MODEL G0624
10" BENCHTOP LATHE
OWNER'S MANUAL

Model G0624 shown with optional Model G0625 Bed Extension.

#BL86839 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.

Table of Contents

INTRODUCTION

Foreword

We are proud to offer the Model G0624 10" Benchtop Lathe. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0624. 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 G0624 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

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

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

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

MACHINE DATA SHEET

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

MODEL G0624 10" CAST IRON BENCHTOP LATHE

Product Dimensions:

Weight	89 lbs.
Length/Width/Height	21 5/8" x 15 1/2" x 9 1/2" in.
Foot Print (Length/Width)	56 x 8 3/4 in.

Shipping Dimensions:

Type	Cardboard
Content	Machine
Weight	113 lbs.
Length/Width/Height	37 3/8" x 11 5/8" x 17 21/64"

Electrical:

Switch	Paddle Type w/Lockout Key
Switch Voltage	110V
Cord Length	8.2 ft.
Cord Gauge	18 gauge
Recommended Circuit Breaker Size	15 amp
Plug	5-15

Motors:

Main

Type	Capacitor Start
Horsepower	1/2 HP
Voltage	110V
Prewired	110V
Phase	Single
Amps	6A
Speed	1725 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Belt Drive
Bearings	Shielded and Lubricated

Main Specifications:

Construction

Swing Over Bed	10"
Swing Over Tool Rest	7 1/2"
Distance Between Centers	15"
Spindle Size	7 51/64" x 1 7/8"
Spindle TPI	1" x 8 TPI
Outboard Spindle TPI	1"
Spindle Bore	23/64" TPI
Spindle Taper	MT#2
Spindle Center	5"
Tailstock Taper	MT#2
Tailstock Center	5"
Number of Spindle Speeds	6
Range of Spindle Speeds	480, 1270, 1960, 2730, 3327, 4023 RPM
Bed Width	8 3/16" RPM

Floor-to-Center Height	$13\frac{5}{32}$"
Faceplate Size	3"
Bed Construction	Cast Iron
Frame Construction	Cast Iron and Steel
Headstock Construction	Cast Iron and Steel
Tailstock Construction	Cast Iron and Steel

Other Specifications:

Country Of Origin	China
Warranty	1 Year
ISO Factory	Yes
Serial Number Location	Data Label on Headstock
Assembly Time	10 minutes
Sound Rating	Less than 80 decibels

Identification

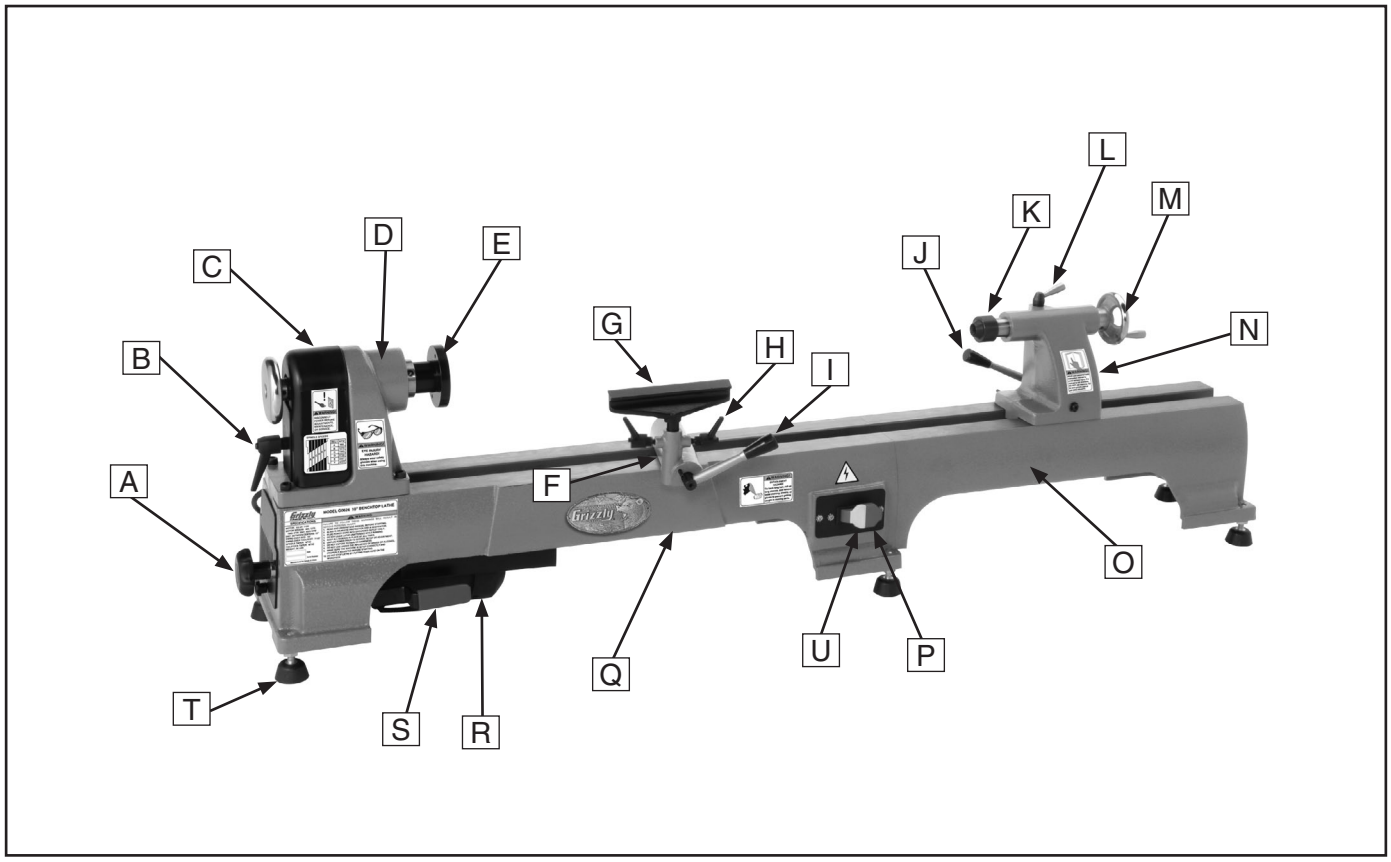


Figure 1. Model G0624 identification.

A. Belt Tension Lock Knob
B. Belt Cover Lock Handle
C. Belt Cover
D. Headstock
E. Faceplate
F. Tool Rest Base
G. Tool Rest
H. Tool Rest Lock Handle
I. Tool Rest Release Lever
J. Tailstock Release Lever
K. Live Center
L. Quill Lock Handle
M. Quill Handwheel
N. Tailstock
O. Bed Extension (optional)
P. ON/OFF Switch
Q. Lathe Bed
R. Motor
S. Belt Tension Lever
T. Foot
U. Safety Key

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

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

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

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

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

⚠WARNING

Safety Instructions for Machinery

1. **READ 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 A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch 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 CHILDPROOF.** 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 LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

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 or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase 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.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Additional Safety for Wood Lathes

1. **KEEPING GUARDS IN PLACE.** Make sure all guards are in place and that the lathe sits on a flat, stable surface.

2. **EYE/FACE PROTECTION.** Always wear eye protection or a face shield when operating the lathe.

3. **RESPIRATORY PROTECTION.** Always wear a respirator when using this machine. Wood dust may cause allergies or long-term respiratory health problems.

4. **MOUNTING WORKPIECE.** Before starting, be certain the workpiece has been properly imbedded on the headstock and tailstock centers and that there is adequate clearance for the full rotation.

5. **WORKPIECE CONDITION.** Always inspect the condition of your workpiece. DO NOT turn pieces with knots, splits, and other potentially dangerous conditions. Make sure joints of glued-up pieces have high quality bonds and won't fly apart during operation.

6. **ADJUSTING TOOL REST.** Adjust tool rest to provide proper support for the turning tool you will be using. Test tool rest clearance by rotating workpiece by hand before turning lathe ***ON***.

7. **TURNING SPEED.** Select the correct tuning speed for your work, and allow the lathe to gain full speed before using.

8. **USING SHARP CHISELS.** Keep lathe chisels properly sharpened and held firmly in position when turning.

9. **OPERATING DAMAGED LATHE.** Never operate the lathe with damaged or worn parts.

10. **ADJUSTMENTS/MAINTENANCE.** Make sure your wood lathe is turned ***OFF***, disconnected from its power source, and all moving parts have come to a complete stop before starting any inspection, adjustment, or maintenance procedure.

11. **STOPPING LATHE.** DO NOT stop the lathe by using your hand against the workpiece. Allow the lathe to stop on its own.

12. **AVOIDING ENTANGLEMENT.** Keep long hair and loose clothing articles such as sleeves, belts, and jewelry items away from the lathe spindle.

13. **FACEPLATE TURNING.** When faceplate turning, use lathe chisels on the downward spinning side of the workpiece only.

14. **SANDING/POLISHING.** Remove the tool rest when performing sanding or polishing operations on the rotating spindle.

15. **MATERIAL REMOVAL RATE.** Removing too much material at once may cause workpiece to fly out of the lathe.

16. **REDUCING WORKPIECE VIBRATION**. If the workpiece vibrates, immediately turn the lathe ***OFF***. Check to make sure the workpiece is centered and balanced. Trim excess waste off corners with a bandsaw or table saw to reduce vibration. Make sure workpiece is securely attached in setup.

⚠WARNING

Like all machinery there is potential danger when operating 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

110V Operation

⚠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 G0624 motor draws the following amps under maximum load:

Motor Draw.....6 Amps

Circuit Recommendations

We recommend connecting your machine to a dedicated and grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit 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, consult a qualified electrician.**

110V Circuit.....15 Amps

Plug/Receptacle Type

Included Plug Type.....NEMA 5-15

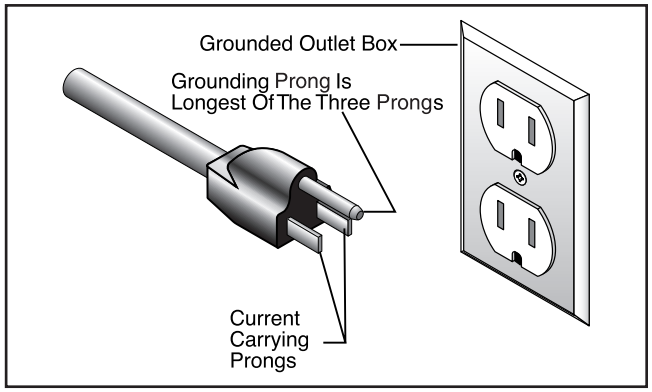
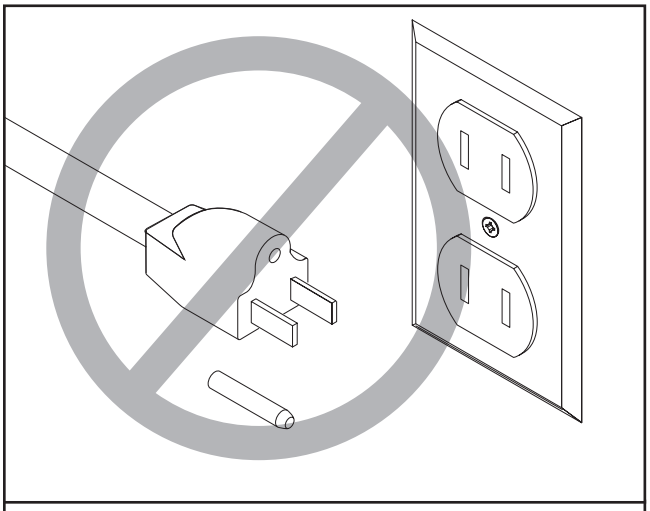


Figure 2. Typical type 5-15 plug and receptacle.

⚠WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!



⚠CAUTION

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

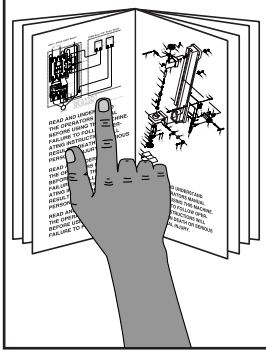
Extension Cords

We do not recommend the use of extension cords, but if you find it absolutely necessary:

- Use at least a 14 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor 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 G0624 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Setup

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

Description	Qty
• Cleaning Solvent (as needed)	1

Unpacking

The Model G0624 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, inventory the contents.

Inventory

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

Box Contents: (Figure 3)		Qty
A.	10" Benchtop Lathe (Not Shown)	1
B.	Safety Glasses	1
C.	Live Center	1
D.	Spur Center	1
E.	3" Faceplate	1
F.	Tool Rest	1
G.	Knock Out Bar	1
H.	Tool Rest Lock Handles	2

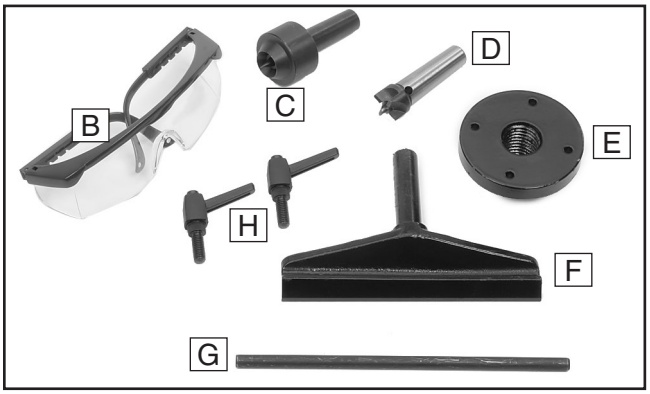


Figure 3. Additional box items.

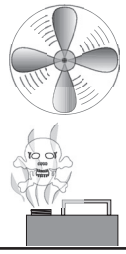
If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

Clean Up

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

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G7895—Grizzly Citrus Degreaser
This natural, citrus-based degreaser is a great solution for removing export grease, and it's much safer to work around than nasty solvents.

Figure 4. Grizzly citrus degreaser.

Site Considerations

Floor Load

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

Placement Location

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.

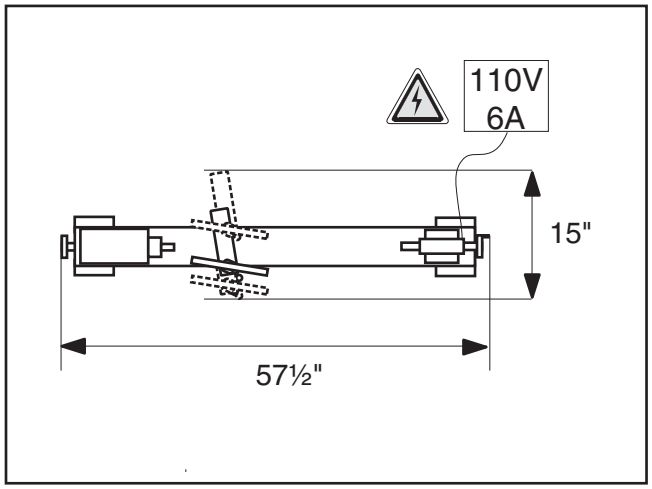
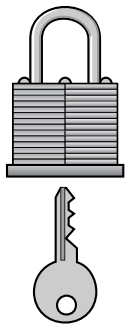


Figure 5. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised. Lock all entrances to the shop when you are away. DO NOT allow unsupervised children or visitors in your shop at any time!

Assembly

To install the tool rest:

1. Turn the release lever on the tool rest base so it does not interfere with assembly.

2. Thread the tool rest lock handles into the tool rest base (**Figure 6**) until the threaded ends of the handles are flush with the inside of the shaft.

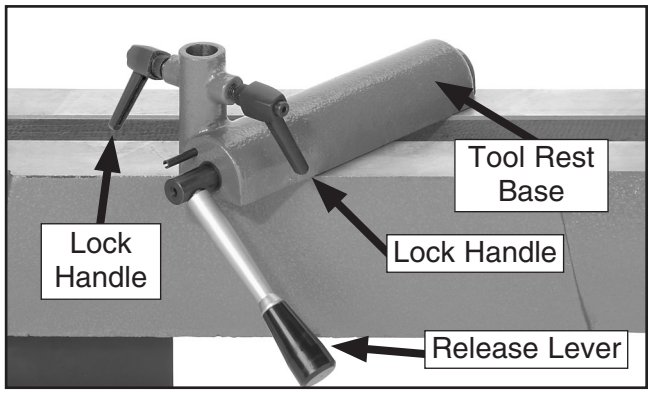


Figure 6. Tool rest lock handles installed onto tool rest base.

3. Insert the tool rest into the shaft and turn the handles to lock it as shown in **Figure 7**.

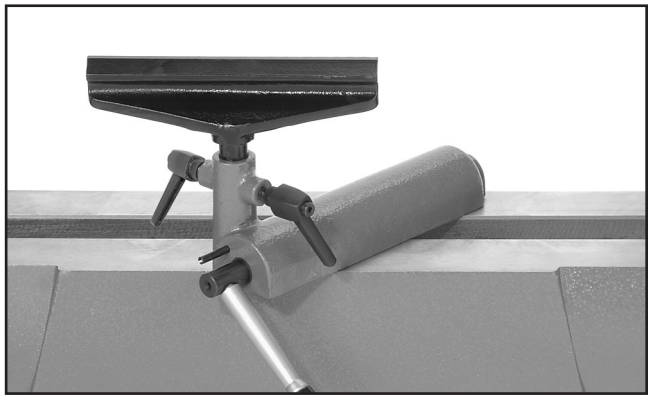


Figure 7. Tool rest installed.

4. Install the optional bed extension, Model G0625 (**Page 21**). Refer to the instruction sheet included with the bed extension.

Test Run

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

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

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 24**. If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure that you have read the safety instructions at the beginning of this manual and that the machine is setup properly.

2. Connect the machine to the power source.

3. Flip the paddle switch up to turn the machine ***ON***. Make sure that your hand stays poised over the switch in case you need to quickly turn the machine ***OFF***.

   —When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

   —Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

4. Turn the machine ***OFF***.

5. Remove the safety key and attempt to turn the machine ***ON***.

   —If the machine starts, stop it. The switch disabling feature is not working. This safety feature must work properly before proceeding. Call Tech Support for help.

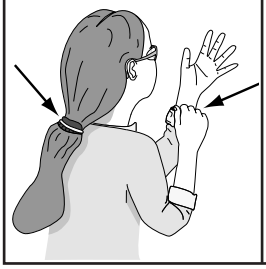
   —If the machine does not start, the switch disabling feature is working.

SECTION 4: OPERATIONS

Operation Safety

⚠WARNING

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



⚠WARNING

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

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, 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.

Changing Speeds

To change speeds, the belt in the headstock must be rearranged. A chart on the pulley cover shows the belt positions needed to make the lathe run at the desired speed.

To change speeds:

1. Loosen the lock handle, remove the belt cover, and open the access plate (**Figure 8**).

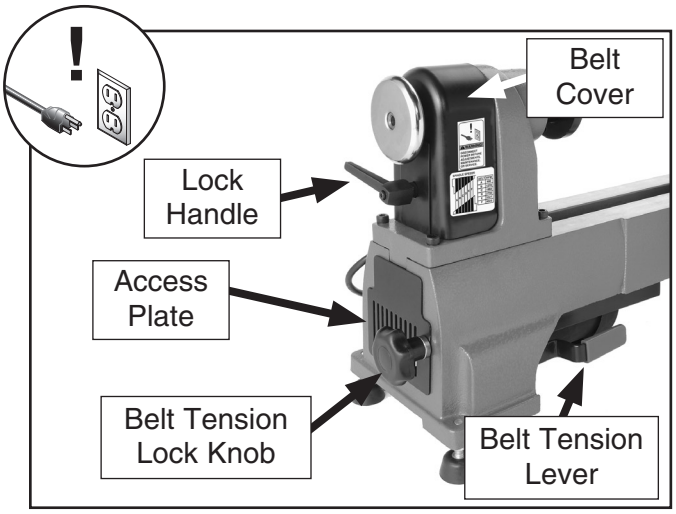
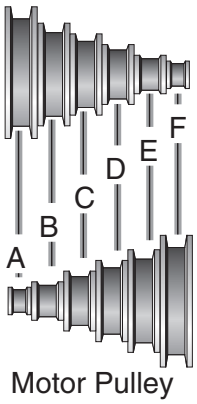


Figure 8. Belt access.

2. Loosen the belt tension lock knob, and move the belt tension lever up to reduce tension on the belt.

3. Locate the desired speed on the speed chart on the belt cover, and move the belt to the desired grooves on the motor and spindle pulleys.

   For Example: As indicated in the speed chart, belt position **B** creates **1270 RPM** (**Figure 9**).



BELT	60 Hz
A	480
B	1270
C	1960
D	2730
E	3327
F	4023

Figure 9. G0624 Spindle speeds.

4. Move the belt tension lever down, tighten the lock knob, and reinstall the access plate and belt cover.

Adjusting Tailstock

The tailstock is equipped with a cam-action clamping system to secure it to the lathe bed. When the lever is tightened, a locking plate lifts up and secures the tool rest to the bed.

To position the tailstock along the bed:

1. Loosen the release lever and move the tailstock to the desired position (**Figure 10**).

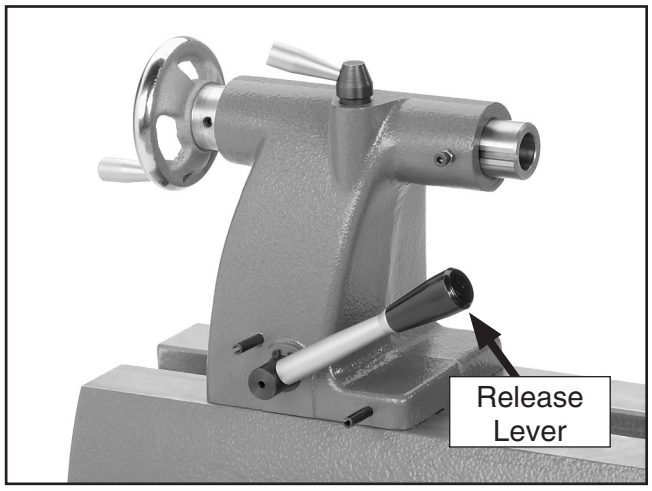


Figure 10. Tailstock controls.

2. Re-engage the release lever.

3. If the release lever will not lock the tailstock down onto the bed (either too loose or too tight), loosen or tighten the hex nut (located on the underside of the tailstock) in small increments as needed to achieve the proper clamping pressure.

Adjusting Tool Rest

The tool rest is equipped with a cam-action clamping system to secure it to the lathe bed. When the lever is engaged, a locking plate lifts up and secures the tool rest base to the bed.

To position the tool rest base along the bed:

1. Loosen the release lever and slide the tool rest base along the bed (**Figure 11**).

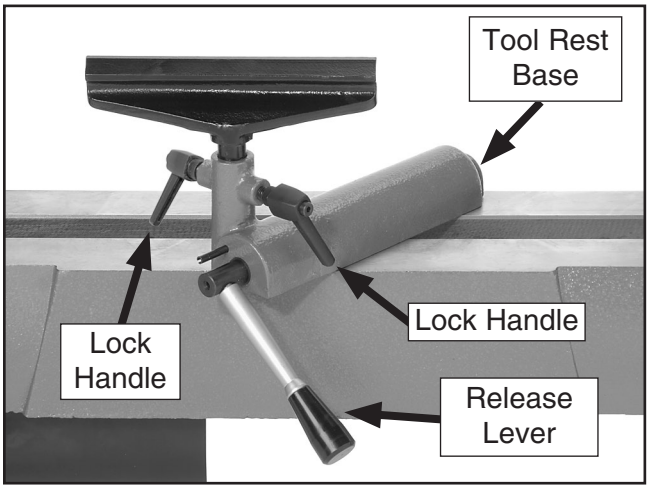


Figure 11. Tool rest controls.

2. Re-engage the release lever to lock the tool rest base in place.

   —If the release lever will not lock the tool rest base onto the bed (either too loose or too tight), then loosen or tighten the hex nut (located on the underside of the tool rest base) in small increments as needed to achieve the proper clamping pressure.

To adjust the tool rest vertically:

1. Loosen the lock handles (**Figure 11**) and adjust the tool rest vertically or swivel it as needed.

2. Tighten the lock handles.

Installing/Removing Spur Center

The spur center installs into the headstock spindle with a taper fit.

To install the spur center:

1. UNPLUG LATHE FROM POWER!

2. Insert the tapered end of the center into the spindle, and push it in quickly and firmly (see **Figure 12**).

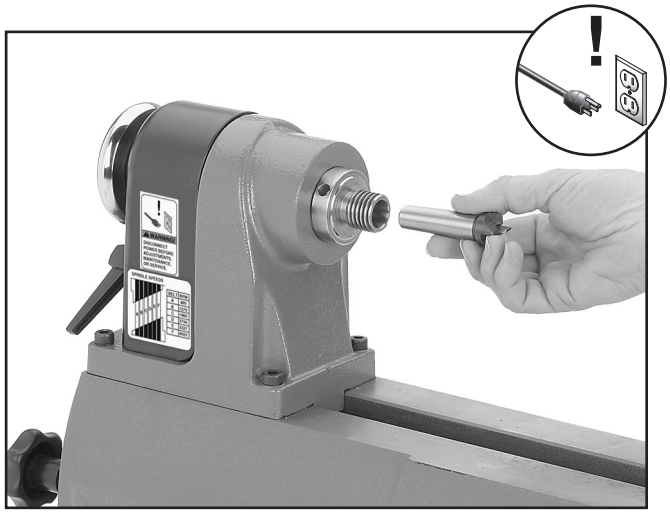


Figure 12. Inserting spur center into spindle.

3. Check that the center is securely installed by giving it a quick tug. (A properly installed center will not pull out by hand.)

To remove the spur center with the knock-out bar:

1. UNPLUG LATHE FROM POWER!

2. Hold a clean rag under the spindle or wear a glove to catch the center when you remove it.

3. Using the knock-out bar, tap the center from the outside end of the spindle (as shown in **Figure 13**) and catch the center as it falls out.

Figure 13. Removing spur center using the knock out bar.

Installing/Removing Live Center

To install the live center:

1. Loosen the quill lock handle (if locked) approximately half a turn counterclockwise.

2. Rotate the quill handwheel clockwise until the tailstock quill protrudes out of the tailstock housing about ¾".

3. Insert the live center, as shown in **Figure 14**, and push firmly.

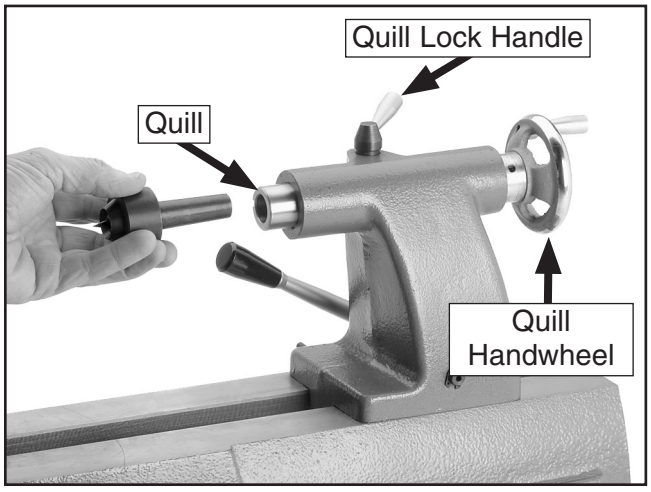


Figure 14. Installing live center in tailstock.

4. Tighten the lock handle.

To remove the live center:

1. Turn the quill handwheel counterclockwise until the tailstock quill bottoms out, causing the center to be forced out of the quill.

⚠WARNING

The tailstock quill lock handle must always be locked down while the lathe is in use. The workpiece can be thrown from the lathe if this step is not observed. Also, the tailstock quill should not protrude from the tailstock housing more than 2" or the quill will not be supported enough. Failure to follow these warnings may result in personal injury.

Installing/Removing Faceplate

The faceplate can be installed only if the spur center has been removed from the headstock spindle. The knock-out bar is included with the lathe for installing and removing the faceplate.

To install the faceplate:

1. UNPLUG LATHE FROM POWER!
2. Remove the spur center (See **Page 15**).
3. Thread the faceplate onto the headstock spindle.
4. Using the knock-out bar, hand tighten the faceplate as shown in **Figure 15**.

   Note: *Reverse **Steps 3-4** to remove the faceplate.*

Figure 15. Tightening faceplate.

To mount a workpiece to your faceplate, refer to **Page 19**.

Selecting Turning Tools

Lathe tools come in a variety of shapes and sizes and usually fall into five major categories.

- **Gouges**—Mainly used for rough cutting, detail cutting, and cove profiles. The rough gouge is a hollow, double-ground tool with a round nose, and the detail gouge is a hollow, double-ground tool with either a round or pointed nose. **Figure 16** shows an example of a gouge.

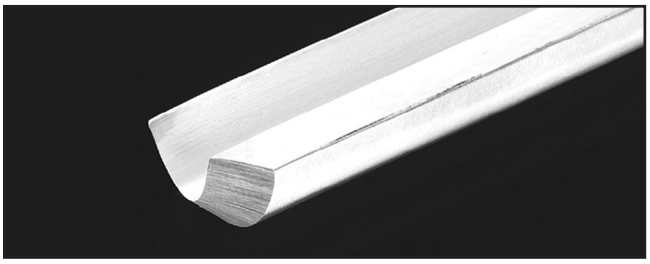


Figure 16. Gouge.

- **Skew Chisel**—A very versatile tool that can be used for planing, squaring, V-cutting, beading, and parting off. The skew chisel is flat, double-ground with one side higher than the other (usually at an angle of 20-40˚).

Figure 17 shows an example of a skew chisel.

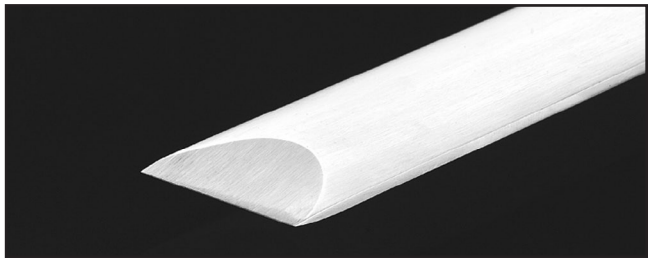


Figure 17. Skew chisel.

- **Scrapers**—Mainly used where access for other tools is limited, such as hollowing operations. This is a flat, double-ground tool that comes in a variety of profiles (Round Nose, Spear Point, Square Nose, etc.) to match many different contours. **Figure 18** shows an example of a round nose scraper.

Figure 18. Round nose scraper.

- **Parting Tools**—Used for sizing and cutting off work. This is a flat tool with a sharp pointed nose that may be single- or double-ground. **Figure 19** shows an example of a parting tool.

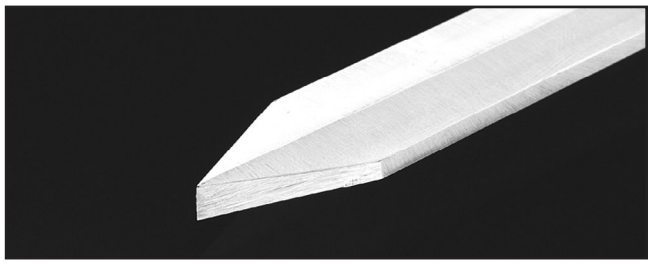


Figure 19. Parting tool.

- **Specialty Tools**—These are the unique, special function tools to aid in hollowing, bowl making, cutting profiles, etc. The Swan Neck Hollowing Tool shown on **Page 22** is a good example of a specialty tool.

Spindle Turning

Spindle turning (**Figure 20**) is the operation performed when a workpiece is mounted between the headstock and the tailstock.

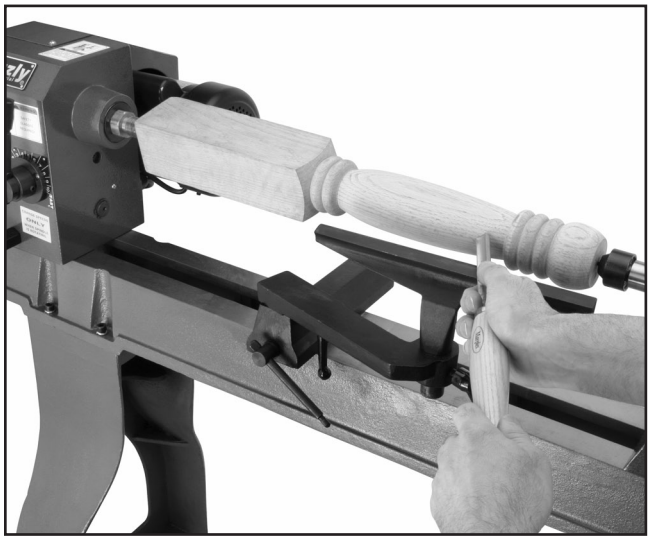


Figure 20. Typical spindle turning operation.

To set up a spindle turning operation:

1. Mark both ends of your workpiece by drawing diagonal lines from corner to corner. The intersection point of these lines will show you the center of your workpiece. See **Figure 21** for details.

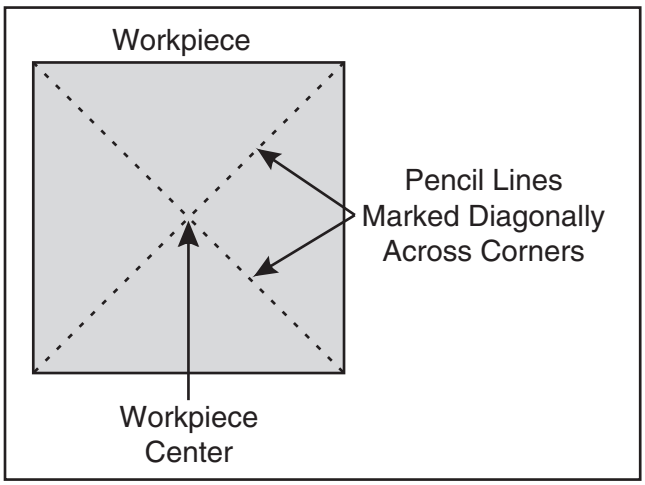


Figure 21. Workpiece marked diagonally from corner to corner to determine the center.

2. Using a wood mallet, tap the point of the spur center into the center of the workpiece, so that it leaves a center mark, then remove the spur center.

3. Using a ⅛" drill bit, drill a 3⁄16" deep hole at the center mark.

4. Cut the corners off your workpiece if it is over 2" x 2" to make turning safer and easier.

5. Drive the spur center into the center of the workpiece with a wood mallet to embed it at least ¼", as shown in **Figure 22**.

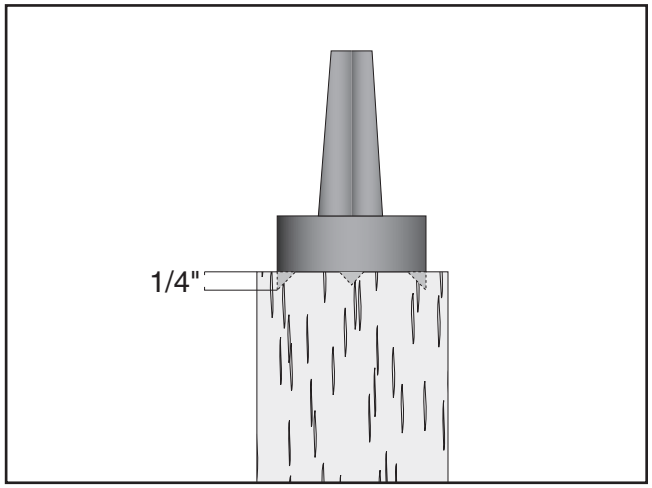


Figure 22. Spur center properly embedded.

6. With the workpiece still attached, insert the spur center into the headstock spindle.

7. With the live center installed in the tailstock, slide the tailstock toward the workpiece until the live center touches the workpiece centerpoint, then lock the tailstock in this position.

8. Use the quill handwheel to push the live center into the workpiece at least a ¼".

⚠WARNING

Do not press the workpiece too firmly with the tailstock or the bearings will bind and overheat. Likewise, do not adjust too loosely or the workpiece will spin off the lathe. Use good judgement. Serious personal injury could result if care is not taken.

9. Position the tool rest approximately ¼" away from the workpiece and approximately ⅛" above the center line, as shown in **Figure 23**.

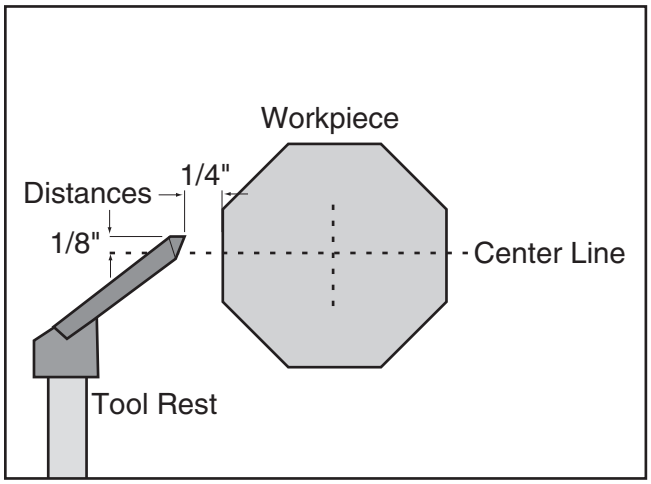


Figure 23. Tool rest set ⅛" above the center line and ¼" away from workpiece.

10. Test the setup by hand turning the workpiece to make sure there is enough clearance all the way around before starting.

Spindle Turning Tips:

- When turning the lathe ***ON***, stand to the side of the spinning direction until the lathe reaches full speed and you can verify that the lathe will not throw the workpiece.

- Use the slowest speed when starting or stopping the lathe, and when rough cutting.

- Select the right speed for the size of workpiece you are turning. Use slower speeds for large workpieces (4" diameter and over); use the middle range speeds for medium sized workpieces (2" to 4" diameter); and use faster speeds for small sized workpieces (under 2" in diameter).

- Keep the turning tool on the tool rest the ENTIRE time that it is in contact with the workpiece.

- Learn the correct techniques for each tool you will use. If you are unsure, read books or magazines about lathe techniques and seek training from experienced users.

- Turn the lathe ***OFF*** immediately if the workpiece vibrates excessively. Check to make sure the workpiece is centered and balanced. Remove the workpiece and trim excess waste off corners with a bandsaw or table saw to reduce vibration. Make sure workpiece is securely attached in the setup.

Faceplate Turning

Faceplate turning (**Figure 24**) is when a workpiece is mounted to the faceplate, which is mounted to the headstock spindle. This type of turning is usually done with open-faced workpieces like bowls.

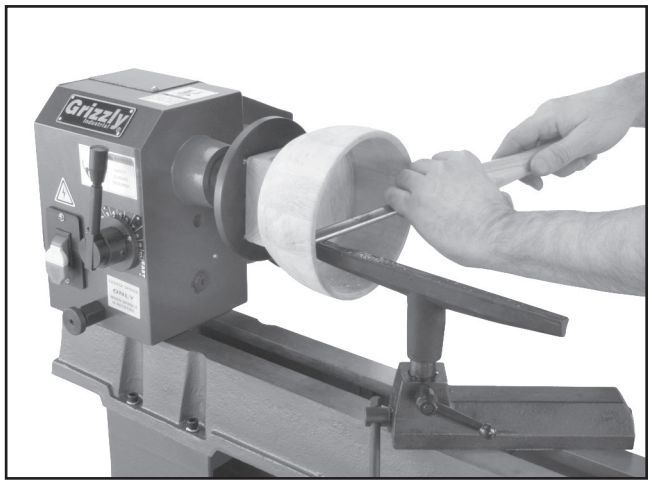


Figure 24. Typical faceplate turning operation.

To mount your workpiece to the faceplate:

1. Find the center of your workpiece in the same manner as when spindle turning.

2. Cut off the corners of the workpiece.

3. Center the faceplate on the workpiece and attach it through the faceplate holes with wood screws.

4. Thread the faceplate onto the headstock spindle and tighten securely.

Note: *If screws cannot be placed in the workpiece, then a backing block can be glued to the workpiece and attached to the faceplate with screws.*

NOTICE: *Only use tap screws or wood screws with non-tapered heads (**Figure 25**) to attach the faceplate to the workpiece. Do NOT use drywall screws or screws with tapered heads because these can split the faceplate, or the screws may snap off during operation.*

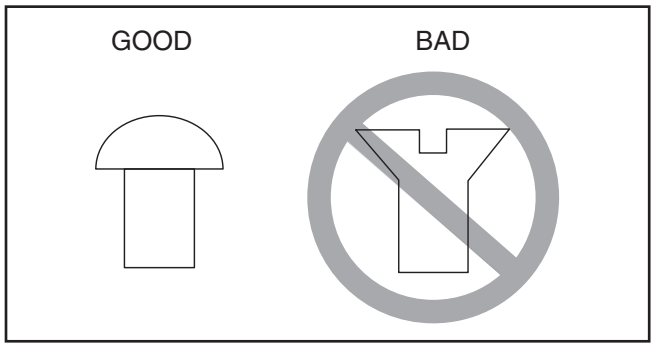


Figure 25. Correct and incorrect screw types for mounting faceplate to workpiece.

To mount your workpiece to a backing block:

1. Make the backing block (**Figure 26**) from a piece of scrap wood that is flat on both sides.

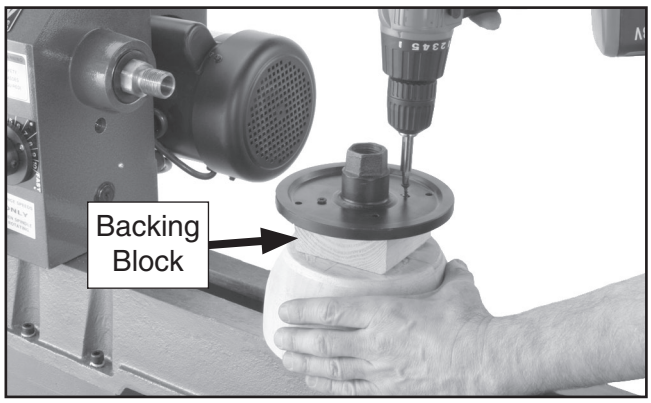


Figure 26. Example of mounting faceplate to a backing block.

2. Locate and mark the center of both the workpiece and the backing block.

3. Drill a ¼" hole in the center of the backing block.

4. Glue the center of the backing block to the center of the workpiece (look through the drilled hole to line up centers), clamp the backing block to the workpiece, and wait for the glue to cure according to the manufacturer's recommendation.

Sanding/Finishing

After turning, the workpiece can be sanded, as shown in **Figure 27**, and finished (in the same manner) before removing it from the lathe.

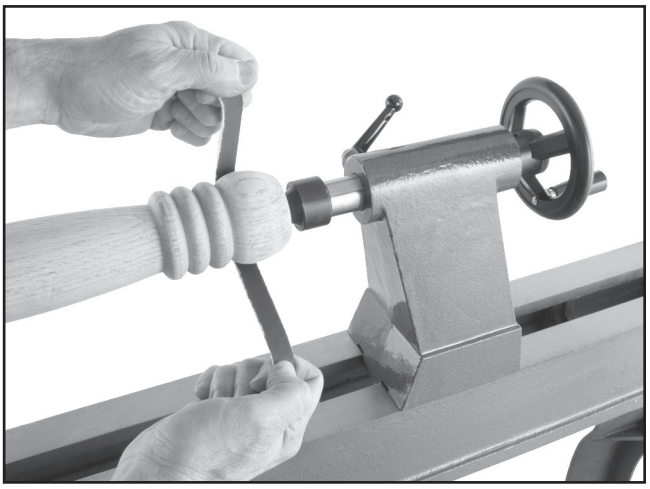
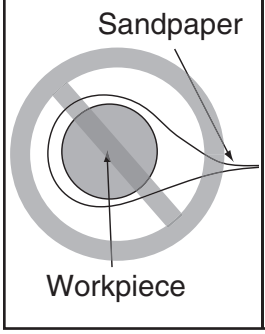


Figure 27. Typical sanding operation.



⚠CAUTION

Wrapping the sandpaper completely around the workpiece will pull your hands into the moving workpiece and may cause injury. Never wrap sandpaper completely around the workpiece!

Whenever sanding or finishing, move the tool rest holder out of the way to increase personal safety and gain adequate working room.

SECTION 5: ACCESSORIES

G1194—3-Jaw Chuck
A "must have" for the serious wood turner. This 3-jaw chuck is a self-centering style chuck used mostly for round work. All three jaws tighten together at the same time. Jaws are reversible for expanded work holding capacity. *Threaded insert required for mounting!*

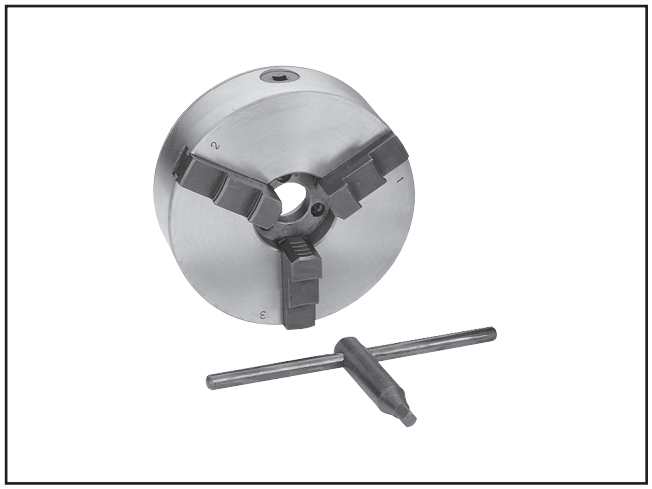


Figure 28. Model G1194 3-Jaw Chuck.

G1082—4-Jaw Chuck
Another "must have" for the serious wood turner. This 4-jaw chuck is an independent type chuck that is used for square and odd-shaped pieces. Each jaw tightens individually and can be turned around to hold larger dimension workpieces. *Threaded insert required for mounting!*

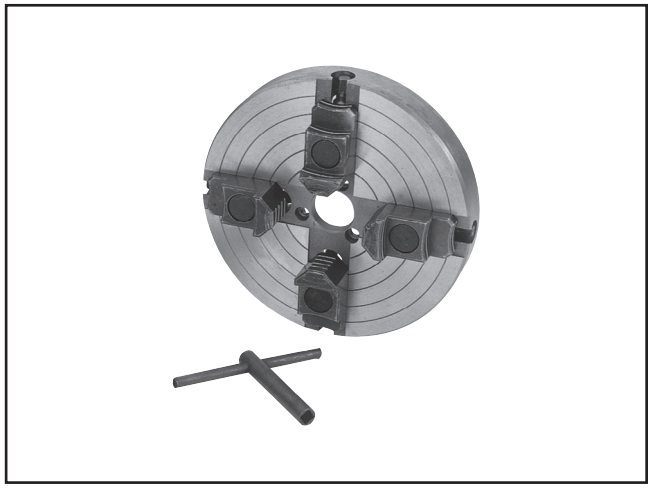


Figure 29. Model G1082 4-Jaw Chuck.

G3163—1" x 8 TPI RH Threaded Insert
This threaded insert is required to mount a 3- or 4-jaw chuck to your wood lathe.

H7828—Tool Table Plus
The new Tool Table Plus was designed in response to customer requests for a slightly wider and taller table to accommodate small planers, wood lathes, sanders and a variety of other bench-top machines.

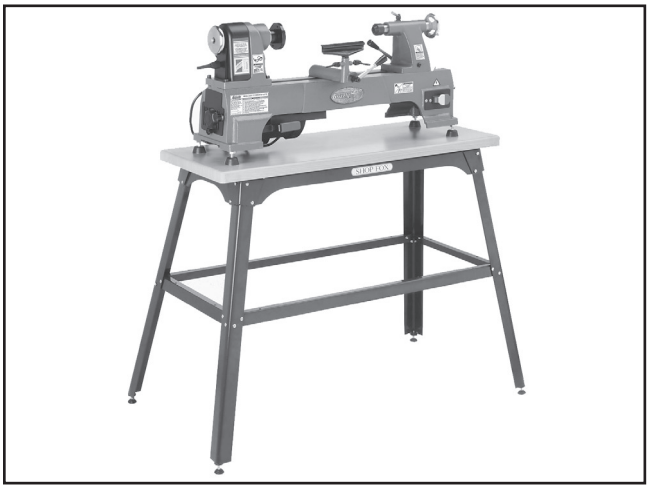


Figure 30. Model H7828 Tool Table Plus with Model G0624.

G0625—Bed Extension
With the Model G0625 Bed Extension attached, the Model G0624 lathe can turn up to 38" between centers.

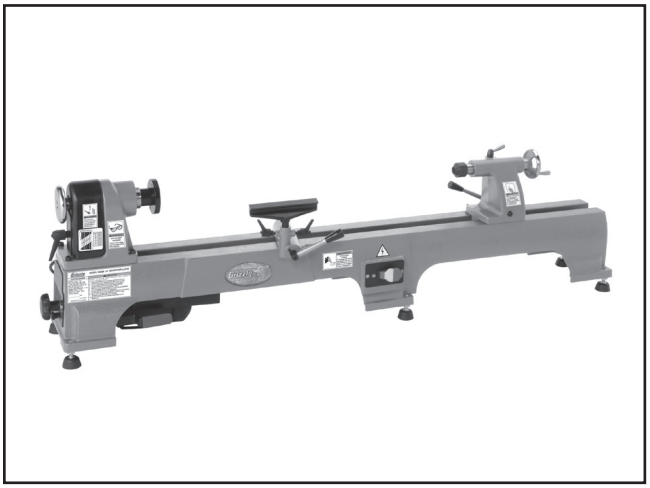


Figure 31. Model G0624 with Model G0625 Bed Extension.

H1064—6-PC Deluxe HSS Lathe Chisel Set
This deluxe chisel set features beefy ash handles for unsurpassed control, brass ferrules and high speed steel blades. Includes: a 17" long 13/16" Parting Tool, 13/16" Round Nose and 3/8" Gouge; a 19" long 1" Skew, a 5/8" Gouge and a 22 3/4" long 3/8" Gouge. Comes in a beautiful blow molded carrying case. An extremely popular set!

Figure 32. Model H1064 6-PC Chisel Set.

H6542—Robert Sorby HSS 8-PC Turning Set
If quality is king, then start bowing. Made in England, these Robert Sorby lathe tools are especially for the perfectionist wood turner. Includes 3/4" roughing gouge, 3/8" & 1/2" spindle gouge, 3/8" bowl gouge, 3/4" standard skew, 3/16" diamond side cut scraper, 1" square scraper and 1/2" round scraper. Full size handles are 16"–19".

Figure 33. Model H6542 Robert Sorby 8-PC Set.

G9863—8-PC HSS Lathe Chisel Set
This chisel set features beautiful 8" ash handles with brass ferrules and 3 1/2" long, high speed steel blades. Chisels include: 1/2" parting tool, 1/2" straight chisel, 1/2" double bevel skew, 1/2" roundnose, 3/4" gouge, 3/8" gouge, 1/2" diamond point and 3/8" veiner. Set comes in fitted wooden case, and is very competitively priced!

Figure 34. Model G9863 8-PC Chisel Set.

H6204—Precision Drill Chuck 1/32"–5/8" x JT#3
G1676—Drill Chuck Arbor MT#2 x JT#3
The best way to bore holes with your lathe!

H0507—20" Swan Neck Hollowing Tool
H0508—24" Swan Neck Hollowing Tool
An excellent choice for blind turning or undercutting where reach is restricted. H0507 is designed for end grain use while H0508 (with a more substantial steel cross section) is designed for both end grain and side grain (bowl) use.

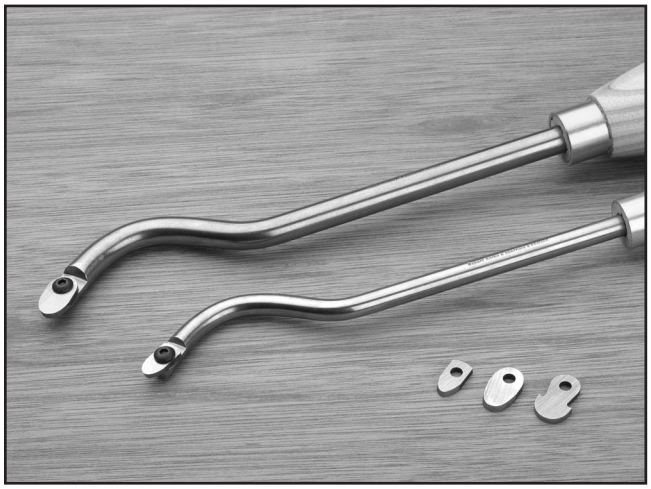
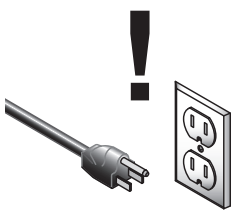


Figure 35. Swan Neck Hollowing Tools.

SECTION 6: MAINTENANCE



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

Schedule

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

Daily Check:
- Loose mounting bolts.
- Worn or damaged wires.
- Worn switch
- Any other unsafe condition.

Monthly Check:
- Belt tension, damage, or wear.
- Clean/vacuum dust buildup off of motor.

Cleaning

Cleaning the Model G0624 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

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

Keep the bed 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

Lubricate the locations shown in **Figure 36** with light machine oil or G96® Gun Treatment.

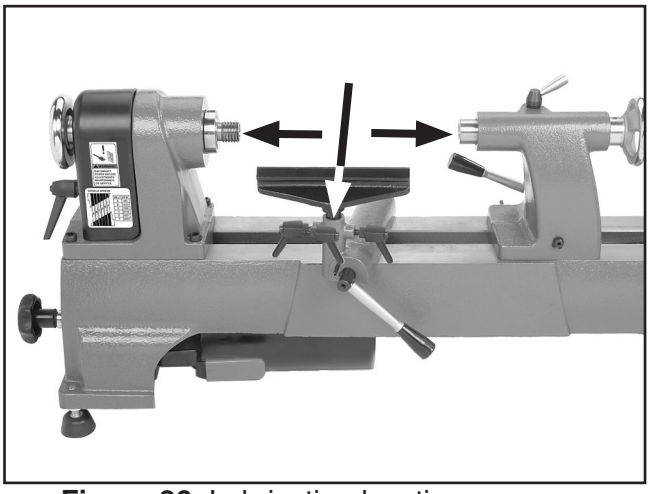


Figure 36. Lubrication locations.

Changing Belt

To change the belt:

1. Perform **Steps 1-2** in the **Changing Speeds** procedure on **Page 13**.

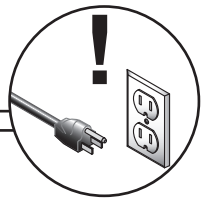
2. Roll the belt off of the pulleys and slide it under the belt cover plates.

3. Reverse **Steps 1-2** to reinstall the belt.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, 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.	1. Plug/receptacle is at fault or wired incorrectly.	1. Test for good contacts; correct the wiring.
	2. Power supply is at fault/switched OFF.	2. Ensure hot lines have correct voltage on all legs and main power supply is switched ON.
	3. Lockout key is at fault.	3. Install/replace lockout key; replace switch.
	4. Motor ON button or ON/OFF switch is at fault.	4. Replace faulty ON button or ON/OFF switch.
	5. Wiring is open/has high resistance.	5. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.
	6. Motor is at fault.	6. Test/repair/replace.
Machine stalls or is underpowered.	1. Plug/receptacle is at fault.	1. Test for good contacts; correct the wiring.
	2. Motor bearings are at fault.	2. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	3. Motor has overheated.	3. Clean off motor, let cool, and reduce workload.
	4. Motor is at fault.	4. Test/repair/replace.
Machine has vibration or noisy operation.	1. Motor or component is loose.	1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid.
	2. Motor fan is rubbing on fan cover.	2. Replace dented fan cover; replace loose/damaged fan.
	3. Workpiece or chuck is at fault.	3. Center workpiece in chuck or face plate; reduce RPM; replace defective chuck.
	4. Motor bearings are at fault.	4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Wood Lathe Operation

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Vibration noise while machine is running; noise changes when speed is changed.	1. Belt cover loose.	1. Tighten the belt cover lock handle; if necessary install a soft, vibration dampening material (between the belt cover and the headstock casting.
	2. Belt cover bent or dented and is making contact with the motor pulley or belt.	2. Remove belt cover and inspect the inside for dents, bends, or indications of rubbing. Tap out the dent with a rubber mallet, bend back into proper shape, or shim belt cover away from the motor pulley.

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Vibration noise while machine is running; noise remains constant when speed is changed.	1. Dented fan cover on motor.	1. Replace or adjust fan cover. Inspect motor fan and replace if damaged.
Excessive vibration.	1. Workpiece mounted incorrectly. 2. Workpiece warped, out of round, or is flawed. 3. Spindle speed is set too fast for mounted workpiece. 4. Lathe is resting on an uneven surface. 5. Motor mount bolts are loose. 6. Belt is worn or damaged. 7. Spindle bearings are worn.	1. Re-mount workpiece, making sure that centers are embedded in true center of workpiece. 2. Cut workpiece to correct, or use a different workpiece. 3. Reduce the spindle speed. 4. Shim or adjust feet to remove any wobbles. 5. Tighten motor mount bolts. 6. Replace belt. 7. Replace spindle bearings.
Chisels grab or dig into workpiece.	1. Tool rest set too low. 2. Tool rest set too far from workpiece. 3. Wrong chisel/tool being used. 4. Chisel/tool dull.	1. Set tool rest higher. See **Page 18** for how to properly set the tool rest height. 2. Move the tool rest closer to the workpiece. See **Page 18** for the proper workpiece/tool rest clearance. 3. Use the correct chisel/tool; educate yourself by reading books, trade magazines, or seeking help from an experienced lathe operator. 4. Sharpen or replace the chisel/tool you are using.
Bad surface finish.	1. Wrong spindle speed. 2. Dull chisel or wrong chisel being used for the operation.	1. Use trial-and-error to find a better spindle speed. 2. Sharpen chisel or try a different chisel.
Tailstock moves.	1. Tailstock mounting bolt loose. 2. Too much clamping pressure applied by tailstock. 3. Bed surface is oily or greasy.	1. Tighten. 2. Apply less clamping pressure with tailstock. 3. Clean bed surface to remove oil/grease.
Can't remove tapered tool from tailstock barrel.	1. Tailstock barrel had not retracted all the way back into the tailstock. 2. Debris was not removed from taper before inserting into barrel.	1. Turn the barrel handwheel until it forces taper out of barrel. 2. Always make sure that taper surfaces are clean.

G0624 Wiring Diagram

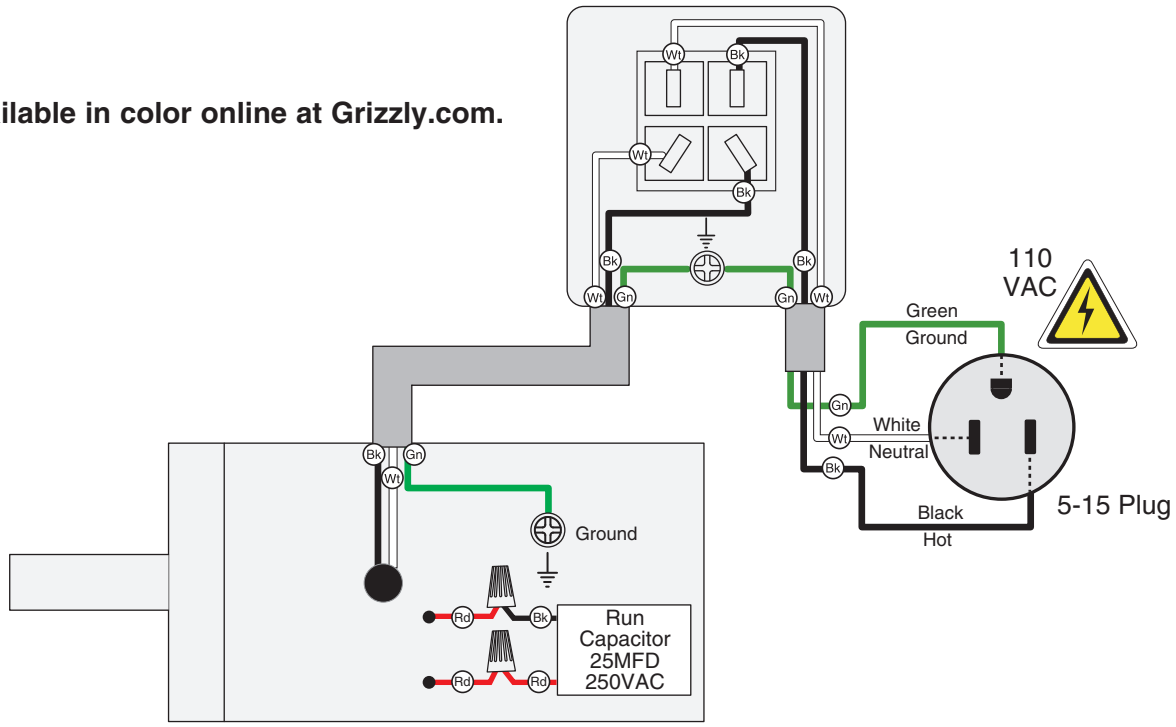
COLOR KEY

BLACK	Bk
WHITE	Wt
GREEN	Gn
RED	Rd

⚠ DANGER

Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

Available in color online at Grizzly.com.



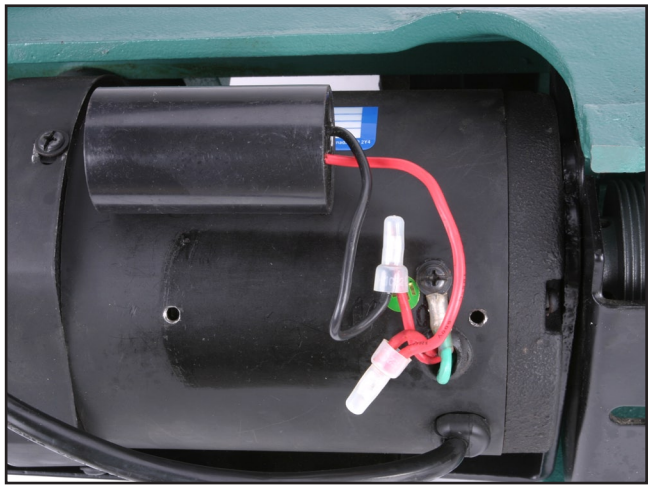


Figure 37. Motor connections.

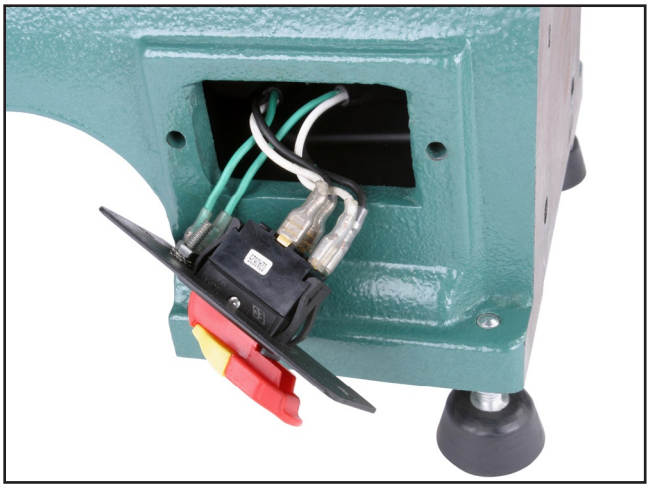
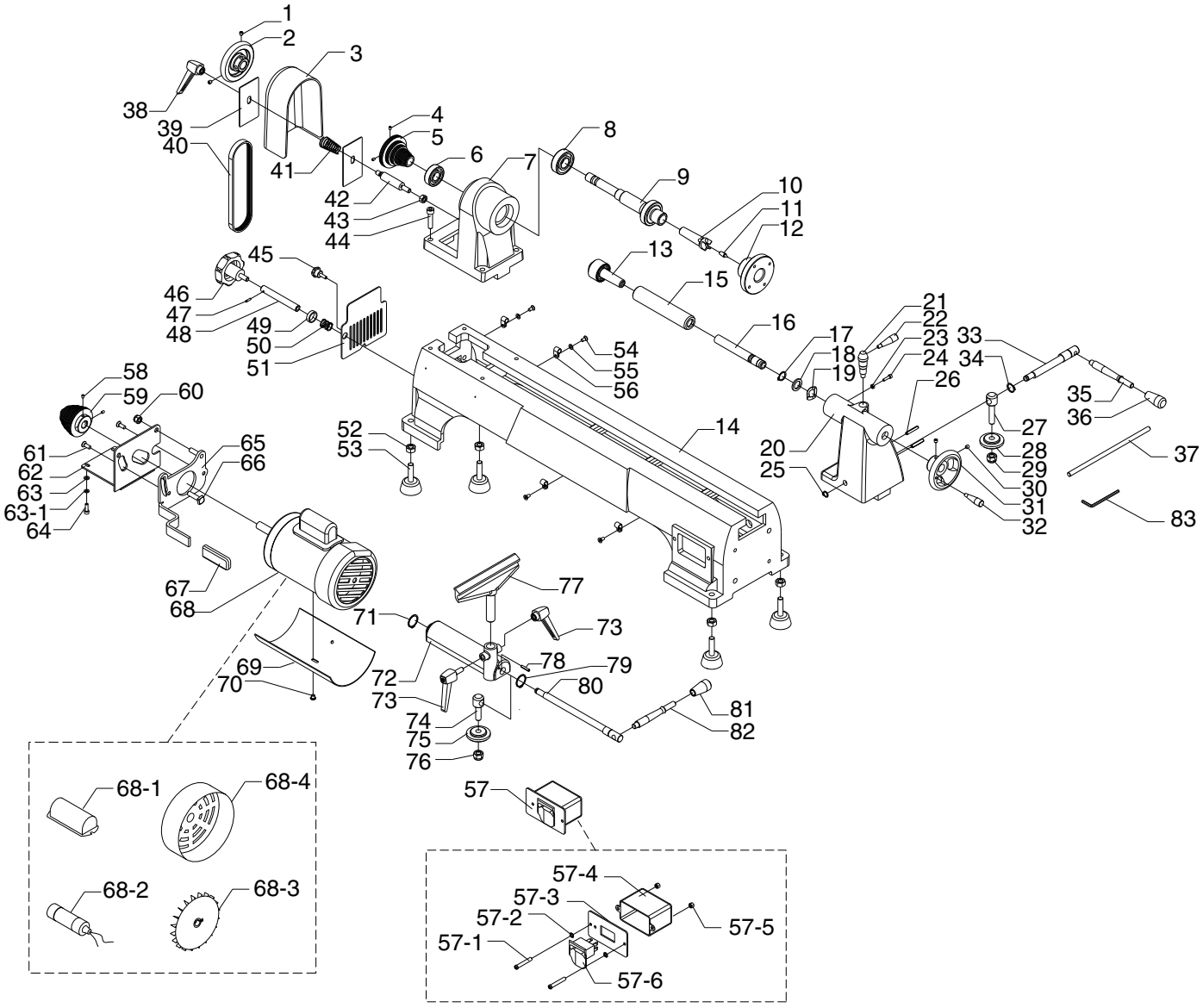


Figure 38. Switch connections.

Parts Breakdown

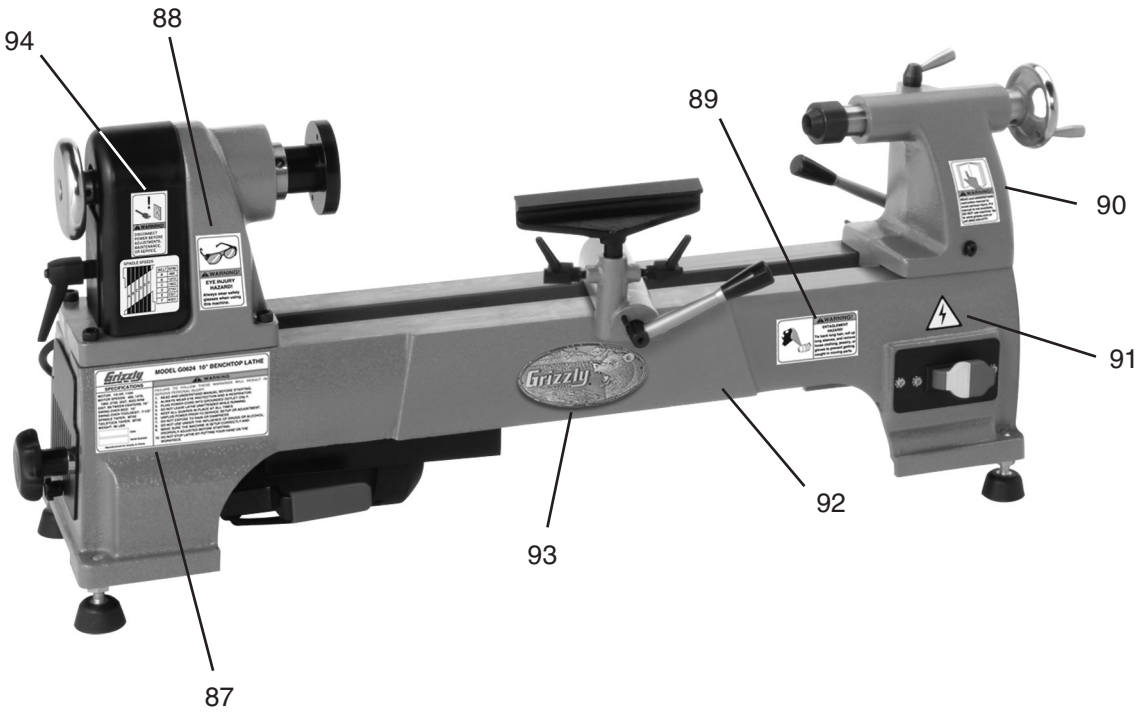


Parts List

REF	PART #	DESCRIPTION
1	PSS02M	SET SCREW M6-1 X 6
2	P0624002	HEADSTOCK HANDWHEEL
3	P0624003	PULLEY SAFETY COVER
4	PSS79M	SET SCREW M4-.7 X 6
5	P0624005	SPINDLE PULLEY
6	P6004	BALL BEARING 6004ZZ
7	P0624007	HEADSTOCK CASTING
8	P6005	BALL BEARING 6005ZZ
9	P0624009	SPINDLE
10	P0624010	SPUR CENTER MT#2
11	P0624011	INDEXED SPINDLE
12	P0624012	FACEPLATE 3"
13	P0624013	LIVE CENTER MT#2
14	P0624014	BEDWAY
15	P0624015	TAILSTOCK QUILL
16	P0624016	TAILSTOCK LEAD SCREW
17	PR05M	EXT RETAINING RING 15MM
18	PW14M	FLAT WASHER 15MM
19	P0624019	RUBBER COLLAR
20	P0624020	TAILSTOCK CASTING
21	P0624021	ECCENTRIC SHAFT
22	P0624022	QUILL LOCK HANDLE
23	PN04M	HEX NUT M4-.7
24	PSB16M	CAP SCREW M4-.7 X 16
25	PR01M	EXT RETAINING RING 10MM
26	PRP05M	ROLL PIN 5 X 30
27	P0624027	ADJUST SHAFT
28	P0624028	SLIDE COLLAR
29	PLN05M	LOCK NUT M10-1.5
30	PSS02M	SET SCREW M6-1 X 6
31	P0624031	TAILSTOCK HANDWHEEL
32	P0624032	QUILL HANDWHEEL HANDLE
33	P0624033	ECCENTRIC SHAFT
34	PR06M	EXT RETAINING RING 16MM
35	P0624035	TAILSTOCK RELEASE LEVER
36	P0624036	LEVER KNOB
37	P0624037	KNOCK OUT BAR
38	P0624038	LOCK HANDLE
39	P0624039	GUARD PLATE
40	P0624040	ULTR-FLEX BELT 7 X 3.4 X 600MM
41	P0624041	COMPRESSION SPRING
42	P0624042	THREADED SHAFT
43	PN03M	HEX NUT M8-1.25
44	PSB40M	CAP SCREW M8-1.25 X 35
45	P0624045	THUMB SCREW M5-.8 X 15
46	P0624046	BELT TENSION LOCK KNOB
47	PRP61M	ROLL PIN 3 X 12

REF	PART #	DESCRIPTION
48	P0624048	SHAFT
49	P0624049	SPACER 18MM
50	P0624050	COMPRESSION SPRING
51	P0624051	LOWER PULLEY ACCESS PLATE
52	PN08	HEX NUT 3/8-16
53	P0624053	RUBBER FOOT
54	PS09M	PHLP HD SCR M5-.8 X 10
55	PW02M	FLAT WASHER 5MM
56	P0624056	WIRE CLAMP
57	P0624057	SWITCH
57-1	PS10	PHLP HD SCR 10-24 X 1-1/2
57-2	PTLW02M	EXT TOOTH WASHER 5MM
57-3	P0624057-3	SWITCH PLATE
57-4	P0624057-4	SWITCH BOX
57-5	PN07	HEX NUT 10-24
57-6	P0624057-6	SWITCH W/SAFETY KEY
58	PSS79M	SET SCREW M4-.7 X 6
59	P0624059	MOTOR PULLEY
60	PLN04M	LOCK NUT M8-1.25
61	PS11M	PHLP HD SCR M6-1 X 16
62	P0624062	MOTOR PLATE
63	PW02M	FLAT WASHER 5MM
63-1	PLW01M	LOCK WASHER 5MM
64	PSB10M	CAP SCREW M5-.8 X 15
65	P0624065	TENSION BRACKET
66	P0624066	SQUARE HEAD BOLT
67	P0624067	RUBBER SLEEVE
68	P0624068	MOTOR
68-1	P0624068-1	CAPACITOR COVER
68-2	P0624068-2	CAPACITOR 25MFD 250VAC
68-3	P0624068-3	FAN
68-4	P0624068-4	FAN COVER
69	P0624069	DUST GUARD
70	P0624070	LOCTITE SCREW 10-24 X 6
71	PR01M	EXT RETAINING RING 10MM
72	P0624072	TOOL POST BASE
73	P0624073	TOOL REST LOCK HANDLE M6-1
74	P0624074	ADJUST SHAFT
75	P0624075	SLIDE COLLAR
76	PLN05M	LOCK NUT M10-1.5
77	P0624077	TOOL REST
78	PRP39M	ROLL PIN 4 X 20
79	PR02M	EXT RETAINING RING 14MM
80	P0624080	ECCENTRIC SHAFT
81	P0624081	LEVER KNOB
82	P0624082	TOOL REST RELEASE LEVER
83	PAW02.5M	HEX WRENCH 2.5MM

Warning Labels Parts List



REF	PART #	DESCRIPTION
87	P0624087	MACHINE ID LABEL
88	P0624088	SAFETY GLASSES LABEL 1-1/2" X 2-1/2"
89	P0624089	ENTANGLEMENT HAZARD LABEL
90	P0624090	READ MANUAL LABEL 1-1/2" X 2-1/2"
91	PLABEL-14	ELECTRICITY LABEL
92	PPAINT-1	GRIZZLY GREEN PAINT
93	G9987	GRIZZLY MINI NAME PLATE
94	P0624094	DISCONNECT POWER-SPINDLE SPEEDS 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 to order new labels.

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 Industrial, Inc. 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?

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

3. What is your annual household income?

____ $20,000-$29,000 ____ $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