



# Fretboard Radiusing Attachment

## MODEL G0577

## INSTRUCTION MANUAL



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#EW6966 PRINTED IN TAIWAN

# 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

<b>INTRODUCTION .....</b>	<b>2</b>
Foreword .....	2
Contact Info .....	2
<b>SECTION 1: SAFETY .....</b>	<b>3</b>
Safety Instructions for Machinery .....	3
<b>SECTION 2: SET UP .....</b>	<b>5</b>
Set Up Safety .....	5
Unpacking .....	5
Items Needed For Set Up .....	5
Inventory .....	6
Drilling & Tapping Installation Holes .....	6
Assembly .....	8
<b>SECTION 3: OPERATIONS .....</b>	<b>10</b>
Operation Safety .....	10
Attaching the Fretboard .....	10
Adjusting Radius .....	11
Sanding .....	11
<b>SECTION 4: MAINTENANCE .....</b>	<b>12</b>
Lubrication .....	12
Cleaning .....	12
G0577 Parts List .....	12
G0577 Parts Breakdown .....	13
<b>WARRANTY AND RETURNS .....</b>	<b>14</b>

# INTRODUCTION

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## Foreword

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We are proud to offer the Model G0577 Fretboard Radiusing Attachment. This attachment is part of a growing Grizzly family of fine woodworking accessories. 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 G0577. 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 G0577 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 attachment 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!



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## Contact Info

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

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

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

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



# SECTION 1: SAFETY

## WARNING

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

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



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



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



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

**NOTICE**

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

## WARNING

### Safety Instructions for Machinery

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

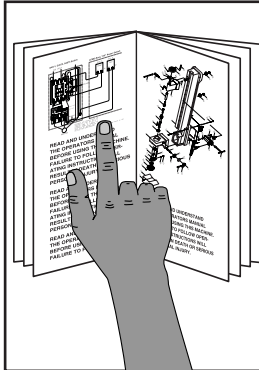
# WARNING

## Safety Instructions for Machinery

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

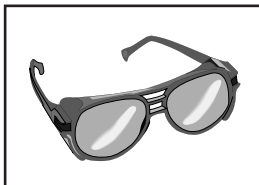
# SECTION 2: SET UP

## Set Up Safety



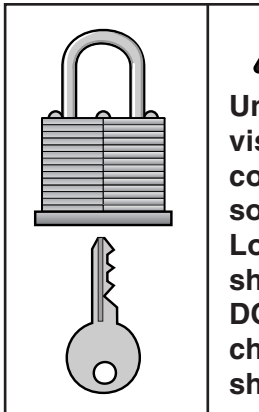
### **!WARNING**

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



### **!WARNING**

Wear safety glasses during the entire set up process!



### **!CAUTION**

Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and **DO NOT** allow unsupervised children or visitors in your shop at any time!



## Unpacking

The Model G0577 was carefully packed when it left our warehouse. If you discover the attachment is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

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

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



## Items Needed For Set Up

The following items may be needed to complete the set up process, but are not included with your radiusing attachment:

DESCRIPTION	QTY
• An Assistant .....	1
• Hand Drill.....	1
• Drill Bit $\frac{7}{16}$ " .....	1
• Drill Bit $\frac{1}{8}$ " or $\frac{3}{16}$ " .....	1
• Drill Bit $\frac{5}{16}$ " .....	1
• Tap $\frac{3}{8}$ " .....	1
• Level.....	1

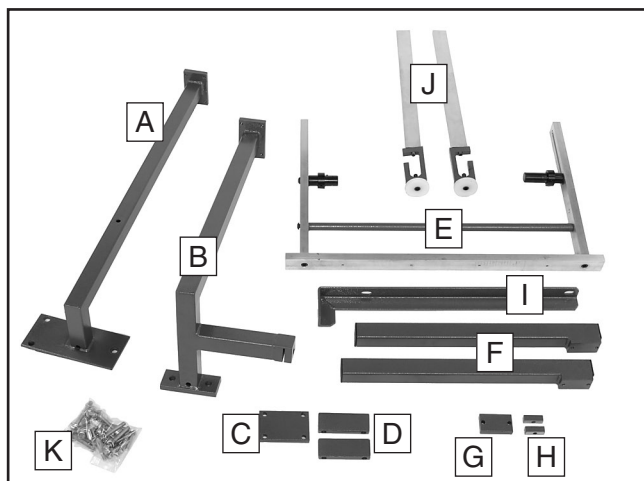




# Inventory

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

<b>G0577 Box Contents (Figure 1)</b>	<b>QTY</b>
<b>A.</b> Long Support Bracket .....	1
<b>B.</b> Short Support Bracket.....	1
<b>C.</b> Guide Rail A .....	2
<b>D.</b> Guide Rail B .....	4
<b>E.</b> Radius Control Swing Arm Assembly .....	1
<b>F.</b> Horizontal Adjustment Tubes .....	2
<b>G.</b> Locking Plate A .....	2
<b>H.</b> Locking Plate B .....	4
<b>I.</b> Brace .....	1
<b>J.</b> Height Adjustment Arms .....	2
<b>K.</b> Hardware Bag .....	1
—Shim.....	1
—Hex Bolt $\frac{5}{16}$ "-18 x $2\frac{1}{2}$ " .....	3
—Hex Bolt $\frac{5}{16}$ "-18 x $1\frac{1}{2}$ " .....	1
—Hex Bolt $\frac{3}{8}$ "-16 x 1" .....	3
—Flat Washer $\frac{3}{8}$ " .....	11
—Flat Washer $\frac{5}{16}$ " .....	6
—Hex Nut $\frac{5}{16}$ "-18 .....	3
—Hex Bolt $\frac{3}{8}$ "-16 x 2 .....	2
—Hex Nut $\frac{3}{8}$ "-16.....	2
— $\frac{7}{32}$ " Hex Wrench.....	1
—12-14mm Open End Wrench.....	1
—3mm Hex Wrench.....	1



**Figure 1.** Radiusing attachment inventory.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or replacements can be obtained at your local hardware store.



# Drilling & Tapping Installation Holes

Older Model G1140 Edge Sanders do not come with the installation holes shown in **Figure 2**. These models will have to be drilled and tapped as described in the following instructions.



**Figure 2.** Installation hole locations.

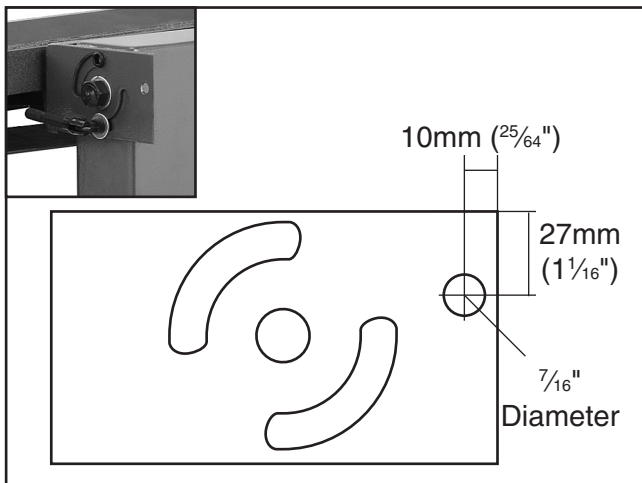
**To drill and tap the installation holes:**

- 1. Unplug the sander!**
- If you are installing the radiusing attachment onto a Model G1140 Edge Sander, remove the end table, main table, table adjustment mechanisms, and the sanding stop.

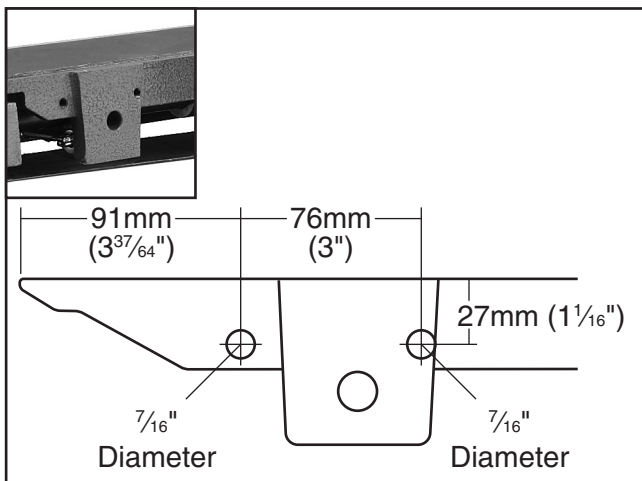
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3. Use a center punch to mark the installation holes shown in **Figures 3 & 4**.

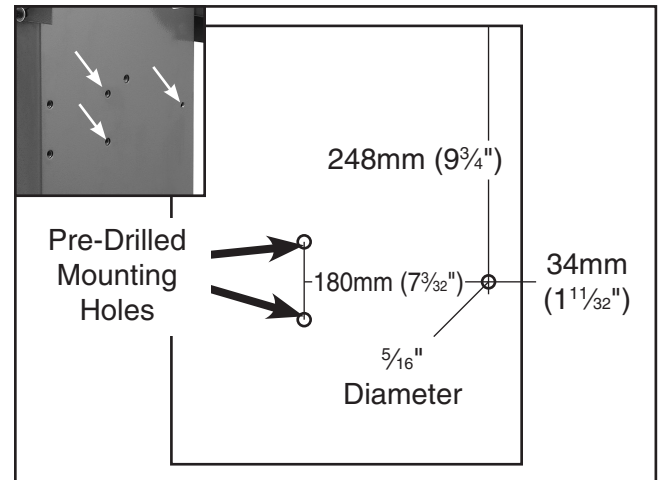


**Figure 3.** Rotation plate mounting hole.



**Figure 4.** Platen mounting holes.

4. Temporarily bolt the long support bracket into the two holes indicated in **Figure 5** and use a center punch to mark the location of the third hole.



**Figure 5.** Stand mounting hole.

5. Drill pilot holes with an  $\frac{1}{8}$ " or a  $\frac{3}{16}$ " drill bit.
6. Drill the holes through the platen and the rotation plate with a  $\frac{7}{16}$ " drill bit.
7. Drill the installation hole in the stand using a  $\frac{5}{16}$ " drill bit.

*Note—Always use cutting fluid when drilling and tapping sheet metal (the stand and rotation plate). When drilling or tapping cast iron (the platen), cutting fluid is not necessary.*

8. Thread the stand installation hole with a  $\frac{3}{8}$ " tap.

*Note—For every half turn of the tap, back off a quarter turn to clear the chips and prevent the tap from breaking.*



# Assembly

## To install the fretboard radiusing attachment onto the sander:

1. Slide the slot in the short support bracket onto the rotation plate and loosely attach the bracket to the platen with two  $\frac{3}{8}$ "-16 x 2" hex bolts, four flat washers, and two hex nuts.

*Note—Some machines may require the included  $\frac{3}{8}$ " thick shim between the bracket and the platen.*

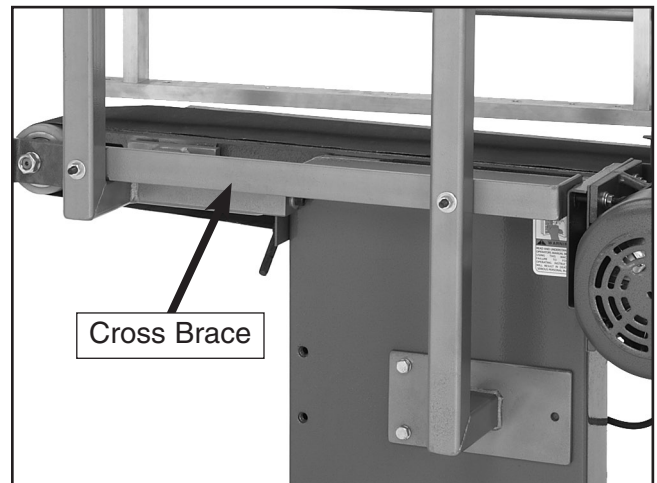
2. Align the hole in the short support bracket with the hole in the rotation plate and loosely secure it with a  $\frac{3}{8}$ "-16 x  $1\frac{1}{2}$ " hex bolt with a flat washer.
3. Plumb the short support bracket as shown in **Figure 6** and tighten the bolts.



**Figure 6.** Plumbing the short support bracket.

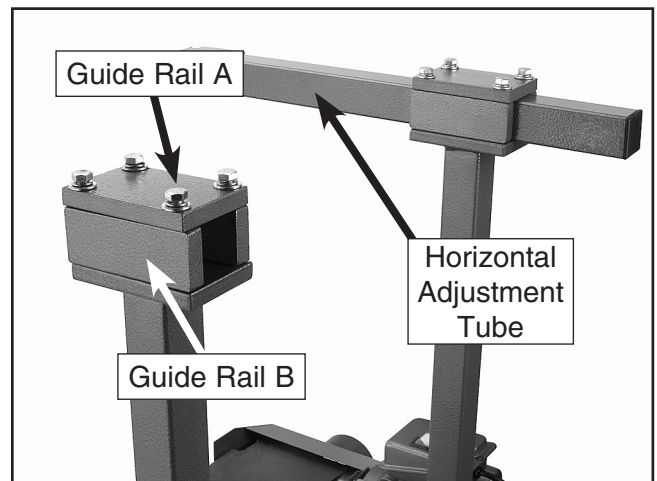
4. Install the long support bracket with three  $\frac{3}{8}$ "-16 x 1" hex bolts and washers.
5. Plumb the long support bracket and tighten the bolts.
6. Remove the upper right motor mounting bolt.

7. Install the cross brace as shown in **Figure 7** with three  $\frac{5}{16}$ "-18 x  $2\frac{1}{2}$ " hex bolts, six flat washers, and three hex nuts.



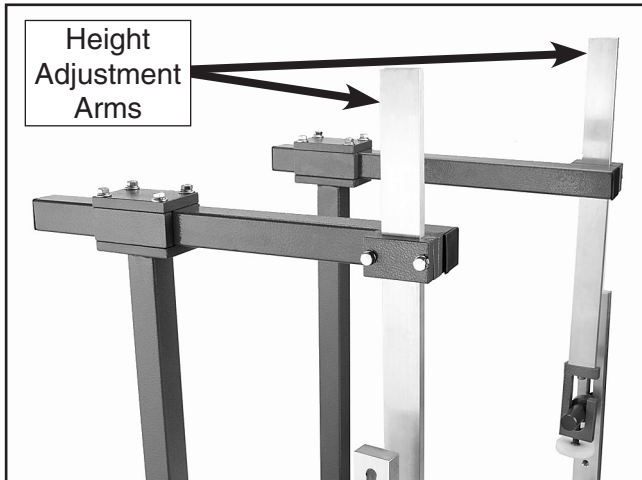
**Figure 7.** Cross brace placement.

8. Slide the horizontal adjustment tubes through the guide rails as shown in **Figure 8**, with the threaded holes towards the outside of the machine, and tighten the hex bolts.



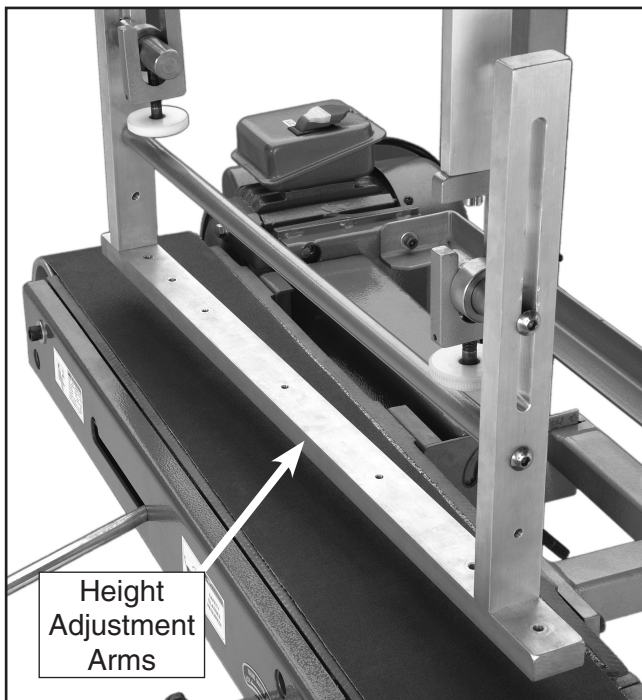
**Figure 8.** Guide rail installation.

9. Slide the height adjustment arms into the locking plates, as shown in **Figure 9**, with the hanger openings outward, and tighten the hex bolts.



**Figure 9.** Height adjustment arm installation.

10. Place the swing arm into the hanger openings as shown in **Figure 10**.



**Figure 10.** Swing arm placement.

11. Adjust the height adjustment arms until the swing arm is seated into the hangers and both ends are an equal distance above the sanding belt.

12. To use the full surface of the sanding belt, slide the horizontal adjustment arms so the swing arm is diagonal across the sanding belt surface.

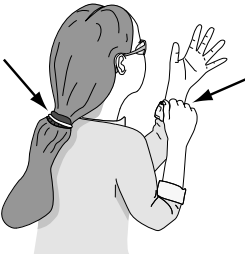
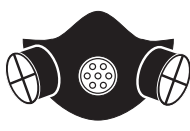


# SECTION 3: OPERATIONS

## Operation Safety

### !WARNING

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



### !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 attachment 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.



## Attaching the Fretboard

There are several methods of attaching the fretboard to the radiusing attachment. These include screws, double stick tape, friction pins, clamping, or a vacuum system. These instructions only cover attaching the fretboard with double stick tape.

**To attach the fretboard to the radiusing attachment:**

1. Use a jointer to flatten the back of the fretboard.
2. Mark a line down the center of the back of the fretboard.

*Note—This center line is important. If it is off center, the radius of the fretboard will be off center.*

3. Place a strip of double stick tape on either side of the holes in the swing arm crossbar.

*Note—Only use high quality, film type, double stick tape. Reinforced and foam backed double stick tape will not hold the fretboard securely.*

4. Line up the swing arm crossbar holes with the center line on the fretboard and carefully stick the fretboard to the crossbar.
5. When finished radiusing the fretboard, remove the tape residue from the crossbar with WD-40®, or an oil, such as gun oil.
6. Clean off the oil residue with lacquer thinner or an alcohol based solvent.

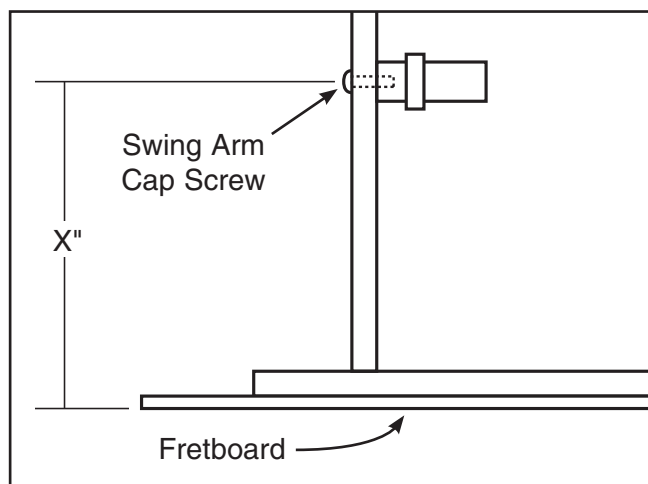


# Adjusting Radius

This fretboard radiusing attachment is capable of creating radiuses from 8" to 16" by adjusting the distance from the swing arm shaft to the sanded surface.

## To adjust the radius:

1. Loosen the button head cap screws that secure the swing arm shafts to the height adjustment arms as shown in **Figure 11**.



**Figure 11.** Swing arm shaft adjustment.

2. Adjust the height from the bottom surface of the fretboard to the center of the swing arm shaft to the desired radius.

**Example:** To achieve a 16" radius on the fretboard, the distance shown as X" in **Figure 11** would be 16".

3. Repeat **Step 2** on the other end of the fretboard.

*Note—To create a compound radius, the distance from the fretboard to the swing arm shaft will be different on each end.*

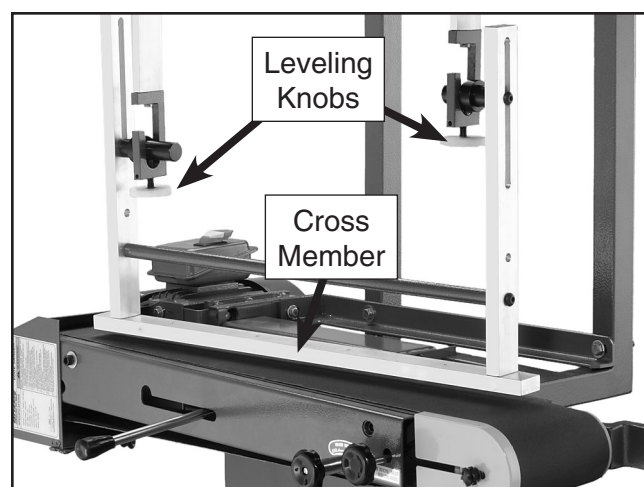


# Sanding

## To radius a fretboard:

1. Adjust the height adjustment arm so the cross member is parallel with the sanding belt as shown in **Figure 12**.

*Note—Notice how the swing arm shafts in **Figure 12** are different distances from the fretboard (to create a compound radius), but the fretboard is parallel with the sanding belt.*



**Figure 12.** Adjusting the cross member parallel with the sanding belt.

2. Use the leveling knobs to fine tune the height so the swing arm can have free motion.
3. Turn the sander *ON*. Lower the fretboard with the leveling knobs and swing the swing arm. Continue with this step until the fretboard is sanded across its entire surface.
4. Check the fretboard for the desired radius with radius gauges.

—If the radius is incorrect, increase the distance between the swing arm shaft and the fretboard to make a larger radius; shorten it to make a smaller radius.

—If the radius is correct, continue sanding the fretboard to the desired thickness.



# SECTION 4: MAINTENANCE

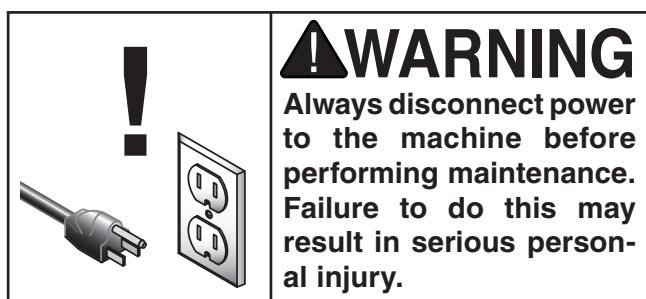
## Lubrication

This radiusing attachment, requires minimal maintenance. For optimum performance, lubricate the swing arm shafts with a general purpose grease, as needed.



## Cleaning

Cleaning the Model G0577 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth.



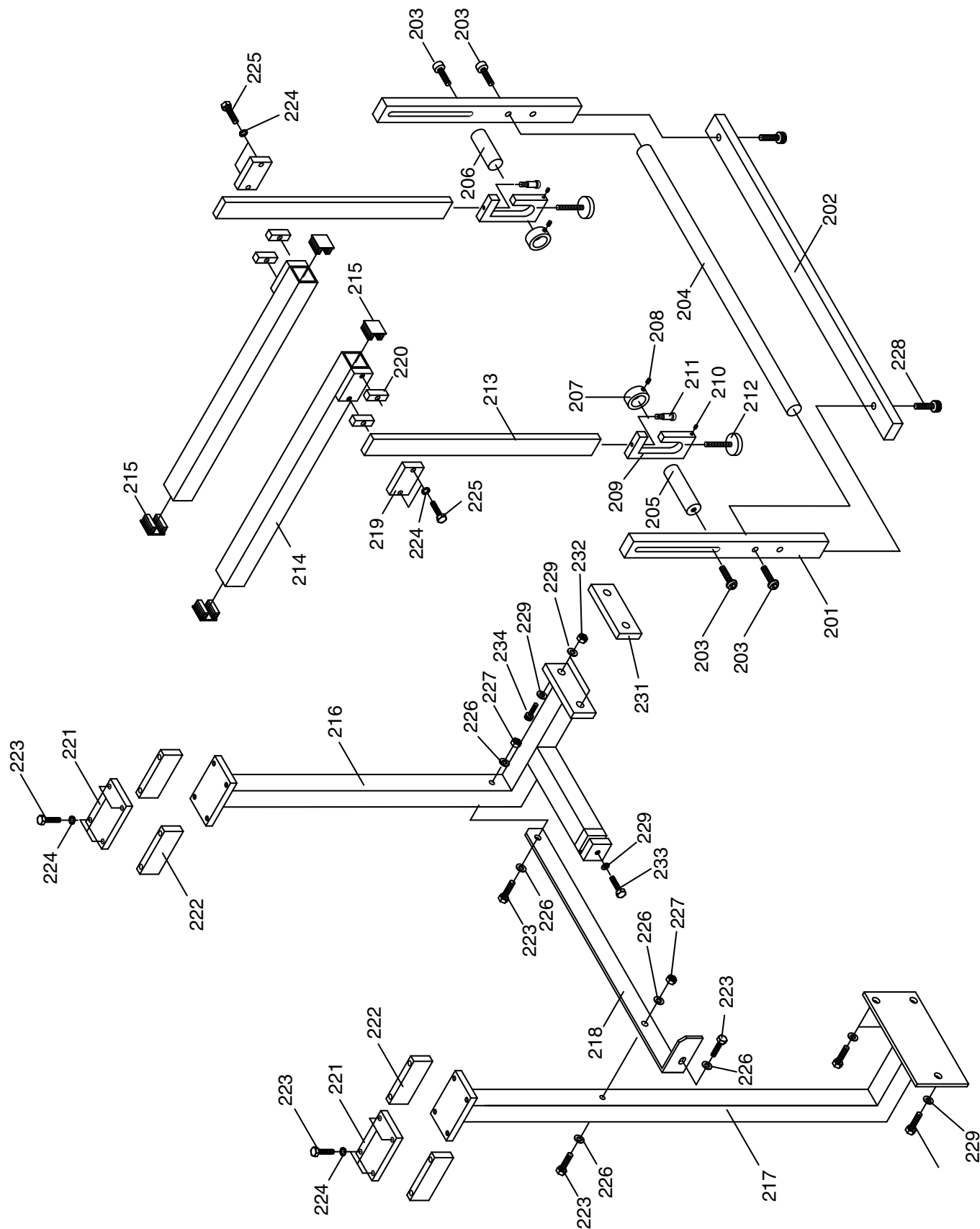
## G0577 Parts List

REF	PART #	DESCRIPTION
201	P0577201	RADIUS SWING ARM
202	P0577202	CROSS MEMBER
203	P0577203	BTN HD CAP SCR 3/8-16 X 1-1/4
204	P0577204	CROSS MEMBER SHAFT
205	P0577205	SWING ARM SHAFT LEFT
206	P0577206	SWING ARM SHAFT RIGHT
207	P0577207	COLLAR
208	PSS11	SET SCREW 1/4-20 X 1/4
209	P0577209	HANGER
210	PSS26	SET SCREW 10-24 X 3/8
211	P0577211	SPECIAL SCREW 5/16
212	P0577212	LEVELING BOLT
213	P0577213	HEIGHT ADJUSTMENT ARM
214	P0577214	HORIZONTAL ADJUST TUBE
215	P0577215	END CAP
216	P0577216	SHORT SUPPORT BRACKET
217	P0577217	LONG SUPPORT BRACKET

REF	PART #	DESCRIPTION
218	P0577218	BRACE
219	P0577219	LOCKING PLATE A
220	P0577220	LOCKING PLATE B
221	P0577221	GUIDE RAIL A
222	P0577222	GUIDE RAIL B
223	PB23	HEX BOLT 5/16-18 X 2-1/2
224	PLW01	LOCK WASHER 5/16
225	PB11	HEX BOLT 5/16-18 X 1-1/2
226	PW07	FLAT WASHER 5/16
227	PN02	HEX NUT 5/16-18
228	PSB14	CAP SCREW 3/8-16 X 1
229	PW02	FLAT WASHER 3/8
230	PB18	HEX BOLT 3/8-16 X 1
231	P0577231	SHIM
232	PN08	HEX NUT 3/8-16
233	PB16	HEX BOLT 3/8-16 X 1-1/2
234	PB58	HEX BOLT 3/8-16 X 2



# G0577 Parts Breakdown





# WARRANTY AND RETURNS

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

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

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

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

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

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



# WARRANTY CARD

Name \_\_\_\_\_  
Street \_\_\_\_\_  
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
Phone # \_\_\_\_\_ Email \_\_\_\_\_ Invoice # \_\_\_\_\_  
Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

\_\_\_\_\_ Advertisement \_\_\_\_\_ Friend \_\_\_\_\_ Catalog  
\_\_\_\_\_ Card Deck \_\_\_\_\_ Website \_\_\_\_\_ Other:

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

\_\_\_\_\_ 0-2 Years \_\_\_\_\_ 2-8 Years \_\_\_\_\_ 8-20 Years \_\_\_\_\_ 20+ Years

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

\_\_\_\_\_ 0-2 \_\_\_\_\_ 3-5 \_\_\_\_\_ 6-9 \_\_\_\_\_ 10+

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

\_\_\_\_\_ Yes \_\_\_\_\_ No

8. Would you recommend Grizzly Industrial to a friend?

\_\_\_\_\_ Yes \_\_\_\_\_ No

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

Note: We never use names more than 3 times.

\_\_\_\_\_ Yes \_\_\_\_\_ No

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

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