

# READ THIS FIRST



**Model G0668**

**\*\*\*IMPORTANT UPDATE\*\*\***

**For Machines Mfd. Since 02/25  
and Owner's Manual Printed 02/08**

*For questions or help with this product contact Tech Support at (570) 546-9663 or [techsupport@grizzly.com](mailto:techsupport@grizzly.com)*

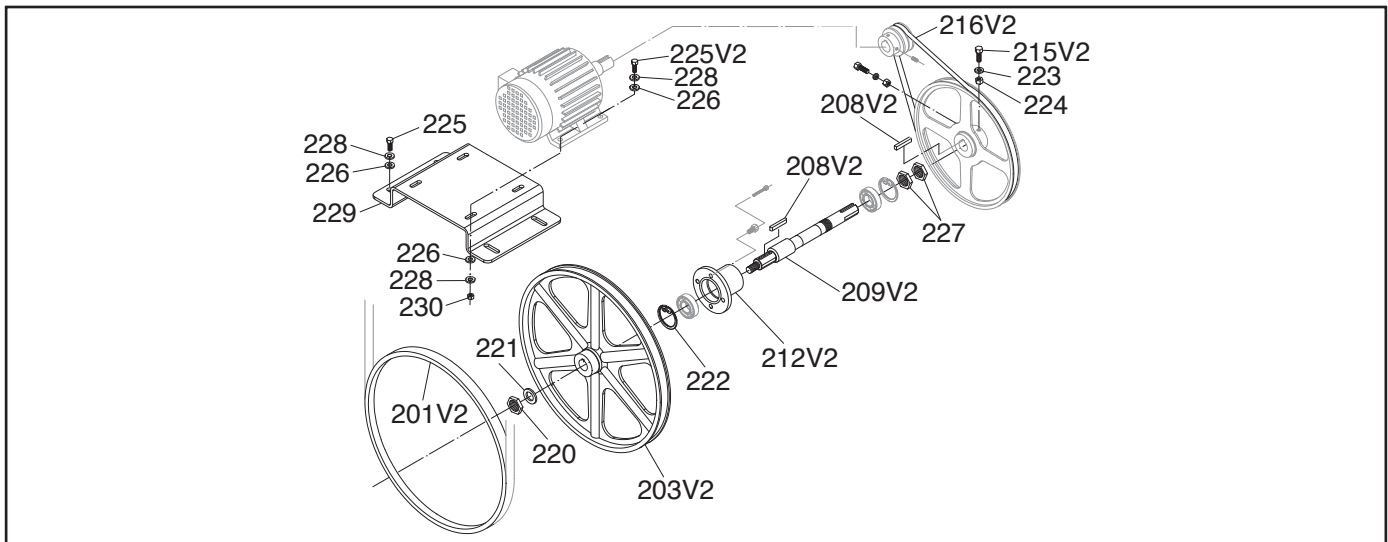
The following changes were recently made since the owner's manual was printed:

- Parts have changed.
- Service sections shown on **Pages 36–37** have been updated.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

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## Revised Motor & Lower Wheel Parts

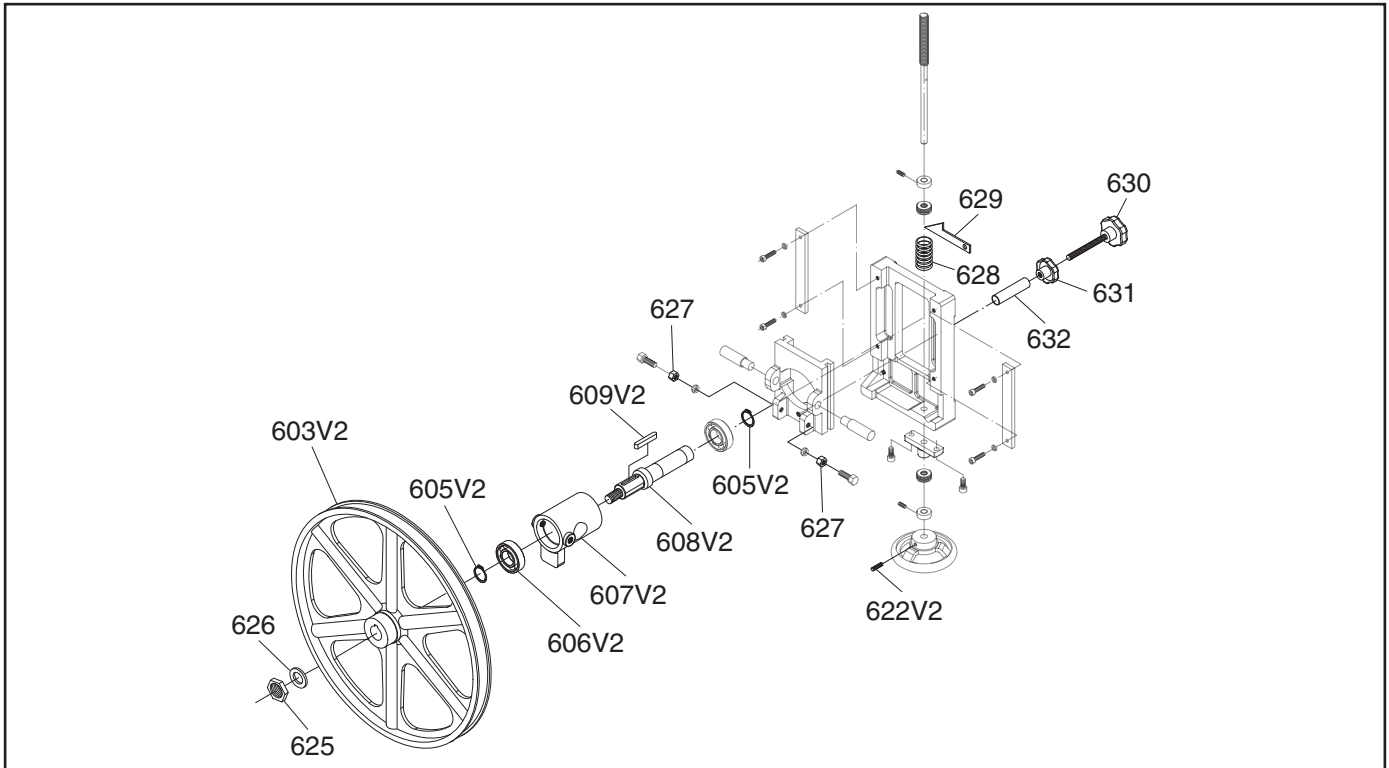


REF	PART #	DESCRIPTION
201V2	P0668201V2	WHEEL TIRE 35.5 X 3 V2.05.22
203V2	P0668203V2	WHEEL LOWER V2.05.22
208V2	P0668208V2	KEY 7 X 7 X 50 V2.05.22
209V2	P0668209V2	WHEEL SHAFT LOWER V2.05.22
212V2	P0668212V2	BEARING HOUSING V2.05.22
215V2	P0668215V2	CAP SCREW M12-1.75 X 35 V2.05.22
216V2	P0668216V2	V-BELT A64 V2.02.25
220	P0668220	HEX NUT M28-1.75
221	P0668221	FLAT WASHER 28MM
222	P0668222	EXT RETAINING RING 30MM

REF	PART #	DESCRIPTION
223	P0668223	LOCK WASHER 12MM
224	P0668224	HEX NUT M12-1.75
225	P0668225	HEX BOLT M8-1.25 X 20
225V2	P0668225V2	HEX BOLT M8-1.25 X 30 V2.02.25
226	P0668226	FLAT WASHER 8MM
227	P0668227	HEX NUT M28-1.75 THIN
228	P0668228	LOCK WASHER 8MM
229	P0668229	MOTOR BRACKET
230	P0668230	HEX NUT M8-1.25

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## Revised Upper Wheel Parts



REF	PART #	DESCRIPTION
603V2	P0668603V2	WHEEL UPPER V2.05.22
605V2	P0668605V2	EXT RETAINING RING 30MM V2.05.22
606V2	P0668606V2	BALL BEARING 6206Z V2.05.22
607V2	P0668607V2	BEARING HOUSING V2.05.22
608V2	P0668608V2	WHEEL SHAFT UPPER V2.05.22
609V2	P0668609V2	KEY 7 X 7 X 30 V2.05.22
622V2	P0668622V2	SET SCREW M8-1.25 X 10 V2.05.22
625	P0668625	HEX NUT M28-1.75

REF	PART #	DESCRIPTION
626	P0668626	FLAT WASHER 28MM
627	P0668627	HEX NUT 3/8-16
628	P0668628	COMPRESSION SPRING 5 X 22 X 61
629	P0668629	POINTER
630	P0668630	KNOB BOLT 1/2-12 X 6-3/4, 6-LOBE, D2-3/4
631	P0668631	KNOB 1/2-12, 6-LOBE, D1-3/4
632	P0668632	SLEEVE



# READ THIS FIRST



Model G0668

**\*\*\*IMPORTANT UPDATE\*\*\***

For Machines Mfd. Since 08/18  
and Owner's Manual Revised 02/08

For questions or help with this product contact Tech Support at (570) 546-9663 or [techsupport@grizzly.com](mailto:techsupport@grizzly.com)

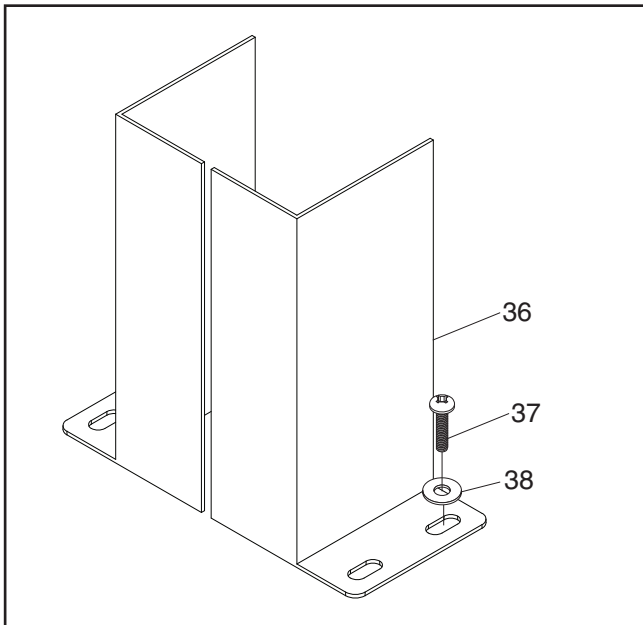
The following changes were recently made since the owner's manual was printed:

- Added lower blade guard.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or [techsupport@grizzly.com](mailto:techsupport@grizzly.com).

## New Parts



REF	PART #	DESCRIPTION
36	P0668036	LOWER BLADE GUARD SET
37	P0668037	PHLP HD SCR M6-1 X 10
38	P0668038	FLAT WASHER 6MM

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# READ THIS FIRST



**Model G0668**

**\*\*\*IMPORTANT UPDATE\*\*\***

**For Machines Mfd. Since June, 2008  
and Owner's Manual Printed February, 2008**

*For questions or help with this product contact Tech Support at (570) 546-9663 or [techsupport@grizzly.com](mailto:techsupport@grizzly.com)*

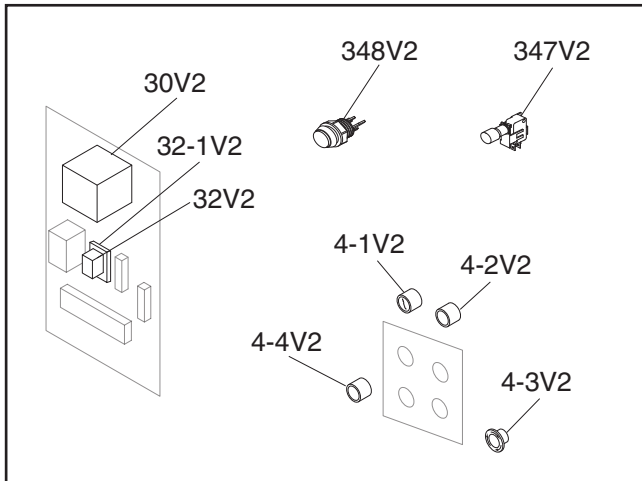
## We recently made the following changes to the Model G0668:

- Revised electrical & control panel wiring diagram and photos.
- Revised welding station wiring diagram.
- Changed transformer manufacturer.
- Revised electrical parts.

Aside from the information contained in this update, all other content in the owner's manual applies to this machine. For your own safety, you **MUST** read and understand this update and the applicable owner's manual. **Keep this update for future reference!**

*If you have any further questions about this manual update or the changes made to the machine, contact our Technical Support at (570) 546-9663 or email [techsupport@grizzly.com](mailto:techsupport@grizzly.com).*

## Revised Electrical Parts



REF	PART #	DESCRIPTION
4-1V2	P0668004-1V2	POWER SWITCH W/KEY NHD CB-10 V2.06.08
4-2V2	P0668004-2V2	POWER LAMP NHD-22 V2.06.08
4-3V2	P0668004-3V2	E-STOP BUTTON NHD CB-01 V2.06.08
4-4V2	P0668004-4V2	MOTOR ON BUTTON NHD CB-10 V2.06.08
30V2	P0668030V2	TRANSFORMER YJ A174-0055 V2.01.13
32V2	P0668032V2	RELAY STON MY4S 24V 3-5A V2.01.13
32-1V2	P0668032-1V2	RELAY HOLDER STON PYF14AE V2.01.13
347V2	P0668347V2	ANNEALING PUSH BUTTON V2.06.08
348V2	P0668348V2	WELDING PUSH BUTTON V2.06.08

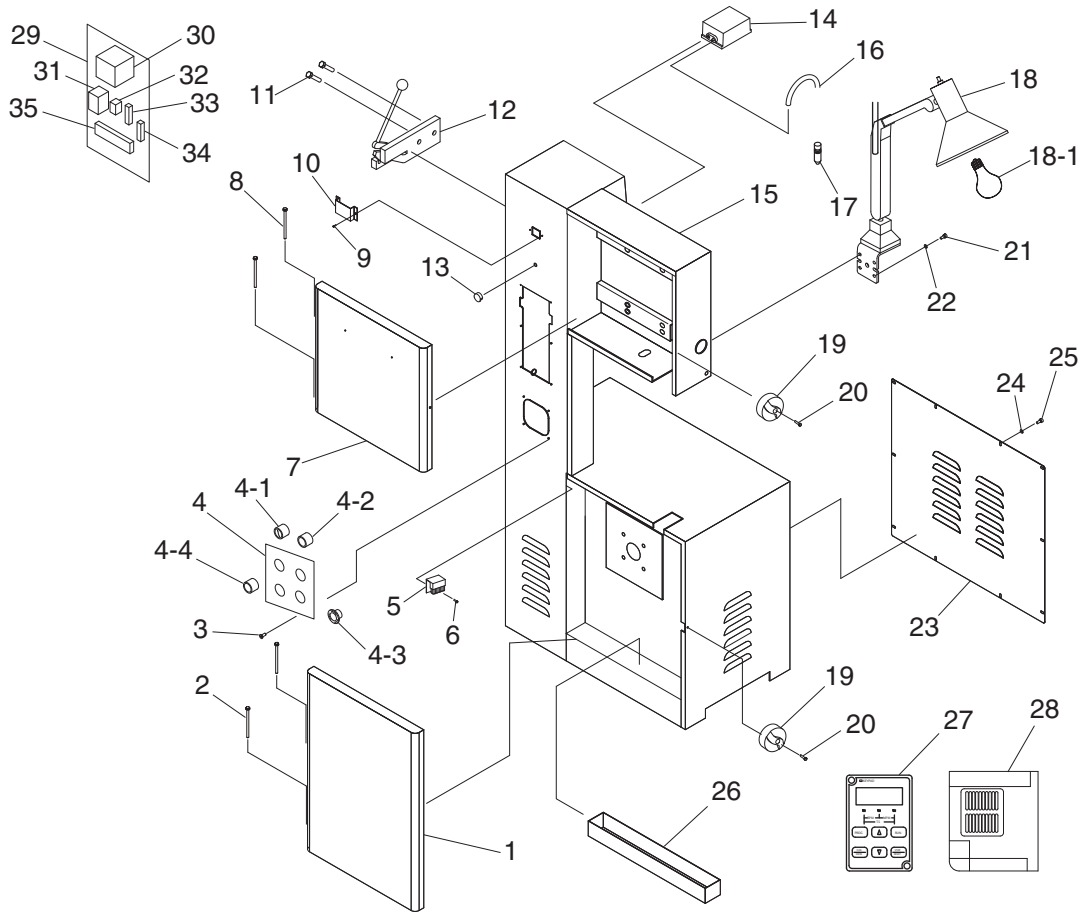
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# SECTION 8: PARTS

## Cabinet

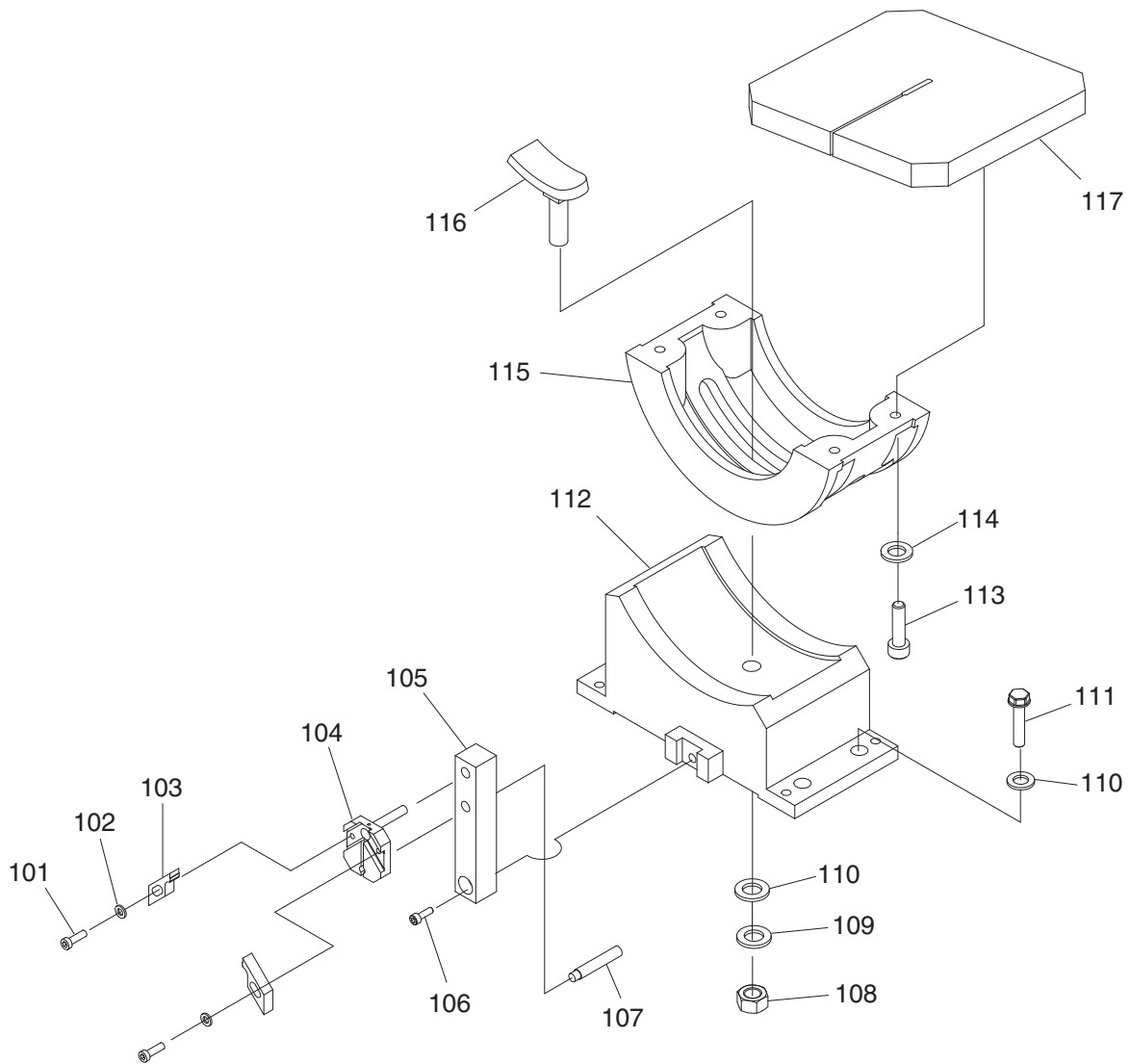


REF	PART #	DESCRIPTION
1	P0668001	WHEEL DOOR LOWER
2	P0668002	HINGE PIN LOWER
3	PS05M	PHLP HD SCR M5-.8 X 8
4	P0668004	CONTROL PANEL
4-1	P0668004-1	POWER SWITCH W/KEY
4-2	P0668004-2	POWER LAMP
4-3	P0668004-3	EMERGENCY STOP BUTTON
4-4	P0668004-4	MOTOR ON BUTTON
5	P0668005	BLADE CLEANING BRUSH
6	PS47M	PHLP HD SCR M6-1 X 25
7	P0668007	WHEEL DOOR UPPER
8	P0668008	HINGE PIN UPPER
9	PS05M	PHLP HD SCR M5-.8 X 8
10	P0668010	DIGITAL DISPLAY BRACKET
11	PSB11M	CAP SCREW M8-1.25 X 16
12	P0668012	BLADE SHEAR
13	P0668013	VARIABLE SPEED DIAL
14	P0668014	AIR PUMP
15	P0668015	BANDSAW CABINET
16	P0668016	AIR HOSE 4X6MM

REF	PART #	DESCRIPTION
17	P0668017	AIR NOZZLE
18	P0668018	WORK LAMP 220V
18-1	P0668018-1	LIGHT BULB 220V
19	P0668019	DOOR KNOB
20	PS47M	PHLP HD SCR M6-1 X 25
21	PSB28M	CAP SCREW M6-1 X 15
22	PW03M	FLAT WASHER 6MM
23	P0668023	MOTOR ACCESS PANEL
24	PW03M	FLAT WASHER 6MM
25	PB04M	HEX BOLT M6-1 X 10
26	P0668026	CHIP PAN
27	P0668027	DIGITAL DISPLAY
28	P0668028	INVERTER RM5G 2HP 220V 3PH
29	P0668029	CONTROL PANEL
30	P0668030	TRANSFORMER 1PH 0-3VA
31	P0668031	CONTACTOR NHD C-12D 220V
32	P0668032	RELAY ARITA MR2P 24V 3-5A
33	P0668033	FUSE HOLDER
34	P0668034	FUSE 3A
35	P0668035	TERMINAL BLOCK 11-POST



# Table & Lower Guide

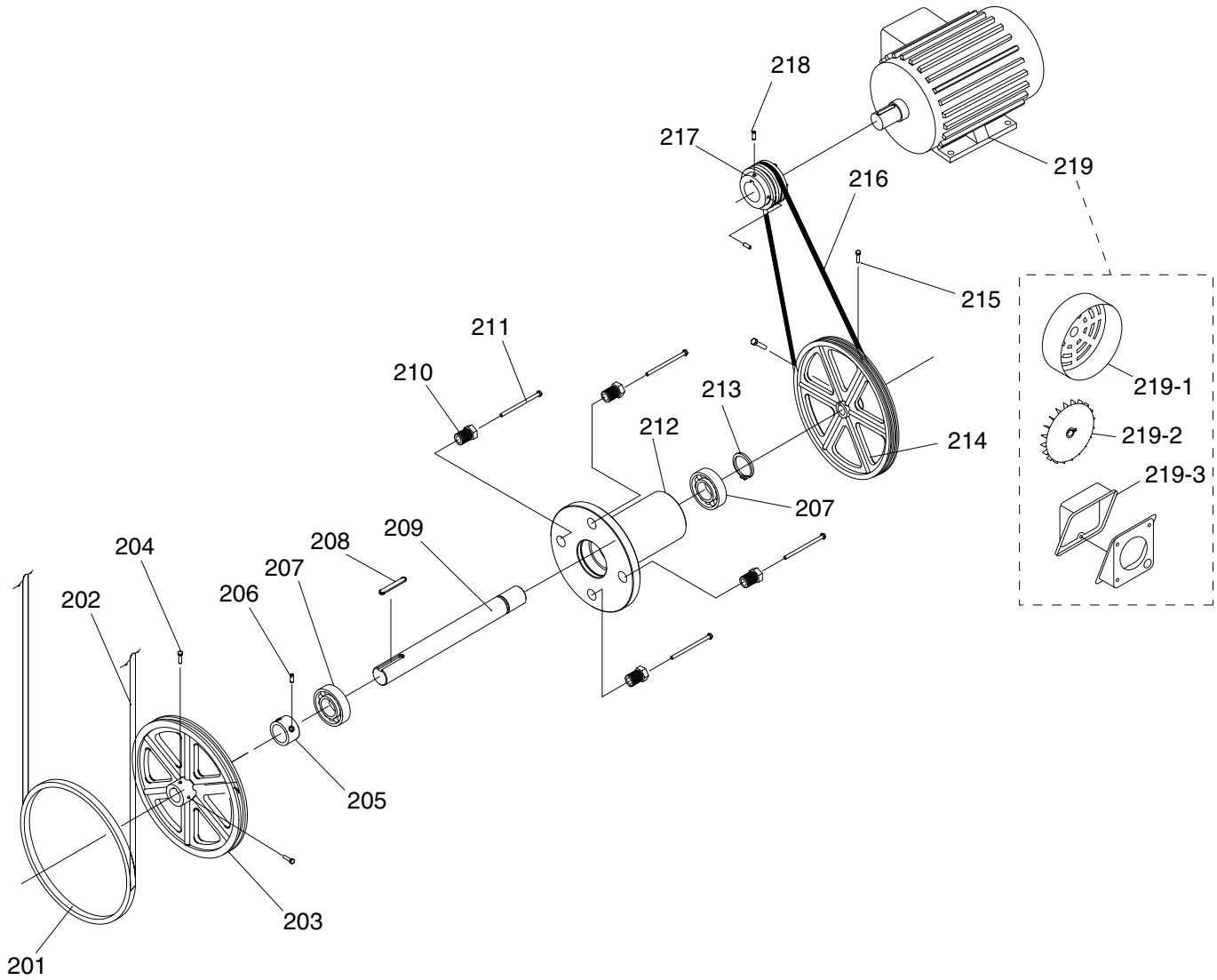


REF	PART #	DESCRIPTION
101	PSB02M	CAP SCREW M6-1 X 20
102	PLW03M	LOCK WASHER 6MM
103	P0668103	BLADE GUIDE
104	P0668104	BLADE GUIDE BRACKET LOWER
105	P0668105	GUIDE POST LOWER
106	PSB06M	CAP SCREW M6-1 X 25
107	P0668107	BLADE SUPPORT
108	PN04	HEX NUT 5/8-11
109	PLW06	LOCK WASHER 5/8

REF	PART #	DESCRIPTION
110	PW01M	FLAT WASHER 8MM
111	PSB14M	CAP SCREW M8-1.25 X 20
112	P0668112	TRUNNION BASE
113	PSB14M	CAP SCREW M8-1.25 X 20
114	PW01M	FLAT WASHER 8MM
115	P0668115	TRUNNION
116	P0668116	TABLE TILT LOCK 5/8-11 X 2
117	P0668117	TABLE



# Motor & Lower Wheel

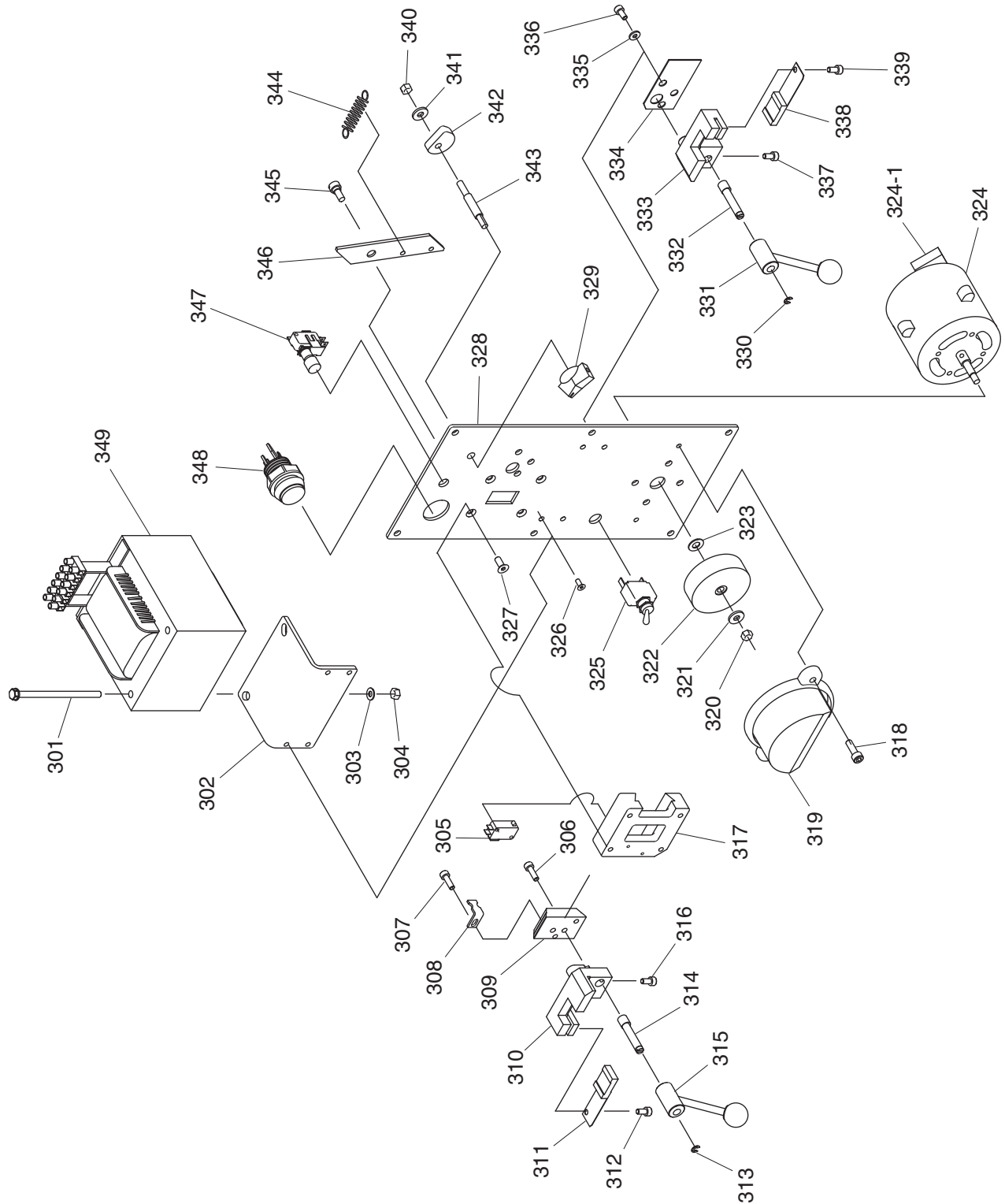


REF	PART #	DESCRIPTION
201	P0668201	WHEEL TIRE
202	P0668202	BANDSAW BLADE 3/8"W STANDARD
203	P0668203	WHEEL LOWER
204	PB170M	HEX BOLT M10-1.5 X 10
205	P0668205	COLLAR
206	PSS20M	SET SCREW M8-1.25 X 8
207	P6206Z	BALL BEARING 6206Z
208	PK107M	KEY 8 X 8 X 20
209	P0668209	LOWER WHEEL SHAFT
210	P0668210	SPECIAL SCREW
211	PB73M	HEX BOLT M10-1.5 X 50

REF	PART #	DESCRIPTION
212	P0668212	BEARING HOUSING
213	PR15M	EXT RETAINING RING 30MM
214	P0668214	WHEEL PULLEY
215	PSS105M	SET SCREW M12-1.75 X 35
216	PVA66	V-BELT A-66 4L660
217	P0668217	MOTOR PULLEY
218	PSS16M	SET SCREW M8-1.25 X 10
219	P0668219	MOTOR 2HP 220V 3PH
219-1	P0668219-1	MOTOR FAN COVER
219-2	P0668219-2	MOTOR FAN
219-3	P0668219-3	MOTOR WIRING JUNCTION BOX



# Welding Station



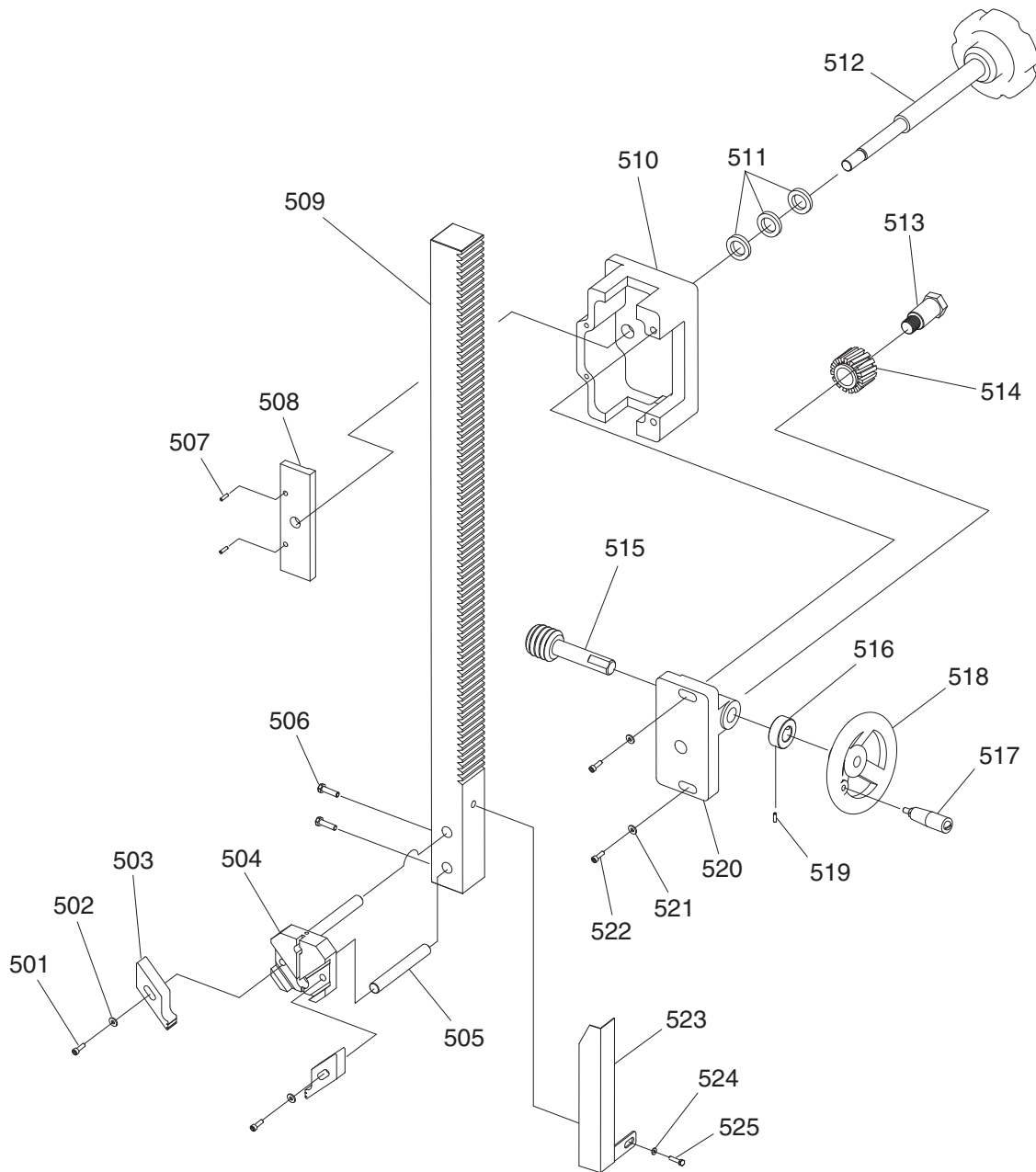
# Welding Station Parts List

REF	PART #	DESCRIPTION
301	PB96	HEX BOLT 1/4-20 X 4
302	P0668302	TRANSFORMER BRACKET
303	PW03M	FLAT WASHER 6MM
304	PN01M	HEX NUT M6-1
305	P0668305	LIMIT SWITCH
306	PSB06M	CAP SCREW M6-1 X 25
307	PSB04M	CAP SCREW M6-1 X 10
308	P0668308	LIMIT SWITCH BRACKET
309	P0668309	SLIDING BLOCK
310	P0668310	WELDING CLAMP LEFT
311	P0668311	WELDING JAW LEFT
312	PSB26M	CAP SCREW M6-1 X 12
313	PEC09M	E-CLIP 6MM
314	P0668314	SHAFT
315	P0668315	CLAMP LEVER
316	PSB26M	CAP SCREW M6-1 X 12
317	P0668317	SLIDING BLOCK BASE
318	PSB01M	CAP SCREW M6-1 X 16
319	P0668319	GRINDER COVER
320	PN01M	HEX NUT M6-1
321	PW03M	FLAT WASHER 6MM
322	P0668322	GRINDING WHEEL 2-1/2"D
323	PW03M	FLAT WASHER 6MM
324	P0668324	GRINDER MOTOR 1/8HP 220V 1PH
324-1	P0668324-1	S CAPACITOR 3M 250V 3/4 X 1-1/4

REF	PART #	DESCRIPTION
325	P0668325	ON/OFF SWITCH
326	PS11M	PHLP HD SCR M6-1 X 16
327	PS26M	PHLP HD SCR M6-1 X 20
328	P0668328	WELDING PANEL
329	P0668329	CLAMP PRESSURE KNOB
330	PEC09M	E-CLIP 6MM
331	P0668331	CLAMP LEVER
332	P0668332	SHAFT
333	P0668333	WELDING CLAMP RIGHT
334	P0668334	INSULATING PLATE
335	PW03M	FLAT WASHER 6MM
336	PSB02M	CAP SCREW M6-1 X 20
337	PSB02M	CAP SCREW M6-1 X 20
338	P0668338	WELDING JAW RIGHT
339	PSB02M	CAP SCREW M6-1 X 20
340	PN01M	HEX NUT M6-1
341	PW03M	FLAT WASHER 6MM
342	P0668342	PRESSURE CAM
343	P0668343	CAM SHAFT
344	P0668344	TENSION SPRING
345	PS04	PHLP HD SCR 1/4-20 X 1/2
346	P0668346	BRACKET
347	P0668347	ANNEALING PUSH BUTTON
348	P0668348	WELDING PUSH BUTTON
349	P0668349	TRANSFORMER 4.2KVA 220V



# Guide Post

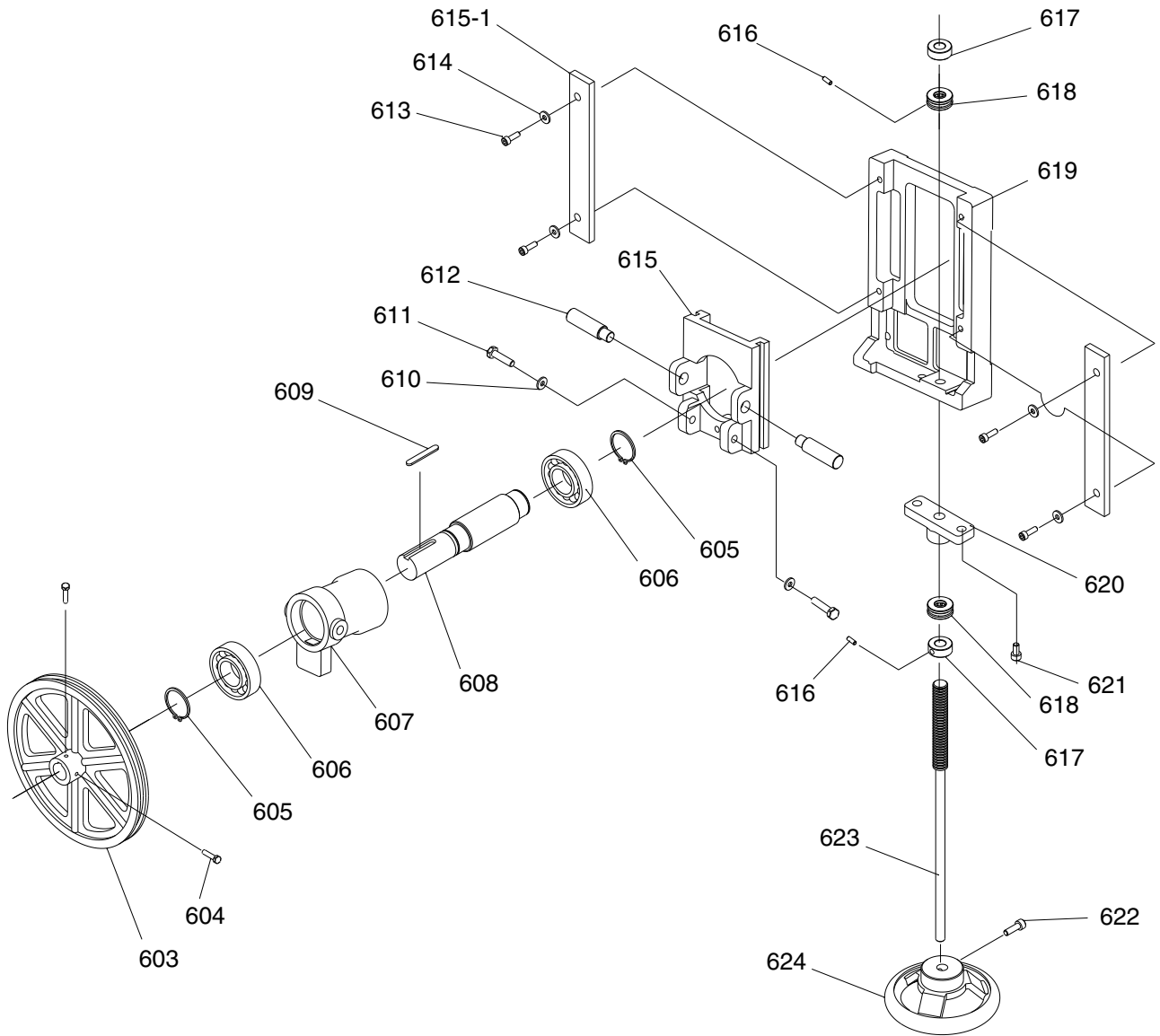


REF	PART #	DESCRIPTION
501	PSB02M	CAP SCREW M6-1 X 20
502	PW03M	FLAT WASHER 6MM
503	P0668503	BLADE GUIDE
504	P0668504	BLADE GUIDE BRACKET UPPER
505	P0668505	BLADE SUPPORT
506	PSB02M	CAP SCREW M6-1 X 20
507	P0668507	PIN 4 X 6
508	P0668508	GUIDE POST CLAMP PLATE
509	P0668509	GUIDE POST RACK
510	P0668510	GUIDE POST BRACKET
511	PLW08M	LOCK WASHER 14MM
512	P0668512	LOCK KNOB
513	P0668513	SPECIAL SCREW

REF	PART #	DESCRIPTION
514	P0668514	GUIDE POST PINION GEAR
515	P0668515	WORM GEAR
516	P0668516	COLLAR
517	P0668517	HANDWHEEL HANDLE
518	P0668518	HANDWHEEL
519	PSS02M	SET SCREW M6-1 X 6
520	P0668520	BRACKET
521	PLW03M	LOCK WASHER 6MM
522	PSB02M	CAP SCREW M6-1 X 20
523	P0668523	BLADE GUARD
524	PW01M	FLAT WASHER 8MM
525	PSB100M	CAP SCREW M8-1.25 X 15



# Upper Wheel



REF	PART #	DESCRIPTION
603	P0668603	WHEEL UPPER
604	PB170M	HEX BOLT M10-1.5 X 10
605	PR09M	EXT RETAINING RING 20MM
606	P6304Z	BALL BEARING 6304Z
607	P0668607	BEARING HOUSING
608	P0668608	UPPER WHEEL SHAFT
609	P0668609	KEY
610	P0668610	SPECIAL WASHER
611	P0668611	SPECIAL BOLT
612	P0668612	PIVOT PIN
613	PB07M	HEX BOLT M8-1.25 X 25
614	PW01M	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
615	P0668615	UPPER WHEEL BRACKET
615-1	P0668615-1	BRACKET PLATE
616	PSS02M	SET SCREW M6-1 X 6
617	P0668617	COLLAR
618	P2901	THRUST BEARING 2901
619	P0668619	TENSIONING BRACKET
620	P0668620	LEADSCREW BRACKET
621	PB07M	HEX BOLT M8-1.25 x 25
622	PB17M	HEX BOLT M8-1.25 X 10
623	P0668623	TENSIONING LEADSCREW
624	P0668624	TENSIONING HANDWHEEL



# Labels



REF	PART #	DESCRIPTION
401	P0668401	MODEL # LABEL
402	P0668402	BLADE SPECIFICATION LABEL
403	P0668403	POWER DISCONNECT LABEL VERT S
404	P0668404	EYE/LUNG HAZARD LABEL VERT L
405	PLABEL-12	READ MANUAL LABEL VERT L
406	G8588	GRIZZLY NAMEPLATE 9-1/2" X 4-1/2"

REF	PART #	DESCRIPTION
407	P0668407	MACHINE ID LABEL
408	P0668408	BLADE HAZARD LABEL VERT L
409	P0668409	DOOR INJURY HAZARD LABEL VERT S
410	PPAINT-11	GRIZZLY PUTTY TOUCH UP PAINT
412	P0668412	STABLE WORKPIECE 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.

