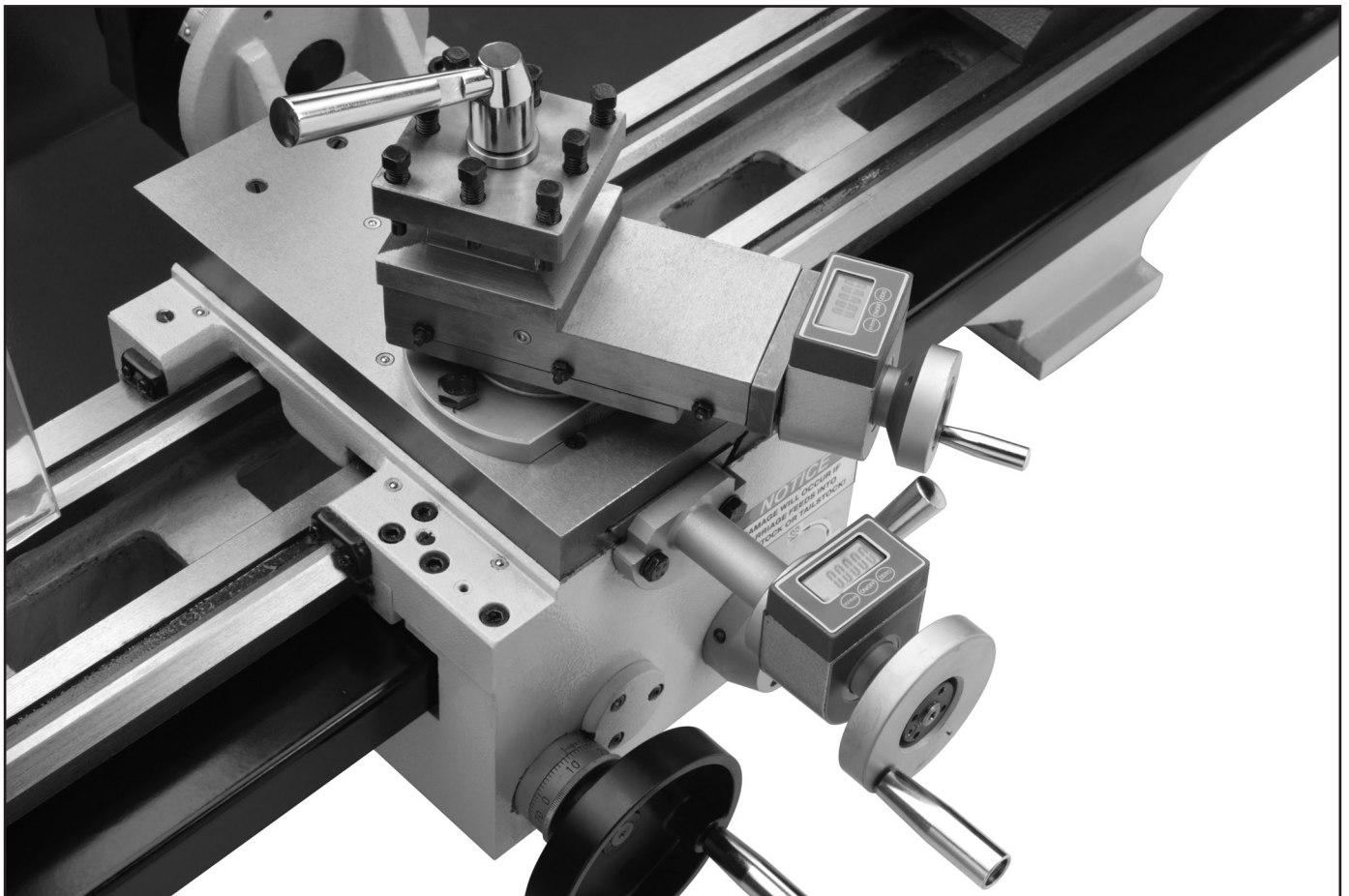


Grizzly **Industrial, Inc.**®

MODEL H8176 DIGITAL READOUT (DRO) KIT FOR G0516 OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#TR10649 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.

INTRODUCTION

Table of Contents

INTRODUCTION	1
Table of Contents	1
Foreword.....	1
Contact Info.....	1
Overview	1
SECTION 1: SETUP	2
Setup Safety	2
Unpacking	2
Items Needed for Setup.....	2
Inventory	3
Compound Slide Installation	4
Cross Slide Installation	9
SECTION 2: OPERATIONS	12
Turning DRO On/Off.....	12
MM/Inch Unit Selection.....	12
Zeroing DRO.....	12
SECTION 3: PARTS	13
Cross Slide Breakdown	13
Compound Slide Breakdown	14
WARRANTY AND RETURNS	17

Foreword

We are proud to offer the Model H8176 DRO for the Model G0516. 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.

The specifications, drawings, and photographs illustrated in this manual represent the Model H8176 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 kit 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

We stand behind our machines. If you have any service questions, parts requests or general questions about the kit, 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

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
Email: manuals@grizzly.com

Overview

This kit provides DRO's (Digital Readouts) to install on the cross slide and compound slides of the Model G0516 Lathe/Mill. These DRO's have a display resolution of $\pm 0.0001"$ or $\pm 0.001\text{mm}$, and can be easily zeroed at any location.

Installing this kit requires basic drilling and tapping skills. The drilling work can be done with the Model G0516 mill/drill with the milling vise installed on the cross slide. A complete list of required tools and equipment needed to install this kit is provided on **Page 2**.

The kit provides the machine components that need to be drilled and tapped, which gives you the option of re-installing the original machine components included with the Model G0516 at a later point.

SECTION 1: SETUP

Setup Safety



Unpacking

The DRO kit was carefully packaged for safe transportation. Remove the packaging materials and inspect the contents. If you discover that components are damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the shipping company. *Otherwise, filing a freight claim can be difficult.*

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

Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your kit. Most of the wrenches needed ARE included with the Model G0516.

Description	Qty
• Model G0516 Lathe/Mill.....	1
• Phillips Head Screwdriver #2	1
• Flat Head Screwdriver #2.....	1
• Hammer.....	1
• Pin Punch 1/8"	1
• Drill Bit 0.169" or #18	1
• Drill Bit 0.196" or 5mm.....	1
• Drill Bit 0.265" or H.....	1
• Taper Tap M6-1	1
• Bottoming Tap M6-1	1
• Tap Handle	1
• Straightedge or 1-2-3 Block.....	1
• Wrenches 7, 8, 10, 14, 17mm	1 Each
• Hex Wrenches 2.5, 3, 4, 5, 8mm	1 Each
• Way Oil	As Needed
• Rubbing Alcohol	As Needed



Inventory

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

Note: *If you can't find an item on this list, check the mounting location or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Inventory Components: (Figure 1)	Qty
A. DRO.....	2
B. DRO Beauty Stickers	2
C. Spare Batteries L1154	2
D. Short Leadscrew	1
E. Long Leadscrew	1
F. Brass Leadscrew Nut	1
G. Adapter 1	1
H. Cross Slide Adapter Shaft.....	1
I. Round Nuts	2
J. Compound Sliding Base.....	1
K. Adapter 2.....	1
L. Large Handwheel	1
M. Small Handwheel	1
N. Hardware Bag (Figure 2)	1
a. Cap Screws M3-.6 x 25	6
b. Cap Screws M5-.8 x 14.....	2
c. Flat Head Screws M3-.6 x 6	2
d. Key 3 x 3 x 10	1
e. Key 3 x 3 x 8.....	1
f. Ball Oiler Assembly.....	1
g. Thrust Bearing 51101	1
h. Cap Screws M4-.7 x 12.....	2

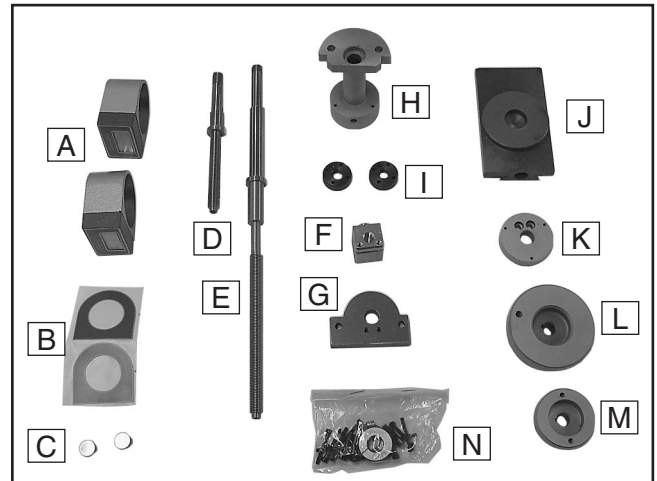


Figure 1. Inventory components.

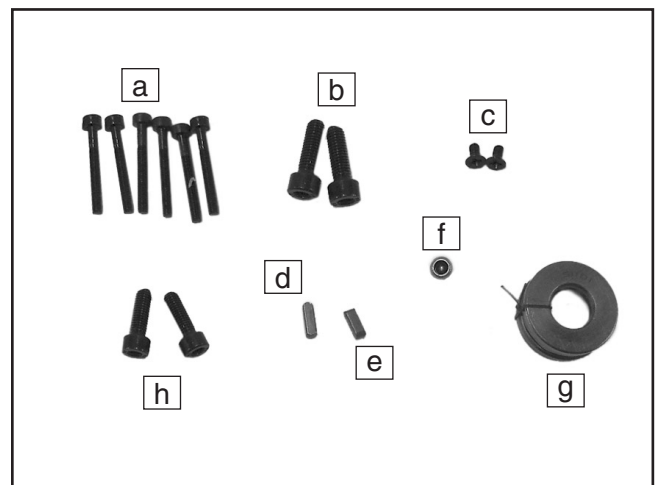


Figure 2. Hardware bag contents.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.



Compound Slide Installation

To install the DRO on the compound slide:

1. Remove the tool post from the top of the compound slide, as shown in **Figure 3**.

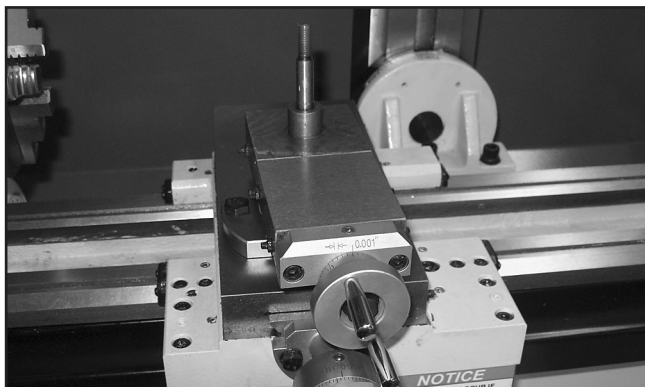


Figure 3. Tool post removed from compound slide.

2. Remove the compound slide by unthreading the two bolts that hold it in place (**Figure 4**).

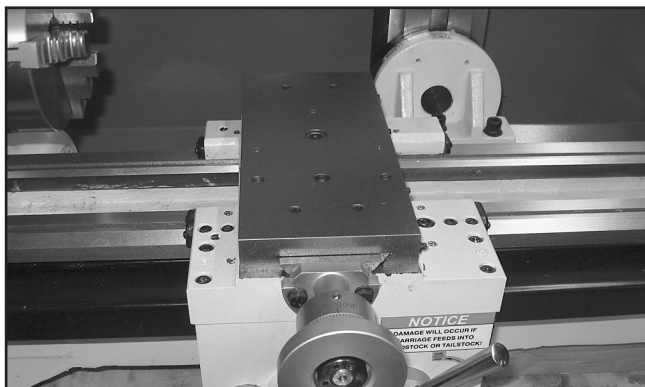


Figure 4. Cross slide with compound slide removed.

3. Support the removed compound slide on a block of wood (or something similar), as shown in **Figure 5**, remove the four screws on the bottom, and set them aside for later use.

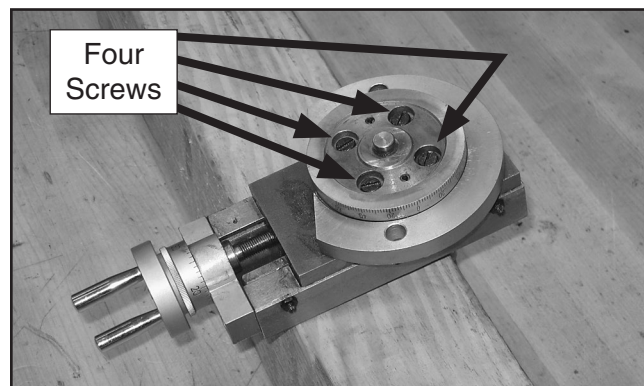


Figure 5. Locating four screws on underside of compound slide.

4. Unthread the compound leadscrew all the way out, using the handwheel.
5. When the sliding base no longer moves, unscrew the two cap screws near the handwheel to separate the handwheel adapter from the compound block, then slide the base out of the compound ways (**Figure 6**).

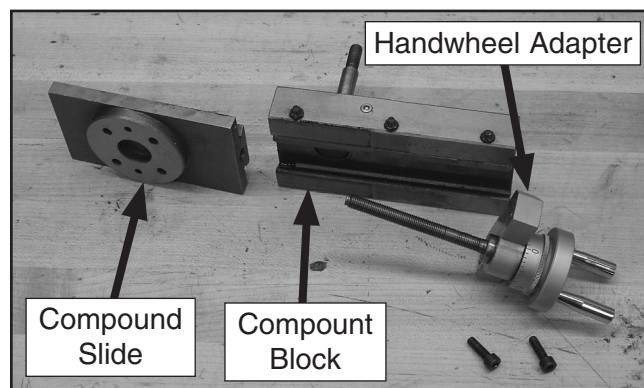


Figure 6. Compound slide disassembled.



6. Compare the old base to the new base included with the DRO kit.

Notice that the new base does not have holes for guide pins or fasteners to accept the adapter plate (see **Figure 7**).

These holes must be created. Although not required, you can use your Model G0516 to drill and assist with tapping these holes. Before starting, you will have to install the milling vise on the cross slide.

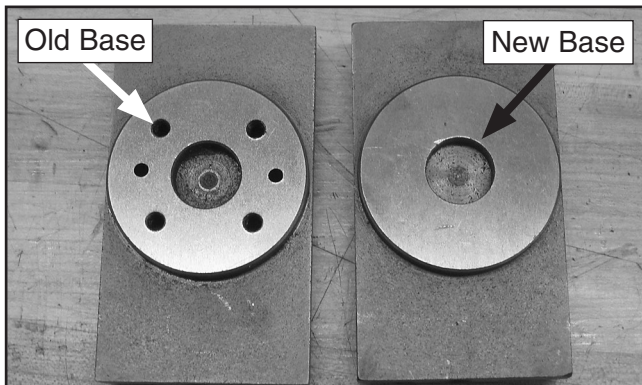


Figure 7. Comparing the old and new bases.

7. Turn the adapter plate upside down, and use a pin punch and hammer to tap the guide pins out of the adapter plate, as shown in **Figure 8**.

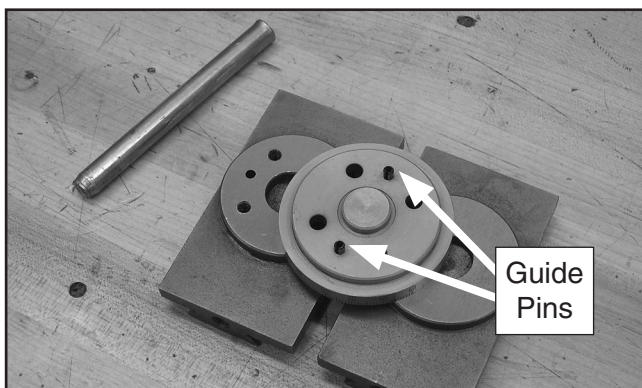


Figure 8. Guide pins.

8. Place the adapter plate in the base, align the new and old base with a straightedge or 1-2-3 block, then rotate the adapter plate so the guide holes in the base are aligned with the guide holes on the old adapter plate, as shown in **Figure 9**.

Important: Make sure the scale on the adapter plate will face in the same direction when installed on the new base as it did on the old base.

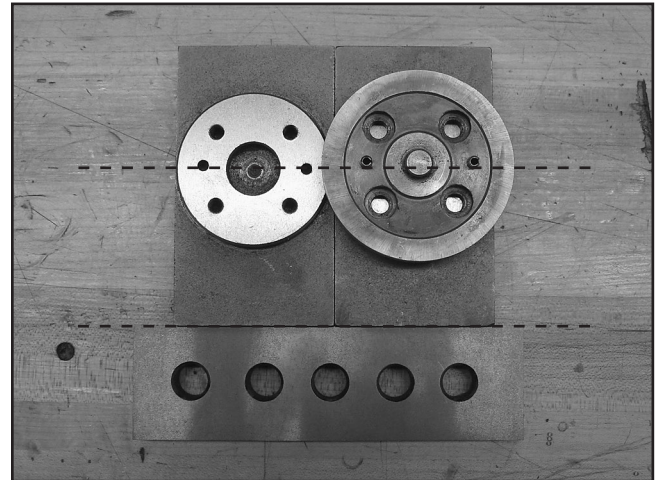


Figure 9. Aligning guide pin holes.

9. Place the 0.169" or #18 drill bit in the guide holes. Using a hammer, lightly tap the drill bit against the new base to make an alignment mark, then rotate the drill bit 90° and lightly tap the drill bit again.

The result of this step, if done correctly, will provide an "X" mark on the new base that is perfectly aligned with the guide pin hole. Repeat this step with the other guide pin hole. (As an alternative, you can use a center punch for this step, but take care to ensure the holes are precisely aligned.)

10. Remove the adapter plate from the base, and drill the guide pin holes with the 0.169" (or #18) drill bit, as shown in **Figure 10**.



Figure 10. Guide pin holes drilled with 0.169" (or #18) drill bit.



11. Fit the adapter plate into the base, align the guide holes, and tap the guide pins halfway into place to temporarily secure the adapter plate.

The adapter plate should fit against the base tightly and not pull apart easily. If it does pull apart easily, fit it in place with the guide pins and clamp it together for the next step.

12. Mount the adapter plate and base assembly into your drilling vise, then install the 0.265" (or H) drill bit into your drill or mill.
13. Align the drill bit with a screw hole in the adapter plate (as shown in **Figure 11**), then run the drill at a low speed and just bump the base lightly with the drill bit to make a starter divot for later drilling and tapping. Repeat this step on all four screw holes.

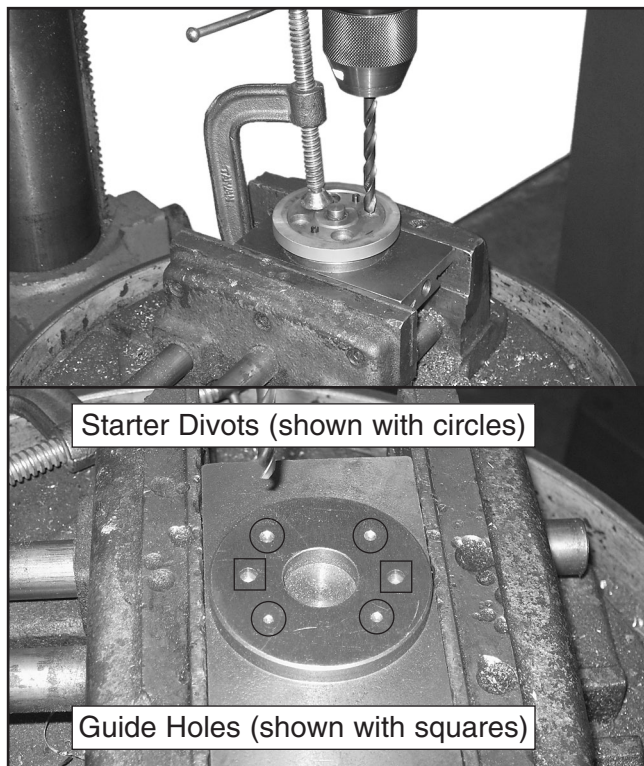


Figure 11. Using a 0.265" (or H) drill bit to bump starter divots in the new base.

14. Remove the adapter plate from the base, and install the 0.196" (or 5mm) drill bit.
15. Drill the first hole into one of the divots you made in the base (take care not to drill through the base and into the ways), then without moving the table or vise, install the M6-1 tap into the drill chuck.

16. Run the drill press at low speed, then slowly lower the tap into the hole and immediately shut the drill **OFF** while maintaining downward pressure until the spindle stops. (As an alternative, you keep the drill press turned off and turn the chuck, with tap, by hand to get it started.)
17. Open the drill chuck to release the tap, then raise the spindle up out of the way, and use the tap handle to cut threads as far as you can with the taper tap (**Figure 12**).

Note: *If you drilled through the table, do not allow your tap to protrude through the table far enough that it contacts the dovetail.*

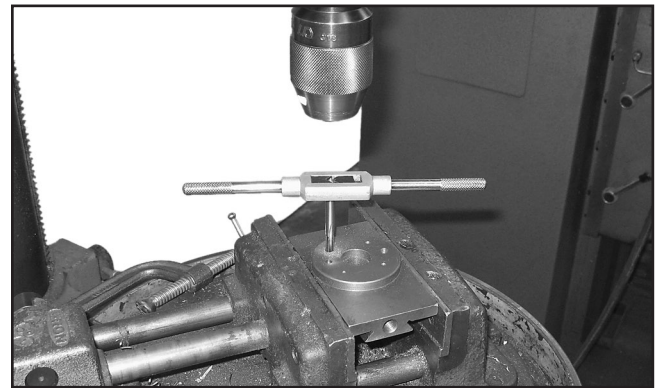


Figure 12. Tapping screw holes in the base one at a time.

18. Finish tapping the hole with the bottoming tap.
19. Repeat **Steps 15–18** with the remaining three cap screw holes. The final result should look similar to **Figure 13**.

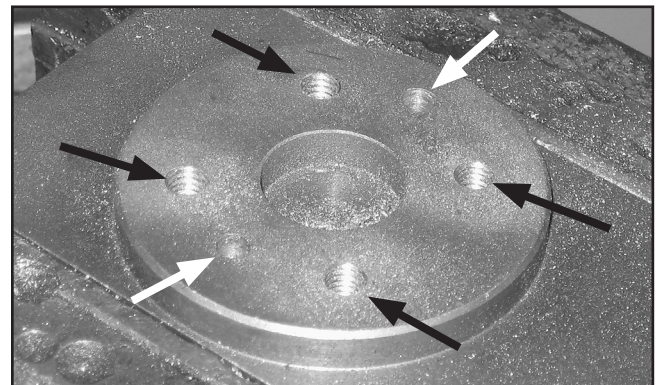


Figure 13. Final drilling and tapping results of new sliding base. (Black arrows point to tapped holes; white arrows point to guide pin holes.)



20. Attach the adapter plate with circular base to the base with the two guide pins and four cap screws that were removed during **Step 3**, as shown in **Figure 14**.

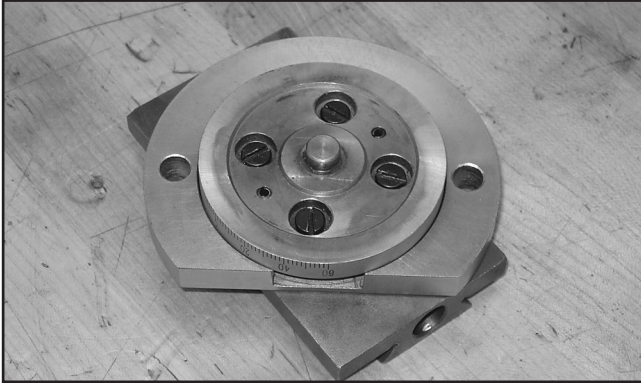


Figure 14. Adapter plate with circular base attached to new sliding base.

21. Coat the sliding ways of the base with way oil, then slide it into the compound slide and thread in the new short leadscrew, as shown in **Figure 15**.

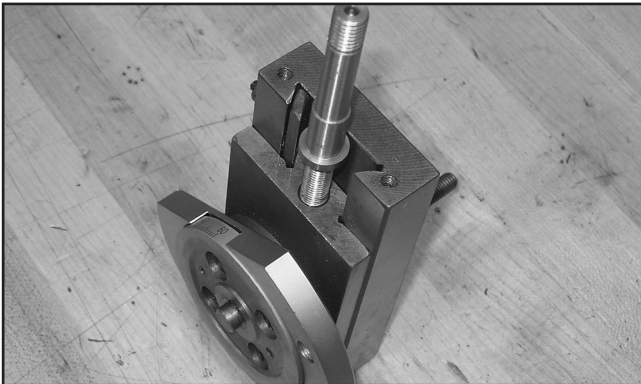


Figure 15. Sliding base and leadscrew assembled on the compound slide.

22. Slide adapter 1 over the leadscrew, adjust the leadscrew as necessary to make the adapter fit against the compound, then secure adapter 1 with two M5-.8 x 14 cap screws, as shown in **Figure 16**.

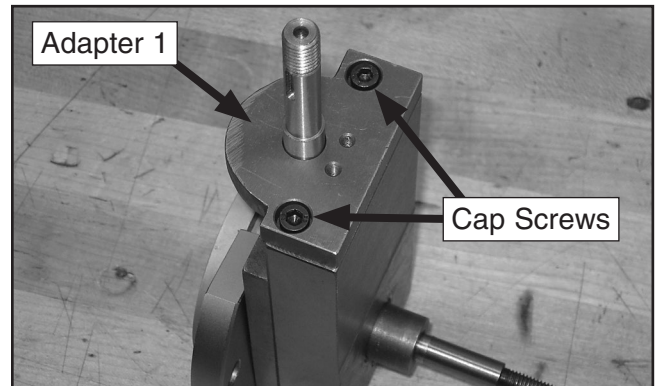


Figure 16. Adapter 1 installed over leadscrew and attached to compound slide.

23. Slide adapter 2 over the leadscrew shaft, and secure it to adapter 1 with two M4-.7 x 12 cap screws, as shown in **Figure 17**.

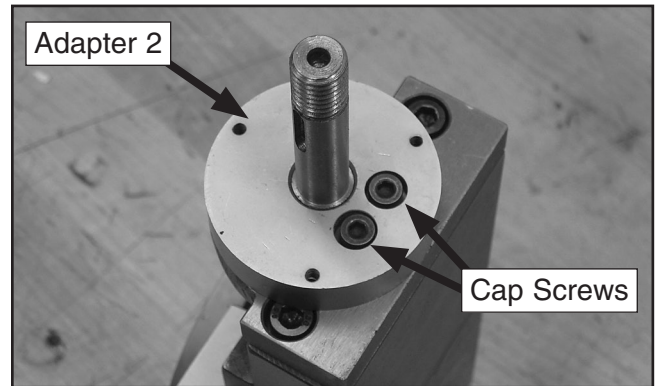


Figure 17. Adapter 2 installed over leadscrew and attached to adapter 1.

24. Rotate the leadscrew counterclockwise a couple turns to ensure that the leadscrew is protruding as far out of the adapters as possible.
25. Slide the DRO over the shaft against adapter 2, and install the 3 x 3 x 8mm key in the leadscrew shaft and DRO sleeve keyway.

Note: If you have trouble installing the key, repeat **Step 24** as necessary to back the leadscrew out and make room for the key. If this does not create enough room to allow the key to fit, file the key slightly to make it fit.



26. Attach the DRO to the adapter with three M3-.6 x 25 cap screws, as shown in **Figure 18**.

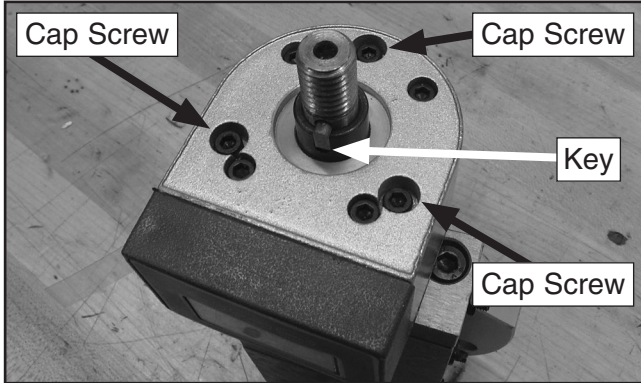


Figure 18. DRO installed and key in keyway.

27. Clean the side of the DRO with rubbing alcohol, allow it to dry, then firmly rub one of the DRO beauty stickers on the DRO to cover the screw holes, as shown in **Figure 19**.



Figure 19. Beauty sticker applied to DRO.

28. Slide the small handwheel on the end of the leadscrew shaft so the keyway aligns with the key, and secure the handwheel in place by threading a round nut onto the end of the leadscrew.
29. Take the handles from the original small handwheel that came with the machine, and install them onto the new small handwheel.

After tightening the round nut, install an M3-.6 x 6 flat head screw and tighten the screw to lock the round nut in place, as shown in **Figure 20**.

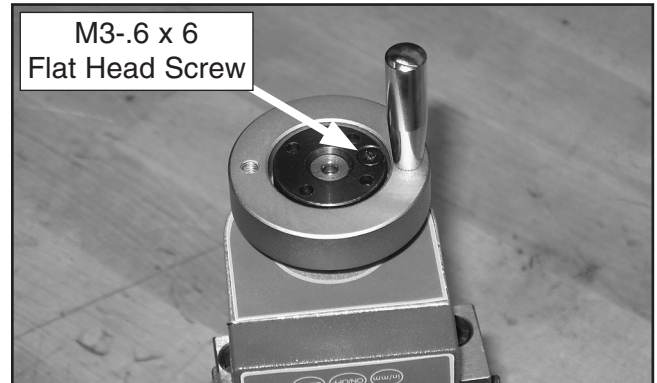


Figure 20. Small handwheel attached to leadscrew.

30. Loosen—but do not remove—the DRO battery cover, pull out the plastic strip (**Figure 21**), then tighten the battery cover. After the plastic strip is removed, the DRO should turn on when the ON/OFF button is pressed.



Figure 21. Removing plastic strip from DRO battery housing.

31. Set the compound slide assembly aside for later installation on the cross slide.



Cross Slide Installation

To install the DRO on the cross slide:

1. Remove the two hex bolts with flat washers from the adapter shaft of the cross slide handwheel, as shown in **Figure 22**.

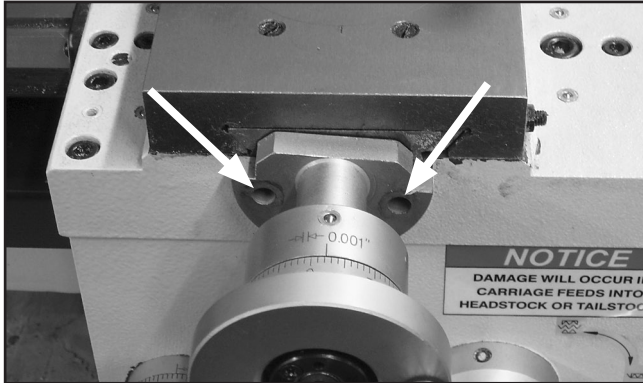


Figure 22. Hex bolts removed from adapter shaft.

2. Hold the cross slide still and rotate the handwheel clockwise to unthread the leadscrew from the cross slide. **Figure 23** shows the leadscrew unthreaded from the cross slide.

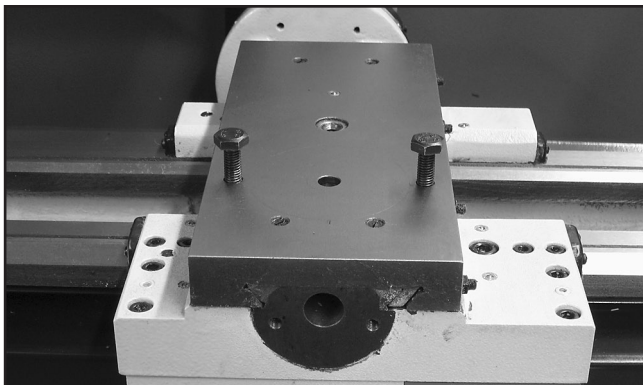


Figure 23. Leadscrew unthreaded from housing.

3. Remove the milling head and back splash.

4. Slide the cross slide off the dovetails, as shown in **Figure 24**.

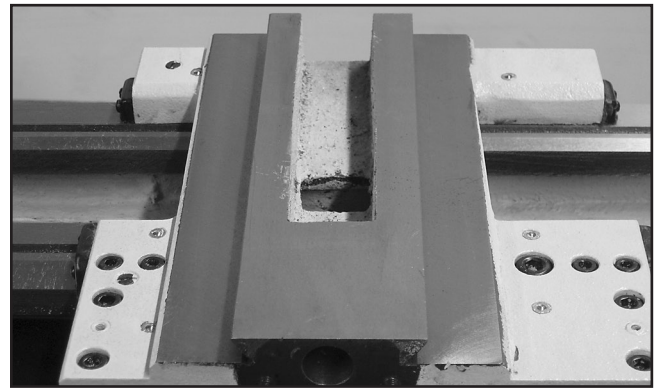


Figure 24. Cross slide removed from dovetails.

5. Remove the leadscrew nut (**Figure 25**) from the cross slide.

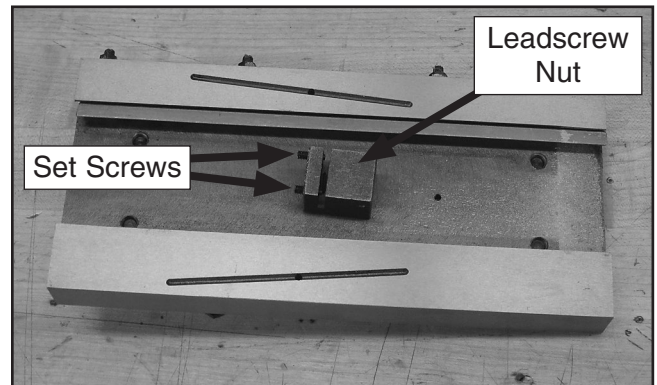


Figure 25. Leadscrew nut on cross slide.

6. Remove the two set screws from the old leadscrew nut and install them into the new brass leadscrew nut.
7. Attach the new leadscrew nut to the cross slide, so the set screws point toward the back of the machine.



8. Apply a liberal coat of way oil on the cross slide ways (**Figure 26**), and slide the cross side back on.

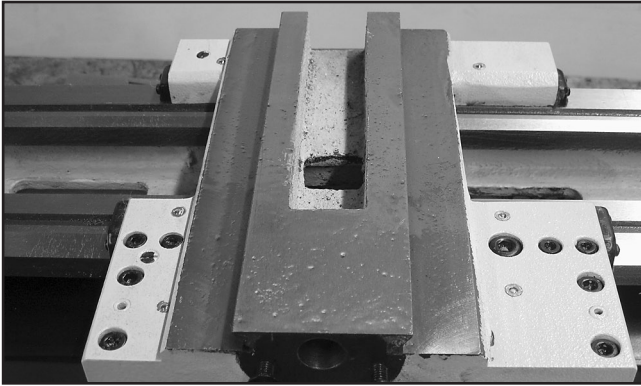


Figure 26. Way oil applied to cross slide ways.

9. Press the ball oiler into the adapter shaft.
10. Apply a coat of way oil on the leadscrew and slide the adapter shaft on the end of the leadscrew, as shown in **Figure 27**.

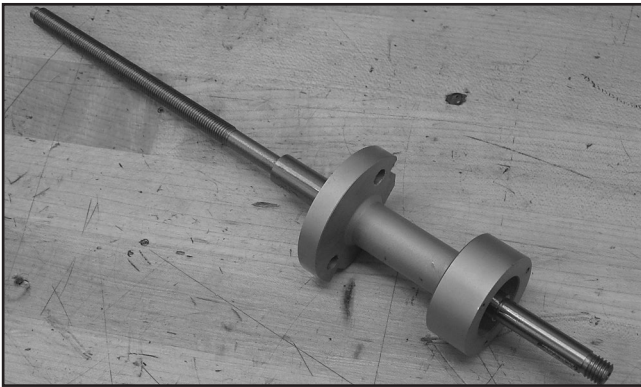


Figure 27. Adapter shaft installed on leadscrew.

11. Pinch the thrust bearing together, cut the string off, coat the bearing with multipurpose bearing grease, then carefully slide it over the end of the leadscrew and press it into the adapter shaft.

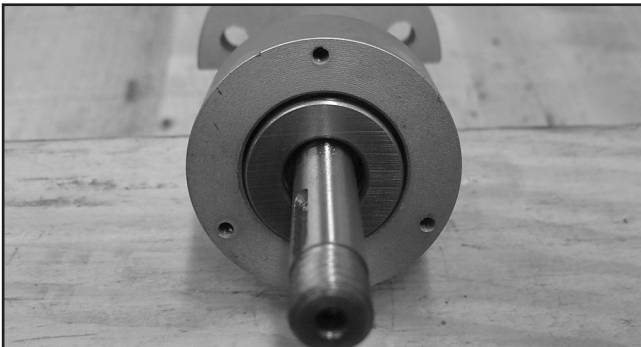


Figure 28. Thrust bearing installed in adapter shaft.

12. Attach the DRO to the adapter shaft with three M3-6 x 25 cap screws, and insert the key into the keyway, as shown in **Figure 29**.



Figure 29. DRO attached to adapter shaft on leadscrew.

13. Clean the side of the DRO with rubbing alcohol, allow it to dry, then firmly rub the DRO beauty sticker on the DRO to cover the screw holes, as shown in **Figure 30**.



Figure 30. Beauty sticker placed on side of DRO to cover screw heads.

14. Slide the large handwheel onto the shaft, as shown in **Figure 31**.



Figure 31. Large handwheel installed.



15. Secure the large handwheel to the shaft by threading a round nut onto the end of the leadscrew.

After tightening the round nut, install an M3-.6 x 6 flat head screw and tighten the screw to lock the round nut in place.

16. Loosen—but do not remove—the DRO battery cover, pull out the plastic strip, then tighten the battery cover.

After the plastic strip is removed, the DRO should turn on when the ON/OFF button is pressed.

17. Remove the handwheel handle from the handwheel that came with the machine, and install it onto the new large handwheel.

18. Thread the leadscrew into the cross slide, and secure the adapter shaft to the carriage with the two hex bolts and washers removed in **Step 1** (see **Figure 32**).



Figure 32. Cross slide DRO installed.

19. Re-install the mill head and backsplash removed in **Step 3**.

20. Install the compound slide on the cross slide, as shown in **Figure 33**.

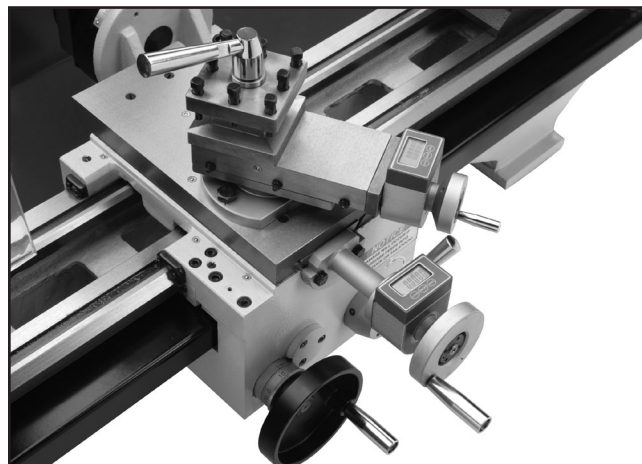


Figure 33. Compound slide attached to cross slide to complete the DRO installation.

21. Re-adjust the gibs on both the cross slide and compound slide. Refer to the Model G0516 manual for steps.

22. If necessary, adjust the leadscrew backlash on both slides.



SECTION 2: OPERATIONS

Turning DRO On/Off

The DRO is easily turned on and off with the ON/OFF button shown in **Figure 34**.

Note: *The DRO does not have an automatic off function, so you must remember to turn it **OFF** after use.*

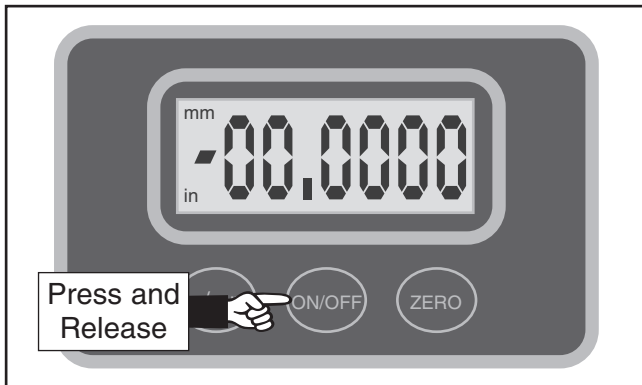


Figure 34. Turning DRO on or off.

Zeroing DRO

The DRO can be zeroed at any point by pressing and releasing the zero button (**Figure 36**). After zeroing, movement in one direction displays a positive number and movement in the other direction displays a negative number, as indicated by the negative sign shown in **Figure 36**.

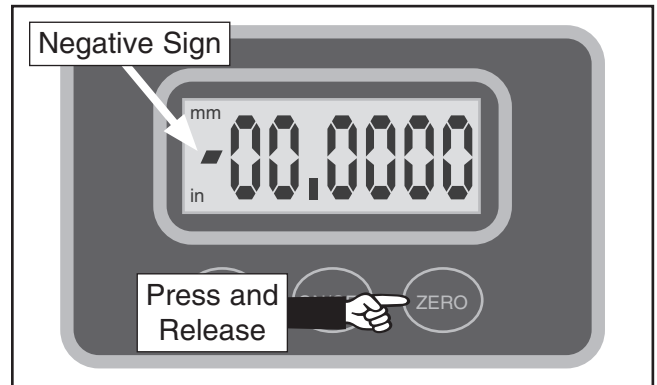


Figure 36. Zeroing the display.

MM/Inch Unit Selection

The DRO can display units in millimeters or inches. To toggle the display between mm and inches, press the in/mm key (**Figure 35**) until the new unit of measure shows on the control panel.

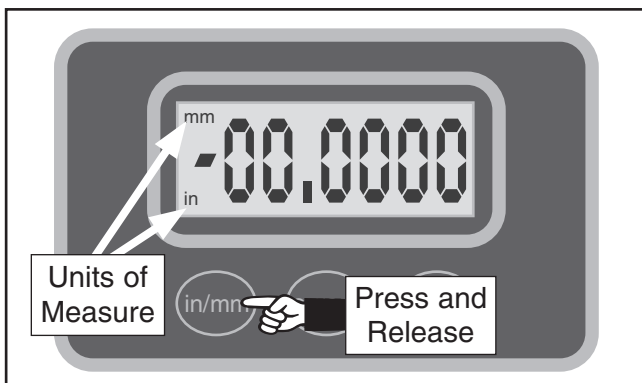
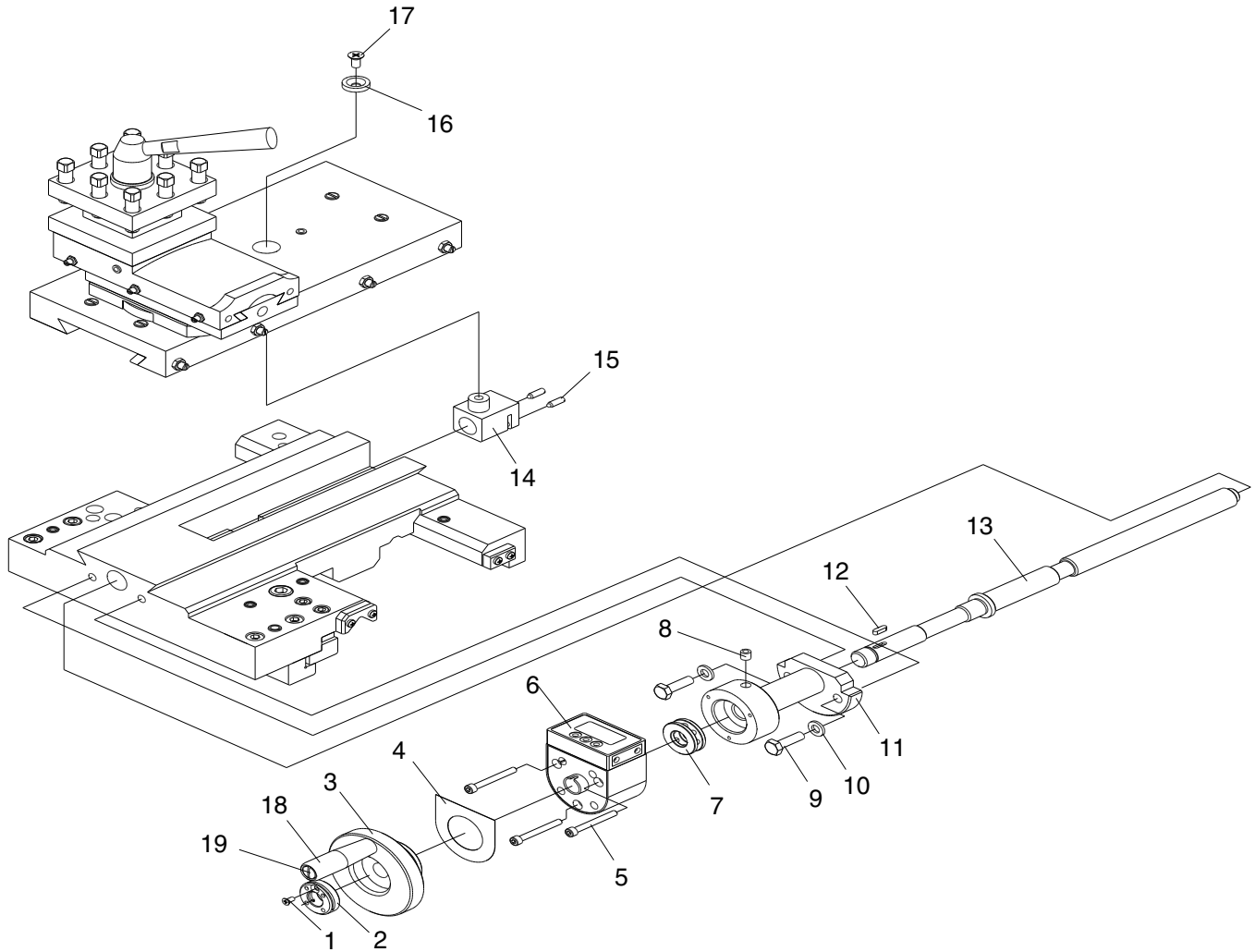


Figure 35. Pressing in/mm key to toggle the displayed unit of measure.



SECTION 3: PARTS

Cross Slide Breakdown

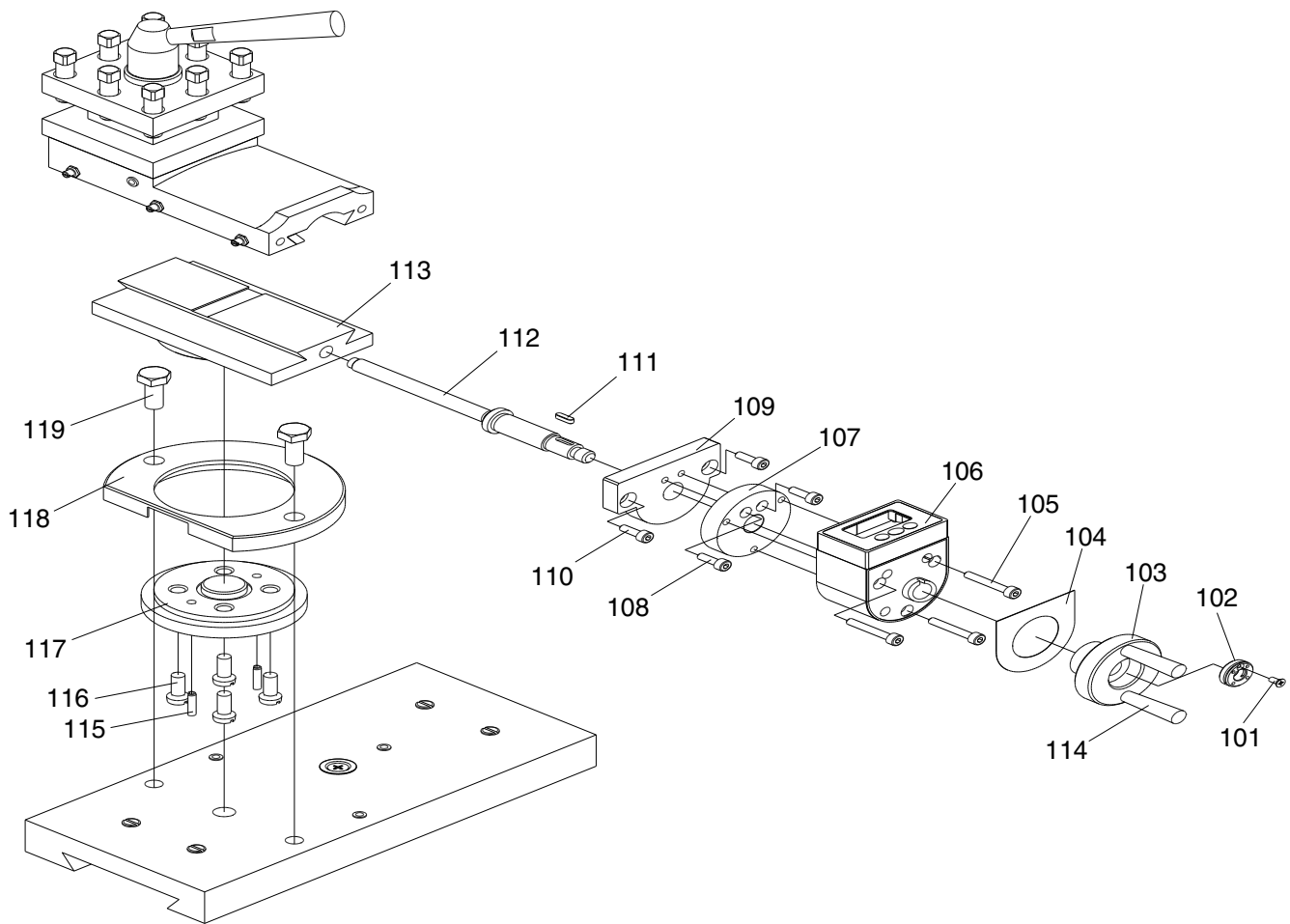


REF	PART #	DESCRIPTION
1	PH8176001	FLAT HD SCREW M3-.6 X 6
2	PH8176002	ROUND NUT
3	PH8176003	LARGE HANDWHEEL
4	PH8176004	DRO BEAUTY STICKER
5	PH8176005	CAP SCREW M3-.6 X 25
6	PH8176006	DRO
7	P51101	THRUST BEARING 51101
8	PH8176008	BALL OILER ASSEMBLY 6MM
9	PB08M	HEX BOLT M6-1 X 20
10	PW03M	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
11	PH8176011	ADAPTER SHAFT
12	PK39M	KEY 3 X 3 X 10
13	PH8176013	LONG LEADSCREW
14	PH8176014	BRASS LEADSCREW NUT
15	PSS22M	SET SCREW M4-.7 X 12
16	PH8176016	BUSHING
17	PH8176017	FLAT HD SCREW M5-.8 X 10
18	PH8176018	HANDWHEEL HANDLE
19	PH8176019	HANDLE SCREW



Compound Slide Breakdown



REF	PART #	DESCRIPTION
101	PH8176001	FLAT HD SCREW M3-.6 X 6
102	PH8176002	ROUND NUT
103	PH8176103	SMALL HANDWHEEL
104	PH8176004	DRO BEAUTY STICKER
105	PH8176005	CAP SCREW M3-.6 X 25
106	PH8176006	DRO
107	PH8176107	ADAPTER 2
108	PSB23M	CAP SCREW M4-.7 X 12
109	PH8176109	ADAPTER 1
110	PSB33M	CAP SCREW M5-.8 X 12

REF	PART #	DESCRIPTION
111	PK03M	KEY 3 X 3 X 8
112	PH8176112	SHORT LEADSCREW
113	PH8176113	SLIDING BASE
114	PH8176114	SMALL HANDWHEEL HANDLE
115	PRP76M	ROLL PIN 4 X 16
116	PH8176116	SPECIAL SCREW M6-1 X 16
117	PH8176117	ADAPTER PLATE
118	PH8176118	CIRCULAR BASE
119	PB09M	HEX BOLT M8-1.25 X 20





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?

- | | | |
|---|--|---|
| <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: _____

CUT ALONG DOTTED LINE

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 AND 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.

grizzly.com

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