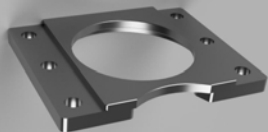


Grizzly G0602 Compound Clamp Upgrade Quick Start Guide

Installation Instructions

Grizzly G0602 Compound Clamp Upgrade



STEP 1



Original G0602 compound, compound clamp and cross slide

STEP 2



Remove 14mm nuts and washers that hold the compound to the cross slide

STEP 3



Lift and remove the compound clamp from cross slide. Set this assembly aside for now.

STEP 4



Remove the two 6mm Allen bolts which retain the cross slide lead screw.

STEP 5



There is no need to remove or adjust the gib adjusters along the right side of the cross slide, unless the gib adjustment is set excessively tight. Take care to capture with one hand the gib on the right side of the cross slide and not to bend the way cover as you pull the complete assembly toward yourself.

STEP 6



Remove the acme lead screw and the sheet metal way cover from the cross slide.

STEP 7



Secure the cross slide. Locate and center the new compound clamp using the original studs. Once the clamp location is acceptable, use a 11/32 transfer punch to mark the location of the new required holes in the cross slide plate.

STEP 8



Once center marked, remove the new clamp and drill the new 4 required holes using a Letter drill H. Provided if you purchased the complete kit.



Using the 8mmx1.25 tap included in the complete kit, tap the 4 new mounting holes. Use of tapping fluid is highly recommended.



Remove the original compound clamp by removing the angle base ring socket head cap screws 5mm allen. Note angle marking orientation before removal



Reinstall the compound angle base with the new 6 bolt compound clamp



Reinstall the gib and way cover sheet metal



Reinstall the acme lead screw



While holding the gib in place slide the entire assembly back on the carriage dovetail. At this point you may install the 4 provided 8mmx1.25 studs as shown here.



Reinstall the cross slide retaining screws



Reinstall the compound assembly with the new compound clamp. With the thin jam nut provided in the complete kit.



Reinstall the compound assembly with the new compound clamp. With the thin jam nut provided in the complete kit.