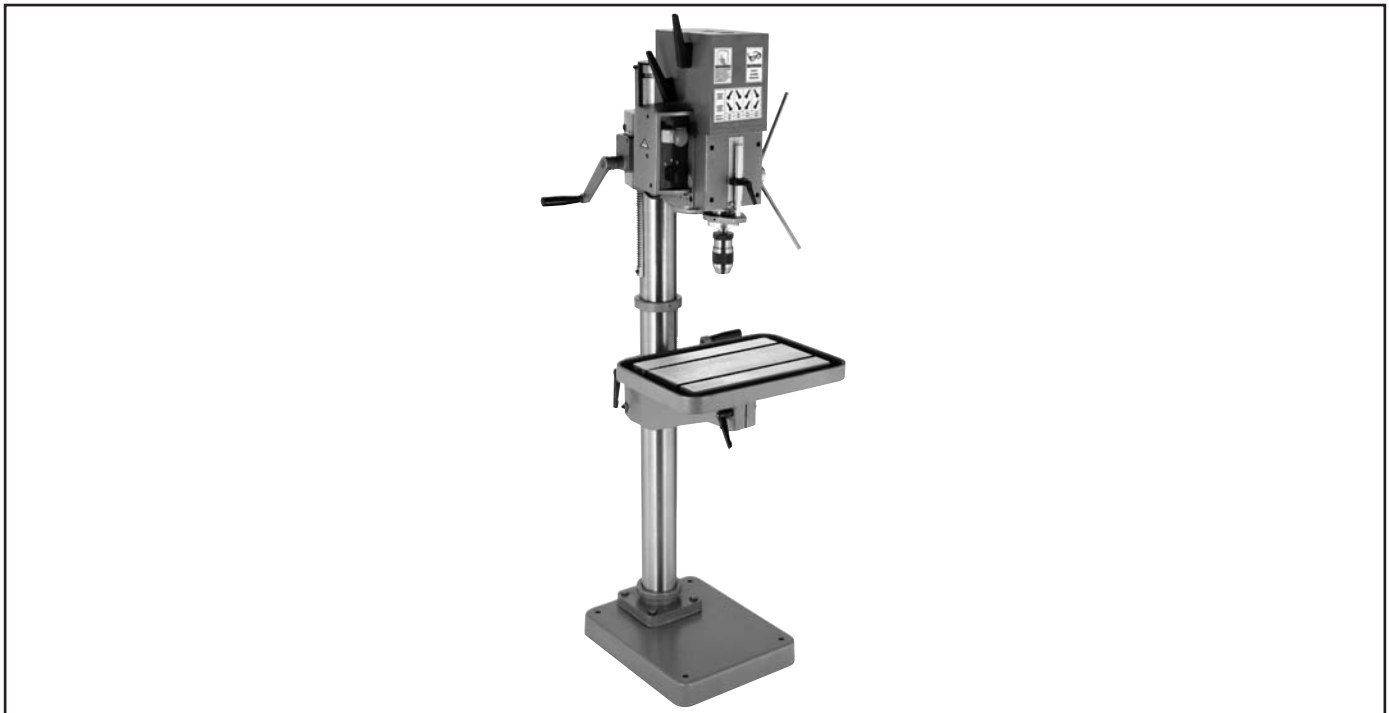




**MODEL G0483  
8 SPEED GEAR-HEAD  
DRILL PRESS  
OWNER'S MANUAL**



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
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#JK7855 PRINTED IN CHINA



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.**

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

**The owner of this machine/equipment 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, blade/cutter 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

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## Foreword

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We are proud to offer the Model G0483 8-Speed Gear-Head Drill Press. This machine is part of a growing Grizzly family of fine machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0483. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0483 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

## Contact Info

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

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

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

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





# MACHINE DATA SHEET

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

## MODEL G0483 GEAR-HEAD DRILL PRESS

### Product Dimensions:

Weight .....433 lbs.  
Length/Width/Height ..... 26-7/8 x 22 x 69 in.  
Foot Print (Length/Width)..... 26-7/8 x 22 in.

### Shipping Dimensions:

Type ..... Plywood Box  
Content.....Machine  
Weight.....500 lbs.  
Length/Width/Height..... 30 x 25 x 66 in.

### Electrical:

Switch..... Emergency Stop Switch  
Switch Voltage ..... 220V  
Cord Length ..... 6 ft.  
Cord Gauge ..... 12 gauge  
Recommended Breaker Size..... 10 amp  
Plug..... NEMA 15-15 (Not included)

### Motors:

#### Main

Horsepower..... 1-1/2 HP/1 HP  
Voltage.....220V  
Prewired.....220V  
Phase.....3-Phase  
Amps.....5.5A  
Speed..... 1725/3450 RPM  
Cycle .....60 Hz  
Number Of Speeds ..... 2  
Power Transfer .....Gearbox  
Bearings..... Shielded and Lubricated

### Main Specifications:

#### Construction

Table Construction..... Precision Ground Cast Iron  
Spindle Housing Construction..... Cast Iron  
Column Construction ..... Cylindrical Ground Steel  
Head Construction ..... Cast Iron  
Base Construction..... Cast Iron  
Paint..... Epoxy

#### Headstock Information

Vertical Headstock Movement ..... Crank Handle Operation  
Maximum Movement of Headstock ..... 11-7/8 in.



**Spindle Information**

Spindle Taper..... MT#3  
Spindle Travel ..... 5 in.  
Dist From Spindle To Column..... 10 in.  
Dist From Spindle To Table ..... 7/16 - 32-5/8 in.  
Dist From Spindle To Base..... 37-1/2 in.

**Table Information**

Table Length ..... 19-5/8 in.  
Table Width..... 13-3/4 in.  
Table Thickness..... 1-3/4 in.  
Vertical Table Movement ..... Crank Handle Operation  
Table Swivel Around Center ..... 80 deg.  
Maximum Movement Of Work Table ..... 20 in.  
No. Of T Slots ..... 2  
T Slot Width ..... 1/2 in.  
T Slot Length..... 16-1/2 in.

**Other Related Information**

Base Length ..... 19-5/8 in.  
Base Width..... 15-3/4 in.  
Quill Diameter ..... 2-3/8 in.  
Depth Stop Type ..... Sliding Block and Rail  
Column Diameter ..... 3-15/16 in.

**Operation Information**

Swing ..... 20 in.  
Drilling Capacity ..... 1 in. in Steel  
No Of Spindle Speeds ..... 8  
Range Of Spindle Speeds ..... 125, 250, 420, 535, 840, 1070, 1740, 3480 RPM  
Drill Chuck Type..... JT6 Keyless Chuck  
Drill Chuck Size..... 5/8 in.

**Other Specifications:**

Country Of Origin ..... China  
Warranty..... 1 Year  
Serial Number Location ..... Machine ID Label on Headstock  
Assembly Time ..... 10 Minutes

**Features:**

..... Crank Handle Operated Rack and Pinion Vertical Table and Headstock Movement  
..... Table and Base are Cast Iron  
..... 1-1/2 HP Motor  
..... 5/8 in. JT3 Keyless Chuck



# Identification

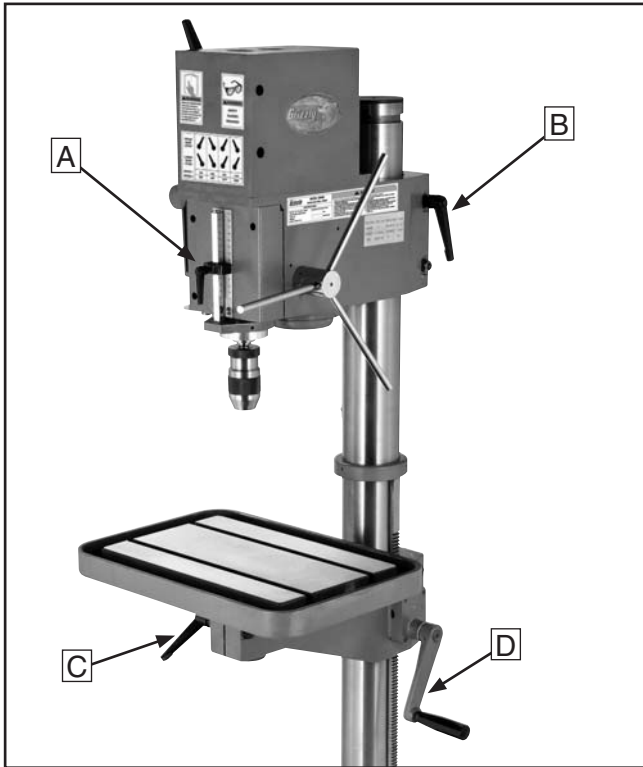


Figure 1. Right-side controls.

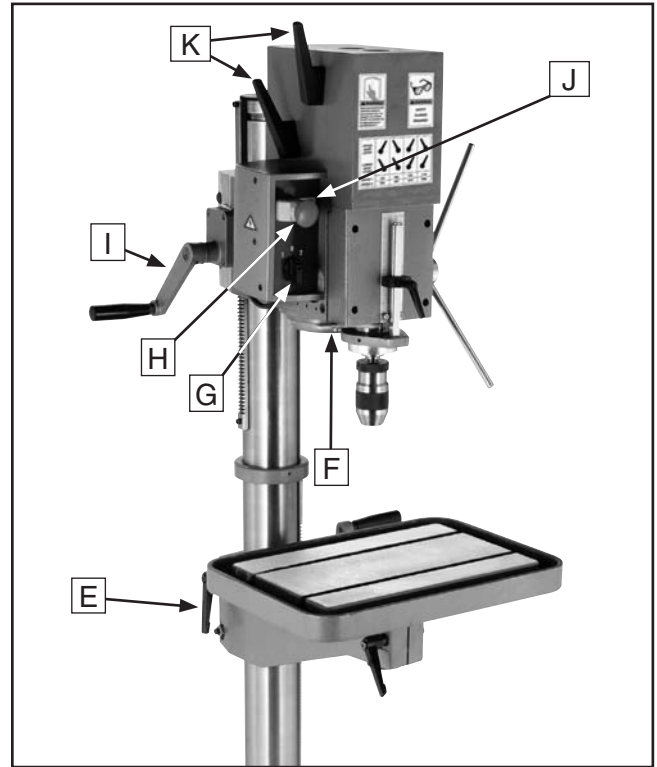


Figure 2. Left-side controls.

Refer to the list below and see **Figures 1 & 2** to become familiar with the drill press controls.

- A. Depth Stop:** Stops quill travel at a pre-set drilling depth.
- B. Upper Lock Lever:** Locks headstock height.
- C. Table Lock Lever:** Locks independent table rotation.
- D. Lower Crank Handle:** Raises/lowers table.
- E. Lower Lock Lever:** Locks table height and rotation.
- F. Automatic Arbor Ejector.**
- G. Speed Selector Switch.**
- H. Emergency Stop Switch.**
- I. Upper Crank Handle:** Raises and lowers headstock.

- J. ON/OFF Switch.**

- K. Gear Levers:** Used to change drill speed in conjunction with the Speed Selector switch.

## Machine Specific Terminology

Refer to the list below to become familiar with these drill press terms and definitions.

**Headstock:** The cast iron upper portion of the drill press which houses the quill and work light, and supports the motor and belt housing.

**Drift Key:** A wedge-shaped tool used to separate tapers.

**T-Slot:** A slot in a table used to trap a T-slot nut or T-slot bolt to clamp down a workpiece or a vise.

**Arbor:** A tapered shaft that connects the chuck to the spindle.

**Quill:** Houses the spindle and bearings.

**Spindle:** The hollow shaft that accepts the arbor.



# 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 which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

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

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

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

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

## WARNING

### Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR AN NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.





# WARNING

## Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.



# WARNING

## Additional Safety for Drill Presses

- 1. EYE/FACE/HAND PROTECTION.** A face shield used with safety glasses is recommended. Always keep hands and fingers away from the drill bit. Never hold a workpiece by hand while drilling! **DO NOT** wear gloves when operating the drill.
- 2. SECURING BIT.** Properly tighten and securely lock the drill bit in the chuck.
- 3. CORRECT BIT.** Use only round, hex, tapered, or triangular shank drill bits.
- 4. ADJUSTING KEYS AND WRENCHES.** Remove all adjusting keys and wrenches before turning the machine **ON**.
- 5. DRILLING SHEET METAL.** Never drill sheet metal unless it is securely clamped to the table.
- 6. SURFACE/WORKPIECE PREP.** Clear the table of all objects (tools, scrap wood, etc.) before turning the drill press **ON**. **DO NOT** drill material that does not have a flat surface, unless a suitable support is used.
- 7. DAMAGED TOOLING.** Never use drill bits in poor condition. Dull or damaged drill bits are hard to control and may cause serious injury.
- 8. DRILL OPERATION.** Never start the drill press with the drill bit pressed against the workpiece. Feed the drill bit evenly into the workpiece. Back the bit out frequently to clear deep holes.
- 9. CLEARING CHIPS.** Turn the machine **OFF** and clear chips and scrap pieces with a brush. Shut power **OFF**, remove drill bit, and clean table before leaving the machine.
- 10. OPERATING SPEED.** Always operate your drill press at speeds that are appropriate for the drill bit size and the material that you are drilling.
- 11. MOUNTING WORKPIECES.** Use clamps or vises to secure the workpiece before drilling. Position the workpiece so you avoid drilling into the table.
- 12. TABLE LOCK.** Make sure the table lock is tightened before starting the drill press.
- 13. MAINTENANCE/SPEED CHANGES.** Never change speeds or do maintenance with the machine plugged in.
- 14. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

### WARNING

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

### CAUTION

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



# SECTION 2: CIRCUIT REQUIREMENTS

## 220V 3-Phase

### **!WARNING**

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

### Amperage Draw

The Model G0483 motor draws the following amps under maximum load:

Motor Draw at 220V .....5.5 Amps

### Circuit Requirements

We recommend connecting this machine to a dedicated 220V circuit with a verified ground, using the circuit breaker size given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire hazard—consult a qualified electrician to reduce this risk.**

220V Circuit Breaker ..... 10 Amps

### Plug/Receptacle Type

Recommended Plug/Receptacle.... NEMA 15-15

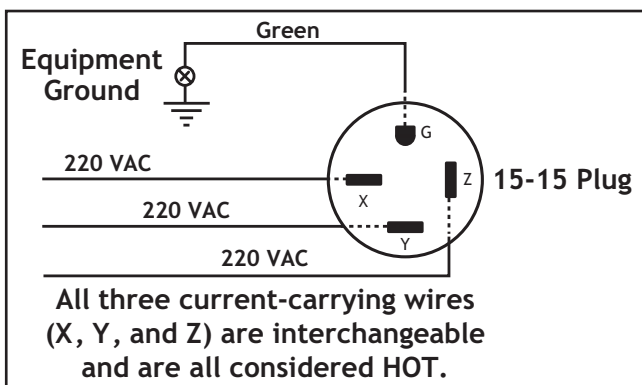
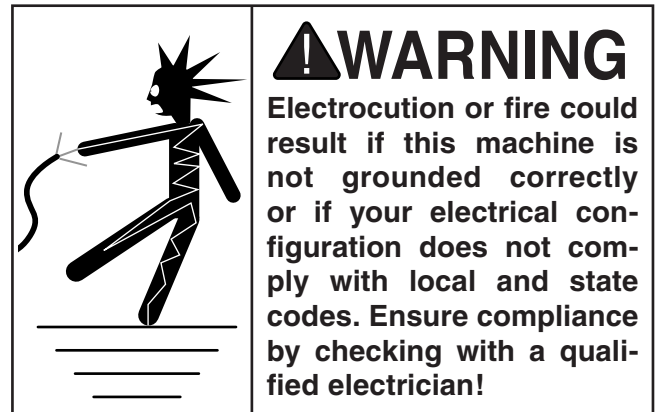


Figure 3. NEMA 15-15 plug wiring.

### Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



### Extension Cords

We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

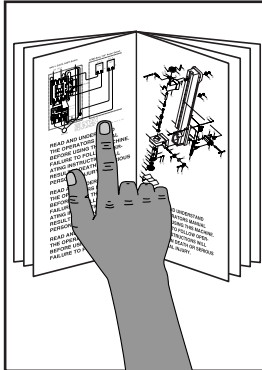
## Phase Converter

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



# SECTION 3: SET UP

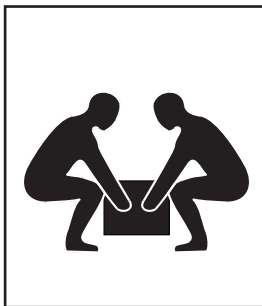
## Set Up Safety



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



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



**!WARNING**  
The Model G0483 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

## Unpacking

The Model G0483 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

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

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

## Items Needed for Set Up

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

Description	Qty
• Safety Glasses (for each person) .....	1
• Hex Wrench 19mm .....	1
• Degreaser/Solvent.....	As needed
• Shop Rags (for clean-up) .....	As needed

## Inventory

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

Inventory (Figure 4)	Qty
A. Crank Handles M12-1.75 x 12 .....	2
B. Steel Drill Sleeve MT3/MT1 .....	1
C. Steel Drill Sleeve MT3/MT2 .....	1
D. Keyless Chuck 5/8" JT6 (installed) .....	1
E. Arbor MT3/JT6 (installed).....	1
F. Drill Press (not shown) .....	1

### Hardware and Tools

Hex Wrenches 3, 4, 5, 6mm .....	1 ea.
Drift Key .....	1

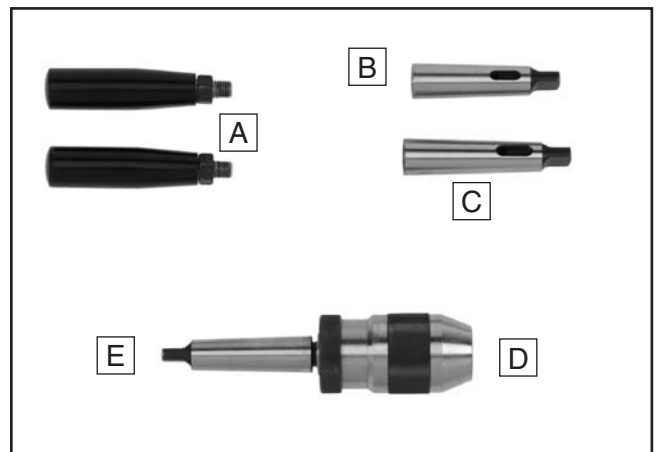



Figure 4. G0483 Inventory.

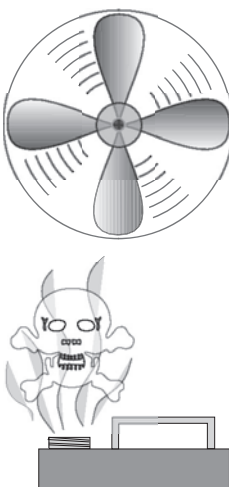
G0483 8 Speed Gear-Head Drill Press



# Clean Up

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

	<p><b>⚠️ WARNING</b> Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. <b>DO NOT</b> use gasoline or petroleum products to clean the machinery.</p>
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	<p><b>⚠️ CAUTION</b> Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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# Site Considerations

## Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

## Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 5** for the minimum working clearances.

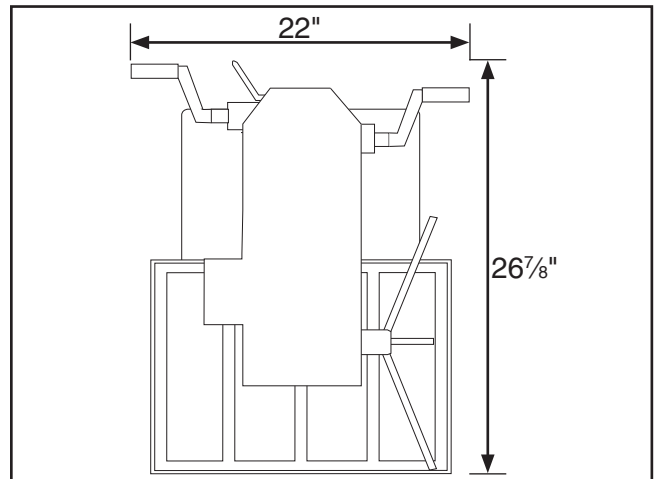


Figure 5. Minimum working clearances.

	<p><b>⚠️ CAUTION</b> Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and <b>DO NOT</b> allow unsupervised children or visitors in your shop at any time!</p>
--	--



# Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Both options are described below. Whichever option you choose, it is necessary to level your machine with a precision level.

## Bolting to Concrete Floors

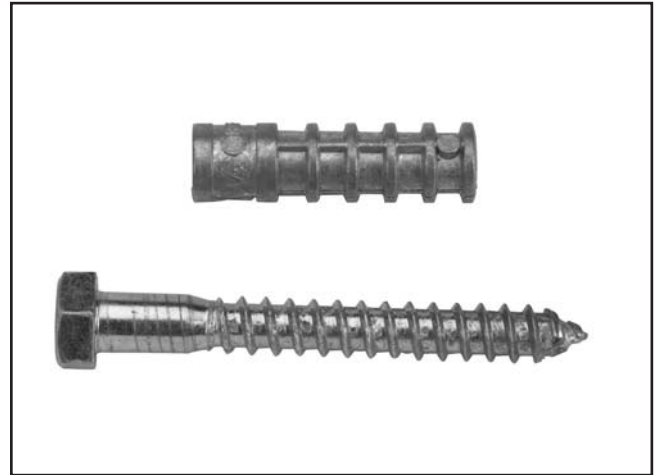
Lag shield anchors with lag bolts (**Figure 6**) and anchor studs (**Figure 7**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

### NOTICE

**Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.**

## Using Machine Mounts

Using machine mounts, shown in **Figure 8**, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine to reduce strain on the floor.



**Figure 6.** Typical lag shield anchor and lag bolt.



**Figure 7.** Typical anchor stud.



**Figure 8.** Machine mount example.



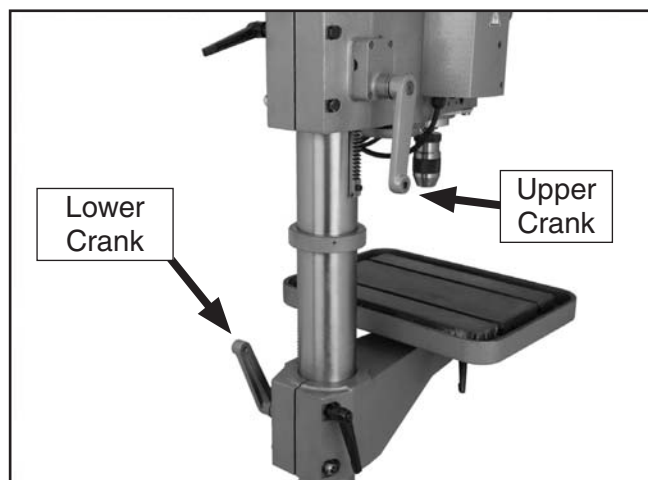
# Installing Crank Handles

The upper and lower crank handles must be installed before the drill press can be used.

**Components and Hardware Needed:** Qty  
Crank Handles M12-1.75 x 12 ..... 2

## To install the crank handles:

1. Screw a crank handle into the upper crank and lower crank, as shown in **Figure 9**.



**Figure 9.** Crank handle locations.

2. On each handle, tighten the jam nut against the crank, as shown in **Figure 10**.



**Figure 10.** Crank handle installation.

# Test Run

Once the assembly is complete, test run your machine.

If you encounter an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 23** for solutions.

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

## To test run the machine:

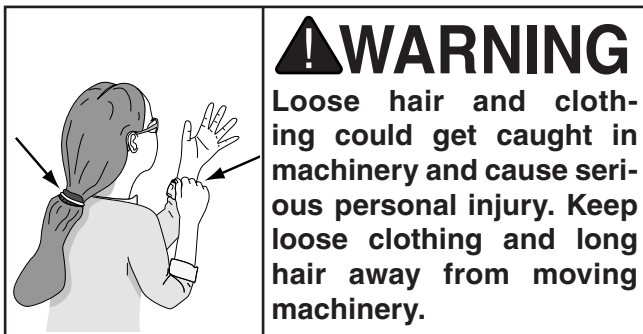
1. Connect the machine to the power source.
2. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
3. Make sure all tools and objects used during set up are cleared away from the machine.
4. Turn the machine **ON**.
5. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.



# SECTION 4: OPERATIONS

## Operational Safety



## NOTICE

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, trade magazines, and/or get formal training 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.

## Installing/Removing Drill Bits

The G0483 is equipped with a keyless chuck. This means that it can be opened and securely closed by hand with little effort. Any drill bit you install in the chuck must be tight enough that it will not come loose during operation.

### To install a drill bit:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Open the drill chuck wide enough to accept the shank of the drill bit.
3. Insert the drill bit as far as possible into the chuck **WITHOUT** allowing the chuck jaws to touch the fluted portion of the bit, and hand tighten the chuck.

**Note:** Make sure smaller drill bits are not trapped between the edges of two jaws; if they are, reinstall the drill bit or it will not be secure enough to use for drilling.

4. Once you are sure the bit is installed correctly, tighten the chuck as tight as possible.

### To remove a drill bit:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Open the drill chuck by hand, and catch the drill bit with a rag to protect your hands.



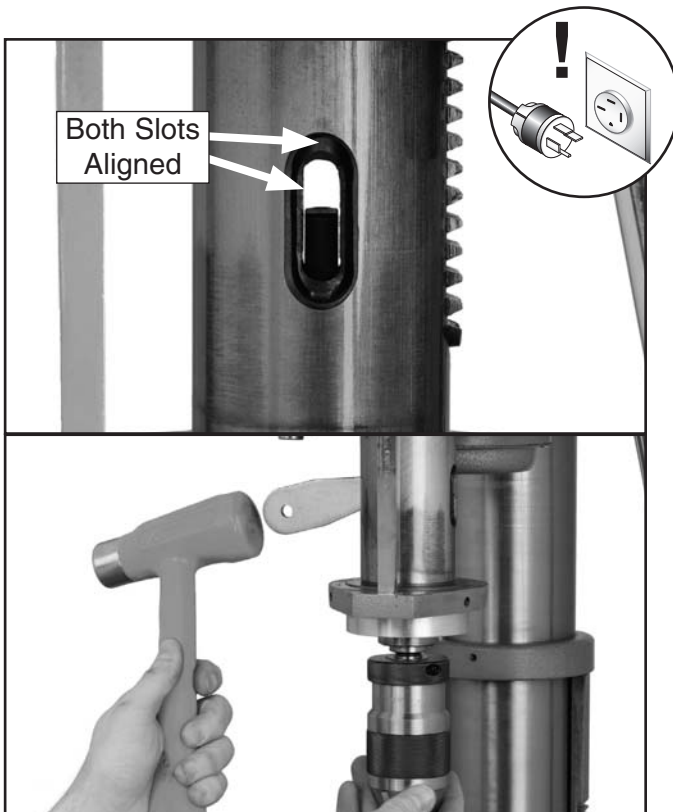


# Arbor Removal

The arbor can be removed to install other Morse Taper tooling in the spindle. A drift key is included to help remove the arbor or other tooling from the spindle. Usually, once the chuck and arbor have been properly mounted together, they are considered semi-permanent connections. (If you would like to install a different chuck, we recommend getting a new arbor for that chuck.)

## To remove the drill chuck and arbor:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Rotate the downfeed handles until the drift key slot is exposed in the side of the quill.
3. Have an assistant hold the downfeed handles in place so you can access the drift key slot in the spindle.
4. Rotate the spindle until the inner drift key slot is aligned with the outer slot, as shown in **Figure 11**. You will see through the spindle when the slot is properly aligned.



**Figure 11.** Using drift key to remove arbor.

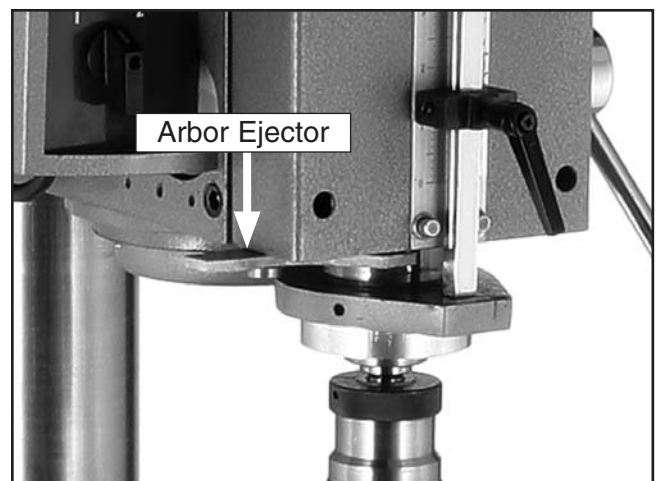
5. Insert the drift key into the drift key slot, and allow the quill to rise and trap the drift key by backing off the downfeed handles slightly.
6. Hold the drill chuck with one hand, and tap on the drift key with a rubber or wooden mallet (**Figure 11**), until the arbor releases.
7. Carefully retract the quill into the headstock.

# Arbor Ejector

The Model G0483 also comes with an automatic arbor ejector pre-installed on the machine. This is useful when quick tooling changes are essential.

## To use the automatic arbor ejector:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Disengage the arbor ejector by rotating it clear of the spindle (no part of the spindle should contact the arbor ejector when it is disengaged). The spindle will now be able to move an extra  $\frac{1}{4}$ " into the headstock.
3. With one hand holding the chuck and/or arbor, give the feed handles a sharp tug towards you. The arbor should disengage and come free of the spindle.
4. If the arbor remains mounted in the spindle, repeat **Step 3** or eject the arbor using the **Arbor Removal** steps on this page.



**Figure 12.** Arbor ejector.



# Using Steel Drill Sleeves

The G0483 also comes with two steel drill sleeves, used for installing MT1 or MT2 taper tooling, such as tapered drill bits.

## To install a tool into a steel drill sleeve:

1. Ensure both the drill bit taper and the inside of the drill sleeve are clean and free of grit, oil, dust, and other debris that could prevent a good fit.
2. Insert the tapered end of the tool into the socket in the drill sleeve while slowly rotating the tool, as shown in **Figure 13**. The sleeve has a rectangular pocket where the tang of the tool fits into.
3. Once the tool has slotted into the sleeve correctly, apply slight force to mate the tool and the sleeve and to ensure a good fit.

## CAUTION

Certain drill press tooling such as drill bits may have sharp edges which can cut skin. Always handle potentially dangerous tooling carefully, and wear safety gloves if necessary.



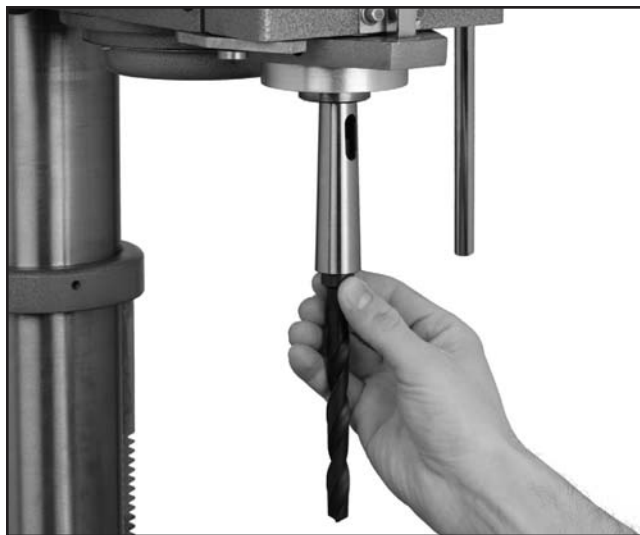
**Figure 13.** Installing tapered tooling into a drill sleeve.

# Installing Steel Drill Sleeves

The spindle can also accept mated drill sleeves and tapered tooling, or MT3 tapered tooling without a drill sleeve. If using MT3 tapered tooling, simply follow the steps below with the MT3 tooling in place of the mated sleeve and tooling.

## To install a steel drill sleeve into the spindle:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Slide the mated drill sleeve and tooling into the spindle socket while slowly rotating the tool as shown in **Figure 14**. The socket has a rectangular pocket where the tang of the sleeve fits into.
3. Once the drill sleeve has slotted into the spindle correctly, apply slight force to mate the sleeve and the spindle and to ensure a good fit.



**Figure 14.** Installing mated tooling into drill press.



# Choosing Speeds

## Using the Drill Bit Speed Chart

The chart shown in **Figure 15** is intended as a guide only. Always follow manufacturer's speed recommendations if provided with your drill bits, cutters, or hole saws. Exceeding the recommended speeds may be dangerous to the operator.

The speeds shown here are intended to get you started. The optimum speed will always depend on various factors, including tool diameter, drilling pressure, material hardness, material quality, and desired finish.

Often, when drilling materials other than wood, some type of lubrication is necessary.

## Lubrication Suggestions

Wood .....None  
 Plastics ..... Soapy Water  
 Brass ..... Water-Based Lubricant  
 Aluminum.....Paraffin-Based Lubricant  
 Mild Steel.....Oil-Based Lubricant

**⚠ CAUTION**

**Larger bits turning at slower speeds tend to grab the workpiece aggressively. This can result in the operator's hand being pulled into the bit or the workpiece being thrown with great force. Always clamp the workpiece to the table to prevent injuries.**

Twist/Brad Point Drill Bits	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/16" – 3/16"	3000	2500	2500	2500	3000	2500
13/64" – 3/8"	2000	1500	2000	1250	2500	1250
25/64" – 5/8"	1500	750	1500	750	1500	600
11/16" – 1"	750	500	1000	400	1000	350
Spade/Forstner Bits	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/4" – 1/2"	2000	1500				
9/16" – 1"	1500	1250				
1-1/8" – 1-7/8"	1000	750				
2–3"	500	350				
Hole Saws	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/2" – 7/8"	500	500	600	600	600	500
1" – 1-7/8"	400	400	500	500	500	400
2" – 2-7/8"	300	300	400	400	400	300
3" – 3-7/8"	200	200	300	300	300	200
4" – 5"	100	100	200	200	200	100
Rosette Cutters	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
Carbide Insert Type	350	250				
One-Piece Type	1800	500				
Tenon/Plug Cutters	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
3/8" – 1/2"	1200	1000				
5/8" – 1"	800	600				

Figure 15. Drill bit speed chart.



# Drilling

---

The Model G0483 is designed for drilling holes in wood, plastics or metal. The basic operation of a drill press is lining up your drill bit with the intended hole location, turning the drill press **ON**, and using the down feed levers to move the spinning drill bit into the workpiece.

**For safe operation and optimum results, it is very important to follow these guidelines when drilling:**

**CLEARING CHIPS:** Raise the drill bit often to clear chips and cool the drill bit. This will ease the work of the drill press motor and extend the life of your drill bits.

**SECURING WORKPIECE TO TABLE:** Secure the workpiece to the table or in a vise that is secured to the table before drilling.

**PROTECTING TABLE:** Protect the table by placing the workpiece on scrap wood. Also, make use of the depth stop so that the drill bit goes no deeper than necessary.

**USING CORRECT SPEEDS:** Use the correct speed for the diameter of the drill bit being used and the type of material being drilled. Refer to the **Drill Bit Speed Chart** on **Page 17** to help you choose the correct speed for your application.

**LARGE DIAMETER BITS:** Large diameter drill bits require slower spindle speeds.

**SMALL DIAMETER BITS:** Smaller diameter drill bits require faster spindle speeds.

**HARD MATERIAL:** The harder the material, (steel vs. wood) the slower the spindle speed.

**SOFT MATERIAL:** The softer the material, the faster the spindle may turn. (Plastics can melt at too high of a spindle speed!)

**LUBRICANT:** Use some form of lubricant on all materials except wood. Refer to **Lubrication Suggestions** on **Page 17** to find the correct lubrication for your application.

**DRILLING ACCURACY:** To prevent drill bit wandering and ensure accurate placement of holes, mark the hole location with a center punch before drilling. Also consider using a center-point drill to start the hole.

**PLUG/ROSETTE CUTTERS:** Plug cutters and rosette cutters are for wood only. However, carbide-tipped bits and cutters cut at a higher speed and can cut materials other than wood, depending on the cutter type.

**5-FLUTE/2-FLUTE CUTTERS:** Use a 5-flute cutter when cutting into plastics, brass, aluminum, and mild steel. A 2-flute cutter can aggressively grab the workpiece and damage the tool if used with materials other than wood.

**SPADE BITS AND PLASTIC:** When drilling plastic with a spade bit, use a spade bit with spurs.

**HOLE SAWS:** When using hole saws, apply firm and even pressure, so the saw teeth contact the surface all at the same time—not at an angle. You can also flip the workpiece and finish cutting from the other side.

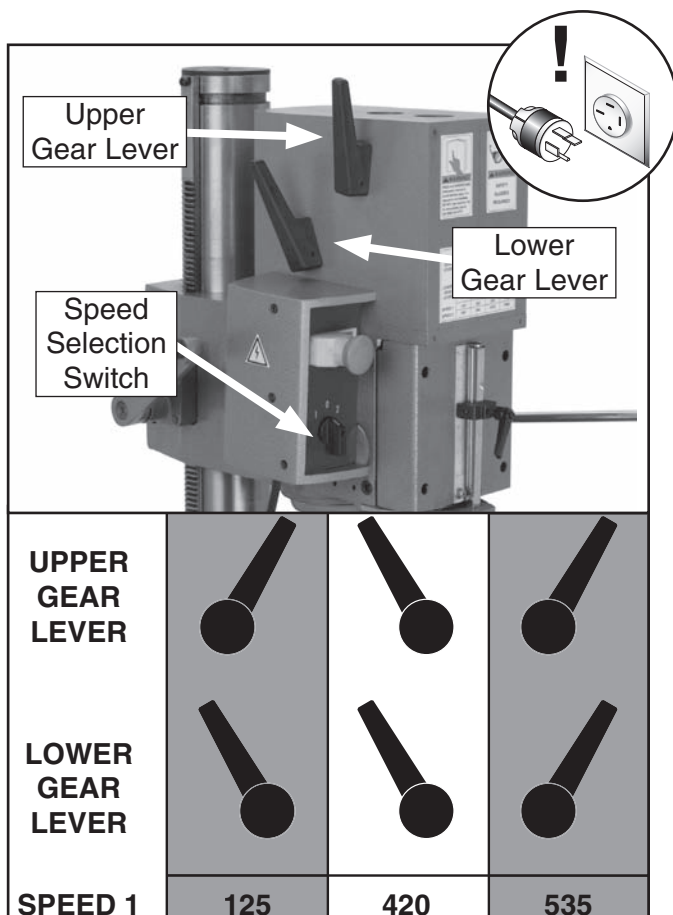


# Changing Speeds

The drill press speed can be adjusted by changing the lever positions on the side of the headstock. **Figure 16** shows an example speed setting and the corresponding speed chart diagram.

## To change speeds:

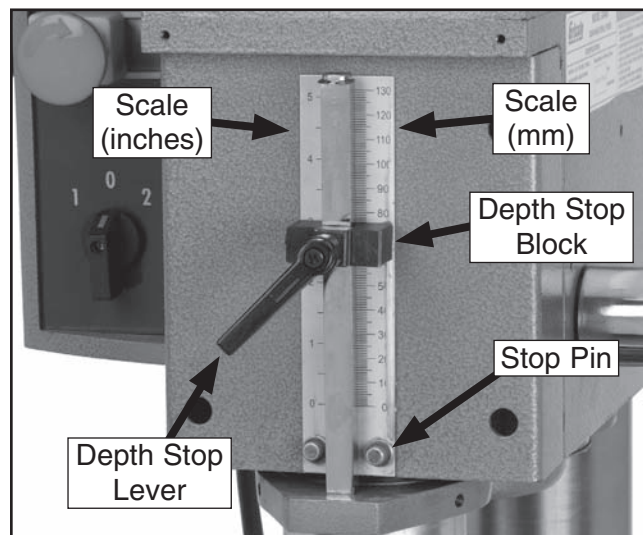
1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Find the desired speed and the corresponding speed selection switch setting on the chart at the front of the machine.
3. Move the speed selection switch to either the '1' or '2' position, depending on the desired speed.
4. Move the gear levers to the positions indicated on the chart. You may need to rotate the tooling or chuck by hand to get the gears to engage properly.



**Figure 16.** Lever combination for 420 RPM.

# Depth Stop

The Model G0483 has a depth stop that allows you to drill repeated non-through holes to the same depth every time. **Figure 17** shows the various components of the depth stop.



**Figure 17.** Depth stop components.

## To set the depth stop:

1. Loosen the depth stop lever by turning it counterclockwise.
2. Lower the drill bit to the required height.
3. Slide the depth stop block down until it hits the stop pins.
4. Tighten the depth stop lever.

**Note:** The depth stop block can move out of place slightly with repeated use or if the depth stop lever is not tightened enough. Always check the depth stop position before performing non-through drilling operations.

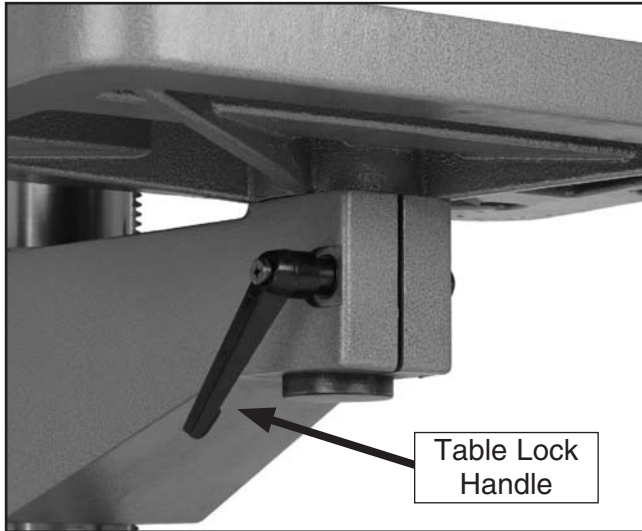


# Table Adjustments

The table can be raised/lowered, rotated 360° around the column, and independently rotated 80°. **Figures 18 & 19** show adjustment controls.

## Independent Table Rotation

1. Loosen the table lock handle.

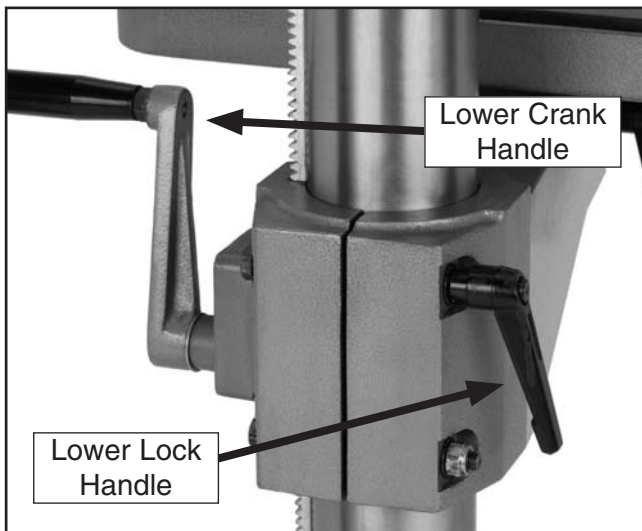


**Figure 18.** Handle for table rotation.

2. Rotate the table to the desired angle.
3. Tighten the table lock handle.

## Table Height and Column Rotation

1. Loosen the lower lock handle.



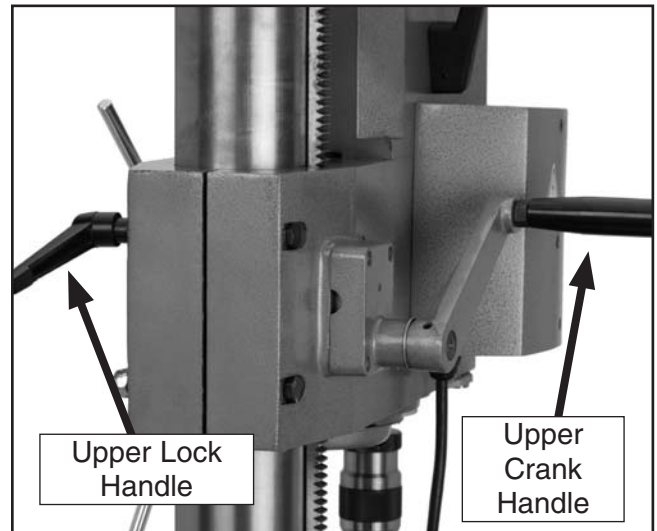
**Figure 19.** Table adjustment controls (rear view).

2. Adjust the height by turning the lower crank handle.
3. Adjust the rotation around the column if desired.
4. Tighten the lower lock handle.

# Headstock Adjustments

The headstock can be raised and lowered, and rotated 360° around the column. **Figure 20** shows adjustment controls.

1. Loosen the upper lock handle.



**Figure 20.** Headstock adjustment controls (rear view).

2. Adjust the height by turning the upper crank handle.
3. Adjust the rotation around the column if desired.
4. Tighten the upper lock handle.



# SECTION 5: ACCESSORIES

**G8865— $\frac{1}{16}$ " - $\frac{1}{4}$ " Cobalt Alloy Drill Bits 13-PC. Set**

**G8866— $\frac{1}{16}$ "-  $\frac{3}{8}$ " Steelex® Cobalt Alloy Drill Bits 21-PC Set**

**G8867— $\frac{1}{16}$ "- $\frac{1}{2}$ " Steelex® Cobalt Alloy Drill Bits 29-PC Set**

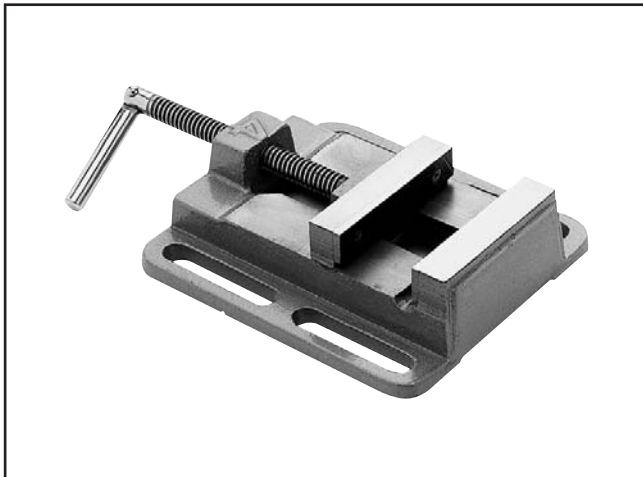
Cobalt Alloy bits will retain their edge sharpness longer than normal HSS bits, resulting in a significant saving of time and money in the workshop. Includes a heavy-gauge steel index case.



**Figure 21.** Model G8865 13-PC Alloy Drill Bits.

**G5753—Drill Press Vise 6"**

If you use a drill press and value your fingers, you need one of these. Made from high-grade cast iron, these hefty horizontal vises offer support and stability, allowing you to keep your hands well away from fast moving bits and cutters.



**Figure 22.** Model G5753 Drill Press Vise 6".

**G7984—Face Shield**

**H1298—Dust Sealed Safety Glasses**

**H1300—UV Blocking, Clear Safety Glasses**

**H2347—Uvex® Spitfire Safety Glasses**

**H0736—Shop Fox® Safety Glasses**

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



**Figure 23.** Our most popular safety glasses.

**G2500—20-PC Regular Sanding Drum Set**

Use on your drill press, lathe, or hand drill. This kit consists of 5 drums in popular  $\frac{1}{2}$ " x  $\frac{1}{2}$ ",  $\frac{3}{4}$ " x 1", 1" x 1",  $1\frac{1}{2}$ " x  $1\frac{1}{2}$ ", and 2" x  $1\frac{1}{2}$ " sizes. Comes with 50, 80 and 120 grit sizes for each drum.



**Figure 24.** Model G2500 Sanding Drum Set.

**Call 1-800-523-4777 To Order**



# SECTION 6: MAINTENANCE



## Schedule

Regular periodic maintenance on your drill press will ensure optimum performance. Make a habit of inspecting your machine each time you use it. Check for the following conditions and repair or replace when necessary:

- Loose mounting bolts.
- Loose or damaged arbor or chuck.
- Worn switch.
- Worn or damaged cords, plugs, or connections.
- Any other condition that could hamper the safe operation of this machine.

## Cleaning

Cleaning the Model G0483 is relatively easy. Vacuum or brush off any waste or excess material, and wipe off any remaining fine material with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

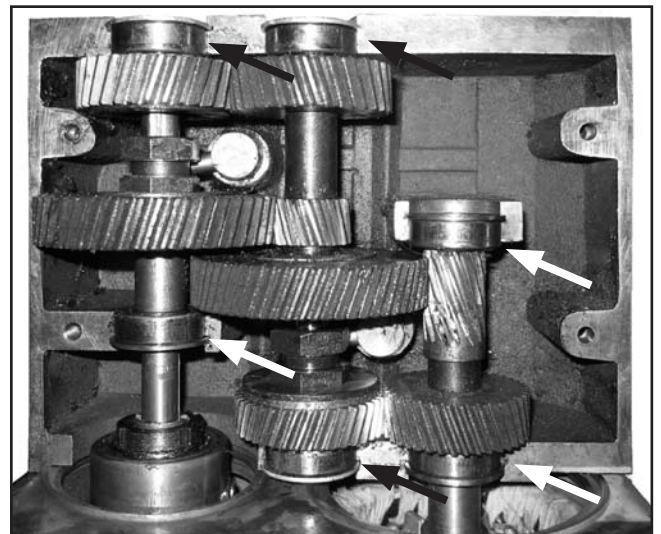
Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Section 5: Accessories on **Page 21** for more details).

## Lubrication

The gearbox of the Model G0483 needs to be lubricated regularly to maintain smooth gear operation.

**To lubricate the gearbox:**

1. Remove the four M8-1.25 x 20 cap screws from the right-hand side of the gearbox, and the two M6-1 x 20 cap screws from the front and rear of the right-hand side cover.
2. Carefully remove the right-hand side cover, taking care not to dislodge any bearing covers. If a bearing cover becomes dislodged, put it back in position before proceeding.
3. Liberally paint the gears and bearings with an automotive-grade high-temperature wheel bearing grease. **Figure 25** shows the inside of the G0483 gearbox, with bearing locations indicated.



**Figure 25.** G0483 gearbox bearing locations.





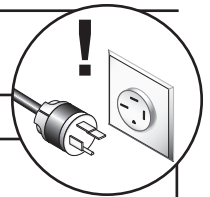
# SECTION 7: SERVICE

## About Service

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If you need help troubleshooting, you need replacement parts, or you are unsure of how to perform the procedures in this section, then feel free to call our Technical Support at (570) 546-9663.

## Troubleshooting

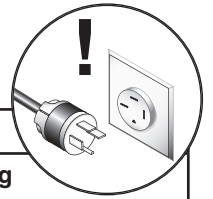
### Motor & Electrical



Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>1. Plug or receptacle is at fault or wired incorrectly.</li> <li>2. Motor connection wired incorrectly.</li> <li>3. Power supply is faulty.</li> <li>4. ON/OFF switch is faulty.</li> <li>5. Cable/wiring is at fault.</li> <li>6. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Test power plug/receptacle for good contact and correct wiring.</li> <li>2. Correct motor wiring (see <b>Page 26</b>).</li> <li>3. Make sure all hot lines and grounds are operational and have correct voltage on all legs.</li> <li>4. Replace faulty switch.</li> <li>5. Troubleshoot wires for internal/external breaks, check for disconnected/corroded connections and repair/replace wiring.</li> <li>6. Test, repair or replace motor.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Incorrect spindle speed for task.</li> <li>2. Bit or cutter is too large for task.</li> <li>3. Bit or cutter is dull.</li> <li>4. Gears not meshing correctly.</li> <li>5. Plug or receptacle is at fault.</li> <li>6. Motor connection wired incorrectly.</li> <li>7. Motor has overheated.</li> <li>8. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease spindle speed.</li> <li>2. Use smaller drill bits/cutters. Reduce feed rate and spindle speed.</li> <li>3. Sharpen/replace bit or cutter.</li> <li>4. Re-engage the gears by following the <b>Changing Speeds</b> steps on <b>Page 19</b>.</li> <li>5. Test power plug/receptacle for good contact and correct wiring.</li> <li>6. Correct motor wiring (see <b>Page 26</b>).</li> <li>7. Clean inside/outside of motor, let cool, and reduce machine workload.</li> <li>8. Test, repair or replace motor.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor or component is loose.</li> <li>2. Gears are not meshing correctly.</li> <li>3. Motor fan rubbing on fan cover.</li> <li>4. Machine incorrectly mounted to floor, or floor is uneven.</li> <li>5. Chuck or cutter is at fault.</li> <li>6. Motor bearings are at fault.</li> <li>7. Spindle bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect, replace for damaged bolts/nuts and retighten with thread locking fluid.</li> <li>2. Re-engage the gears by following the <b>Changing Speeds</b> steps on <b>Page 19</b>.</li> <li>3. Replace/repair dented fan cover; replace loose/damaged fan.</li> <li>4. Make sure floor mounting hardware is tight; place shims under machine.</li> <li>5. Replace out-of-round chuck, replace or resharpen cutter; use appropriate feed rate and cutting RPM.</li> <li>6. Check bearings, replace motor or bearings as required.</li> <li>7. Replace bearing.</li> </ol>



## Drill Press Operations



Symptom	Possible Cause	Possible Solution
Drilling stops, but the motor still operates.	<ol style="list-style-type: none"> <li>1. Gears are not meshed together.</li> <li>2. Bit slips in chuck, or tapered tooling is poorly seated.</li> <li>3. Drive system at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-engage the gears by following the <b>Changing Speeds</b> steps on <b>Page 19</b>.</li> <li>2. Tighten bit or re-seat tooling; inspect bit for burrs or other obstructions that might interfere with clamping or mating surface.</li> <li>3. Replace broken/faulty gear, key, or shaft</li> </ol>
Chuck wobbles or is loose on spindle shaft.	<ol style="list-style-type: none"> <li>1. Foreign material stuck between the chuck-to-spindle mating surface.</li> <li>2. Damaged chuck.</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove the chuck and clean and de-burr the tapered chuck and spindle mating surfaces, then reassemble.</li> <li>2. Replace.</li> </ol>
The spindle does not retract completely or spindle binds.	<ol style="list-style-type: none"> <li>1. The quill shaft is gummy with sawdust and oil.</li> <li>2. The quill deflection screw is binding the quill.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean the gummy substance with penetrating oil and lubricate with a light coat of oil.</li> <li>2. Loosen jam nut, and slightly turn out screw where the quill binds. Retighten jam nut and recheck for binding and looseness at all spindle locations.</li> </ol>
Excessive quill deflection.	<ol style="list-style-type: none"> <li>1. The quill shaft is at fault.</li> <li>2. The quill and/or bearings are worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust the quill screw.</li> <li>2. Replace the quill and/or bearings.</li> </ol>
Drill bit wobbles, holes are oversized.	<ol style="list-style-type: none"> <li>1. Drill bit installed incorrectly.</li> <li>2. Faulty/bent drill bit.</li> <li>3. Workpiece is not secured properly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove drill bit and reinstall.</li> <li>2. Replace faulty/bent bit.</li> <li>3. Resecure workpiece and vise.</li> </ol>



# Electrical Components

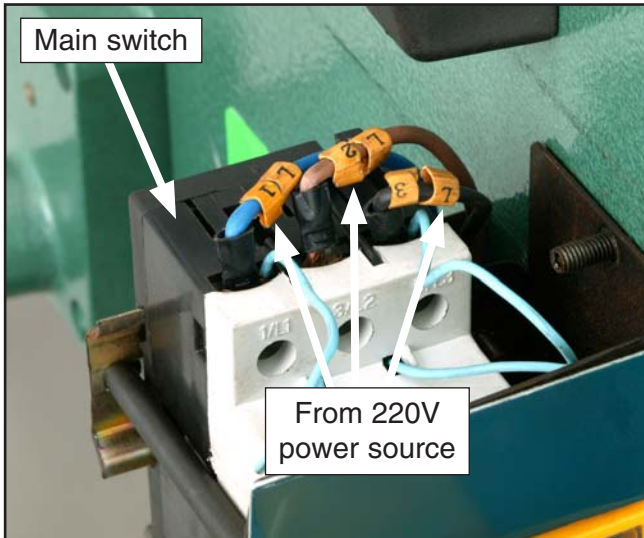


Figure 26. Top of main switch.

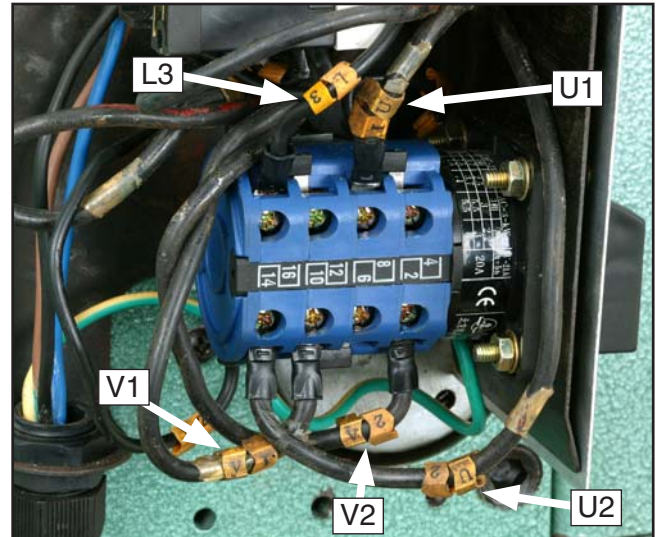


Figure 28. Left side of speed selector switch.

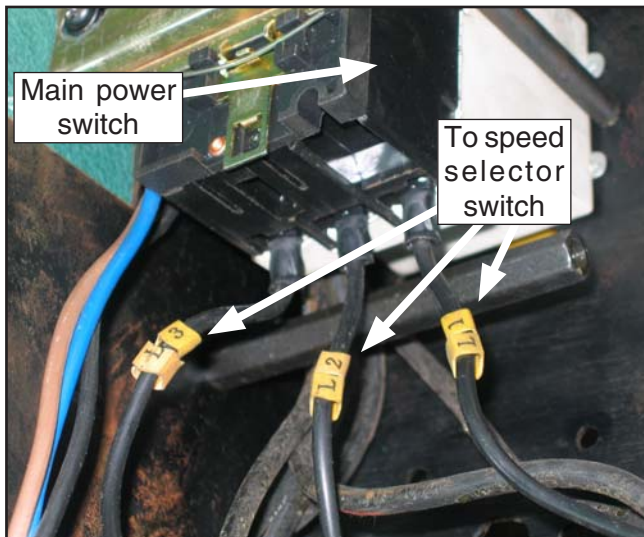


Figure 27. Bottom of main switch.

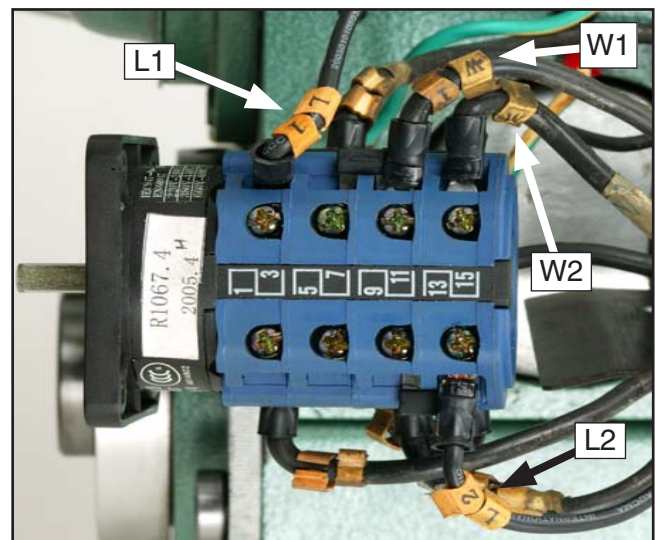
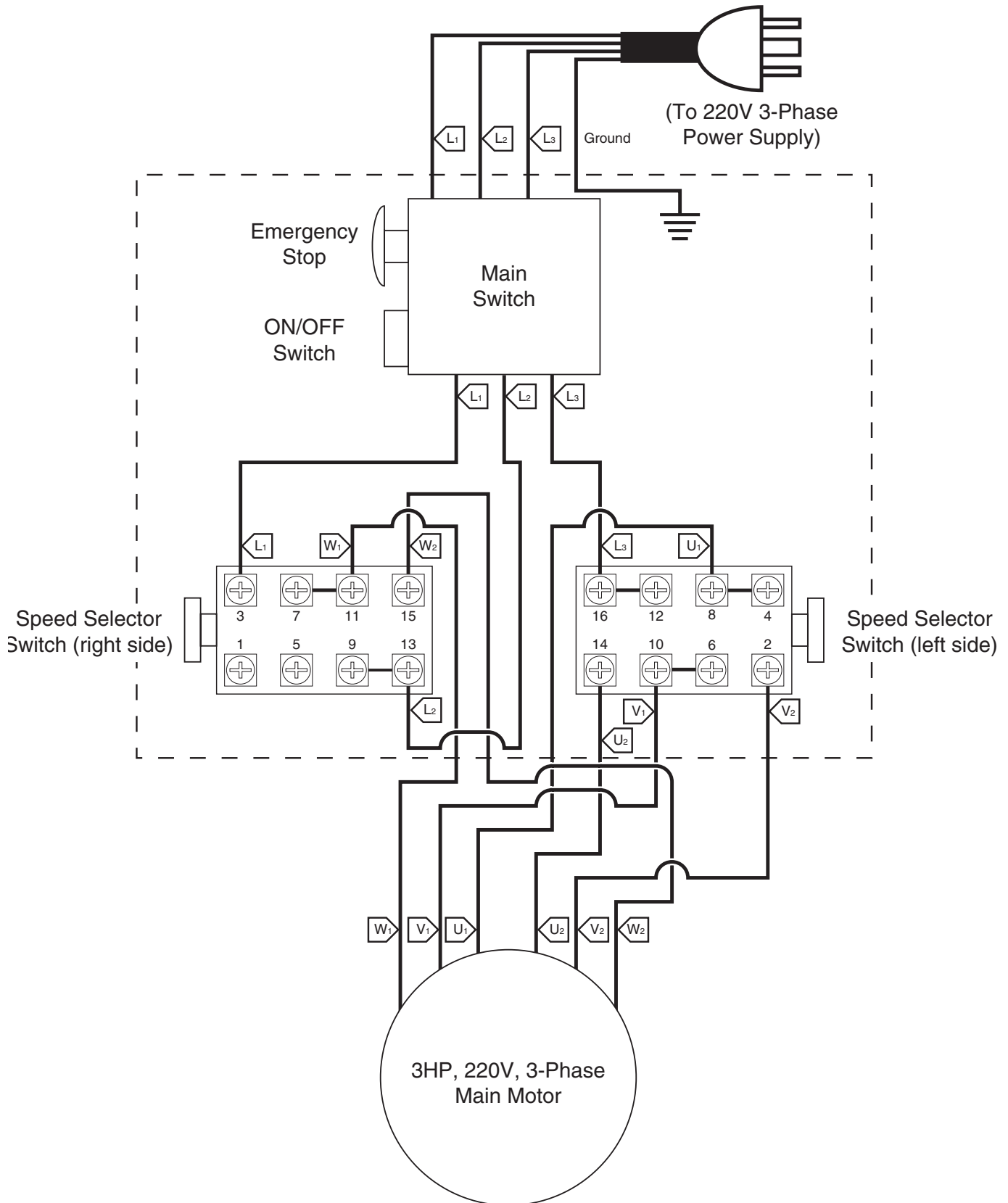


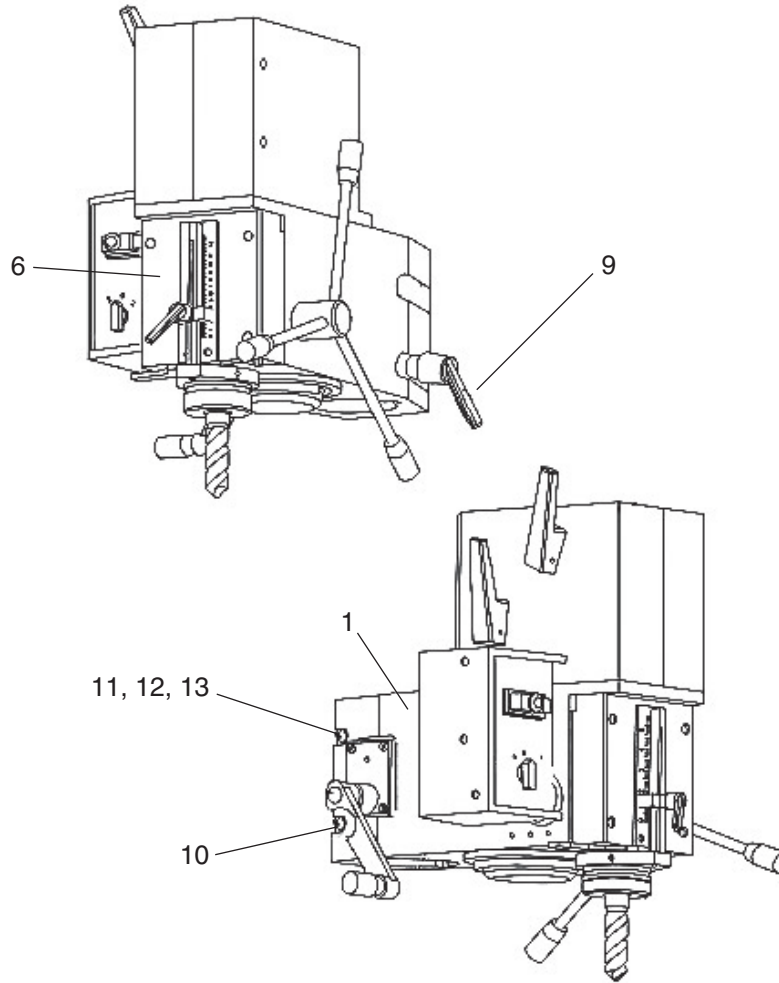
Figure 29. Right side of speed selector switch.



# Wiring Diagram



# Headstock Breakdown and Parts List

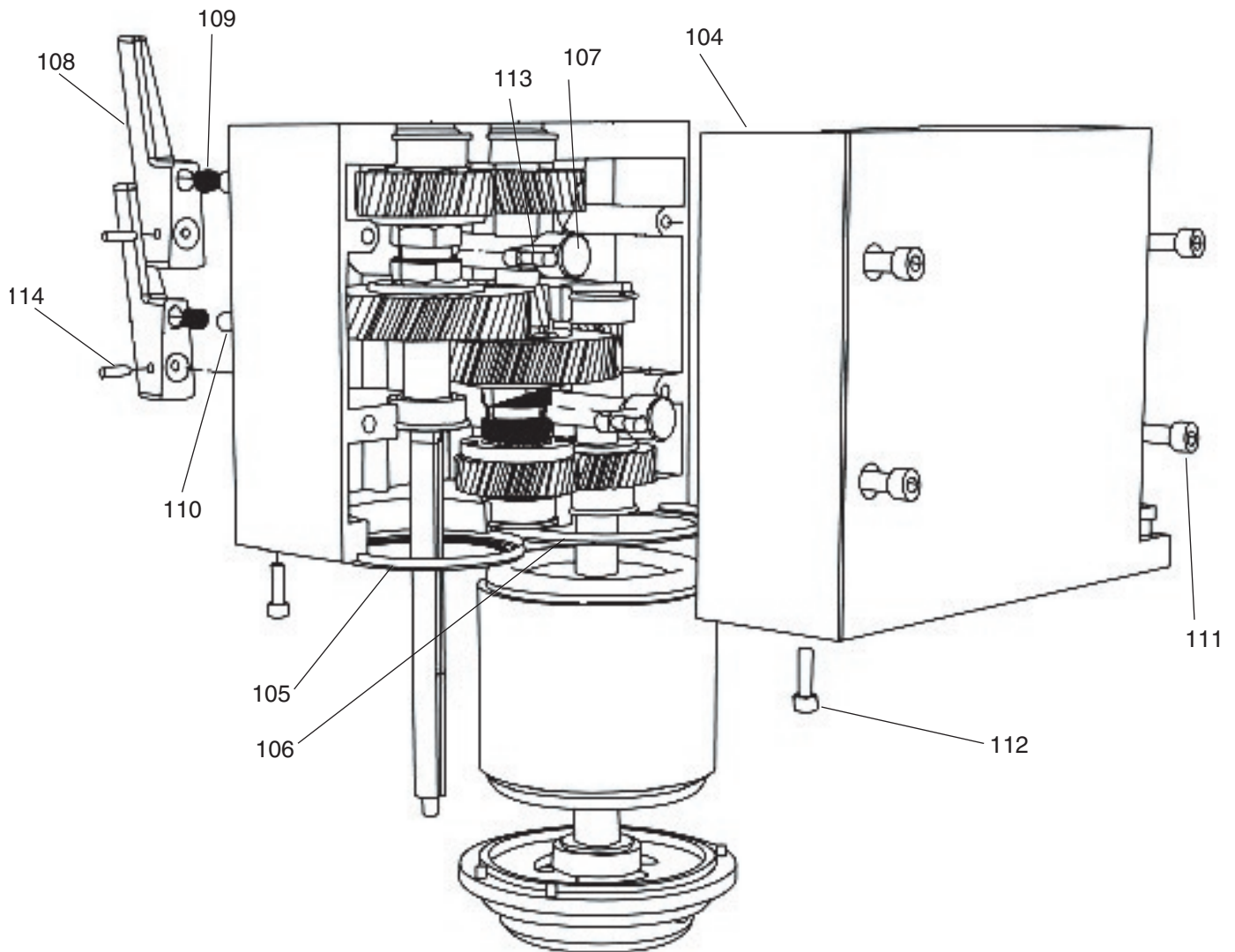


REF	PART #	DESCRIPTION
1	P0483001	SPINDLE HOUSING
6	P0483006	FRONT COVER
9	P0483009	LOCKING LEVER
10	PB143M	HEX BOLT M12-1.75 X 120

REF	PART #	DESCRIPTION
11	PB157M	HEX BOLT M12-1.75 X 130
12	PLN09M	LOCK NUT M12-1.75
13	PW06M	FLAT WASHER 12MM



# Gearbox Breakdown and Parts List

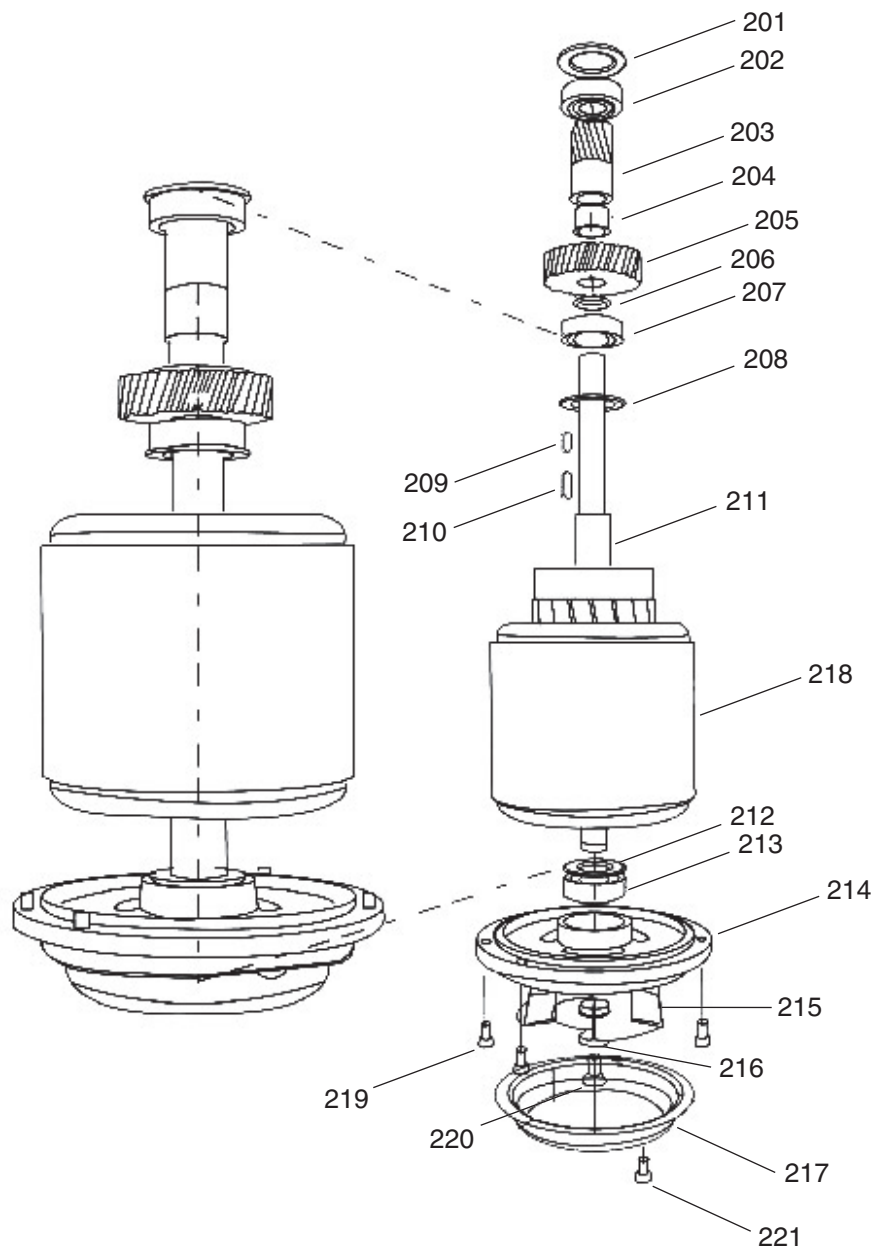


REF	PART #	DESCRIPTION
104	P0483104	GEAR BOX COVER
105	P0483105	RING 100 x 5.5
106	P0483106	RING 130.5 x 5.5
107	P0483107	GEAR SELECTOR ARM
108	P0483108	GEAR LEVER
109	P0483109	COMPRESSION SPRING

REF	PART #	DESCRIPTION
110	P0483110	STEEL BALL 8MM
111	PSB14M	CAP SCREW M8-1.25 X 20
112	PSB02M	CAP SCREW M6-1 X 20
113	P0483113	SHIFT PIN
114	PRP88M	ROLL PIN 5 X 22



# Motor Breakdown and Parts List

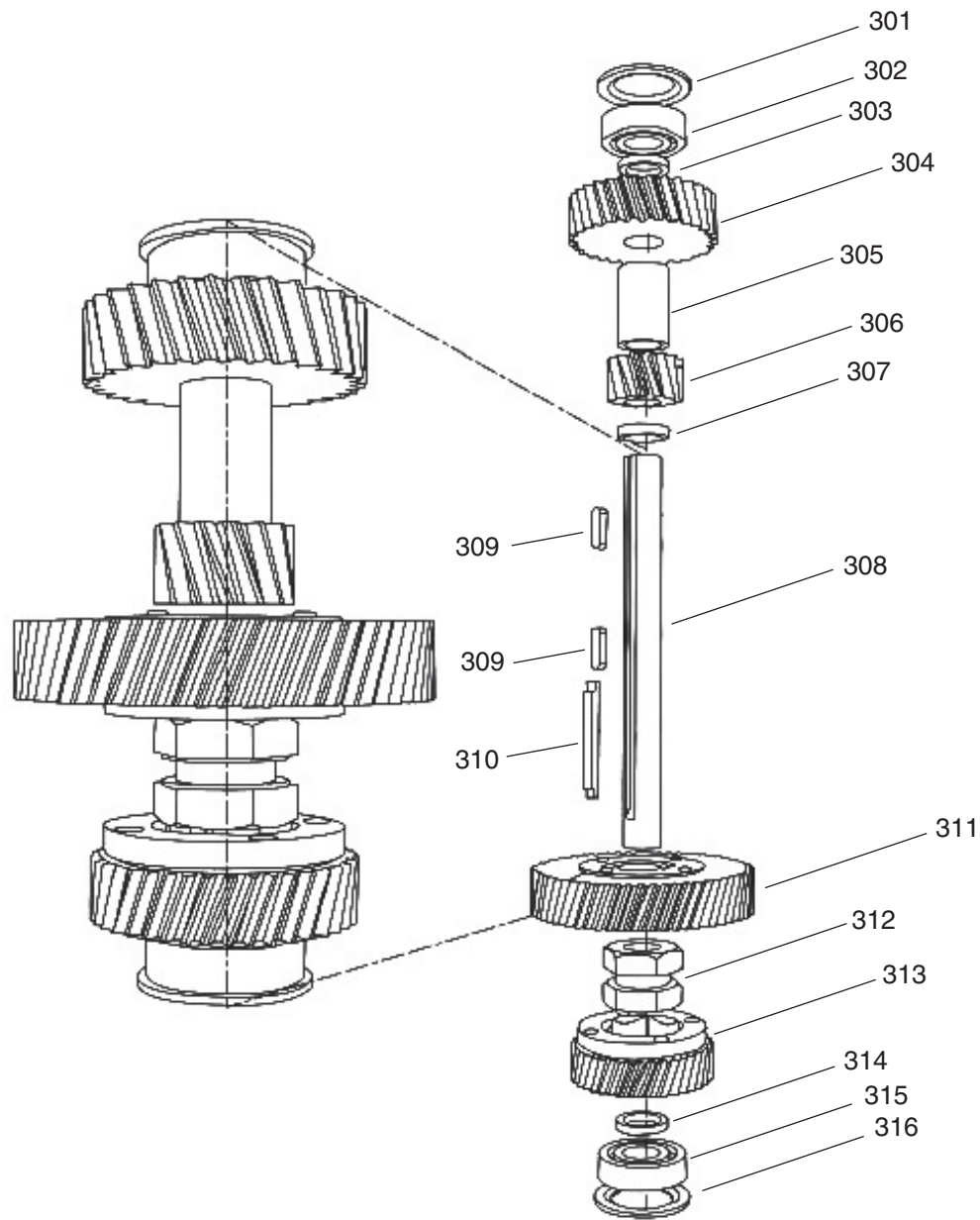


REF	PART #	DESCRIPTION
201	P0483201	BEARING COVER
202	P6203	BALL BEARING 6203
203	P0483203	GEAR
204	P0483204	SPACING SLEEVE
205	P0483205	GEAR
206	P0483206	SPACING SLEEVE
207	P6203	BALL BEARING 6203
208	P0483208	BEARING COVER
209	P0483209	KEY 5 X 5 X 14
210	P0483210	KEY 5 X 5 X 20
211	P0483211	ROTOR

REF	PART #	DESCRIPTION
212	P0483212	FLAT WASHER 17MM
213	P6203	BALL BEARING 6203
214	P0483214	FAN HOUSING
215	P0483215	FAN
216	PW05M	FLAT WASHER 4MM
217	P0483217	FAN COVER
218	P0483218	STATOR
219	PSB50M	CAP SCREW M5-.8 X 10
220	PS07M	PHLP HD SCR M4-.7 X 8
221	PSB18M	CAP SCREW M4-.7 X 8



# Rear Shaft Breakdown and Parts List



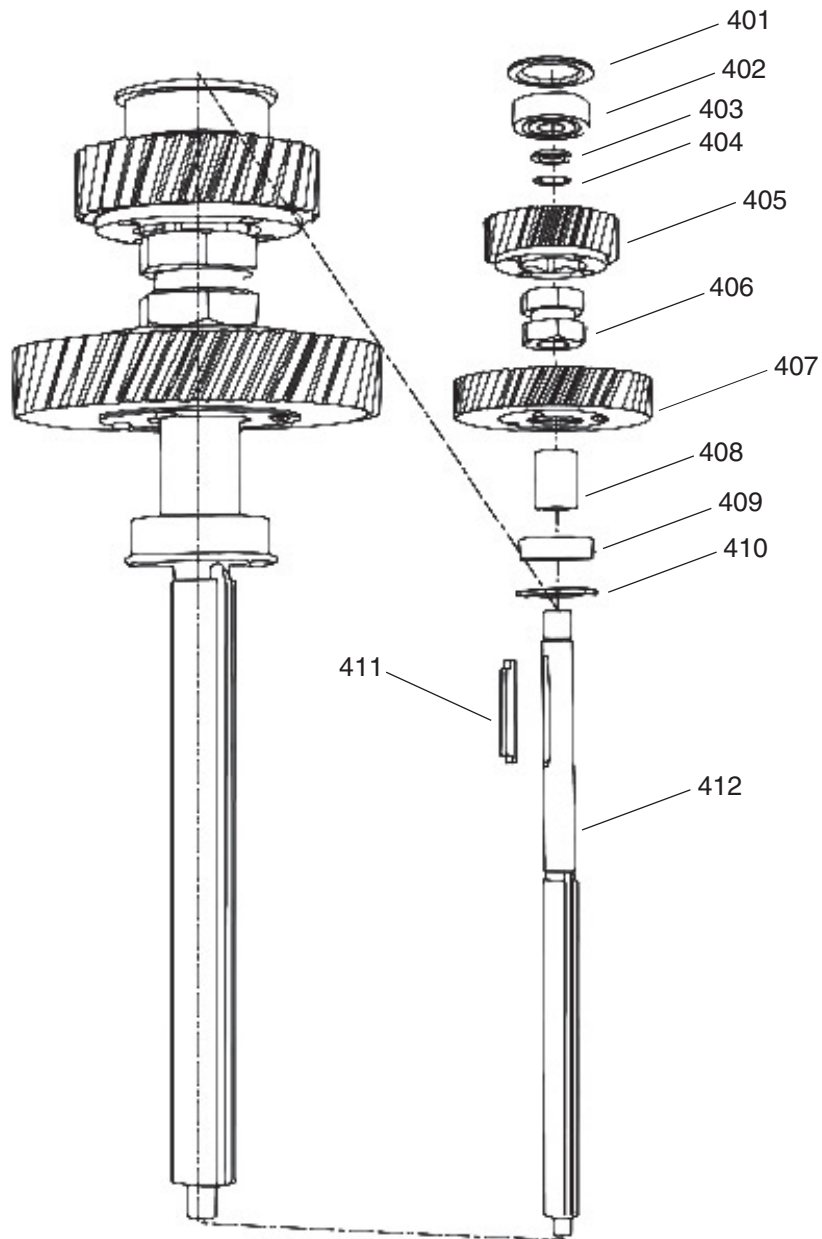
REF	PART #	DESCRIPTION
301	P0483301	BEARING COVER
302	P6203	BALL BEARING 6203
303	P0483303	SPACING SLEEVE 17 X 3.5
304	P0483304	GEAR
305	P0483305	SPACING SLEEVE 17 X 38
306	P0483306	GEAR
307	P0483307	SPACING SLEEVE 17 X 5
308	P0483308	AXLE

REF	PART #	DESCRIPTION
309	PK34M	KEY 5 X 5 X 20
310	PK112M	KEY 5 X 5 X 55
311	P0483311	GEAR
312	P0483312	CLUTCH
313	P0483313	GEAR
314	P0483314	SPACING SLEEVE 17 X 3.5
315	P6203	BALL BEARING 6203
316	P0483316	BEARING COVER





# Front Shaft Breakdown and Parts List

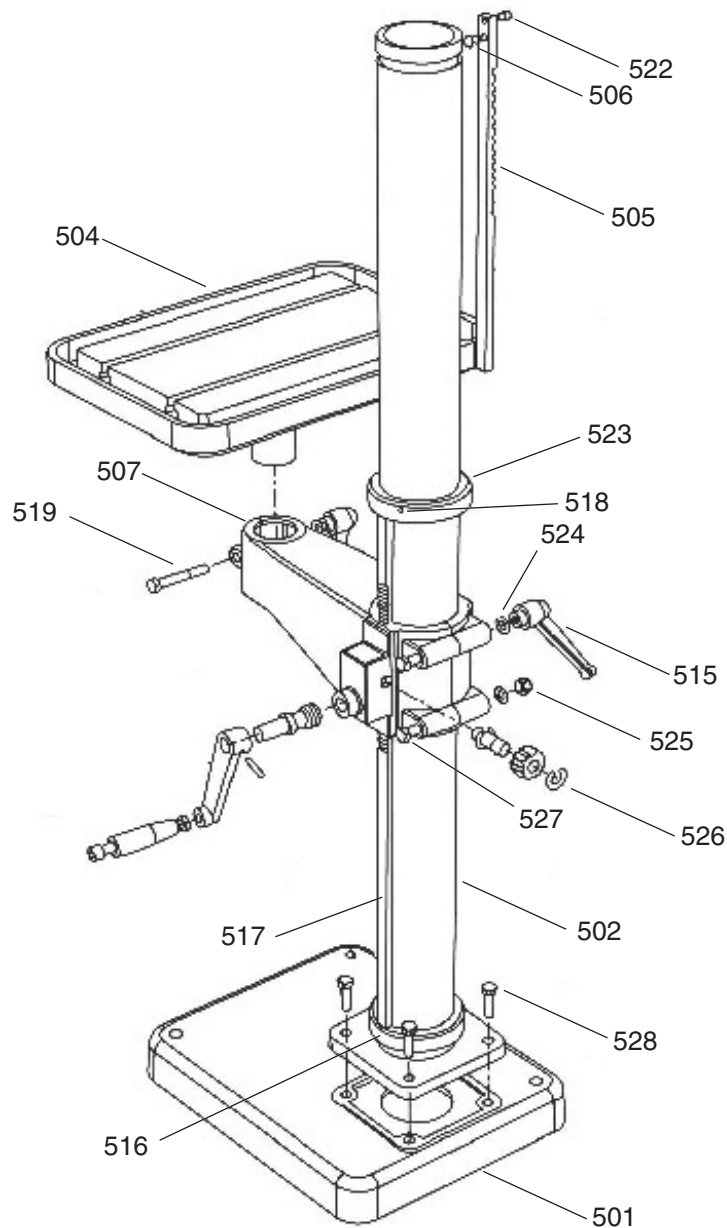


REF	PART #	DESCRIPTION
401	P0483401	BEARING COVER
402	P6302	BEARING 6302
403	P0483403	SPACING SLEEVE
404	PR05M	EXT RETAINING RING 15MM
405	P0483405	GEAR
406	P0483406	CLUTCH

REF	PART #	DESCRIPTION
407	P0483407	GEAR
408	P0483408	SPACING SLEEVE 17 X 31.5
409	P6203	BALL BEARING 6203
410	P0483410	BEARING COVER
411	PK112M	KEY 5 X 5 X 55
412	P0483412	AXLE



# Column Breakdown and Parts List

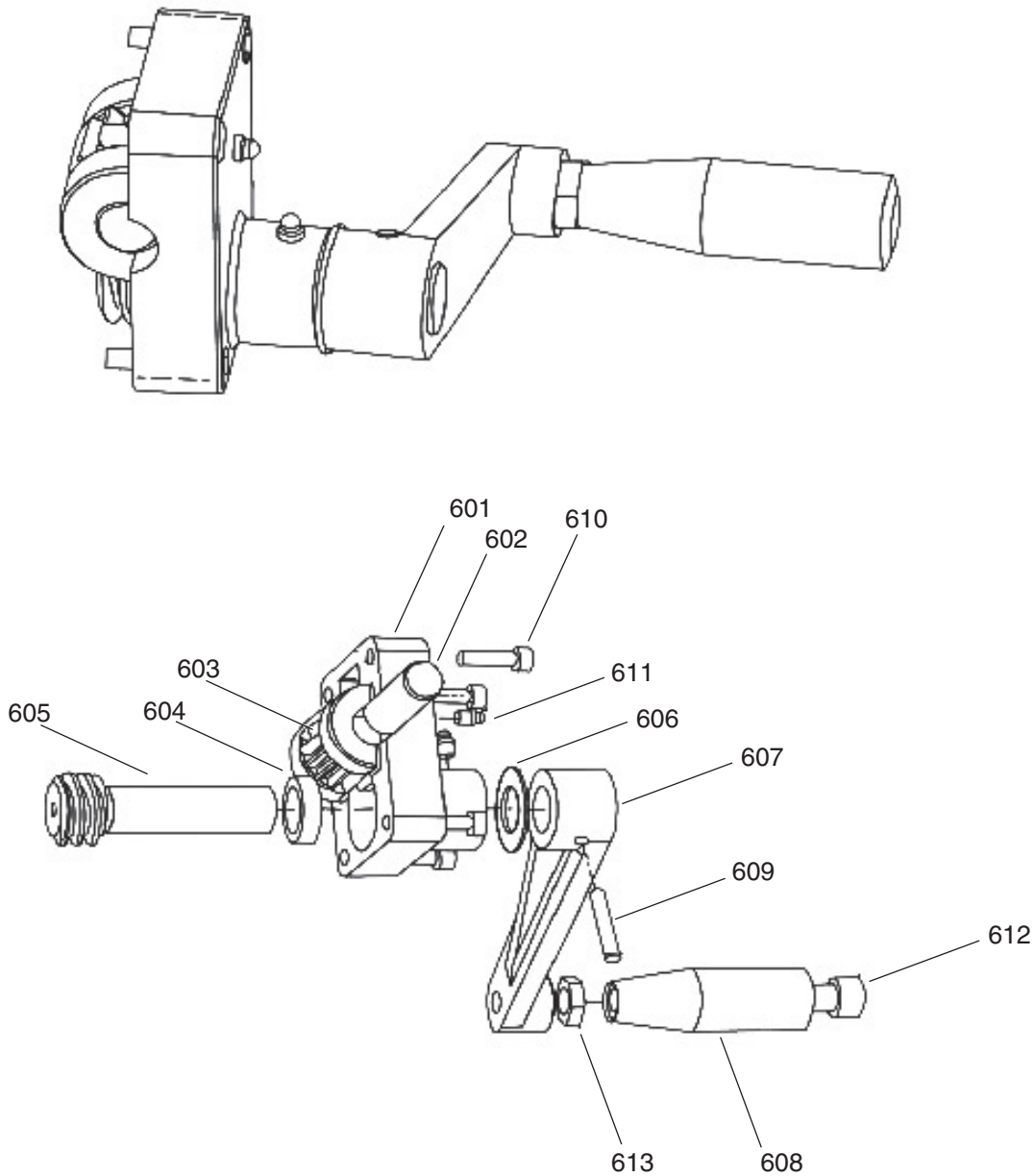


REF	PART #	DESCRIPTION
501	P0483501	BASE
502	P0483502	COLUMN
504	P0483504	TABLE
505	P0483505	UPPER RACK
506	PRP87M	ROLL PIN 12 x 16
507	P0483507	TABLE BRACKET
515	P0483515	LOCKING HANDLE
516	P0483516	LOWER RING 100 x 130 x 20
517	P0483517	LOWER RACK

REF	PART #	DESCRIPTION
518	P0483518	UPPER RING 100 x 130 x 26
519	PB158M	HEX BOLT M12-1.75 X 90
522	PSB26M	CAP SCREW M6-1 X 12
523	PSS20M	SET SCREW M8-1.25 X 8
524	PW06M	FLAT WASHER 12MM
525	PLN09M	LOCK NUT M12-1.75
526	PR54M	INT RETAINING RING 15MM
527	PB143M	HEX BOLT M12-1.75 X 120
528	PB35M	HEX BOLT M12-1.75 X 40



# Table Crank Breakdown and Parts List

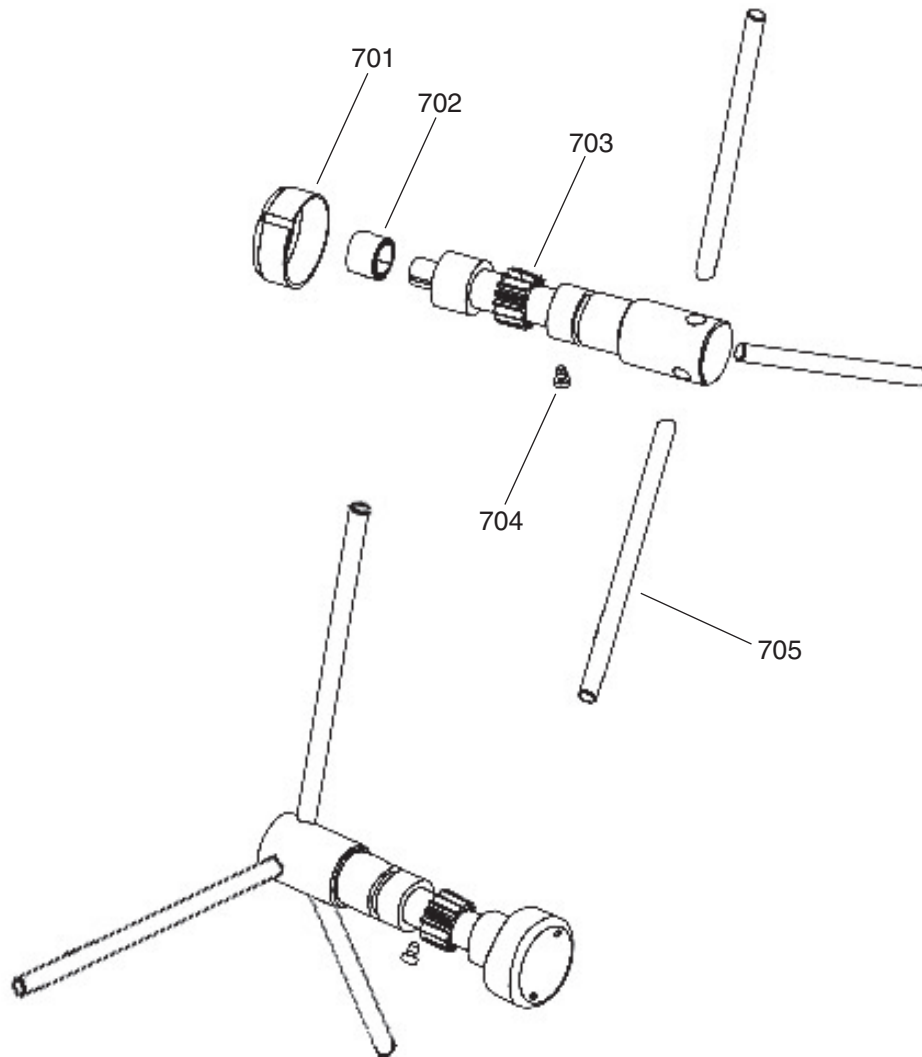


REF	PART #	DESCRIPTION
601	P0483601	CRANK HOUSING
602	P0483602	SHAFT
603	P0483603	GEAR
604	P0483604	SPACER 20 x 25 x 8
605	P0483605	WORM SHAFT
606	PW13M	FLAT WASHER 20MM
607	P0483607	CRANK

REF	PART #	DESCRIPTION
608	P0483608	CRANK HANDLE
609	PSS20M	SET SCREW M8-1.25 X 8
610	PSB07M	CAP SCREW M6-1 x 30
611	PZERK2	GREASE FITTING M6-1 X 5
612	PSB149M	CAP SCREW M12-1.75 x 100
613	PN09M	HEX NUT M12-1.75



# Downfeed Handles Breakdown and Parts List

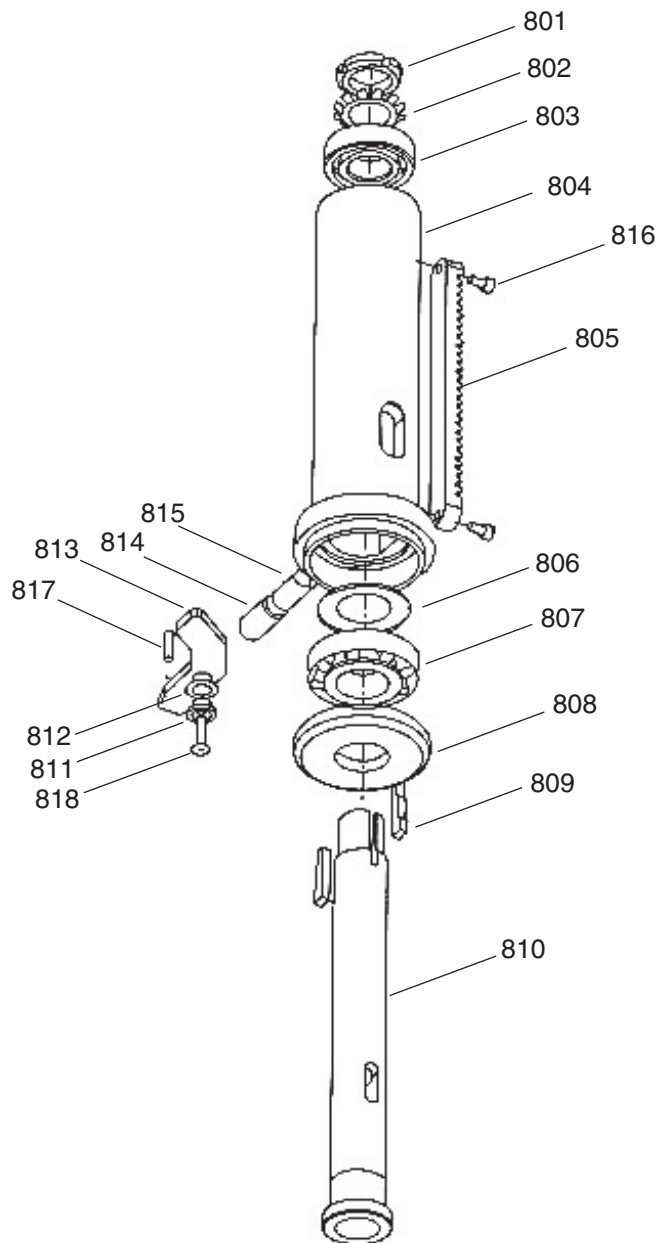


REF	PART #	DESCRIPTION
701	P0483701	SPRING HOUSING
702	P0483702	COIL SPRING
703	P0483703	FEED SHAFT

REF	PART #	DESCRIPTION
704	P0483704	SPECIAL SCREW
705	P0483705	FEED LEVER



# Spindle Breakdown and Parts List

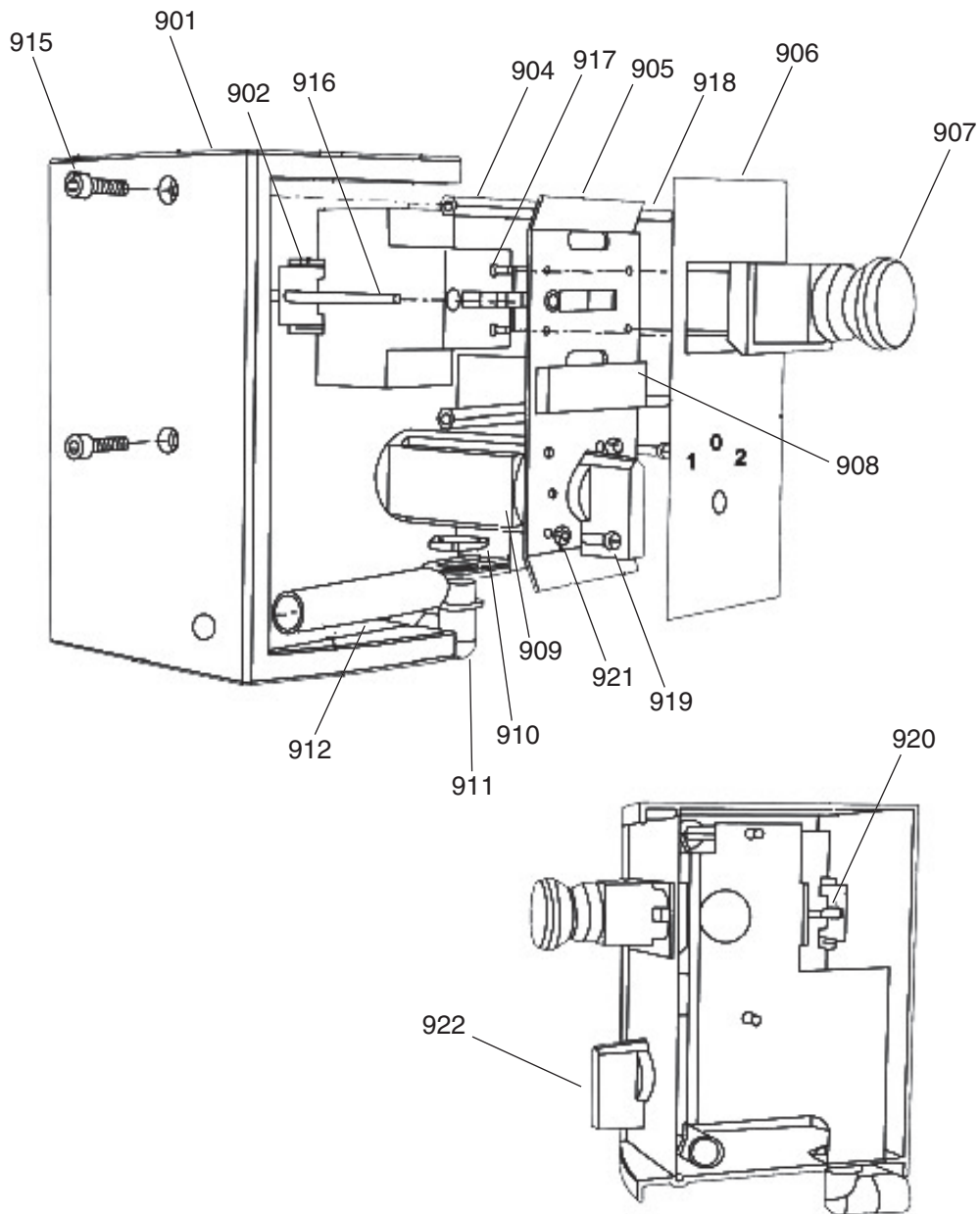


REF	PART #	DESCRIPTION
801	P0483801	SPANNER NUT M25-1.5
802	PLW15M	LOCK WASHER 25MM
803	P6205	BALL BEARING 6205
804	P0483804	SPINDLE SLEEVE
805	P0483805	RACK
806	P0483806	SPECIAL WASHER 52 X 2 X .3
807	P30206	TAPER ROLLER BEARING 30206
808	P0483808	BEARING COVER
809	P0483809	KEY 35 X 5 X 9

REF	PART #	DESCRIPTION
810	P0483810	SPINDLE
811	P0483811	SPACING SLEEVE
812	PLW06M	LOCK WASHER 10MM
813	P0483813	STOP
814	PSS88M	SET SCREW M16-2 X 25
815	P0483815	COLLET JAW
816	PSB50M	CAP SCREW M5-.8 X 10
817	PRP03M	ROLL PIN 5 X 20
818	PSB15M	CAP SCREW M5-.8 X 20



# Electric Box Breakdown and Parts List

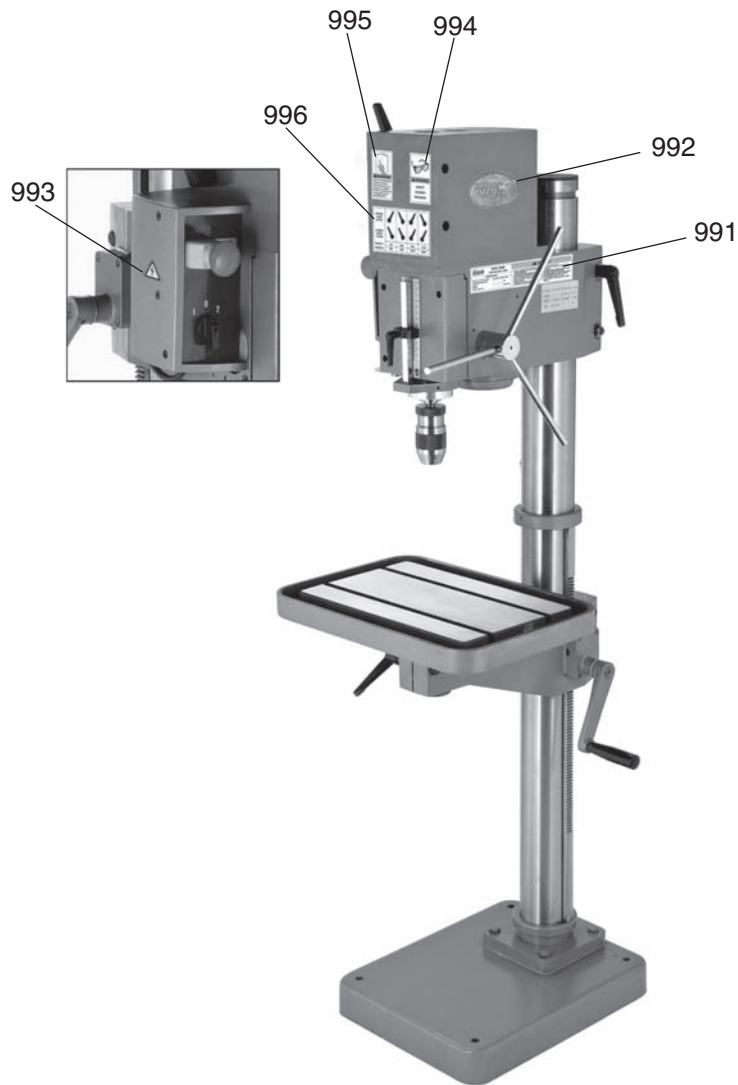


REF	PART #	DESCRIPTION
901	P0483901	ELECTRIC BOX COVER
902	P0483902	RAIL ANCHOR
904	P0483904	THREADED HEX ROD M5-.8
905	P0483905	ANCHOR PLATE
906	P0483906	ELECTRIC BOX PLATE
907	P0483907	SWITCH ASSEMBLY
908	P0483908	RUBBER MOULDING 15 X 8
909	P0483909	SPEED SELECTOR
910	PN15M	HEX NUT M18-1.5
911	PZERK4	GREASE FITTING M18-1.5 x 5

REF	PART #	DESCRIPTION
912	P0483912	PROTECTION CONDUIT
915	PSB33M	CAP SCREW M5-.8 X 12
916	PSB150M	CAP SCREW M4-.7 X 80
917	PS21M	PHLP HD SCR M4-.7 X 15
918	P0483918	SUPPORT SCREW M5-.8
919	PS02M	PHLP HD SCR M4-.7 X 12
920	PSB22M	CAP SCREW M4-.7 X 35
921	PN04M	HEX NUT M4-.7
922	P0483922	SPEED SELECTOR SWITCH



# G0483 Label Placement



REF	PART #	DESCRIPTION
991	P0483991	MACHINE ID LABEL
992	G9987	GRIZZLY NAMEPLATE
993	PLABEL-14	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
994	PLABEL-11	SAFETY GLASSES 2" X 3-5/16"
995	PLABEL-12	READ MANUAL 2" X 3-5/16"
996	P0483996	P0483 SPEED CHART LABEL

## WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or [www.grizzly.com](http://www.grizzly.com) to order new labels.



# WARRANTY AND RETURNS

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

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

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

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

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

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







# 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                       Friend                       Catalog  
 Card Deck                               Website                       Other:

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

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

3. What is your annual household income?

\$20,000-\$29,000                       \$30,000-\$39,000                       \$40,000-\$49,000  
 \$50,000-\$59,000                       \$60,000-\$69,000                       \$70,000+

4. What is your age group?

20-29                                       30-39                                       40-49  
 50-59                                       60-69                                       70+

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

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

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

0-2                       3-5                       6-9                       10+

7. Do you think your machine represents a good value?

Yes                       No

8. Would you recommend Grizzly Industrial to a friend?

Yes                       No

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

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

10. Comments: \_\_\_\_\_

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 \_\_\_\_\_

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