90° stop screw. Proceed to the next step.

4. Tilt the blade to about 5°, so there is room for the set screw to move.
5. Adjust the 90° set screw according to how far off the blade was from 90°, then recheck the blade and repeat the adjustment as necessary until the blade stops at 90°.

Note: Turning the set screw clockwise adjusts the blade further right, turning it counterclockwise adjusts the blade to the left.



Setting 45° Stop Bolt

1. DISCONNECT SAW FROM POWER!
2. Raise the blade as high as it will go, then tilt it towards 45° until it stops and cannot be tilted any more.
3. Place a 45° square against the table and blade so it contacts the blade evenly from bottom to top, as shown in **Figure 112**. Make sure a blade tooth does not obstruct the placement of the square.

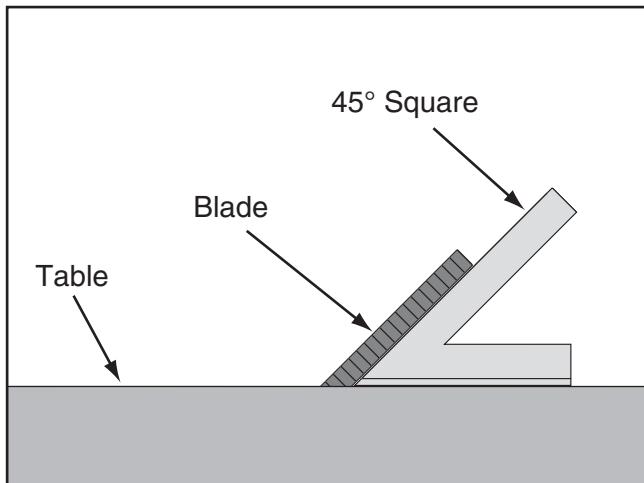


Figure 112. Checking blade at 45°.

- If the blade *is* 45° to the table, then adjustments do not need to be made.
- If the blade *is not* 45° to the table, you will need to adjust the 45° stop screw. Proceed to the next step.

4. Tilt the blade away from 45° by about 5°, so there is room for the set screw to move.
5. Adjust the 45° set screw according to how far off the blade was from 45°, then recheck the blade and repeat the adjustment as necessary until the blade stops at 45°.

Miter Slot to Blade Parallelism

The table saw will provide best results if the miter slot and the rip fence are adjusted parallel to the blade. If either of these is not exactly parallel, your cuts and your finished work will be lower in quality, but more importantly, the risk of kickback will be increased. Take the time to adjust your table saw properly. A few minutes now will be time well spent.

Tools Needed	Qty
Adjustable Square	1
Marker	1

To adjust the blade parallel to the miter slot:

1. DISCONNECT SAW FROM POWER!
2. Use an adjustable square to measure the distance from the miter slot to a carbide tip on the blade, as shown in **Figure 113**. Make sure that the face of the adjustable square is even along the miter slot.

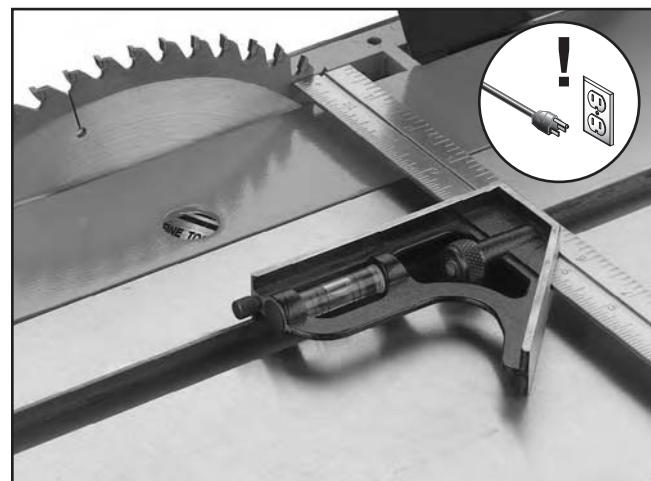


Figure 113. Example of adjusting blade to miter slot.



- With the end of the adjustable square just touching the tip, lock the square in place. Now, mark the carbide tip with a marker where you made this measurement.

CAUTION

The saw blade is sharp. Use extra care or wear gloves when handling the blade or working near it.

- Rotate the marked blade tip to the other end of the table insert.
- Slide the adjustable square down to the other end of the table insert, and compare the distance from the marked blade tip to the end of the adjustable square.
 - If the blade tip measurement *is* the same on both sides, the miter slot is parallel with the table; the procedure is complete.
 - If the blade tip measurement *is not* the same on both sides, the table will need to be adjusted. Proceed to **Step 6**.
- To adjust the table, slightly loosen the hex bolts in the trunnion mounting locations (see **Figure 114**) and slightly tap the trunnions in the needed direction. Repeat **Steps 2–5** until the blade and miter slot are parallel.
- Tighten the trunnion mounting bolts.

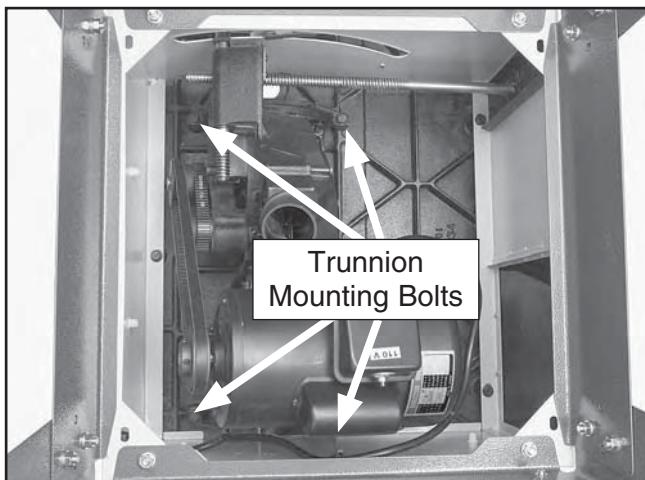


Figure 114. Trunnion mounting bolts.

Spreader or Riving Knife Alignment

Checking Alignment

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

Tools Needed	Qty
Straightedge	1

To check the spreader/riving knife alignment:

- DISCONNECT SAW FROM POWER!
- Raise the saw blade to the maximum height so you have easy working access.
- Check to make sure the blade is 90° to the table. Follow "Setting 90° Stop Bolt" instructions on **Page 65**.
- Place the straightedge against the top and bottom of blade and spreader/riving knife, as shown in **Figure 115**. The spreader/riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone," as shown in **Figure 116** on **Page 68**.

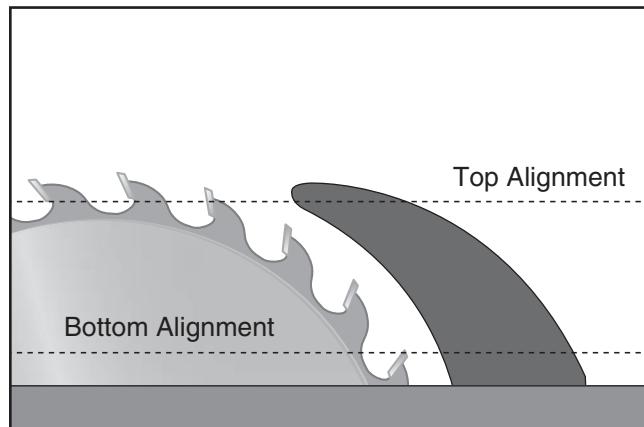


Figure 115. Checking top and bottom riving knife parallelism with blade.



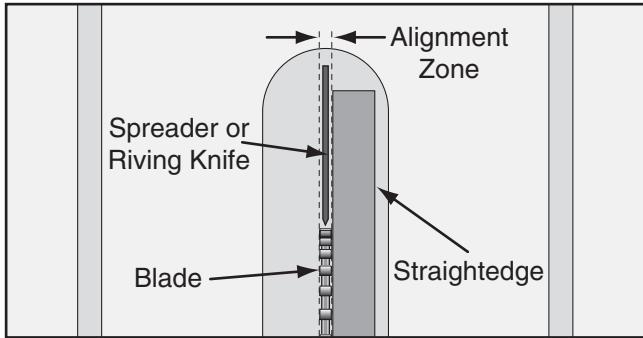


Figure 116. Spreader/riving knife alignment zone.

- If the spreader *is* in the alignment zone no adjustments need to be made.
- If the spreader/riving knife *is not* parallel with the blade and inside the alignment zone, then it needs to be adjusted. Proceed to **Adjusting Alignment** instructions.
- If the spreader/riving knife *is not* parallel with the blade at either the top or bottom, it may be bent. Remove the spreader/riving knife and place it on a flat surface and check to see if the spreader/riving knife lays evenly along its length. If the spreader/riving knife does not lay evenly, proceed to **Adjusting Bent Spreader/Riving Knife on Page 69**.

Adjusting Alignment

The spreader/riving knife mounts to a block that can be repositioned to correctly align the spreader/riving knife to the blade. The mounting block adjusts by turning the set screws in each corner of the block.

Figure 117 shows the set screws associated with controlling the mounting block position.

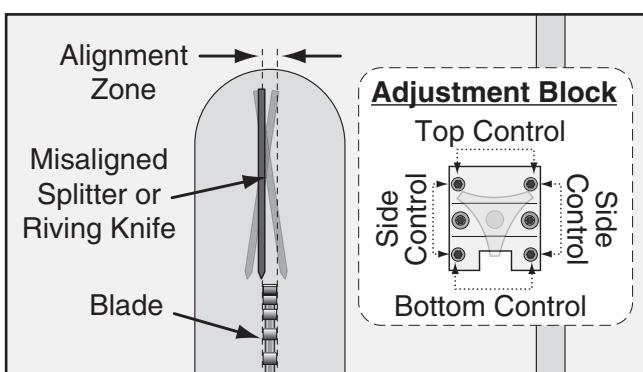


Figure 117. Set screws for adjusting spreader/riving knife position.

Possible Tools Needed

	Qty
Hex Wrench 2.5mm.....	1
Hex Wrench 3mm.....	1

To adjust the spreader/riving knife position:

1. DISCONNECT SAW FROM POWER!
2. Remove the table insert.
3. Loosen the two button head cap screws on the mounting block, then adjust the set screws on the block to move it in the necessary direction (see "Mounting Block" inset in **Figure 117**).
4. Re-install the spreader/riving knife, tighten the lock knob (see **Figure 118**), then re-install the table insert.

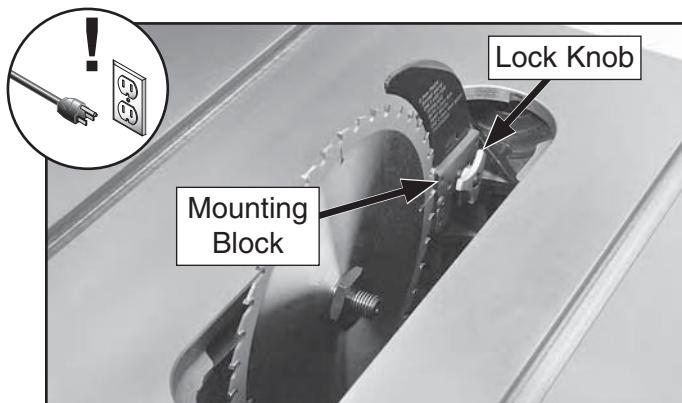


Figure 118. Lock knob location.

5. Follow **Checking Alignment, Steps 1–4**, on **Page 67**.
 - If the spreader/riving knife *is* in the alignment zone, no additional steps are necessary.
 - If the spreader/riving knife *is still not* in the alignment zone, continue adjusting the set screws on the mounting block as necessary to correctly position the spreader/riving knife.
6. Tighten the two button head cap screws on the mounting block to secure the spreader/riving knife adjustment.



Adjusting Bent Spreader/Riving Knife

1. DISCONNECT SAW FROM POWER!
2. Bend the spreader or riving knife by hand while installed, then follow **Steps 1–4** in **Checking Alignment on Page 67** to determine if it is parallel with the blade and inside the "Alignment Zone."
 - If this *does not* work, remove it to straighten it.
 - If you cannot straighten it properly, replace it.

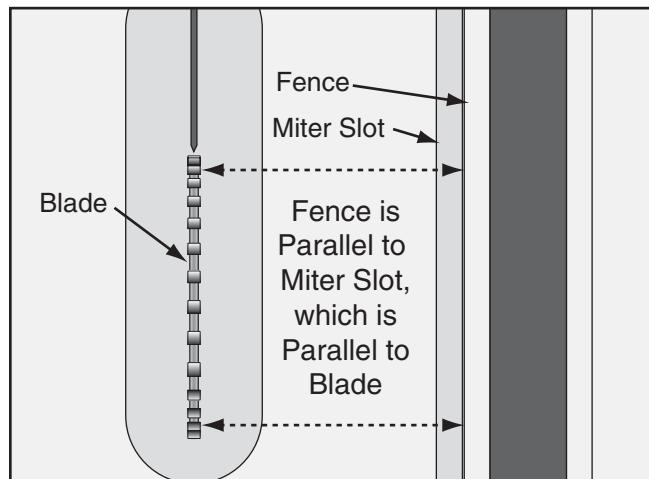


Figure 119. Checking fence parallelism with blade.

Fence Adjustments

There are two main adjustments for the fence: (1) parallelism and (2) clamping pressure. Some trial-and-error may be needed to achieve satisfactory results.

Tools Needed	Qty
Hex Wrench 5mm.....	1
Hex Wrench 6mm.....	1
Fine Ruler.....	1
Socket 10mm.....	1

Parallelism

Two cap screws on the top front of the fence position it parallel with the blade.

To verify fence parallelism:

1. DISCONNECT SAW FROM POWER!
2. Slide the fence up against the right hand edge of the miter slot, lock it in place, then raise the blade above the insert. Using a fine ruler, examine how the fence lines up with the miter slot and the blade, as shown in **Figure 119**.

Note: *It is permissible for the back of the fence to pivot outward $\frac{1}{64}$ " from being parallel with the blade (see **Figure 122 on Page 70**). Many woodworkers intentionally set up their fence in this manner. This creates a slightly larger opening between the fence and the rear of the blade to reduce the risk of workpiece binding or burning as it is fed through the cut. Keep this in mind before adjusting your fence.*

- If the fence *is* parallel with the miter slot/blade, as shown in **Figure 119**, no further adjustments need to be made.
- If the fence *is not* parallel with the miter slot/blade, then you must adjust the fence parallel with the miter slot/blade.
- If the miter slot *is not* parallel with the blade, you must follow the procedures described in **Miter Slot to Blade Parallelism on Page 66**.



To adjust the parallelism to the blade:

1. DISCONNECT SAW FROM POWER!
2. Loosen the two cap screws on the top front of the fence, as indicated in **Figure 120**.



Figure 120. Location of cap screws for adjusting fence parallelism.

3. Unlock the fence, align the left side of the fence with the right edge of the miter slot, then lock the fence.
4. Check to make sure the fence is parallel with the miter slot.
 - If the fence *is* parallel with the miter slot, tighten the cap screws.
 - If the fence *is not* parallel with the miter slot, repeat Steps 3–4.

Clamping Pressure

A lock nut on the back of the fence adjusts the clamping pressure to hold the fence securely.

To adjust the fence clamping pressure:

1. DISCONNECT SAW FROM POWER!
2. Unlock the fence.
3. Using a 10mm socket, adjust the lock nut inside the back of the fence (see **Figure 121**) to loosen or tighten the fence clamping pressure.

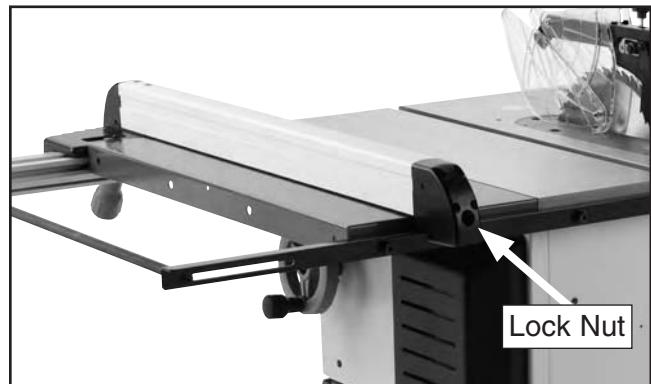


Figure 121. Location of lock nut for adjusting clamping pressure.

4. Lock the fence handle and verify whether the clamping pressure is satisfactory.
5. Re-adjust as needed until the fence will not move as pressure is applied against it.

Offsetting Fence

Some woodworkers prefer to offset the rear of the fence $1/64"$ from the blade, as shown in **Figure 122**.

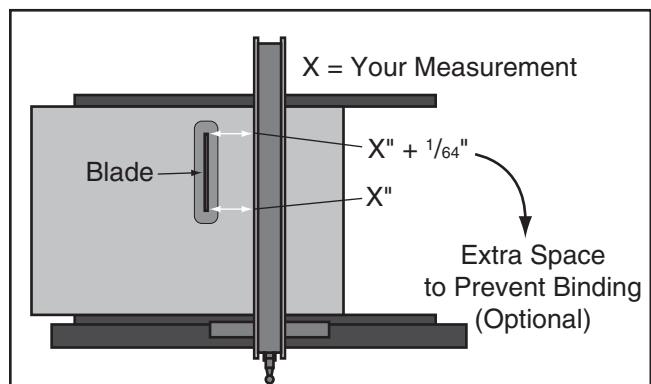


Figure 122. Adjusting fence with a $1/64"$ offset.

The reason for this wider gap at the back side of the blade is to help prevent the chance of kickback and the blade burning the workpiece because a workpiece may be inconsistent. However, the trade-off is less accurate cuts, and if the fence is placed on the other side of blade for other table saw operations, the potential of workpiece burning and kickback can be increased. Whenever using a fence, make sure that if an offset has been adjusted in the fence alignment, you use the fence on the side of the blade where the offset creates the wide gap.



Fence Scale Calibration

The fence scale indicator windows, shown in **Figure 123**, can be calibrated with the fence scale by loosening the mounting screw and sliding it in the desired direction. The indicator window on the right side is used when the fence is positioned to the right side of the blade. The indicator window on the left is used when the fence is positioned on the left side of the blade.

IMPORTANT: Do not use the fence on the left side of the blade if it has been purposely offset, as described on **Page 70, Offsetting Fence**.

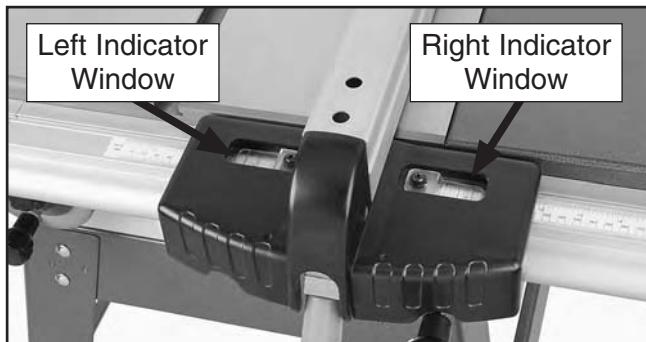


Figure 123. Fence indicator windows.

Tools Needed	Qty
Phillips Screwdriver	1
Scrap Piece of Wood	1

To calibrate the fence scale indicator windows:

1. Lock the fence at 13" and cut your scrap piece of wood.
2. Reposition and lock the fence at 12", as indicated by the scale.
3. Flip your scrap piece of wood over, placing the side that was cut in **Step 1** against the fence, then make your cut.
4. Measure the width of the freshly cut workpiece with a tape measure. The workpiece width should be exactly 12". If it is not, then adjust the indicator window to match the width of the workpiece.

Miter Gauge Adjustments

The miter gauge is equipped with stop screws that allow you to easily adjust the miter gauge from 45° to the left, 90°, and 45° to the right (see **Figure 124**). The stop screws contact the shaft, which moves in or out of the way for adjustments.

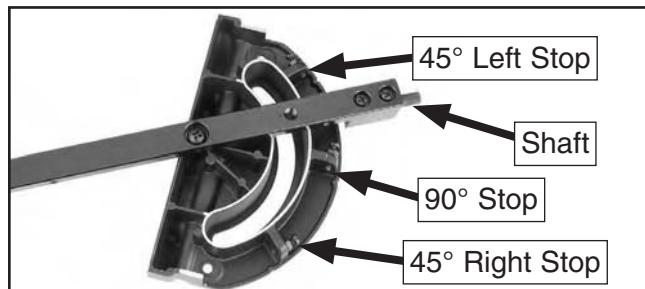


Figure 124. Miter gauge stops.

Tools Needed	Qty
Phillips Screwdriver	1
Square 90° and 45°	1 Each
Wrench 8mm	1

Checking/Setting 90° Stops

1. DISCONNECT SAW FROM POWER!
2. Slide the miter gauge into the T-slot on the table, then push the sliding shaft all the way into the miter gauge.
3. Adjust the miter gauge so the 90° stop screw rests against the sliding shaft.
4. Place the 90° square evenly against the face of the miter gauge and the blade, as shown in **Figure 125**.

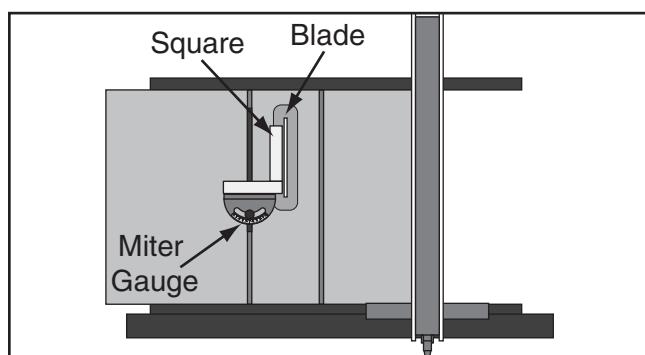


Figure 125. Example of checking 90° stop on miter gauge.



- If the square touches the miter body and the body of the blade (not the teeth) evenly at the same time, then it is square to the blade and the 90° stop is set correctly. No further adjustments are necessary.
- If the square *does not* touch the miter body and blade body evenly at the same time, then proceed to **Step 5**.

5. Loosen the hex nut (jam nut) that secures the 90° stop screw and adjust the stop screw until it is seated against the shaft while the square is evenly touching the miter body and the blade body, then tighten the hex nut.
6. Loosen the screw on the front of the miter bar, adjust the pointer to 0°, then tighten the screw.

Checking/Setting 45° Stops

Follow the same process with the 45° stops that you followed with the 90°, except using a 45° square or adjustable square to verify that the miter body is 45° to the blade, as shown in **Figure 126**.

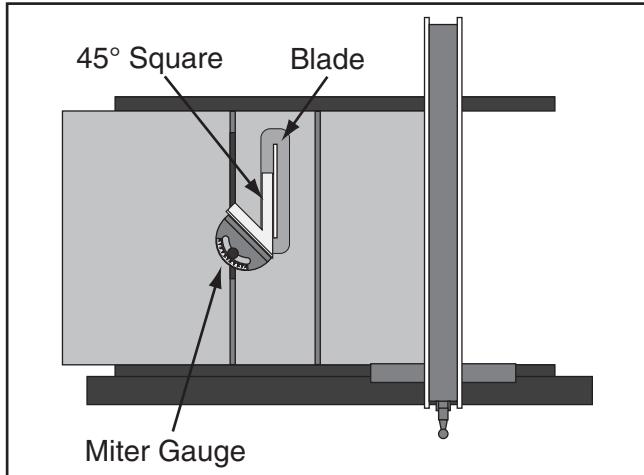


Figure 126. Example of checking 45° stop on miter gauge.

Belt Tension & Replacement

The belt stretches slightly as the saw is used. Most of the stretching will happen during the first 16 hours of use, but it may continue to gradually stretch with continued use and repeated tensioning.

Tools Needed	Qty
Wrench or Socket 14mm	1
Wrench or Socket 17mm	1

Tensioning Belt

1. DISCONNECT SAW FROM POWER!
2. Loosen the hex bolt and lock nut shown in **Figure 127**, and pivot the motor up and down to make sure that it is movable.

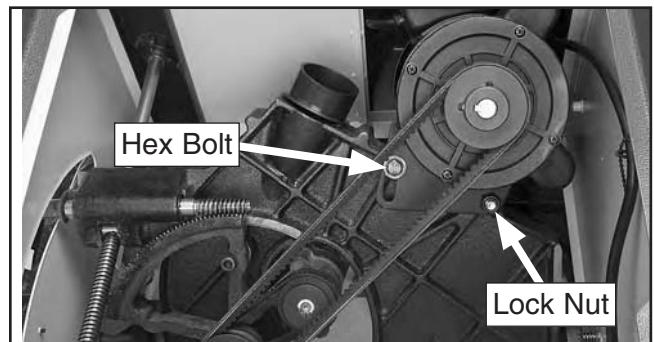


Figure 127. Motor mounting fasteners.

3. Push up on the motor with one hand to keep the belt tension tight, and tighten the hex bolt and lock nut.
4. Press the belt in the center to check the belt tension.



The belt is correctly tensioned when there is approximately $\frac{1}{4}$ " deflection when it is pushed with moderate pressure, as shown in **Figure 128**.

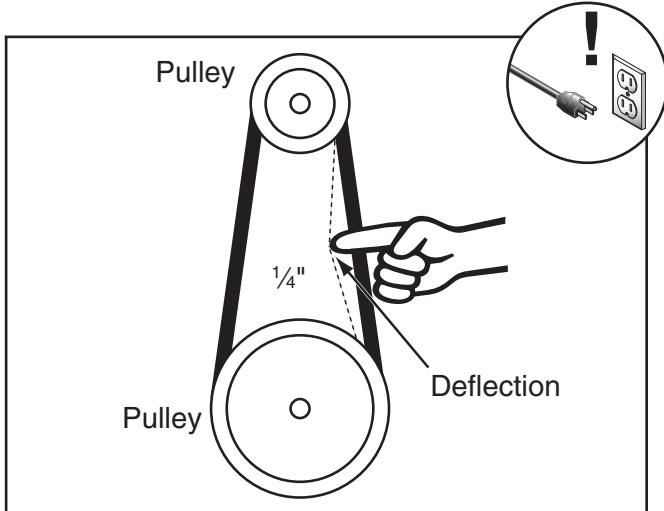


Figure 128. Checking belt tension.

—If there is more than $\frac{1}{4}$ " deflection when the belt is pushed with moderate pressure, loosen the hex bolt, adjust the motor upward, then tighten the hex bolt.

Replacing Belt

1. Follow Steps 1–2 in **Tensioning Belt**.
2. Pivot the motor down and roll the belt off of the pulleys.
3. Install the new belt in the reverse manner that you removed the old one.
4. Repeat Steps 3–4 in **Tensioning Belt**.



SECTION 9: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. 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 aftermarket 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		BLUE	
GREEN		GRAY		GREEN		WHITE	
RED		ORANGE		PURPLE		TURQUOISE	
				PINK			



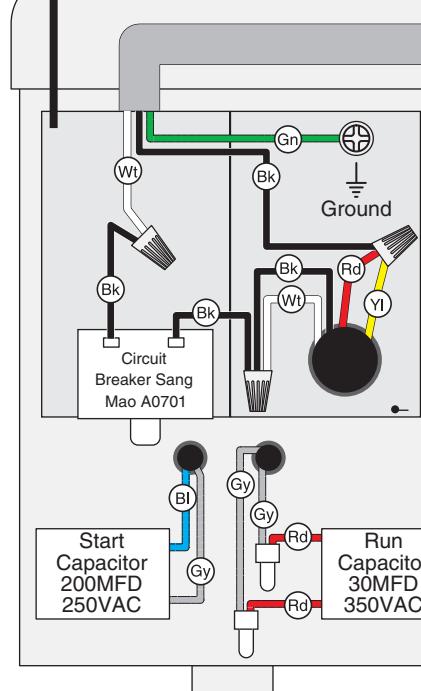
Wiring Diagram



MOTOR JUNCTION BOX

PADDLE SWITCH
(viewed from behind)

MOTOR (Prewired 110V)



Switch G9301A

NOTICE

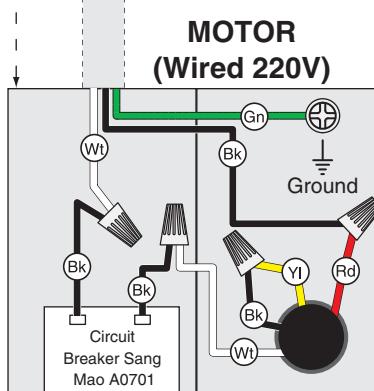
Voltage conversion or electrical repair must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.

5-15 Plug
(Included)

Neutral



110V



NOTICE

The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

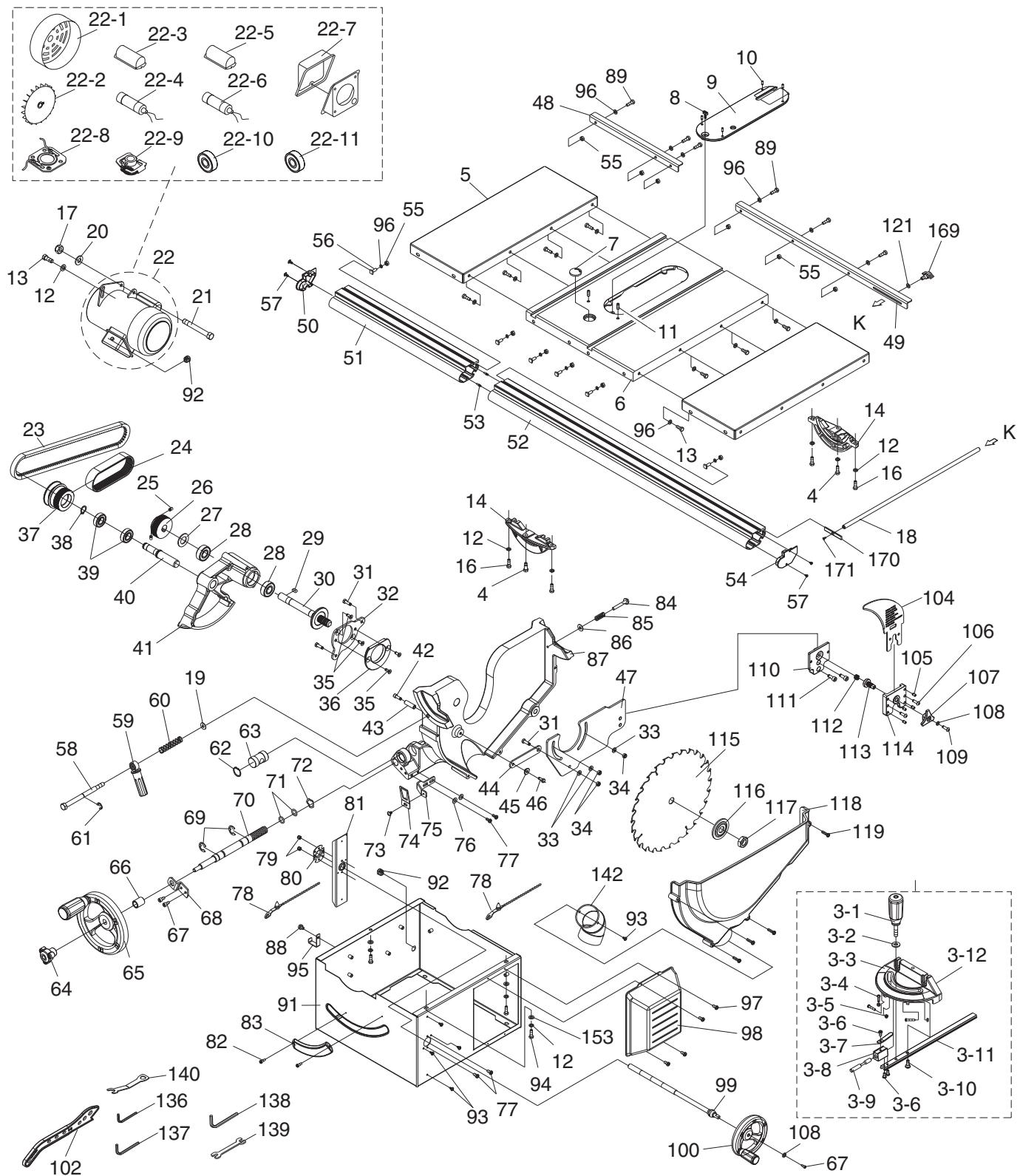


6-15 PLUG
(As Recommended)



SECTION 10: PARTS

Main



Main Parts List

REF	PART #	DESCRIPTION
3	P0732003	MITER GAUGE ASSEMBLY
3-1	P0732003-1	MITER GAUGE HANDLE
3-2	PW01M	FLAT WASHER 8MM
3-3	P0732003-3	MITER GAUGE BODY
3-4	PS52M	PHLP HD SCR M4-.7 X 20
3-5	PN04M	HEX NUT M4-.7
3-6	PS09M	PHLP HD SCR M5-.8 X10
3-7	P0732003-7	MITER GAUGE POINTER
3-8	P0732003-8	SLIDING SHAFT BLOCK
3-9	P0732003-9	SLIDING SHAFT
3-10	P0732003-10	SHOULDER SCREW M7 X 4, M6-1 X 8
3-11	P0732003-11	MITER GAUGE PLATE
3-12	P0732003-12	MITER GAUGE SCALE LABEL
4	P0732004	SHOULDER BOLT M15.5 X 10, M8-1.25 X 8
5	P0732005	EXTENSION WING
6	P0732006	TABLE
7	P0732007	ALIGN-A-CUT MARKER
8	P0732008	LOCK KNOB M5-.8
9	T21876	ZERO CLEARANCE TABLE INSERT
10	PSS53M	SET SCREW M5-.8 X 12
11	PSS09M	SET SCREW M8-1.25 X 20
12	PLW04M	LOCK WASHER 8MM
13	PB09M	HEX BOLT M8-1.25 X 20
14	P0732014	TRUNNION
16	PB07M	HEX BOLT M8-1.25 X 25
17	PLN05M	LOCK NUT M10-1.5
18	P0732018	RAIL SUPPORT SHAFT
20	PW04M	FLAT WASHER 10MM
21	PB13M	HEX BOLT M10-1.5 X 80
22	P0732022	MOTOR 1.5HP 1PH 110/220V
22-1	P0732022-1	MOTOR FAN COVER
22-2	P0732022-2	MOTOR FAN
22-3	P0732022-3	R CAPACITOR COVER
22-4	P0732022-4	R CAPACITOR 30M 350V 1-1/2 X 2-3/8
22-5	P0732022-5	S CAPACITOR COVER
22-6	P0732022-6	S CAPACITOR 200M 250V 1-3/8 X 3-1/8
22-7	P0732022-7	MOTOR JUNCTION BOX
22-8	P0732022-8	CONTACT PLATE
22-9	P0732022-9	CENTRIFUGAL SWITCH
22-10	P0732022-10	FRONT MOTOR BEARING
22-11	P0732022-11	REAR MOTOR BEARING
23	P0732023	BELT 17-320
24	P0732024	RIBBED V-BELT 125J-6
25	PSS01M	SET SCREW M6-1 X 10
26	P0732026	SPINDLE PULLEY
27	P0732027	SPINDLE WASHER 15MM
28	P6202-2RS	BALL BEARING 6202 2RS
29	PK14M	KEY 5 X 5 X 18
30	P0732030	ARBOR SPINDLE
31	PB08M	HEX BOLT M6-1 X 20
32	P0732032	SPINDLE PLATE
33	PW03M	FLAT WASHER 6MM
34	PLN03M	LOCK NUT M6-1
35	PFH02M	FLAT HD SCR M6-1 X 12
36	P0732036	SPINDLE BRACKET

REF	PART #	DESCRIPTION
37	P0732037	TRANSFER PULLEY
38	PR05M	EXT RETAINING RING 15MM
39	P6002-2RS	BALL BEARING 6002-2RS
40	P0732040	TRANSFER PULLEY SHAFT
41	P0732041	GEARED BEARING HOUSING
42	PCAP05M	CAP SCREW M8-1.25 X 50
43	P0732043	BUSHING
44	P0732044	LINK ARM
45	P0732045	BUSHING
46	PB107M	HEX BOLT M5-.8 X 12
47	P0732047	RIVING KNIFE MOUNTING PLATE
48	P0732048	LEFT REAR RAIL
49	P0732049	RIGHT REAR RAIL
50	P0732050	LEFT FRONT RAIL CAP
51	P0732051	LEFT FRONT RAIL
52	P0732052	RIGHT FRONT RAIL
53	P0732053	RAIL MOUNTING PIN
54	P0732054	RIGHT FRONT RAIL CAP
55	PN03M	HEX NUT M8-1.25
56	P0732056	T-BOLT M8-1.25 X 20
57	PHTEK15M	TAP SCREW M4 X 10
58	P0732058	TRUNNION ANGLE LOCK SHAFT
59	P0732059	LOCK SHAFT HANDLE
60	P0732060	COMPRESSION SPRING
61	PEC015M	E-CLIP 8MM
62	PR93M	INT RETAINING RING 24MM
63	P0732063	HANDWHEEL SHAFT
64	P0732064	BLADE HEIGHT LOCK KNOB
65	P0732065	BLADE HEIGHT HANDWHEEL
66	P0732066	HEIGHT HANDWHEEL BUSHING
67	PCAP33M	CAP SCREW M5-.8 X 12
68	P0732068	HANDWHEEL MOUNTING PLATE
69	PEC12M	E-CLIP 12MM
70	P0732070	HEIGHT LEADSCREW
71	PORP012	O-RING 11.8 X 2.4 P12
72	P0732072	WAVE WASHER 16MM
73	P0732073	PHLP HD SCR M4-.7 W/WASHER
74	P0732074	BLADE ANGLE POINTER
75	P0732075	BLADE ANGLE POINTER BRACKET
76	PW03M	FLAT WASHER 6MM
77	PS08M	PHLP HD SCR SCREW M5-.8 X 12
78	P0732078	CHAIN
79	PLN02M	LOCK NUT M5-.8
80	P0732080	TILT LEADSCREW BRACKET
81	P0732081	TILT LEADSCREW SUPPORT PLATE
82	PS02M	PHLP HD SCR M4-.7 X 12
83	P0732083	TILT PLATE W/SCALE
84	PFB28M	FLANGE BOLT M6-1 X 40
85	P0732085	COMPRESSION SPRING
86	PW03M	FLAT WASHER 6MM
87	P0732087	TRUNNION BRACKET
88	P0732088	HEX BOLT M8-1.25 X 10 W/WASHER
89	PCAP14M	CAP SCREW M8-1.25 X 20
91	P0732091	CABINET
92	P0732092	STRAIN RELIEF SB8R-1



Main Parts List

REF PART # DESCRIPTION

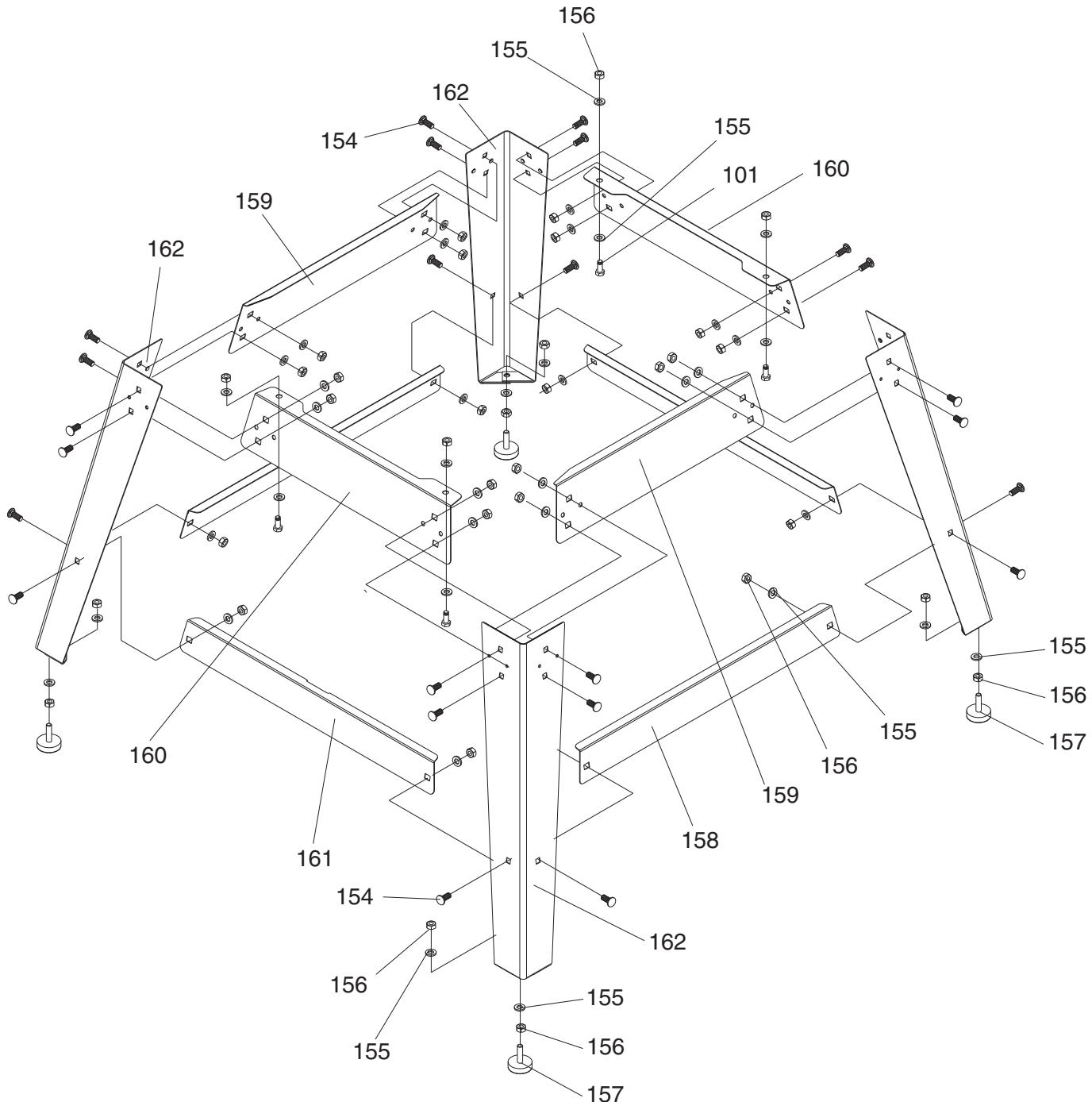
93	PHTEK15M	TAP SCREW M4 X 9
94	PB03M	HEX BOLT M8-1.25 X 16
95	P0732095	PUSH STICK HOLDER
96	PLW04M	LOCK WASHER 8MM
97	PS38M	PHLP HD SCR M4-.7 X 10
98	P0732098	MOTOR ACCESS COVER
99	P0732099	LEADSCREW TILT SHAFT
100	P0732100	BLADE TILT HANDWHEEL
102	P0732102	PUSH STICK
104	P0732104	RIVING KNIFE
105	PSS31M	SET SCREW M5-.8 X 8
106	PBHS16M	BUTTON HD CAP SCR M5-.8 X 16
107	P0732107	STAR HANDLE
108	PLW01M	LOCK WASHER 5MM
109	PBHS06M	BUTTON HD CAP SCR M5-.8 X 12
110	P0732110	MOUNTING BASE
111	PCAP52M	CAP SCREW M8-1.25 X 10
112	P0732112	COMPRESSION SPRING

REF PART # DESCRIPTION

113	P0732113	LOCKING BOLT
114	P0732114	MOUNTING PLATE
115	P0732115	BLADE 10" X 40T
116	P0732116	BLADE MOUNTING FLANGE
117	P0732117	ARBOR NUT 5/8"-12 RH
118	P0732118	BLADE COVER
119	PS60M	PHLP HD SCR M5-.8 X 30
121	PW03M	FLAT WASHER 6MM
136	PAW02.5M	HEX WRENCH 2.5MM
137	PAW04M	HEX WRENCH 4MM
138	PAW06M	HEX WRENCH 6MM
139	PWR1113	WRENCH 11 X 13 OPEN ENDS
140	P0732140	ARBOR WRENCH 25MM
142	P0732142	DUST CHUTE
153	PW01M	FLAT WASHER 8MM
169	P0732169	KNOB M6-1 X 12
170	P0732170	REAR SLIDING PLATE
171	PFH25M	FLAT HD SCR M4-.7 X 12



Stand

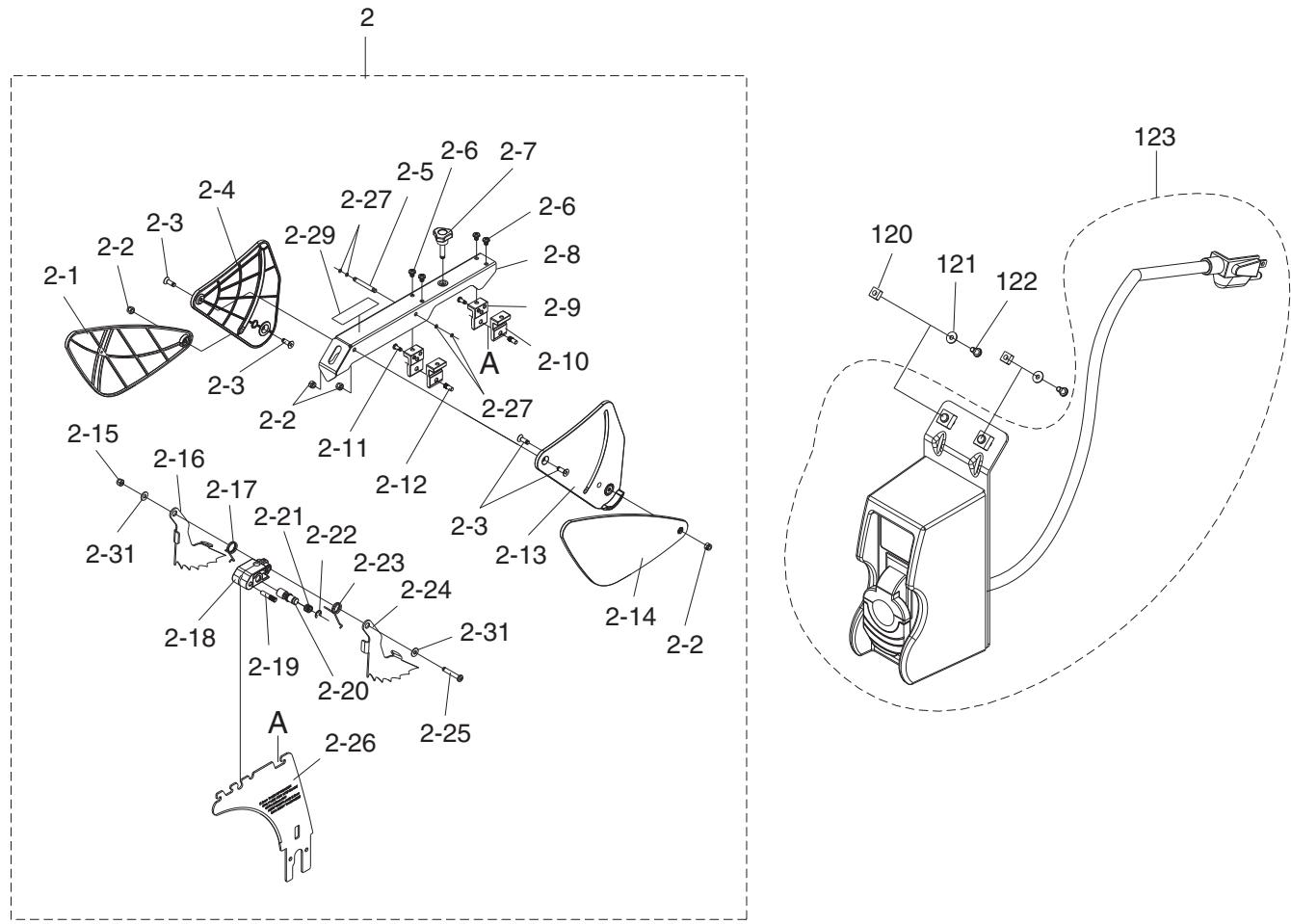


REF	PART #	DESCRIPTION
101	PB09M	HEX BOLT M8-1.25 X 20
154	PCB06M	CARRIAGE BOLT M8-1.25 X 16
155	PW01M	FLAT WASHER 8MM
156	PN03M	HEX NUT M8-1.25
157	P0732157	RUBBER FOOT M8-1.25 X 20

REF	PART #	DESCRIPTION
158	P0732158	LONG LOWER STAND BRACE
159	P0732159	LONG UPPER STAND BRACE
160	P0732160	SHORT UPPER STAND BRACE
161	P0732161	SHORT LOWER STAND BRACE
162	P0732162	STAND LEG



Guard & Switch

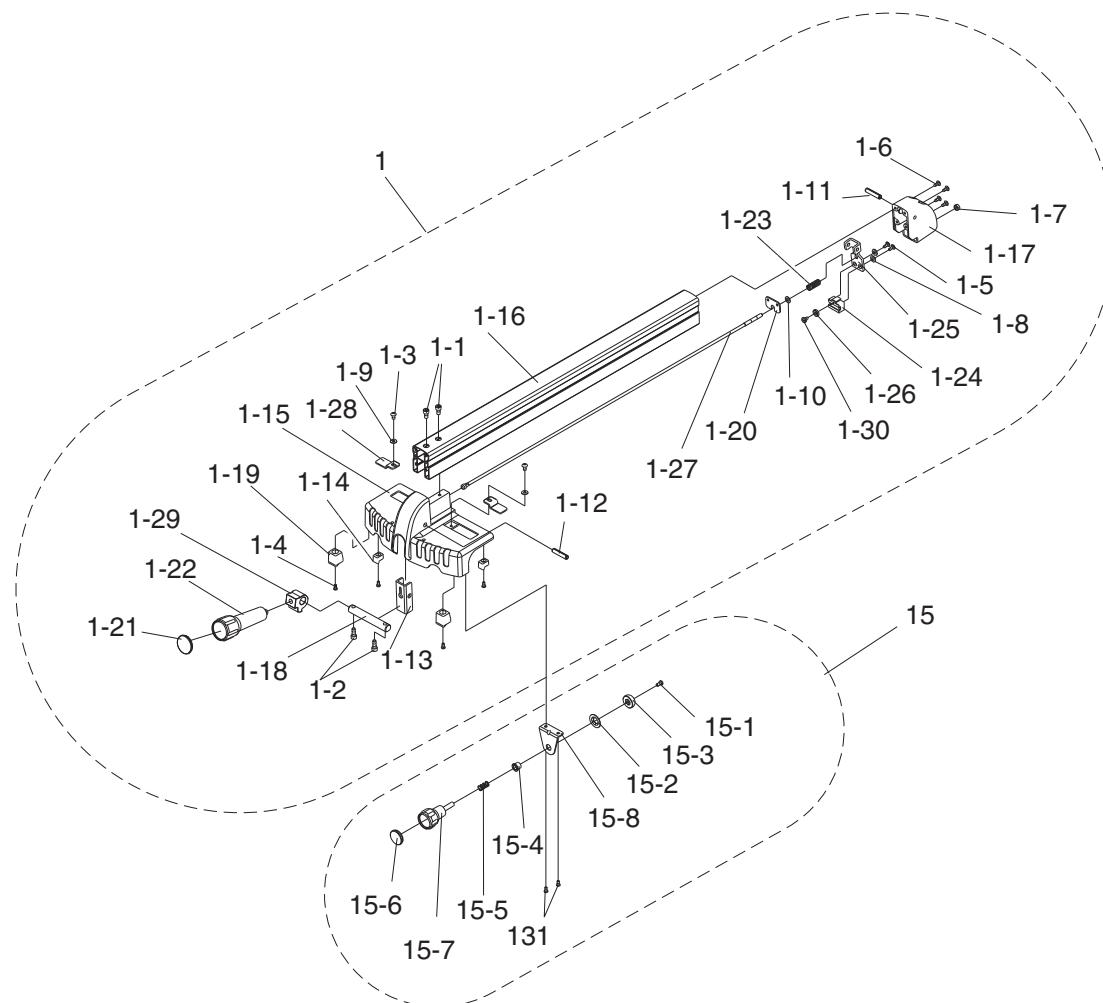


REF	PART #	DESCRIPTION
2	P0732002	BLADE GUARD ASSEMBLY
2-1	P0732002-1	LEFT PLATE
2-2	PLN02M	LOCK NUT M5.8
2-3	PFH01M	FLAT HD SCR M5.8 X 15
2-4	P0732002-4	LEFT COVER
2-5	P0732002-5	ROD CENTER PIN
2-6	PS19M	PHLP HD SCR M5.8 X 6
2-7	P0732002-7	KNOB BOLT
2-8	P0732002-8	ROD
2-9	P0732002-9	LEFT BRACKET
2-10	P0732002-10	RIGHT BRACKET
2-11	PBHS24M	BUTTON HD CAP SCR M4.7 X 10
2-12	P0732002-12	MOUNTING PIN
2-13	P0732002-13	RIGHT COVER
2-14	P0732002-14	RIGHT PLATE
2-15	PLN02M	LOCK NUT M5.8
2-16	P0732002-16	LEFT PAWL

REF	PART #	DESCRIPTION
2-17	P0732002-17	RIGHT TORSION SPRING
2-18	P0732002-18	PAWL MOUNTING BRACKET
2-19	P0732002-19	MOUNTING BRACKET PIN
2-20	P0732002-20	MOUNTING BRACKET SHAFT
2-21	P0732002-21	SHAFT SPRING
2-22	PEC07M	E-CLIP 7MM
2-23	P0732002-23	LEFT TORSION SPRING
2-24	P0732002-24	RIGHT PAWL
2-25	PS60M	PHLP HD SCR M5.8 X 30
2-26	P0732002-26	SPREADER
2-27	PORP003	O-RING 2.8 X 1.9 P3
2-29	P0732202	BLADE GUARD LABEL
2-31	PW02M	FLAT WASHER 5MM
120	PSN02M	SQUARE NUT M6-1
121	PW03M	FLAT WASHER 6MM
122	PS14M	PHLP HD SCR M6-1 X 12
123	P0732123	SWITCH ASSY W/CORD 14G 3C 5-15



Fence



REF PART # DESCRIPTION

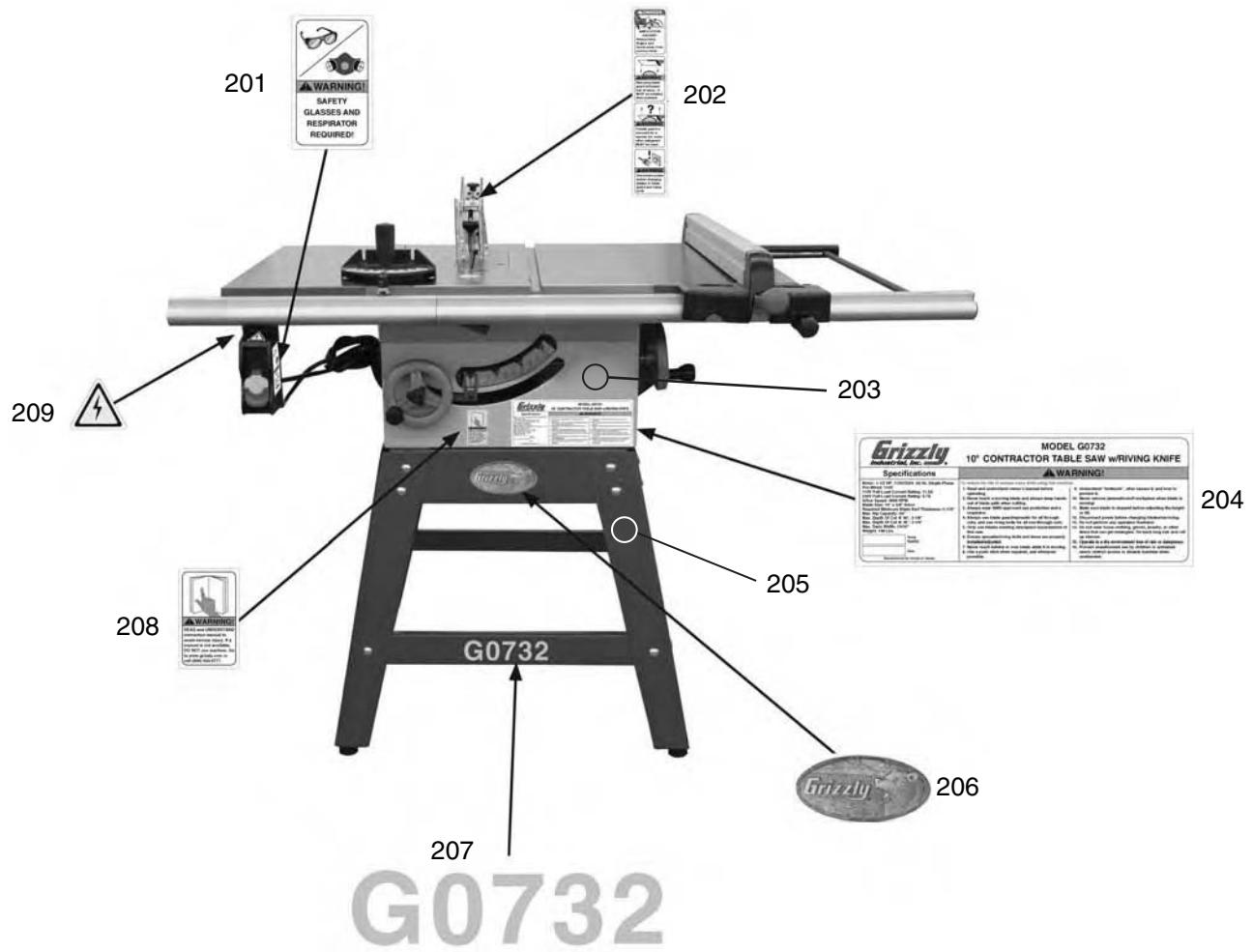
1	P0732001	FENCE ASSEMBLY
1-1	PCAP04M	CAP SCREW M6-1 X 10
1-2	PCAP02M	CAP SCREW M6-1 X 20
1-3	PS05M	PHLP HD SCR M5-.8 X 8
1-4	PHTEK4M	TAP SCREW M4 X 8
1-5	PS38M	PHLP HD SCR M4-.7 X 10
1-6	PHTEK6M	TAP SCREW M4 X 16
1-7	PLN03M	LOCK NUT M6-1
1-8	PW05M	FLAT WASHER 4MM
1-9	PW02M	FLAT WASHER 5MM
1-10	PW03M	FLAT WASHER 6MM
1-11	PRP32M	ROLL PIN 6 X 40
1-12	PRP110M	ROLL PIN 8 X 40
1-13	P0732001-13	PLATE
1-14	P0732001-14	REAR SLIDING BLOCK
1-15	P0732001-15	FRONT FENCE BLOCK
1-16	P0732001-16	FENCE TUBE
1-17	P0732001-17	FENCE CAP
1-18	P0732001-18	SHAFT
1-19	P0732001-19	FRONT SLIDING BLOCK
1-20	P0732001-20	TIGHTENING ROD PLATE

REF PART # DESCRIPTION

1-21	P0732001-21	FENCE HANDLE CAP
1-22	P0732001-22	FENCE HANDLE
1-23	P0732001-23	COMPRESSION SPRING
1-24	P0732001-24	LOCKING PLATE BLOCK
1-25	P0732001-25	LOCKING PLATE
1-26	P0732001-26	PLASTIC FLAT WASHER 6MM
1-27	P0732001-27	FENCE TIGHTENING ROD
1-28	P0732001-28	POINTER
1-29	P0732001-29	CAM
1-30	P0732001-30	SHOULDER SCREW M4 X 6, M4-.7 X 5
15	P0732015	MICRO ADJUSTMENT ASSY
15-1	PS05M	PHLP HD SCR M5-.8 X 8
15-2	P0732015-2	INT TOOTH WASHER 12MM
15-3	P0732015-3	RUBBER WHEEL
15-4	P0732015-4	BUSHING
15-5	P0732015-5	COMPRESSION SPRING
15-6	P0732015-6	MICRO ADJUSTMENT KNOB CAP
15-7	P0732015-7	ADJUSTMENT KNOB M5-.8
15-8	P0732015-8	ADJUSTMENT KNOB BRACKET
131	PS05M	PHLP HD SCR M5-.8 X 8



Label Placement



REF	PART #	DESCRIPTION
201	PLABEL-57	GLASSES/RESPIRATOR LABEL
202	P0732202	BLADE GUARD LABEL
203	PPAINT-11	PUTTY TOUCH-UP PAINT
204	P0732204	MACHINE ID LABEL
205	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT

REF	PART #	DESCRIPTION
206	G9987	GRIZZLY NAMEPLATE
207	P0732207	MODEL NUMBER LABEL
208	PLABEL-12C	READ MANUAL LABEL 1.5W X 2.5H
209	PLABEL-14	ELECTRICITY LABEL

⚠️WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.





WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

*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
 Card Deck

Friend
 Website

Catalog
 Other:

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

Cabinetmaker & FDM
 Family Handyman
 Hand Loader
 Handy
 Home Shop Machinist
 Journal of Light Cont.
 Live Steam
 Model Airplane News
 Old House Journal
 Popular Mechanics

Popular Science
 Popular Woodworking
 Precision Shooter
 Projects in Metal
 RC Modeler
 Rifle
 Shop Notes
 Shotgun News
 Today's Homeowner
 Wood

Wooden Boat
 Woodshop News
 Woodsmith
 Woodwork
 Woodworker West
 Woodworker's Journal
 Other:

3. What is your annual household income?

\$20,000-\$29,000
 \$50,000-\$59,000

\$30,000-\$39,000
 \$60,000-\$69,000

\$40,000-\$49,000
 \$70,000+

4. What is your age group?

20-29
 50-59

30-39
 60-69

40-49
 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2

3-5

6-9

10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times. Yes No

10. Comments: _____

FOLD ALONG DOTTED LINE



Place
Stamp
Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

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.



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~Since 1983~

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Current Specials!*

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