

READ THIS FIRST



Model G0634X

*****IMPORTANT UPDATE*****

For Machines Mfd. Since 04/23
and Owner's Manual Revised 04/22

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

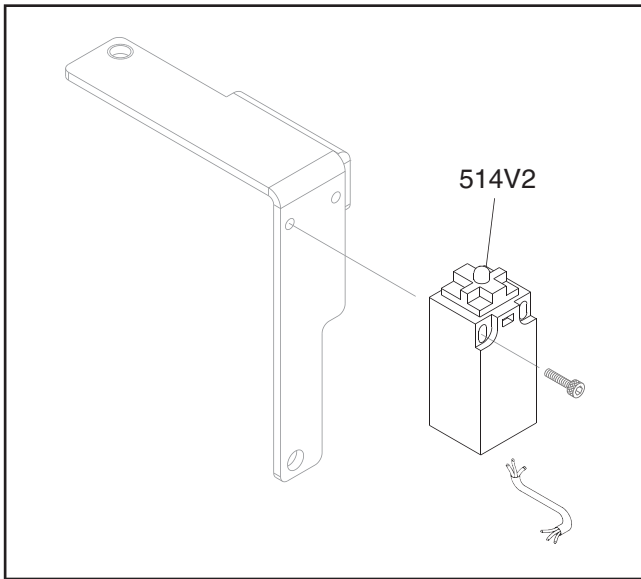
The following change was recently made since the owner's manual was printed:

- Limit switch changed.

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.

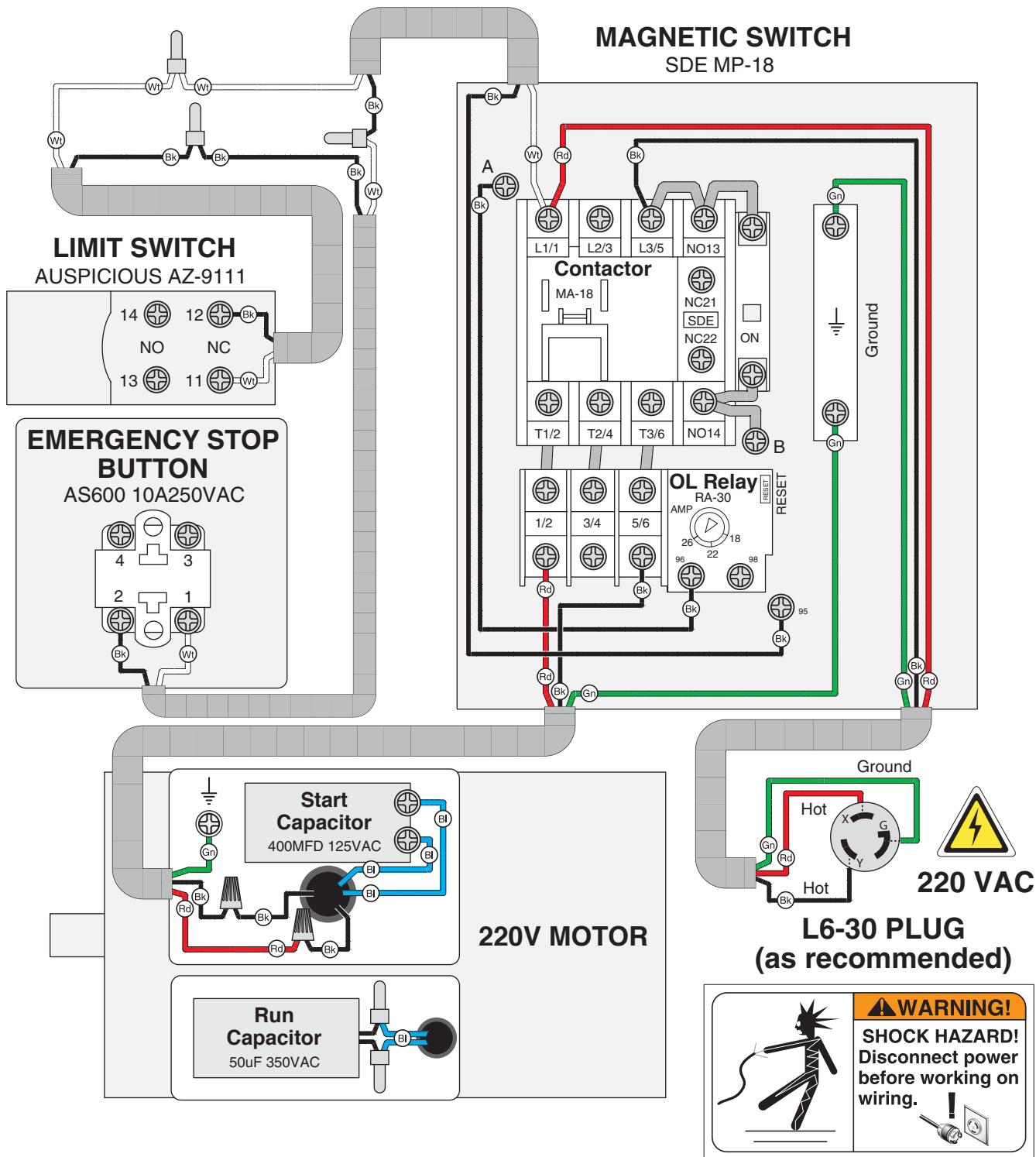
Revised Parts



REF	PART #	DESCRIPTION
514V2	P0634X514V2	LIMIT SWITCH AUSPICIOUS AZ-9111 V2.04.23

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OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
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Wiring Diagram



Electrical Component Photos



Figure 79. Magnetic switch.

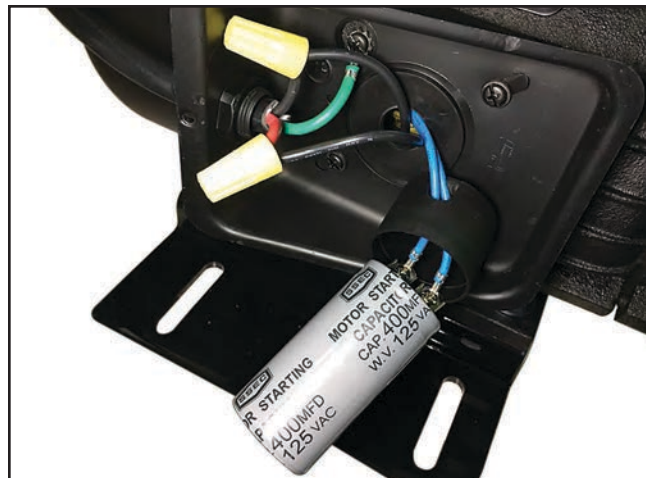


Figure 81. Start capacitor.



Figure 82. Run capacitor.



Figure 80. Emergency Stop button.

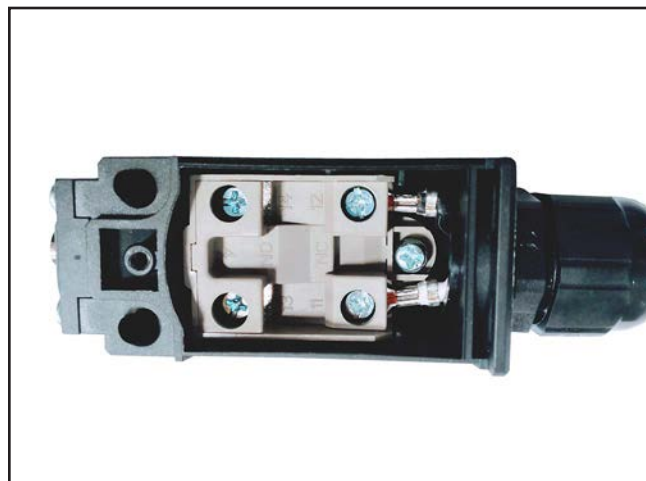


Figure 83. Jointer table limit switch.

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Grizzly **Industrial, Inc.**®

MODEL G0634X **12" JOINTER/PLANER** **W/V-HELICAL CUTTERHEAD** **OWNER'S MANUAL** *(For models manufactured since 11/20)*



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V5.04.22

*****Keep for Future Reference*****

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool 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, cutting/sanding/grinding tool 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.

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INTRODUCTION

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com


Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at www.grizzly.com.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety is correctly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not use while tired, drowsy, or under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
	Manufactured for Grizzly in Taiwan		

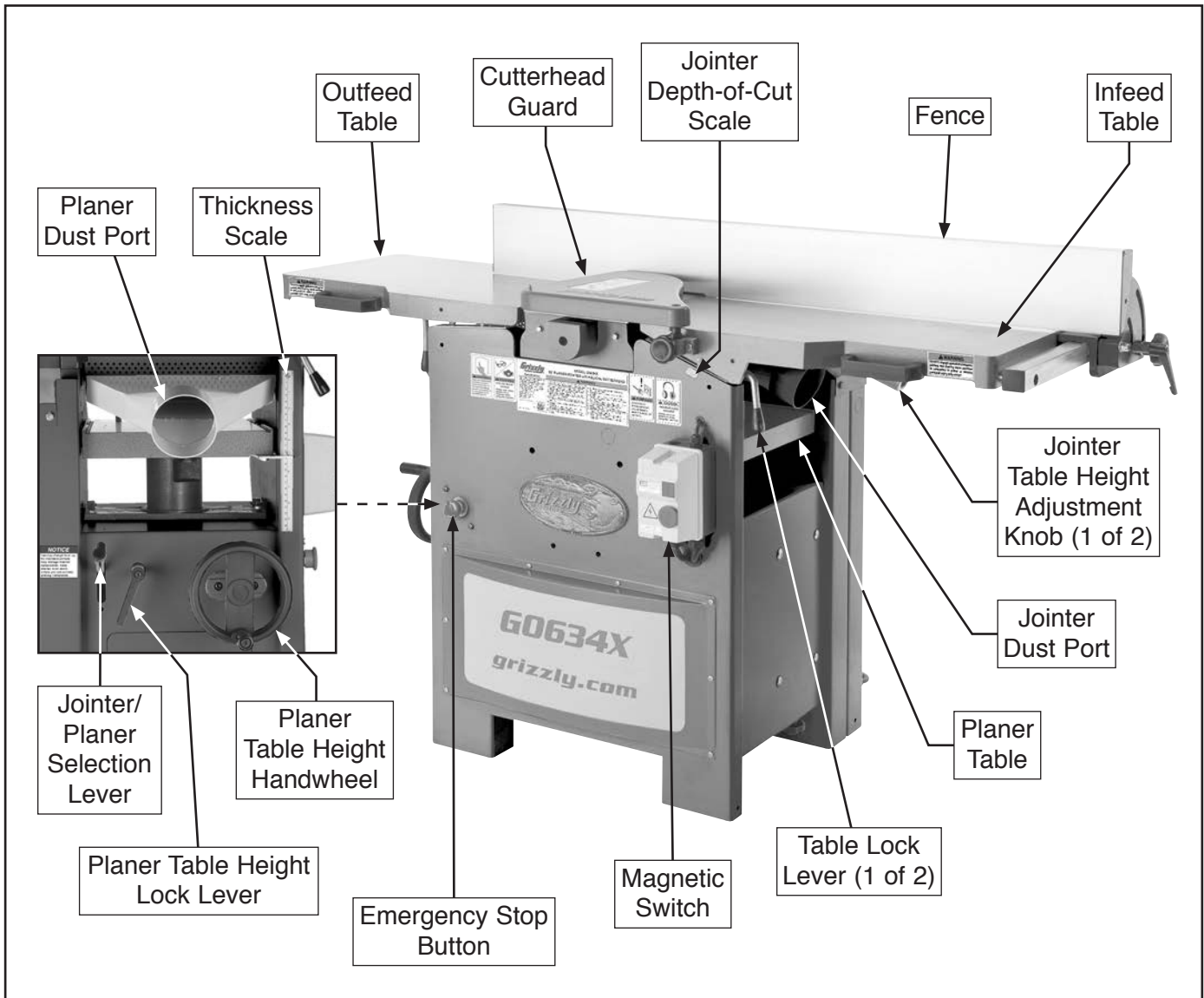
Manufacture Date

Serial Number



Main Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



⚠️ WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

- a) **Wear eye protection.**
- b) **Always keep cutterhead and drive guards in place and in proper operating condition.**
- c) **Never make jointing or planing cut deeper than $\frac{1}{8}$ in.**
- d) **Always use hold-down/push blocks for jointing material narrower than 3 inches, or planing material thinner than 3 inches.**
- e) **Never perform jointing or planing cuts on pieces shorter than 12 inches in length.**



Controls & Components



Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

Power Controls

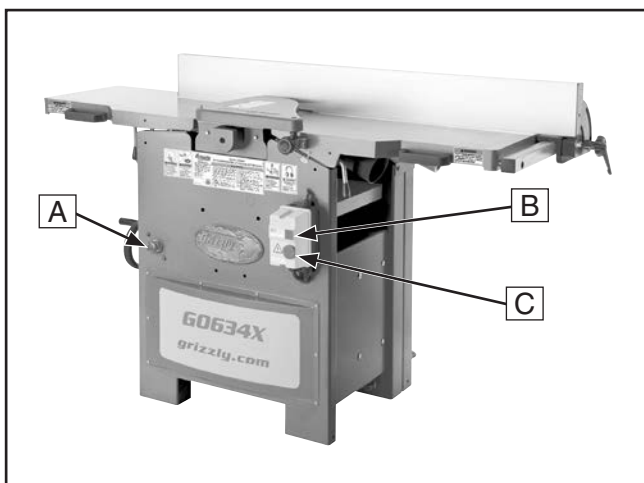


Figure 1. Locations of ON Button, OFF Button, and Emergency Stop button.

- A. Emergency Stop Button:** Stops motor when pressed. Remains depressed until manually reset. Reset by twisting button clockwise until it springs outward.
- B. ON Button:** Starts motor. (Only if Emergency Stop button is not in depressed position).
- C. OFF Button:** Stops motor when pressed.

Jointer Table Adjustment Controls

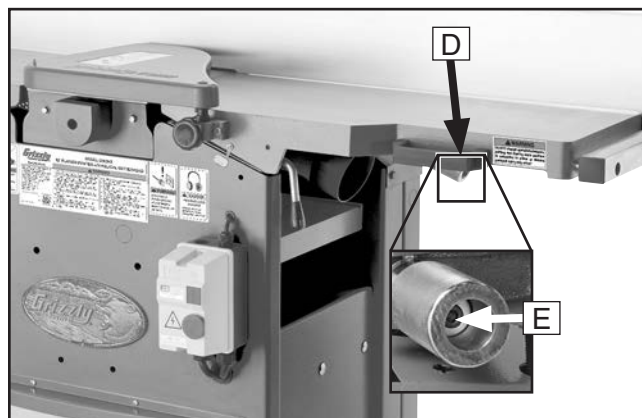


Figure 2. Location of infeed jointer table adjustment controls.

- D. Infeed Table Height Adjustment Knob:** Adjusts position of jointer infeed table (when infeed table height lock is loosened).
- E. Infeed Table Height Lock:** Secures infeed table height adjustment (requires 6mm hex wrench).

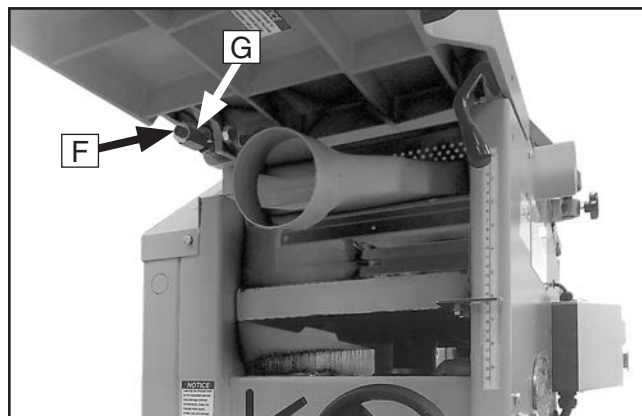


Figure 3. Location of outfeed jointer table adjustment controls.

- F. Outfeed Table Height Adjustment Knob:** Adjusts position of jointer outfeed table (when outfeed table height lock is loosened).
- G. Outfeed Table Height Lock:** Secures outfeed table height adjustment (requires 6mm hex wrench).



Jointer Fence Controls

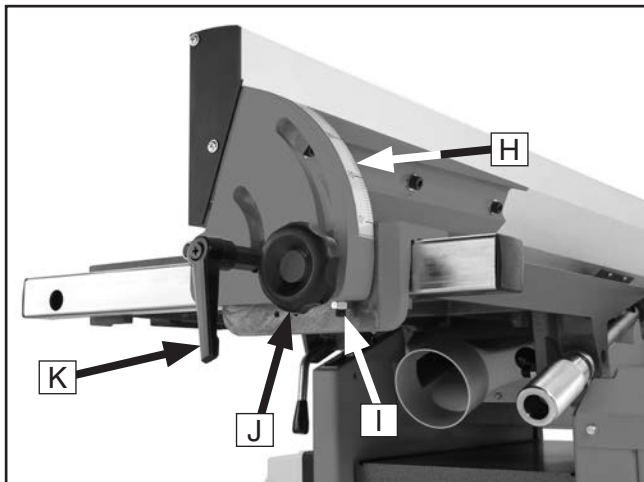


Figure 4. Locations of jointer fence controls.

- H. **Fence Tilt Scale:** Indicates angle of fence tilt adjustment.
- I. **90° Fence Stop:** Allows fence to be quickly positioned at 90° when adjusting tilt setting.
- J. **Fence Tilt Lock:** Tightens to secure fence tilt setting at desired angle; loosens to allow tilt adjustment.
- K. **Fence Lock Lever:** Tightens to secure lateral fence position along width of tables; loosens to allow adjustment.

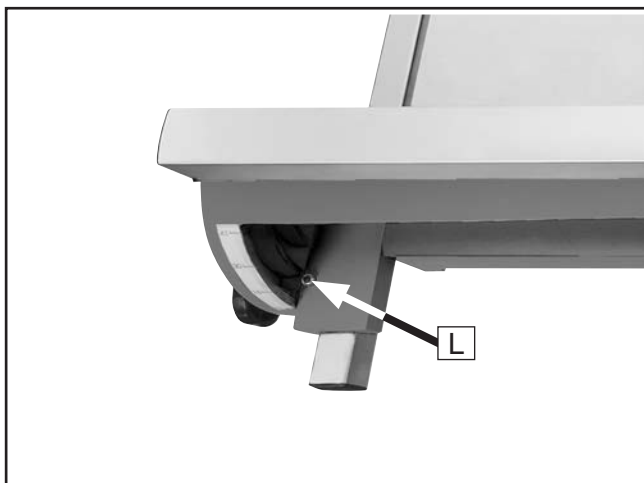


Figure 5. Location of 45° fence stop.

- L. **45° Fence Stop:** Allows fence to be quickly positioned at 45° when adjusting tilt setting.

Jointer/Planer Conversion Components

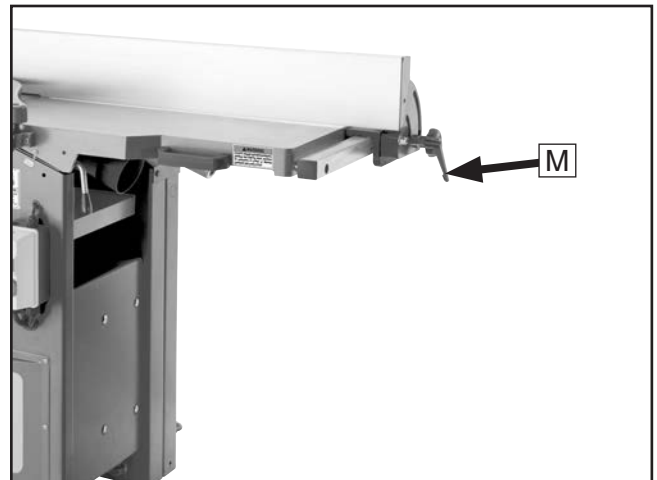


Figure 6. Location of fence lock.

- M. **Fence Lock Lever:** Loosen to allow removal of fence when converting jointer to planer.



Figure 7. Locations of table lock levers.

- N. **Table Lock Levers:** Loosen and pull out to swing jointer tables into UP position when converting jointer to planer.



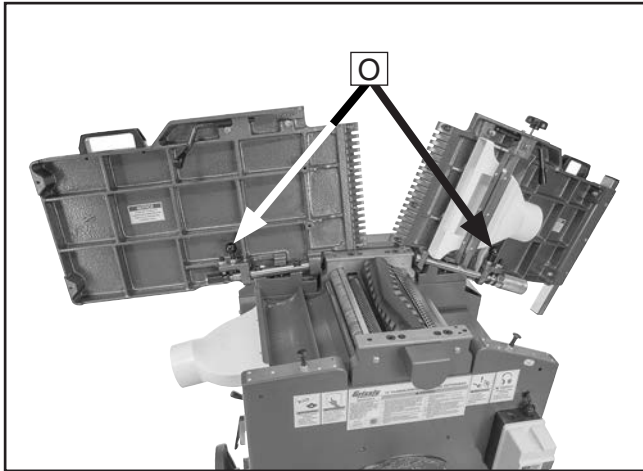


Figure 8. Location of jointer table lock knobs.

- O. Jointer Table Lock Knobs:** Secure jointer tables in UP position during planing.

⚠ CAUTION

Serious personal injury could occur if you place fingers between tables and base or between pivot points. Hands could be pinched or crushed!

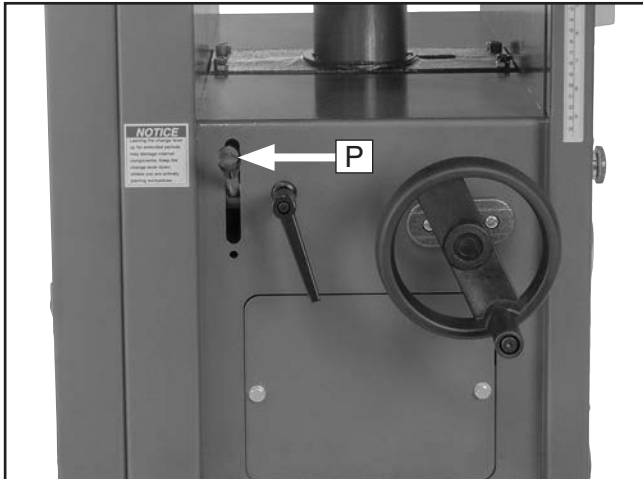


Figure 9. Location of jointer/planer selection lever.

- P. Jointer/Planer Selection Lever:** Moves UP to engage feed rollers for planer operation. Moves DOWN to disengage feed rollers for jointer operation.

Planer Controls

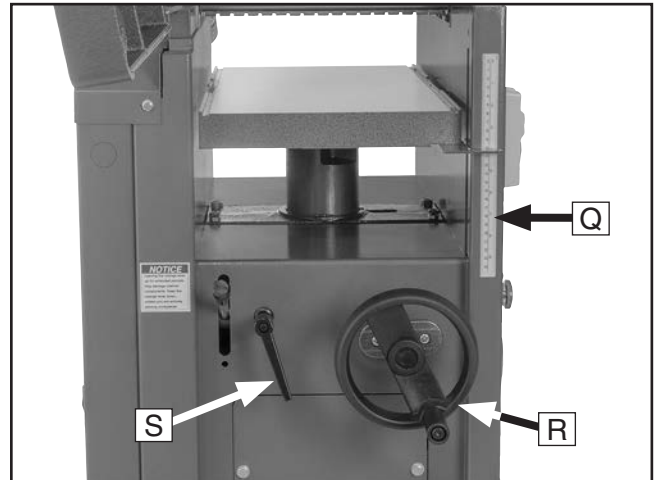


Figure 10. Locations of planer controls.

- Q. Thickness Scale:** Indicates thickness of finished workpiece.
- R. Table Height Handwheel:** Rotates to raise and lower planer table.
- S. Table Height Lock Lever:** Tightens to secure planer table height adjustment; loosens to allow adjustment.





MACHINE DATA SHEET

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

MODEL G0634X 12" JOINTER/PLANER w/V-HELICAL CUTTERHEAD

Product Dimensions:

Weight 610 lbs.
Width (side-to-side) x Depth (front-to-back) x Height 67-1/2 x 24 x 41-1/2 in.
Footprint (Length x Width) 26 x 19-1/2 in.

Shipping Dimensions:

Type Wood Crate
Content Machine
Weight 704 lbs.
Length x Width x Height 72 x 46 x 30 in.
Must Ship Upright Yes

Electrical:

Power Requirement 220V, Single-Phase, 60 Hz
Full-Load Current Rating 25A
Minimum Circuit Size 30A
Connection Type Cord & Plug
Power Cord Included Yes
Power Cord Length 10 ft.
Power Cord Gauge 12 AWG
Plug Included No
Recommended Plug Type L6-30
Switch Magnetic Switch w/Thermal Overload Protection

Motor:

Main

Horsepower 5 HP
Phase Single-Phase
Amps 25A
Speed 3450 RPM
Type TEFC Capacitor-Start Induction
Power Transfer Belt
Bearings Shielded & Permanently Lubricated

Main Specifications:

Fence Information

Fence Length 51-1/4 in.
Fence Width 2 in.
Fence Height 6 in.
Fence Stops 45 and 90 deg.

Cutting Capacities (Jointer)

Bevel Jointing 0 - 45 deg.
Maximum Width of Cut 12 in.
Maximum Depth of Cut 1/8 in.
Number of Cuts Per Minute 20,136
Minimum Stock Length 12 in.
Minimum Stock Thickness 1/4 in.



Cutting Capacities (Planer)

Maximum Width of Cut.....	11-3/4 in.
Maximum Depth of Cut Planing Full Width.....	1/8 in.
Maximum Depth of Cut Planing 6" Wide Board.....	5/32 in.
Number of Cuts Per Minute.....	20,136
Number of Cuts Per Inch.....	75
Planing Feed Rate.....	22 FPM
Minimum Stock Length.....	12 in.
Minimum Stock Thickness.....	1/4 in.
Maximum Stock Thickness.....	8 in.

Cutterhead Information

Cutterhead Type.....	V-Helical
Cutterhead Diameter.....	3-1/8 in.
Number of Cutter Rows.....	4
Number of Indexable Cutters.....	48
Cutter Insert Type.....	Indexable Carbide
Cutter Insert Length.....	15mm
Cutter Insert Width.....	15mm
Cutter Insert Thickness.....	2.5mm
Cutterhead Speed.....	5034 RPM

Table Information (Jointer)

Table Length.....	59-1/2 in.
Table Width.....	14 in.
Table Thickness.....	1-5/8 in.
Floor to Table Height.....	35-1/2 in.
Adjustment Type.....	Knob

Table Information (Planer)

Table/Headstock Movement.....	8 in.
Table Length.....	23-1/8 in.
Table Width.....	12-1/4 in.
Table Thickness.....	1-5/8 in.
Floor to Table Height.....	32-1/2 in.

Construction

Body Assembly.....	Cast Iron
Infeed Roller.....	Steel
Outfeed Roller.....	Rubber
Fence Assembly.....	Aluminum
Guard.....	Die-Cast Aluminum
Stand.....	Heavy Gauge Sheet Metal
Table.....	Cast Iron
Paint Type/Finish.....	Powder Coated

Other Information

Number of Dust Ports.....	2
Dust Port Size.....	4 in.
Measurement Scale (Jointer).....	Inch
Measurement Scale (Planer).....	Inch/Metric

Other Specifications:

Country of Origin.....	Taiwan
Warranty.....	1 Year
Approximate Assembly & Setup Time.....	30 Minutes
Serial Number Location.....	ID Label
ISO 9001 Factory.....	Yes



SECTION 1: SAFETY

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. Always use common sense and good judgment.

⚠ 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 Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery

⚠ WARNING

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



Additional Safety for Jointers

WARNING

Serious cuts, amputation, entanglement, or death can occur from contact with rotating cutterhead or other moving components! Flying chips from cutting operations can cause eye injuries or blindness. Workpieces or inserts/knives thrown by cutterhead (kickback) can strike nearby operator or bystanders with deadly force. To reduce the risk of serious personal injury from these hazards, operator and bystanders **MUST** completely heed the hazards and warnings below.

KICKBACK. Occurs when workpiece is ejected from machine at a high rate of speed. Kickback injuries occur from getting struck by workpiece or hands being pulled into cutterhead. To reduce the risk of kickback, only use proper workpieces, safe feeding techniques, and proper machine setup or maintenance.

GUARD REMOVAL. Operating jointer without guards unnecessarily exposes operator to knives/inserts and other hazardous moving parts. Except when rabbeting, never operate jointer or allow it to be connected to power if any guards are removed. Turn jointer **OFF** and disconnect power before clearing any shavings or sawdust from around cutterhead. After rabbeting or maintenance is complete, immediately replace all guards and ensure they are properly installed/adjusted before resuming regular operations.

DULL OR DAMAGED KNIVES/INSERTS. Dull or damaged knives/inserts increase risk of kickback and cause poor workpiece finish. Only use sharp, undamaged knives/inserts.

OUTFEED TABLE ALIGNMENT. Setting outfeed table too high can cause workpiece to hit table or get stuck while feeding. Setting outfeed table too low may cause workpiece to rock or shift while feeding. Both of these results will increase risk of kickback. Always keep outfeed table even with knives/inserts at highest point during rotation.

INSPECTING STOCK. Impact injuries or kickback may result from using improper workpieces. Thoroughly inspect and prepare workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or other foreign material. Always joint warped workpieces with cupped side facing down.

MAXIMUM CUTTING DEPTH. To reduce risk of kickback, never cut deeper than $\frac{1}{8}$ " per pass.

GRAIN DIRECTION. Jointing against the grain or end grain can increase risk of kickback. It also requires more cutting force, which produces chatter or excessive chip out. Always joint or surface plane **WITH** the grain.

CUTTING LIMITATIONS. Cutting workpieces that do not meet minimum dimension requirements can result in kickback or accidental contact with cutterhead. Never perform jointing, planing, or rabbeting cuts on pieces smaller than specified in machine data sheet.

PUSH BLOCKS. Push blocks reduce risk of accidental cutterhead contact with hands. Always use push blocks when planing materials less than 3" high or wide. Never pass your hands directly over cutterhead without a push block.

WORKPIECE SUPPORT. Poor workpiece support or loss of workpiece control while feeding will increase risk of kickback or accidental contact with cutterhead. Support workpiece with fence continuously during operation. Support long stock with auxiliary tables if necessary.

FEED WORKPIECE PROPERLY. Kickback or accidental cutterhead contact may result if workpiece is fed into cutterhead the wrong way. Allow cutterhead to reach full speed before feeding. Never start jointer with workpiece touching cutterhead. Always feed workpiece from infeed side to outfeed side without stopping until cut is complete. Never move workpiece backwards while feeding.

SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can be thrown from cutterhead with dangerous force. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than $\frac{1}{8}$ " (0.125") from cutterhead body.



Additional Safety for Planers

WARNING

Amputation, serious cuts, entanglement, or death can occur from contact with rotating cutterhead or other moving parts! Flying chips can cause eye injuries or blindness. Workpieces or knives thrown by cutterhead can strike nearby operator or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders MUST completely heed hazards and warnings below.

KICKBACK. Know how to reduce risk of kickback and kickback-related injuries. “Kickback” occurs during operation when the workpiece is ejected back through infeed side of machine at a high rate of speed. Kickback is commonly caused by poor workpiece selection, unsafe feeding techniques, or improper machine setup/maintenance. Kickback injuries typically occur as follows: (1) operator/bystanders are struck by workpiece, resulting in impact injuries (i.e., blindness, broken bones, bruises, death); (2) operator’s hands are pulled into blade from outfeed side, resulting in amputation or severe lacerations.

AVOID CONTACT WITH MOVING PARTS. Never remove guards/covers or reach inside planer during operation or while connected to power. You could be seriously injured if you accidentally touch spinning cutterhead or get entangled in moving parts. If a workpiece becomes stuck or sawdust removal is necessary, turn planer **OFF**, allow cutterhead to stop, disconnect power before clearing.

DULL/DAMAGED KNIVES/INSERTS. Only use sharp, undamaged knives/inserts. Dull or damaged knives/inserts increase the risk of kickback.

INSPECTING STOCK. To reduce the risk of kickback injuries or machine damage, thoroughly inspect and prepare the workpiece before cutting. Verify workpiece is free of nails, staples, loose knots, or foreign material. Workpieces with minor warping should be jointed first or planed with the cupped side facing the table.

BODY PLACEMENT. Stand to one side of planer during entire operation to avoid getting hit if kickback occurs.

GRAIN DIRECTION. Planing across grain is hard on planer and may cause kickback. Plane in same direction or at a slight angle with wood grain.

PLANING CORRECT MATERIAL. Only plane natural wood stock with this planer. DO NOT plane MDF, OSB, plywood, laminates or other synthetic materials that can break up inside the planer and be ejected towards the operator.

LOOKING INSIDE PLANER. Wood chips fly around inside the planer at a high rate of speed during operation. To avoid injury from flying material, DO NOT look inside planer during operation.

CUTTING LIMITATIONS. To reduce the risk of kickback hazards or damage to the machine, do not exceed the maximum depth of cut or minimum board length and thickness found in the **Data Sheet**. Only feed one board at a time.

INFEED ROLLER CLEARANCE. The infeed roller is designed to pull material into the spinning cutterhead. To reduce the risk of entanglement, keep hands, clothing, jewelry, and long hair away from the infeed roller during operation.

FEED WORKPIECE PROPERLY. To reduce the risk of kickback, never start planer with workpiece touching cutterhead. Allow cutterhead to reach full speed before feeding, and do not change feed speed during cutting operation.

WORKPIECE SUPPORT. To reduce the risk of kickback, always make sure workpiece can move completely across table without rocking or tipping. Use auxiliary support stands for long stock.

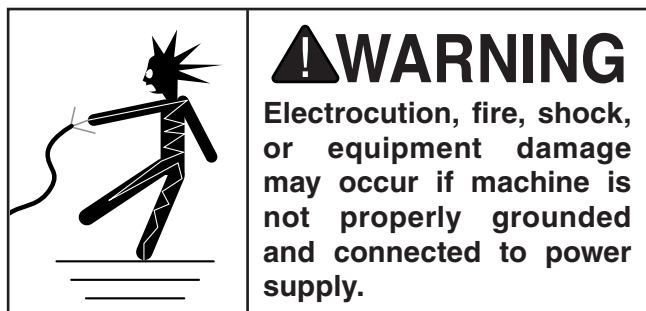
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation.



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V 25 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

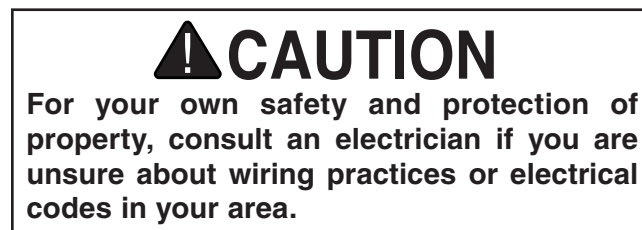
If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

Circuit Requirements for 220V

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase 1-Phase
Power Supply Circuit 30 Amps
Plug/Receptacle NEMA L6-30
Cord “S”-Type, 3-Wire, 12 AWG, 300 VAC

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)



Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*



Grounding Instructions

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

The power cord and plug specified under “Circuit Requirements for 220V” on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

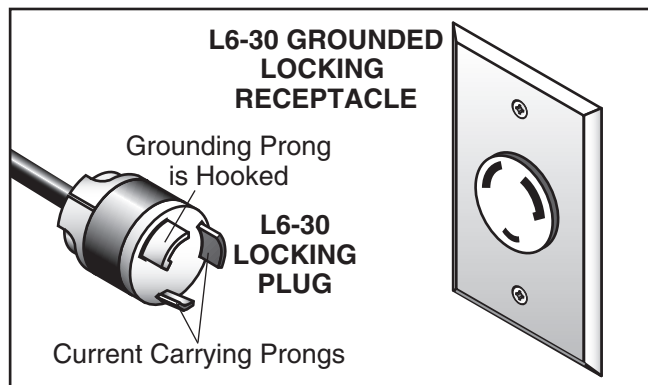

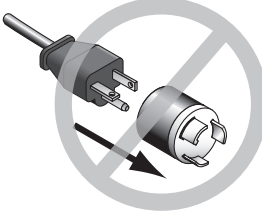


Figure 11. Typical L6-30 plug and receptacle.

 **CAUTION**



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

WARNING

Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

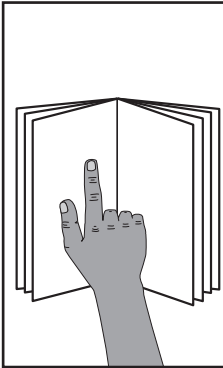
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size10 AWG
Maximum Length (Shorter is Better).....50 ft.

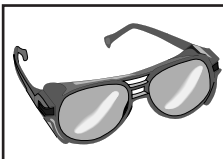


SECTION 3: SETUP



!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 setup process!



!WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Safety Glasses (per person).....	1 Pair
• Lifting Equipment (Min. 800 lb. Capacity) ..	1
• Lifting Sling (800 lb. Capacity, Optional)	1
• Dust Collection System	1
• Dust Hose 4" (length as needed)	1
• Hose Clamp 4"	1
• Shop Rags for Cleaning	As Needed
• Degreaser/Cleaner (Page 17)	As Needed
• Disposable Gloves	As Needed
• Plug L6-30.....	1

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. *You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.*



Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary 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.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

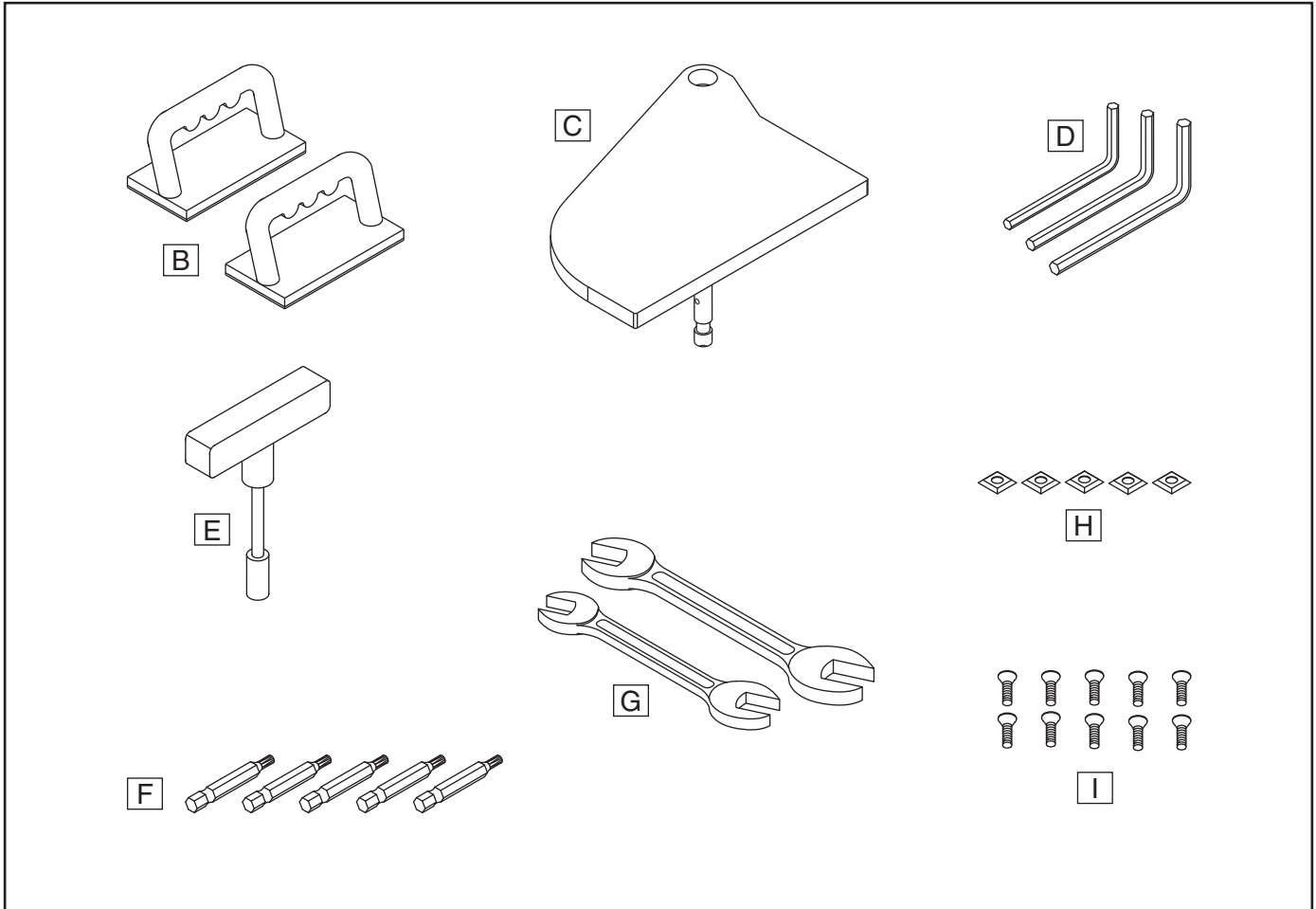


Figure 12. Loose inventory.

Box 1 (Figure 12)	Qty	
A. Jointer/Planer Assembly (Not Shown).....	1	E. T-Handle T20 Torx Driver.....
B. Push Blocks.....	2	F. Torx Bits T20
C. Cutterhead Guard Assembly	1	G. Open-End Wrenches 8/10, 12/14mm ..
D. Hex Wrenches 2.5, 3, 4mm	1 Ea.	H. Carbide Inserts 15 x 15 x 2.5mm
		I. Flat Hd T20 Torx Screws M6-1 x 16.....



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

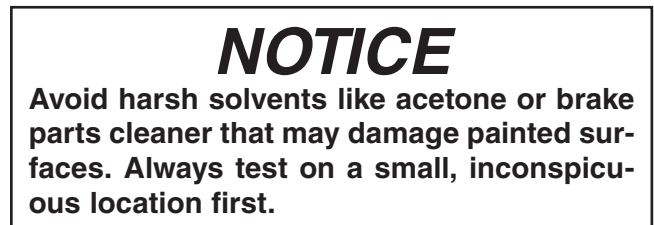
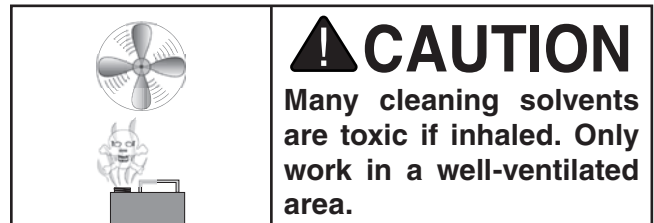
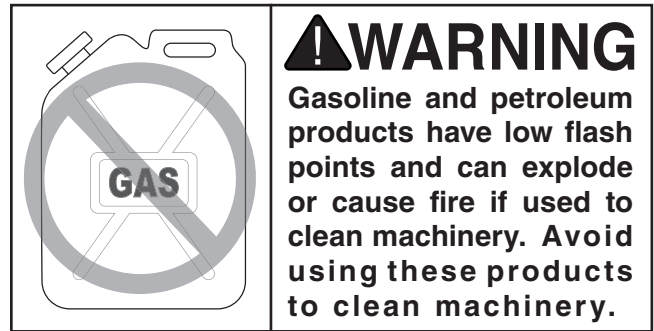
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from the **non-painted** parts of the machine during clean up.



Figure 13. T23692 Orange Power Degreaser.



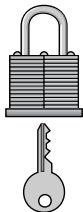
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**

	<p>CAUTION</p> <p>Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
---	--

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

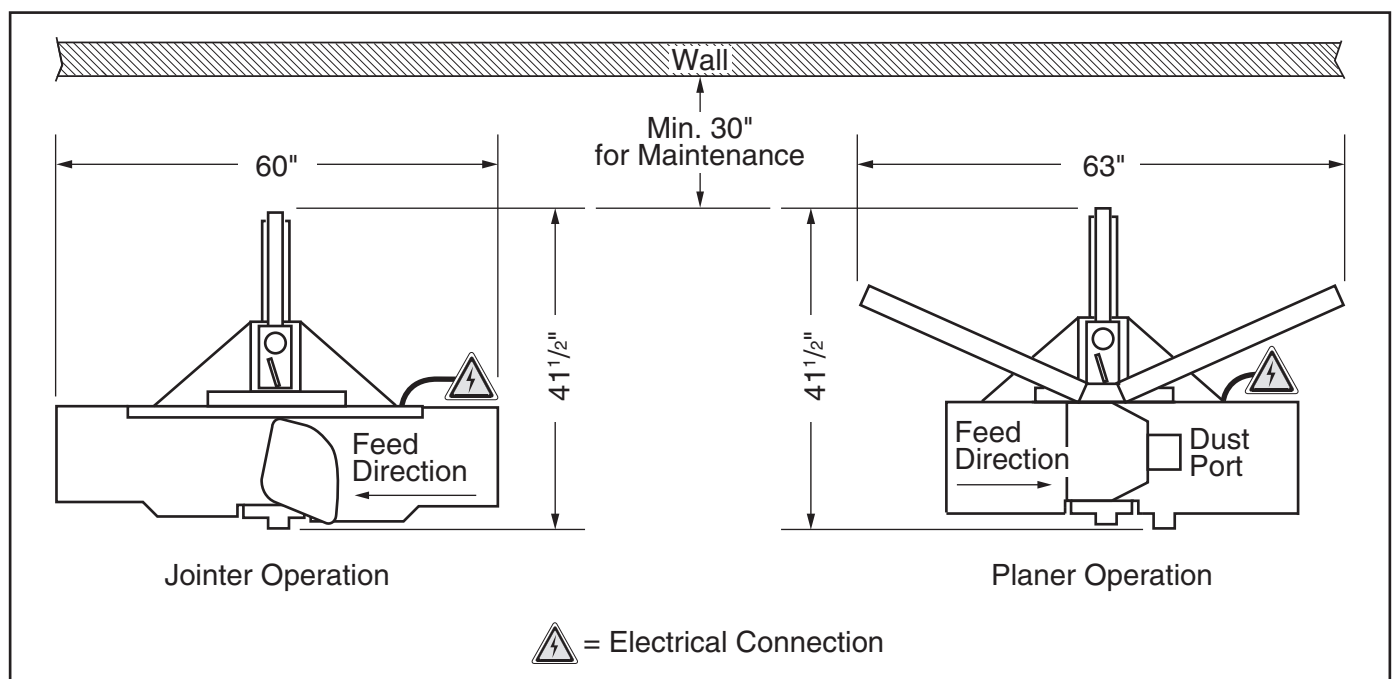
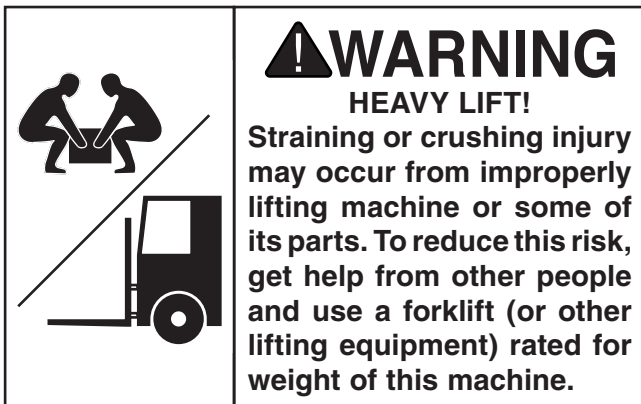


Figure 14. Minimum working clearances.



Lifting & Placing



Unbolt the jointer/planer from the pallet, and use a forklift to lift the machine off the pallet and onto a suitable location as shown in **Figure 15**. Only lift the machine enough to clear the floor.

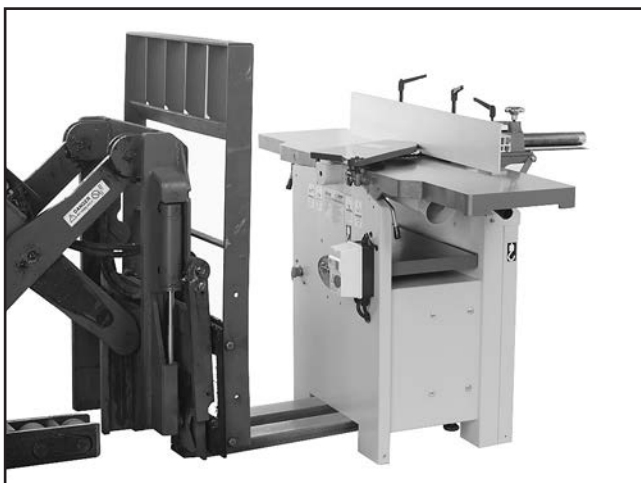


Figure 15. Example of lifting machine with forklift.

You can also attach hooks and lifting slings to the machine using the three lifting holes shown in **Figures 16–17** with a forklift, hoist, or boom crane. If you choose this alternative, you must punch out the lifting strap holes—this will permanently alter your machine.

If you are unsure how to lift this machine, consult a qualified professional.

After setting the machine in place, remove the shipping braces on both sides (see **Figure 16**).

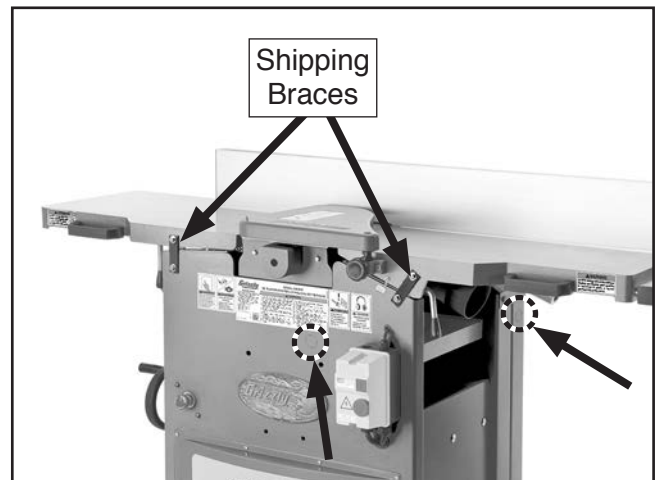


Figure 16. Locations of front and right rear lifting holes and shipping braces.

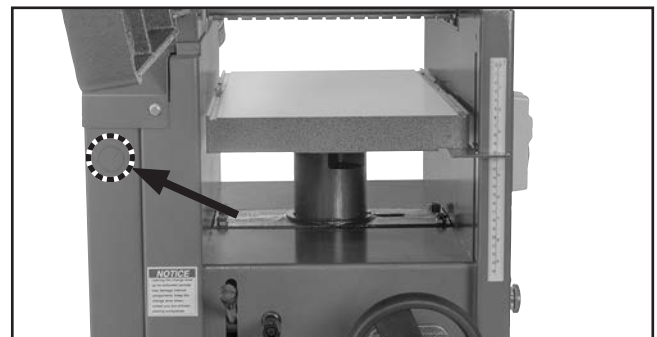


Figure 17. Location of left rear lifting hole.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

The Model G0634X comes fully assembled except for installation of the cutterhead guard. The cutterhead guard helps to protect hands and fingers from the rotating cutterhead during jointing operations. The cutterhead guard **MUST** be installed before operating this machine.



To assemble machine:

1. Remove shaft lock knob and insert cutterhead guard shaft into bracket hole, as shown in **Figure 18**.

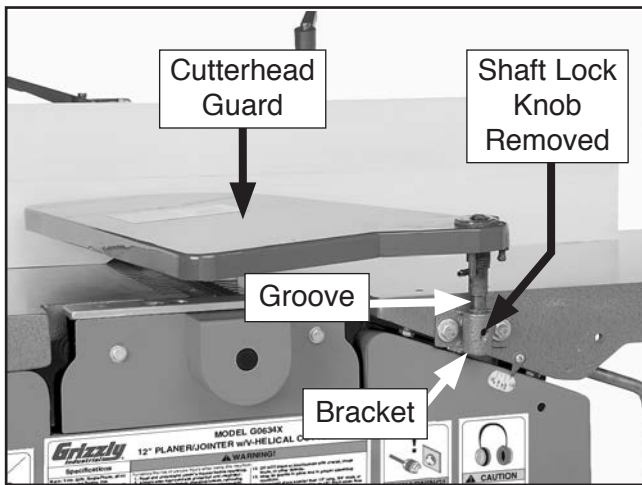


Figure 18. Installing cutterhead guard.

2. Move fence forward until it touches cutterhead guard.
3. Thread lock knob into bracket so threads fit into shaft groove (see **Figure 18**), and secure guard into place. Adjust guard and lock knob as needed so guard fully covers cutterhead.
4. Test guard by pulling it back and letting go. Rubber bumper on guard should hit fence when guard comes back.
 - Guard should snap back over cutterhead without dragging across table.
 - If guard drags across table, raise it until it does not drag, then tighten shaft lock.
 - If guard does not snap back, remove it and repeat **Steps 1–3**.

Dust Collection

⚠ CAUTION

This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

Minimum CFM at Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect dust collection hose:

1. Fit 4" dust hose over jointer dust port, (see **Figure 19**), or over planer dust port (see **Figure 20**), depending upon operation mode, and secure in place with hose clamp.



Figure 19. Example of dust hose attached to jointer dust port.



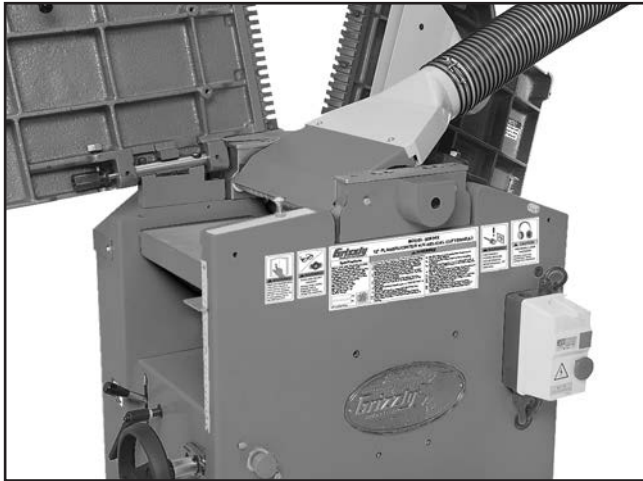


Figure 20. Example of dust hose attached to planer dust port.

2. Tug hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.

Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual, and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly.

Always make sure the Emergency Off button is pushed in before connecting power.

Connecting Plug to Power Cord

To connect plug to power cord, install L6-30 plug on end of power cord per plug manufacturer's instructions. If no instructions were included, use Wiring Diagram on **Page 53**.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem **BEFORE** operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The Test Run consists of verifying the following:
 1) The motor powers up and runs correctly, 2) the OFF button works correctly, and 3) the Emergency Stop button works correctly.

!WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

!WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.
2. Press Emergency Stop button in.
3. Make sure jointer tables are folded down and locked in place (see **Page 32**).
4. Connect machine to power by inserting power cord plug into matching receptacle.



- Twist Emergency Stop button clockwise until it springs out (see **Figure 21**). This resets switch so machine can start.



Figure 21. Resetting the switch.

- Press ON button to turn machine **ON**. Verify motor starts up and runs smoothly without any unusual problems or noises.
- Press Emergency Stop button to turn machine **OFF**.
- WITHOUT resetting Emergency Stop button, try to start machine by pressing ON button. Machine should not start.
 - If machine *does not* start, safety feature of Emergency Stop button is working correctly.
 - If machine *does* start, immediately turn it **OFF** and disconnect power. Safety feature of Emergency Stop button is NOT working properly and must be replaced before further using machine.
- Twist Emergency Stop button clockwise to reset.
- Press ON button, then immediately press OFF button on magnetic switch (see **Figure 1** on **Page 4**).
 - If machine turns **OFF**, OFF button is working correctly. Test Run is complete.
 - If machine does not turn **OFF**, disconnect power to machine. OFF button is not working correctly. This feature must work properly and must be replaced before further using machine.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping and storage, some of these adjustments may need to be repeated to ensure optimum cutting results. Keep this in mind as you start to use your new jointer/planer.

Step-by-step instructions for these adjustments can be found in SECTION 7: SERVICE ADJUSTMENTS.

- Outfeed Table Height (**Page 44**)
- Jointer Table Parallelism (**Page 45**)
- Depth Scale Calibration (**Page 50**)
- Fence Stop Accuracy (**Page 50**)
- Planer Table Parallelism (**Page 48**)
- Feed Roller Spring Tension (**Page 52**)

Tighten V-Belts

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the V-belts will stretch and seat into the pulley grooves. After this 16 hours, you must re-tension the V-belts to avoid slippage and burn out. Refer to **Page 42** when you are ready to perform this important adjustment.

Note: *Pulleys and belts can get hot. This is a normal condition. Allow them to cool before making adjustments.*

A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate premature belt failure is in progress.

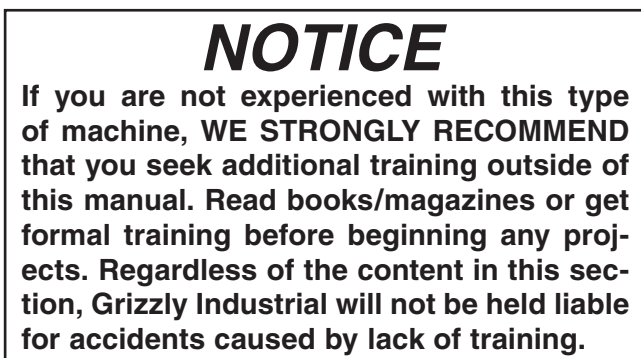
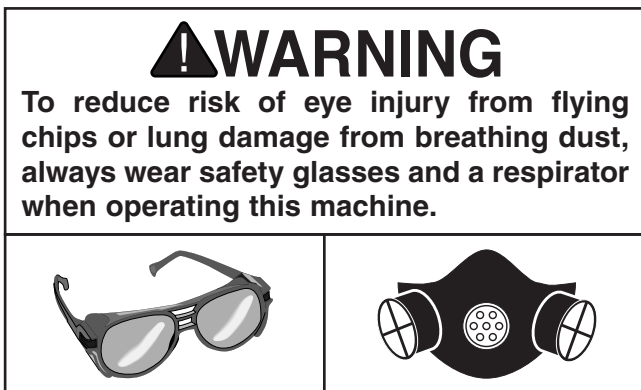


SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



Typical Jointing Operation

1. Operator examines workpiece to verify it is safe and suitable for jointing.
2. Ensures jointer tables are secured in DOWN position, and jointer/planer selection lever is set for jointing operations.
3. Adjusts fence for width of workpiece and locks it in place.
4. Adjusts fence tilt, if necessary.
5. Adjusts infeed table height to set depth of cut per pass.
6. Puts on safety glasses, respirator, and any other required protective equipment.
7. Starts jointer.
8. Using push blocks as needed, holds workpiece firmly against infeed table and fence, and feeds workpiece into cutterhead at steady and controlled rate until entire length of workpiece has been cut and it clears cutterhead on outfeed table side.
9. Repeats cutting process described above until desired results are achieved.
10. Stops jointer.



Typical Planing Operation

1. Operator examines workpiece to make sure it is safe and suitable for planing.
 - If workpiece is bowed, operator surface planes workpiece on jointer until one side is flat. Doing so ensures that it sits solidly on planer table during operation.
2. Ensures machine is properly set up for planing operations.
3. Puts on safety glasses or face shield, respirator, and ear protection.
4. Places workpiece on table with flat side down and correctly adjusts table height for workpiece thickness and depth of cut.

Note: *Any time you switch directions with table height handwheel, there will be small amount of backlash—so first crank of handwheel after switching directions will be slightly less than $\frac{1}{16}$ ". However, as long as you move handwheel in same direction during operation, backlash will not be a factor.*

5. When all safety precautions have been taken, turns planer **ON**.
6. Stands to one side of planer path to reduce risk of kickback injuries, then feeds workpiece into planer until infeed roller grabs it.

Note: *Infeed and outfeed rollers control feed rate of workpiece as it passes through planer. Operator does not push or pull on workpiece.*

 - If cut is too deep and bogs down planer, operator immediately reduces depth of cut.
7. Once workpiece is clear of outfeed roller and stops moving, operator removes workpiece from outfeed table and measures workpiece thickness. If further planing is required, operator raises table slightly (approximately $\frac{1}{4}$ to $\frac{1}{2}$ turn of handwheel), then feeds workpiece into front of planer again.
8. Operator continues process until desired thickness is achieved, then turns machine **OFF**.



Stock Inspection & Requirements

Basic rules to follow before milling stock on a jointer or thickness planer:

- **Large/Loose Knots:** Loose knots can become dislodged and kickback during operation, causing machine damage. Ensure workpieces that do not have large/loose knots.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. **DO NOT** use workpieces with these characteristics!
- **DO NOT joint or surface plane against grain direction.** Cutting against the grain increases likelihood of stock kickback, as well as tear-out on workpiece.
- **Jointing and surface planing with grain produces better finish and is safer for operator.** Cutting with the grain is described as feeding stock so grain points down and toward you on jointer (see **Figure 22**) or away from you on planer (see **Figure 23**), as viewed from edge.

Note: If grain changes direction along edge of board, decrease cutting depth and make additional passes.

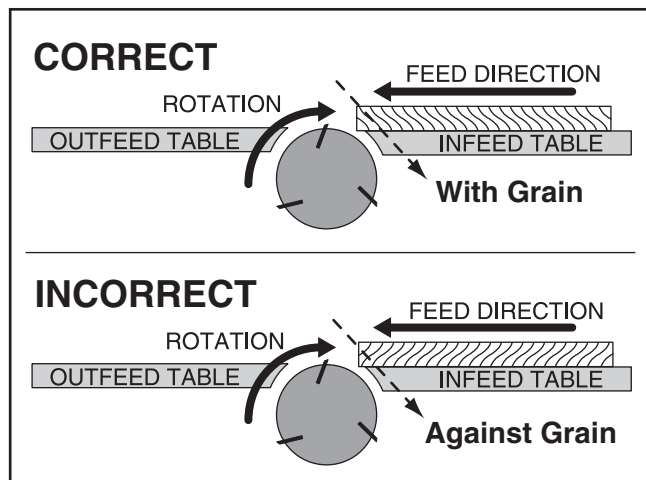


Figure 22. Correct and incorrect grain alignment to cutterhead (jointer).

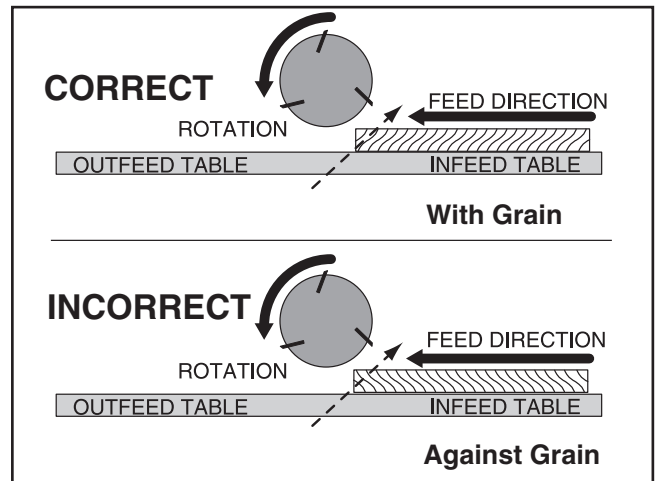


Figure 23. Correct and incorrect grain alignment to cutterhead (planer).

- **Minor Cupping:** Workpieces with slight cupping can be safely supported if cupped side is facing table. On the contrary, workpiece supported on bowed side will rock during operation and could cause severe injury from kickback.
- **Remove foreign objects from stock.** Make sure that any stock you process with jointer/planer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects, which if they hit inserts and are drawn into dust collector, may cause fire hazard. Particles may also damage inserts. Wood stacked on concrete floor can have small pieces of stone or concrete pressed into surface.
- **Only process natural wood fiber through jointer/planer.** Never joint or plane MDF, particle board, plywood, laminates or other synthetically made materials.
- **Make sure all stock is sufficiently dried before jointing or planing.** Wood with moisture content over 20% will cause unnecessary wear on inserts and poor cutting results. Excess moisture can also hasten rust and corrosion.
- **Scrape all glue off of boards before planing.**
- **Keep work area clear.**



Wood Types

Jointer-Specific Rules:

- Always joint with cupped side of workpiece facing down, otherwise workpiece could rock during cut, increasing likelihood of kickback.
- Make sure workpiece exceeds minimum dimension requirements (see **Figures 24–25**) before edge jointing or surface planing, or it may break or kick back during operation!

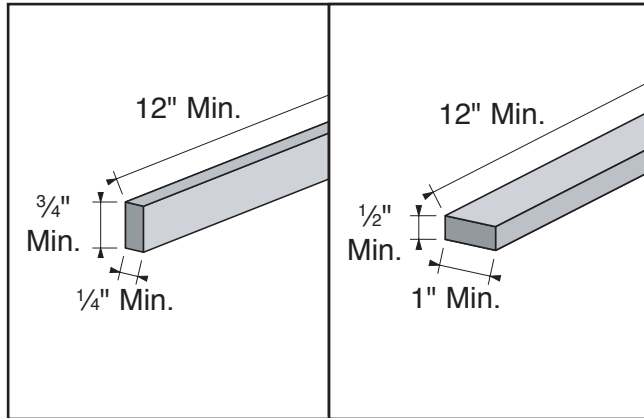


Figure 24. Minimum dimensions for edge jointing and surface planing (jointer).

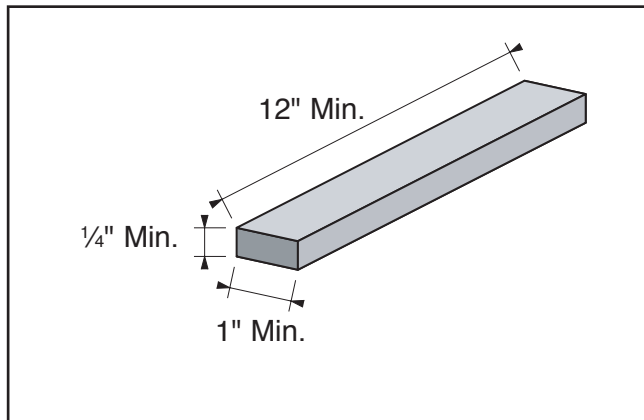


Figure 25. Minimum dimensions for surface planing (thickness planer).

Thickness Planer-Specific Rules:

- Use full width of planer. Alternate between left, right, and middle when feeding narrower lumber into planer. Inserts will remain sharp much longer.

The species of wood, as well as its condition, greatly affects the depth of cut the jointer/planer can effectively take with each pass.

The chart in the figure below shows the Janka Hardness Rating for a number of commonly used species. The larger the number, the harder the workpiece, and the less material should be removed in any one pass for good results.

Note: The Janka Hardness Rating is expressed in pounds of force required to embed a 0.444" steel ball into the surface of the wood to a depth equal to half the ball's diameter.

Species	Janka Hardness
Ebony	3220
Red Mahogany	2697
Rosewood	1780
Red Pine	1630
Sugar Maple	1450
White Oak	1360
White Ash	1320
American Beech	1300
Red Oak	1290
Black Walnut	1010
Teak	1000
Black Cherry	950
Cedar	900
Sycamore	770
Douglas Fir	660
Chestnut	540
Hemlock	500
White Pine	420
Basswood	410
Eastern White Pine	380
Balsa	100

Figure 26. Janka Hardness Rating for some common wood species.



Setting Jointer Depth of Cut

The depth of cut on a jointer is the amount of material removed from the bottom of the workpiece as it passes over the cutterhead.

The depth of cut is set by adjusting the height of the infeed table relative to the carbide inserts at TDC (top dead center).

The jointer depth-of-cut scale (see **Figure 27**) goes up to $\frac{3}{16}$ " , however the recommended depth of cut per pass is $\frac{1}{16}$ "– $\frac{1}{8}$ " depending on the operation.

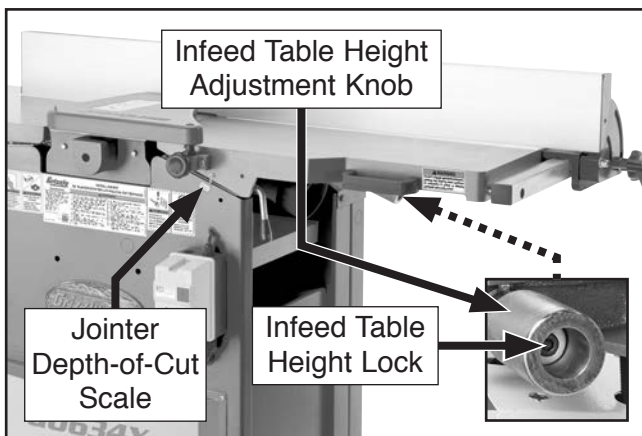


Figure 27. Location of jointer depth-of-cut scale and infeed table height adjustment controls.

DO NOT exceed the recommended depth of cut per pass, or kickback and serious injury may occur.

Adjusting Infeed Table Height

Item Needed	Qty
Hex Wrench 6mm.....	1

To adjust infeed table height:

1. Loosen infeed table height lock, rotate infeed table height adjustment knob, then tighten table height lock to secure (see **Figure 27**).
 - Rotate infeed table height adjustment knob *clockwise* to *raise* table.
 - Rotate knob *counterclockwise* to *lower* table.

Jointer Depth-of-Cut Scale

The depth of cut can be referenced directly from the depth scale located on the front of the jointer, as shown.

Note: The depth scale can be calibrated or "zeroed" if it is not correct. Refer to **Calibrating Depth Scale** for more information.

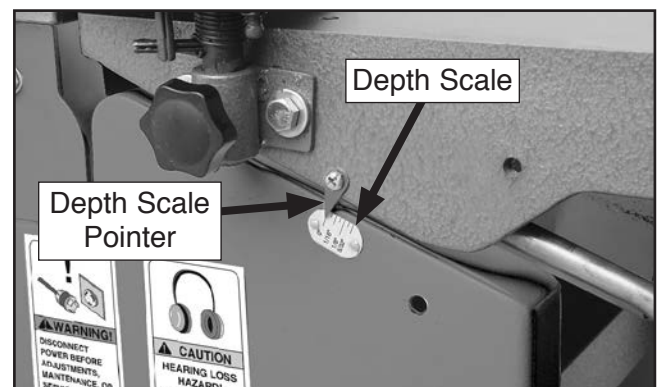


Figure 28. Location of jointer depth-of-cut scale.



Squaring Stock For Jointing

Squaring stock means making it flat and parallel along both length and width, and making the length and width perpendicular to one another.

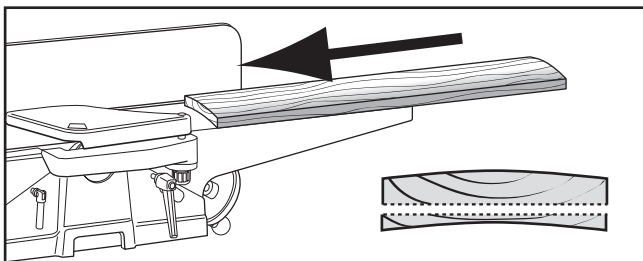
The purpose of squaring stock is to prepare it for accurate cuts and construction later on.

A properly "squared up" workpiece is essential for tasks such as accurate table saw cuts, glue-ups/laminations, cutting accurate bevels on a bandsaw, and many other applications where one surface of a workpiece is used to reference another.

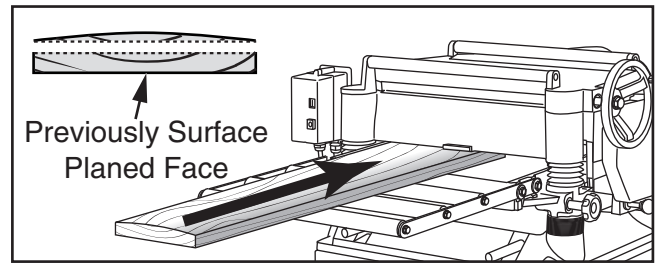
Items Needed	Qty
Jointer	1
Planer	1
Table Saw	1

Squaring stock involves four steps performed in the order below:

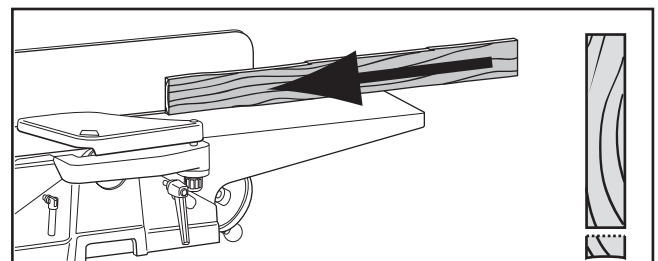
- 1. Surface Plane on Jointer**—Concave face of workpiece is surface planed flat with jointer.



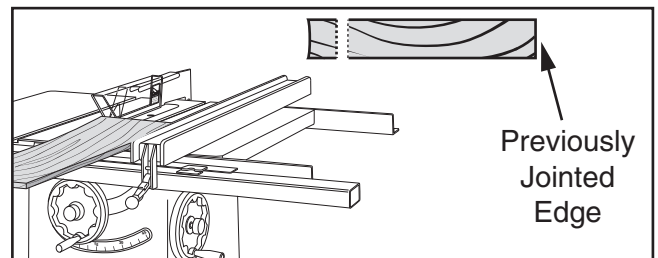
- 2. Surface Plane on a Thickness Planer**—Opposite face of workpiece is surface planed flat with a thickness planer.



- 3. Edge Joint on Jointer**—Concave edge of workpiece is jointed flat with jointer.



- 4. Rip Cut on a Table Saw**—Jointed edge of workpiece is placed against a table saw fence and opposite edge cut off.



Surface Planing On Jointer

The purpose of surface planing (see example **Figures** below) on the jointer is to make one flat face on a piece of stock to prepare it for thickness planing on a planer.

! WARNING

Failure to use push blocks when surface planing could result in your hands contacting rotating cutterhead, which will cause serious personal injury. ALWAYS use push blocks when surface planing on jointer!

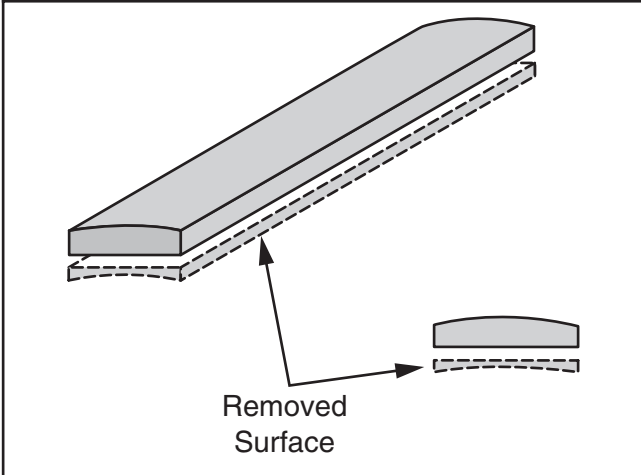


Figure 29. Example surface planing operation.

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Set infeed table height to desired cutting depth for each pass.

! CAUTION: To minimize risk of kickback, do not exceed a cutting depth of $\frac{1}{16}$ " per pass when surface planing.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

! CAUTION: To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

6. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during the entire cut.

! CAUTION: Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

7. Repeat **Step 6** until entire surface is flat.

Tip: When squaring up stock, cut opposite side of workpiece with a planer instead of the jointer to ensure both sides are parallel.



Edge Jointing

Edge jointing (see example **Figures** below) produces a flat and true surface along the side of a workpiece by removing uneven areas. It is an essential step for squaring up warped or rough stock and when preparing a workpiece for joinery or finishing.

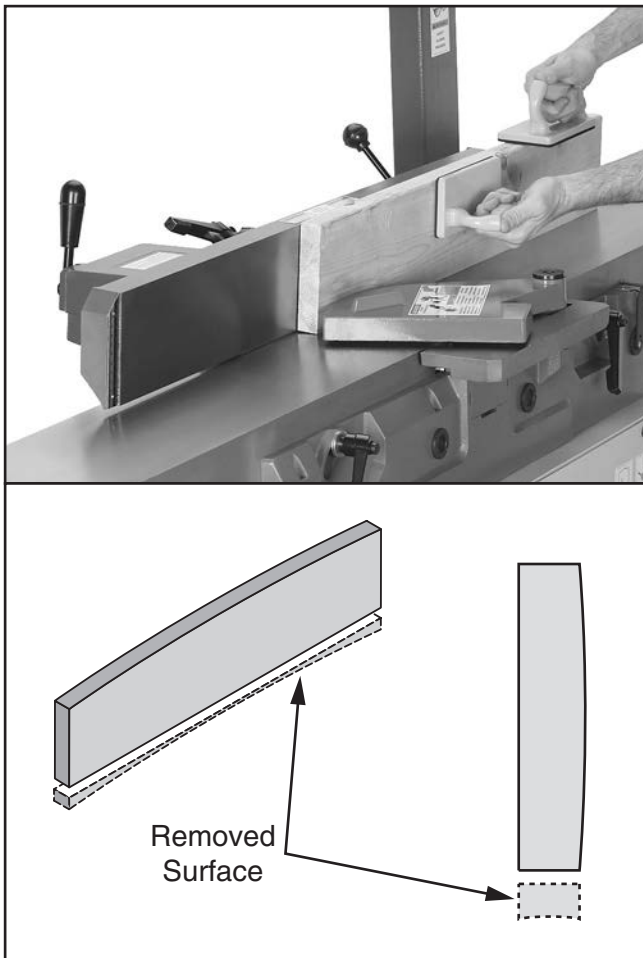


Figure 30. Example edge jointing operation.

NOTICE

If you are not experienced with a jointer, set depth of cut to 0", and practice feeding workpiece across tables as described. This will help you prepare for actual operations.

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Surface plane workpiece (see **Surface Planing** section).
3. Set infeed table height to desired cutting depth for each pass.
⚠ CAUTION: To minimize risk of kickback, do not exceed a cutting depth of $\frac{1}{8}$ " per pass.
4. Set fence to 90°.
5. Start jointer.
6. Place workpiece firmly against fence and infeed table with concave side facing down.
⚠ CAUTION: To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.
7. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during the entire cut.
⚠ CAUTION: Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.
8. Repeat **Step 6** until the entire edge is flat.

Tip: When squaring up stock, cut opposite edge of workpiece with a table saw instead of the jointer—otherwise, both edges of workpiece will not be parallel with each other.



Bevel Cutting On Jointer

Bevel cuts (see example **Figures** below) can be made by setting the fence at the desired angle and feeding the workpiece firmly along the fence face, with the bottom inside corner firmly against the table. The cutting process typically requires multiple passes or cuts to bevel the entire edge of a workpiece.

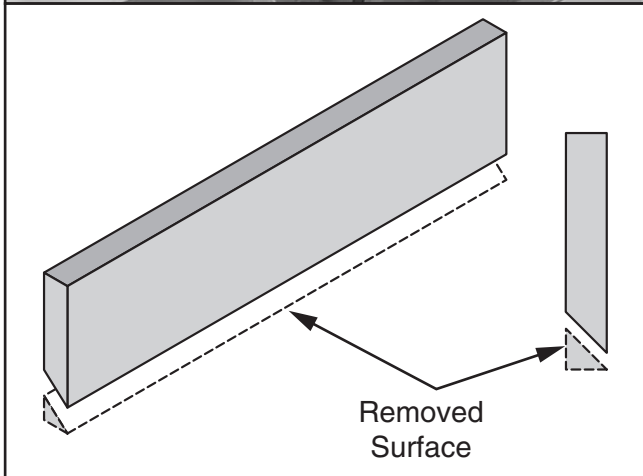


Figure 31. Example of fence setup for bevel cut of 45°.

NOTICE

If you are not experienced with a jointer, set depth of cut to 0", and practice feeding workpiece across tables as described. This will help you prepare for actual operations.

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Surface plane workpiece (see **Surface Planing** section).
3. Edge joint workpiece (see **Edge Jointing** section).
4. Set infeed table height to cutting depth desired for each pass.

▲ CAUTION: Cutting depth for bevel cuts is typically between $\frac{1}{16}$ " and $\frac{1}{8}$ ", depending on hardness and width of stock.

5. Set fence tilt to desired angle of cut.
6. Place workpiece against fence and infeed table with concave side face down.
7. Start jointer.
8. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

▲ CAUTION: When your leading hand gets within 4" of the cutterhead, lift it up and over cutterhead, and place push block on portion of the workpiece once it is 4" past cutterhead. Now, focus your pressure on outfeed end of the workpiece while feeding, and repeat same action with your trailing hand when it gets within 4" of cutterhead. To help keep your hands safe, **DO NOT** let them get closer than 4" from moving cutterhead at any time during operation!

9. Repeat cutting process, as necessary, until you are satisfied with the results.



Jointer/Planer Conversion

The Model G0634X is ready for jointer operations after it is first setup. To use the machine as a planer, you must convert it from a jointer to a planer.

Converting for Planer Operations

1. DISCONNECT MACHINE FROM POWER!
2. Loosen fence lock lever, slide fence toward front of machine, carefully slide protective flap through bracket, and lift fence off of fence rail (see **Figure 32**).

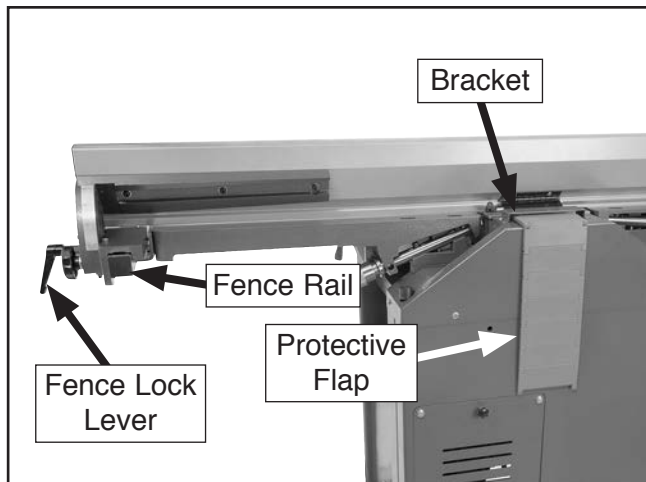


Figure 32. Fence removal components.

3. Remove dust hose from jointer dust port.
4. Rotate infeed table lock lever (see **Figure 33**) clockwise, pull it out, and pivot table upward.

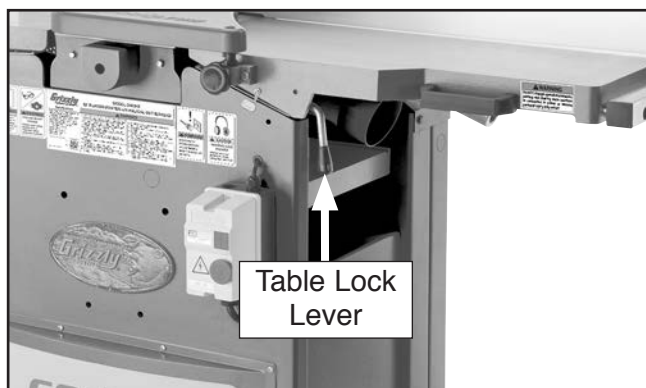


Figure 33. Location of infeed table lock lever.

Note: Table will lock into place when raised to its highest position, as shown in **Figure 34**.



Figure 34. Infeed table pivoted up.

5. Raise outfeed table in same manner as you did with infeed table.
6. Swing planer dust port clockwise over cutterhead and connect dust collection hose, as shown in **Figure 35**.
7. Move jointer/planer selection lever to up position (see **Figure 35**).

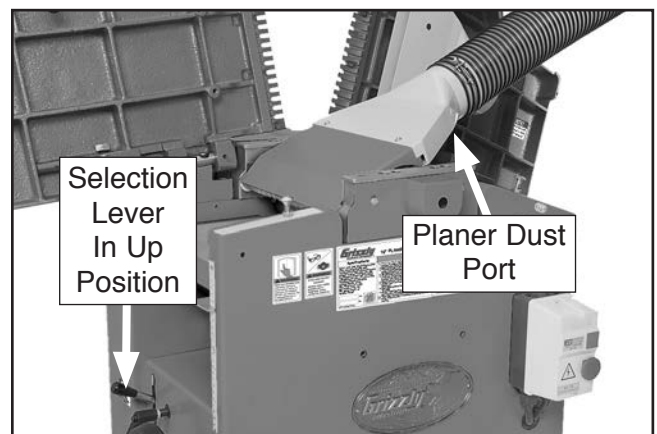


Figure 35. Machine converted to planer.



Converting for Jointer Operations

1. Lower planer table to below 4" mark on thickness scale.
2. Move jointer/planer selection lever to down position.
3. Remove dust hose from planer dust port, then swing dust port counterclockwise below cutterhead (see **Figure 36**).
4. Pull infeed jointer table release knob, then pivot infeed table down and lock in position with infeed table lock lever (see **Figure 36**).

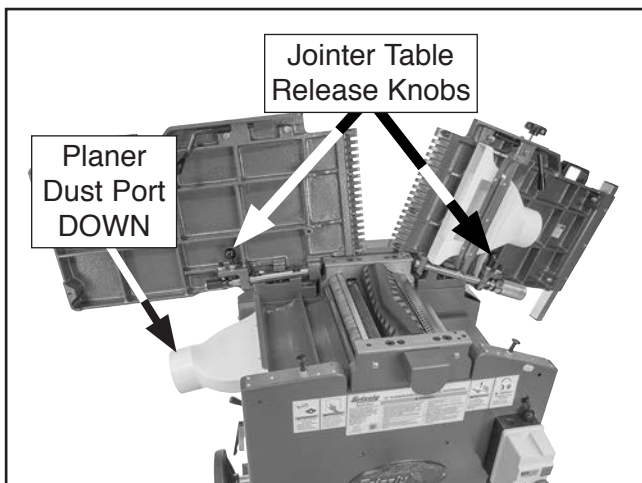


Figure 36. Planer dust port in DOWN position and location of jointer table release knobs.

⚠ CAUTION

Serious personal injury could occur if you place fingers between tables and base or between pivot points. Hands could be pinched or crushed!

5. Pivot outfeed table down in same manner as you did with infeed table.
6. Connect dust collection hose to jointer dust port.
7. Install fence and position it for jointing operation, then tighten fence lock lever.

Note: When installing fence, carefully insert protective flap through bracket, so rear of cutterhead is covered when fence is adjusted.

Planing Tips

- Inspect your lumber for twisting or cupping, and surface one face on a jointer if necessary before planing workpiece.
- Scrape off all glue when planing glued-up panels. Dried glue can quickly dull knives/inserts.
- DO NOT plane more than one piece at a time. Never plane multiple pieces side by side.
- Never remove more than the recommended amount of material on each pass. Only remove a small amount of material on each pass when planing wide or dense stock.
- Support the workpiece on both ends. Get assistance from another person if you are planing long lumber, or use roller stands to support the workpiece.
- Measure the workpiece thickness with calipers to get exact results.
- Carefully inspect all stock to make sure it is free of large knots or foreign objects that may damage your knives/inserts, cause kickback, or be ejected from the planer.
- When possible, plane equal amounts on each side of the board to reduce the chance of twisting or cupping.
- Use the entire width of the planer to wear knives/inserts evenly. With narrow workpieces, alternate between far left, far right, and the middle of the table. Your knives/inserts will remain sharp much longer.
- To avoid "chip marks," always plane WITH the grain direction of the wood. Never plane cross-grain or end-grain.
- Plane ONLY natural wood fiber. Do not plane wood composites or other materials that could break up in the planer and cause operator injury or damage to planer.
- Always true cupped or warped stock on a jointer before planing.



Common Planing Problems

Below is a list of wood characteristics you may encounter when planing. The following descriptions of defects will give you some possible answers to problems you may encounter while planing different materials. Possible solutions follow the descriptions.

Chipped Grain

Problem: Usually a result of cutting against the grain, planing lumber with knots or excessive amount of cross grain, or using dull knives/inserts.

Note: *Some amount of chipping is normal with highly figured wood.*

Solution: Decrease the depth of cut. Reduce the feed rate. Inspect your lumber and determine if its grain pattern is causing the problem. If the lumber does not show substantial crossgrain, inspect your knives/inserts.

Fuzzy Grain

Problem: Usually caused by surfacing lumber with too high of a moisture content. Sometimes fuzzy grain is an unavoidable characteristic of some woods, such as basswood. Fuzzy grain can also be caused by dull knives/inserts.

Solution: Check the lumber with a moisture meter. If moisture is greater than 20%, sticker the lumber and allow it to dry. Otherwise, inspect the knife/insert condition.

Snipe

Problem: Occurs when board ends have more material removed than the rest of the board. Usually caused when the workpiece is not properly supported as it goes through the machine. In many cases, however, a small amount of snipe is inevitable.

Solution: Hold workpiece up slightly as it leaves the outfeed end of the planer. The best way to deal with snipe is by planing lumber longer than your intended work length and then cutting off the excess after planing is completed.

Pitch & Glue Build-up

Problem: Glue and resin buildup on the rollers and cutterhead will cause overheating by decreasing cutting sharpness while increasing drag in the feed mechanism. The result can include scorched lumber, uneven knife/insert marks, and chatter.

Solution: Clean the rollers and cutterhead.

Chip Marks or Indentations

Problem: Chip indentation or chip bruising is the result of wood chips not being thrown away from the cutterhead and out of the machine. Instead they are carried around the cutterhead, deposited on the planed surface and crushed by the outfeed roller. Some of the causes of chip indentation are:

- Wood chips/sawdust not being properly expelled from the cutterhead.
- The type of lumber being planed. Certain species have a tendency to chip bruise.
- A high moisture content (over 20%) or surface moisture (refer to **Workpiece Inspection**).
- Dull knives/inserts.
- Excessive depth of cut.

Solution:

- Use a proper dust-collection system; adjust chip deflector in or out as necessary.
- Lumber must be completely dry, preferably kiln-dried (KD). Air-dried (AD) lumber must be seasoned properly and have no surface moisture. DO NOT surface partially-air-dried (PAD) lumber.
- Make sure planer knives/inserts are sharp.
- Reduce depth of cut.



Setting Planer Depth of Cut

Table Movement per Handwheel Revolution

One Full Revolution $\frac{1}{16}$ "

Material Thickness Range

Minimum—Maximum Stock Thickness $\frac{1}{4}$ "–8"

The depth of cut on a planer means the amount of material that is removed from the top of the workpiece as it passes underneath the cutterhead.

The depth of cut is set by adjusting the distance of the table below the cutterhead. This distance is the thickness of the workpiece minus the depth of cut. The planing depth of cut is controlled by using the table height handwheel on the right side of the machine. Rotating the handwheel clockwise raises the table.

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend the maximum depth of cut (per pass) be no more than $\frac{1}{16}$ ". A series of light cuts will give better end results and put less stress on the planer than trying to take off too much material in a single pass.

The depth of cut can be referenced directly from the inch/millimeter scale on the front of the planer, as shown.

Note: *The scale functions as a general guide only, and is not intended for low-tolerance, precision results.*

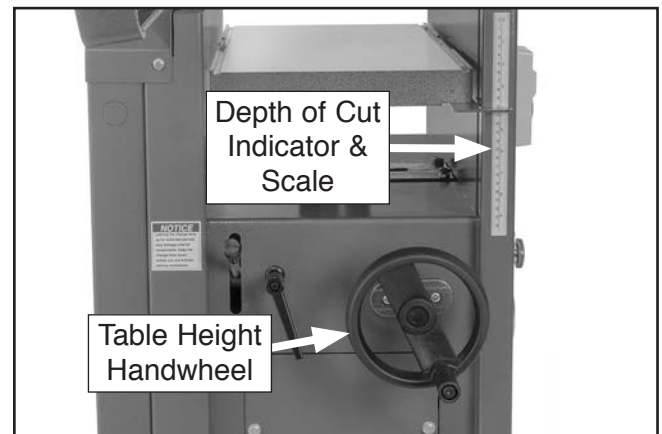


Figure 37. Location of table height handwheel and thickness scale.



SECTION 5: ACCESSORIES

! WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

T32014—Carbide Inserts (10 Pack)

These indexable carbide inserts can be rotated to provide four factory sharp edges before replacement. Inserts measure 15 x 15 x 2.5mm.



Figure 38. T32014 Carbide Inserts.

H9816—Power Twist® V-Belt - 3/8" x 60"

Smooth running with less vibration and noise than solid belts. The Power Twist® V-belts can be customized in minutes to any size—just add or remove sections to fit your needs. Requires two Power Twist® V-belts to replace the stock V-belts on your Model G0634X.

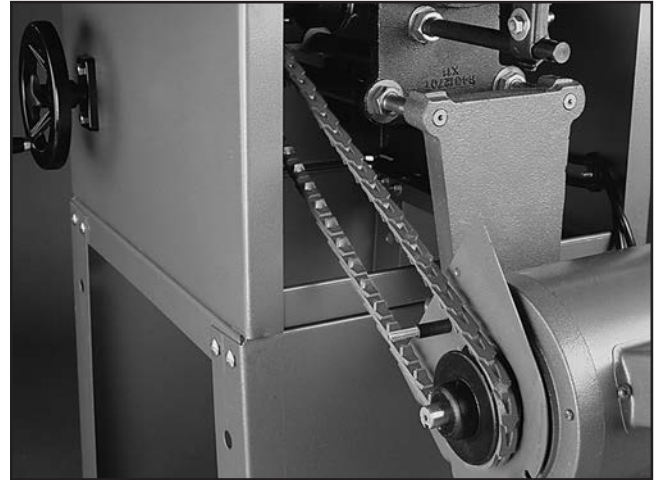


Figure 39. H9816 Power Twist® V-Belt.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray

H3789—G96® Gun Treatment 4.5 Oz. Spray

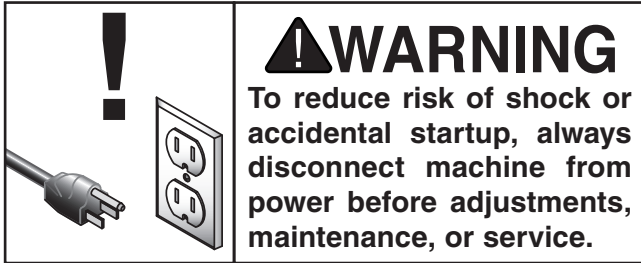


Figure 40. Recommended products for protecting unpainted cast iron/steel parts on machinery.

order online at www.grizzly.com or call 1-800-523-4777



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Vacuum all dust on and around machine.
- Wipe down tables and all other unpainted cast-iron with metal protectant.
- Check for/repair worn or damaged wires.
- Check/resolve any other unsafe condition.
- Check/tighten loose mounting hardware.
- Check/replace damaged cutterhead knives/inserts.

Weekly

- Clean cutterhead.

Monthly

- Check belt for proper tension, damage, or wear/replace belt.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Lubricate worm gear.
- Lubricate roller chains.
- Lubricate elevation leadscrew.
- Lubricate worm shaft.

Cleaning & Protecting

Cleaning the Model G0634X 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.

Protect unpainted cast-iron tables by wiping them clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 36** for more details).

Lubrication

NOTICE

Failure to follow reasonable lubrication practices as instructed in this manual for your machine could lead to premature failure of components and void the warranty.

This machine features bearings that are lubricated and sealed at the factory. These bearings do not require any further attention unless they need to be replaced. If a bearing fails, your machine will probably develop a noticeable rumble or vibration, which will increase when the machine is under a load. The bearings are standard sizes and can be replaced through Grizzly.

Follow the procedures in this section to properly lubricate the other components, essential for long life and trouble-free operation of your machine.



Drive Chains & Sprockets

Grease Type..... NLGI#2 Equivalent
Frequency..... Every 160 Hours of Operation

The infeed and outfeed rollers receive the transferred power from the cutterhead through the drive chain system, as shown in **Figure 41**. Remove the fence assembly and cutterhead pulley cover to access these parts. Use shop rags and mineral spirits to clean away any debris and grime, then brush on a light coat of multi-purpose grease to the chain and sprockets.

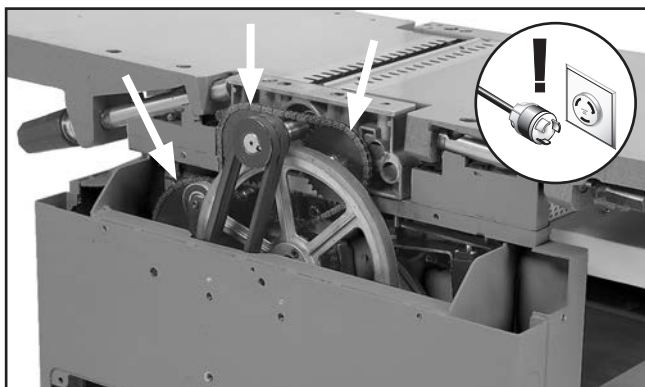


Figure 41. Location of drive chains and sprockets.

Elevation Shaft Bushing

Oil Type..... SB1365 or ISO 68 Equivalent
Oil Amount..... Thin Coat

The elevation shaft transfers motion from the planer table height handwheel to the leadscrew. The elevation shaft rotates in a bushing that must be well lubricated. Remove the leadscrew access panel to access these parts. Use a small amount of ISO 68 machine oil or spray lubricant to lubricate the bushing (see **Figure 42**).

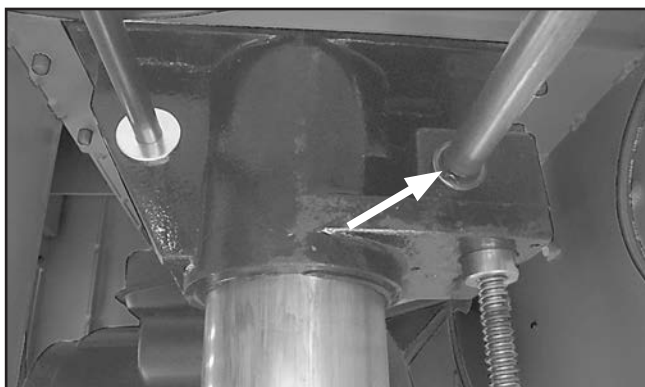


Figure 42. Location of elevation shaft bushing.

Column & Leadscrew

Oil Type..... SB1365 or ISO 68 Equivalent
Oil Amount..... Thin Coat
Grease Type..... NLGI#2 Equivalent
Frequency..... Every 40 Hours of Operation

The planer table rides on the column and is moved by the rotation of the leadscrew (see **Figure 43**). Remove the leadscrew access panel (see **Figure 44**) to access these parts. Clean and apply a thin coat of ISO 68 machine oil to the outside surface of the column and brush on a light application of multi-purpose grease to the leadscrew threads. Move the table up and down to distribute the lubricant.

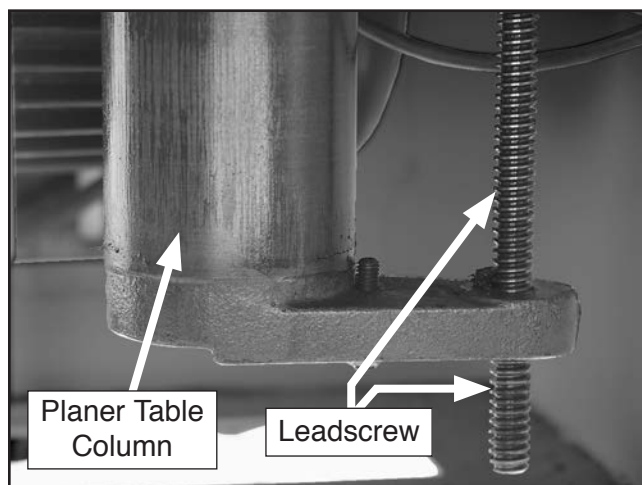


Figure 43. Location of planer table column and leadscrew.

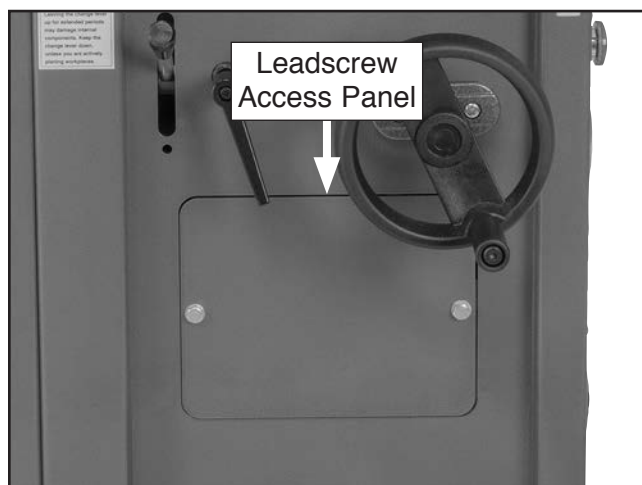


Figure 44. Location of leadscrew access panel.



Fence

Oil Type SB1365 or ISO 68 Equivalent
Oil Amount 1–2 Drops
Lubrication Frequency As Needed

Place one or two drops of ISO 68 machine oil on fence pivot points and other lubrication locations as needed (see **Figure 45–46**).

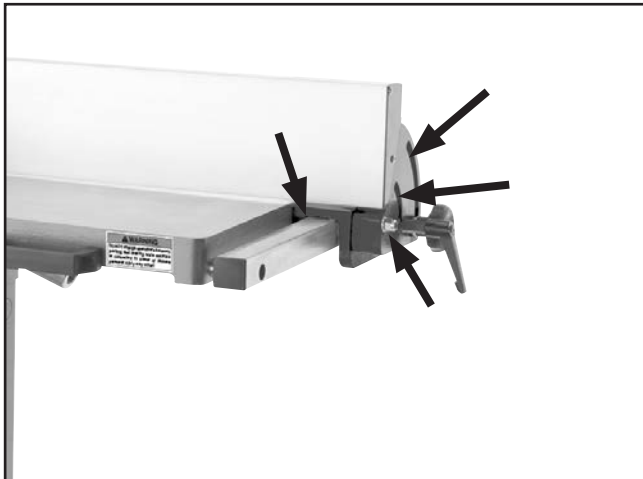


Figure 45. Front fence lubrication locations.

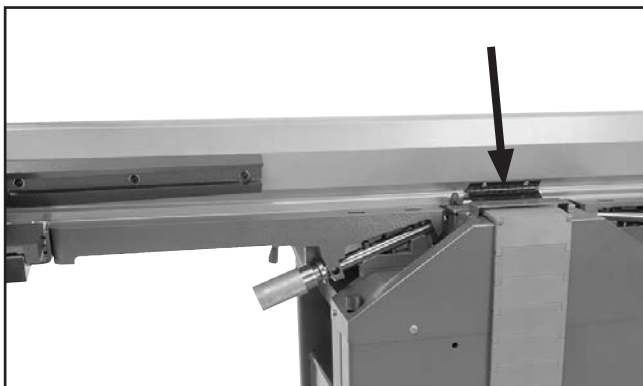


Figure 46. Rear fence lubrication location.

Jointer Tables

Oil Type SB1365 or ISO 68 Equivalent
Oil Amount 1–2 Drops
Frequency As Needed

The jointer infeed and outfeed table elevation knobs and pivot points require periodic lubrication. Raise and secure tables in up position and lubricate with ISO 68 machine oil as needed (see **Figures 47–48**). Wipe off excess oil and sawdust with a cloth.

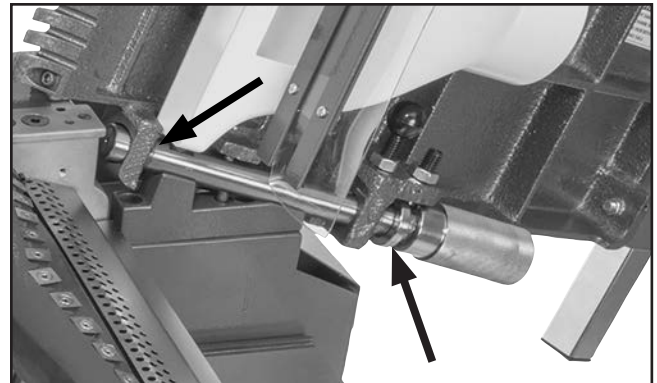


Figure 47. Jointer infeed table lubrication locations.

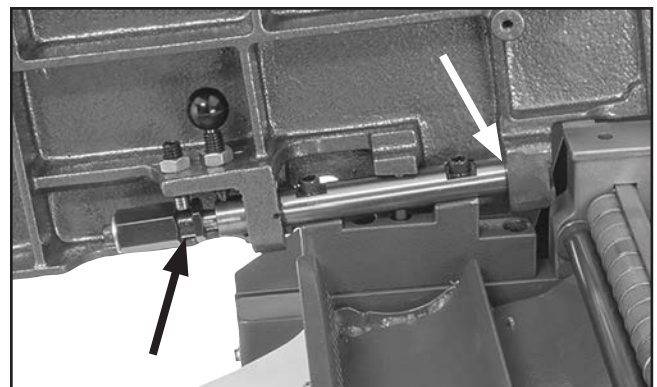


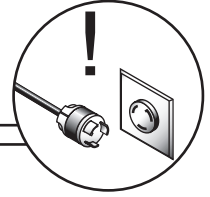
Figure 48. Jointer outfeed table lubrication locations.



SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Motor will not start or fuses or circuit breakers blow.	<ol style="list-style-type: none"> Emergency off button depressed. Short circuit in line cord or plug. Start capacitor is at fault. Thermal protection circuit breaker amperage is set too low or motor is at fault. Open circuit in motor or loose connections. 	<ol style="list-style-type: none"> Rotate clockwise until it pops out/replace. Repair or replace cord or plug for damaged insulation and shorted wires. Replace start capacitor. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting. If dial cannot be set any higher, replace motor. Inspect all lead connections on motor for loose or open connections.
Motor fails to develop full power or motor decreases rapidly with load, overheats, or stalls.	<ol style="list-style-type: none"> Motor run capacitor at fault. Motor overloaded during operation. Air circulation through the motor restricted. Motor overloaded during operation. Thermal protection circuit breaker amperage is set too low or motor is at fault. Short circuit in motor or loose connections. Circuit breaker tripped. 	<ol style="list-style-type: none"> Replace run capacitor. Reduce cutting load; take lighter cuts. Clean out motor to provide normal air circulation. Reduce cutting load; take lighter cuts. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting. If dial cannot be set any higher, replace motor. Repair or replace connections on motor for loose or shorted terminals or worn insulation. Install correct circuit breaker; reduce number of machines running on that circuit.
Cutterhead slows or squeals when cutting, especially on start-up.	<ol style="list-style-type: none"> V-belt loose. V-belt worn out. 	<ol style="list-style-type: none"> Tension V-belt (Page 42). Replace V-belt (Page 42).
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> Pulley set screws or keys are missing or loose. V-belts are damaged. Motor fan is hitting the cover. 	<ol style="list-style-type: none"> Inspect keys and set screws. Replace or tighten if necessary. Replace V-belts (Page 42). Adjust fan cover mounting position, tighten fan, or shim fan cover.



Table (Jointer)

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	1. Table gibs are too tight.	1. Adjust table gibs (Page 51).
Tables do not lock.	1. Table lock levers too high or too low.	1. Adjust lock nuts and bolts.

Cutting (Jointer and Planer)

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	<ol style="list-style-type: none"> 1. Outfeed table is set too low. 2. Operator pushing down on trailing end of workpiece. 3. Workpiece is not supported as it leaves the planer. 	<ol style="list-style-type: none"> 1. Align outfeed table with inserts at top dead center (Page 44). 2. Reduce/eliminate downward pressure on trailing end of workpiece. 3. Support the workpiece as it leaves the outfeed end of the planer.
Workpiece stops/slow in the middle of the cut.	<ol style="list-style-type: none"> 1. Taking too heavy of a cut. 2. Table not parallel with head casting. 3. Pitch and glue build up on planer components. 	<ol style="list-style-type: none"> 1. Take a lighter cut. 2. Adjust the table so it is parallel to the head casting (Page 48). 3. Clean the internal cutterhead components with a pitch/resin dissolving solvent.
Chipping (consistent pattern).	<ol style="list-style-type: none"> 1. Knots or conflicting grain direction in wood. 2. Nicked or chipped carbide insert. 3. Taking too deep of a cut. 	<ol style="list-style-type: none"> 1. Inspect workpiece for knots and grain direction; only use clean stock. 2. Rotate/replace affected insert (Page 49). 3. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hardwoods.)
Fuzzy grain.	<ol style="list-style-type: none"> 1. Wood may have high moisture content or surface wetness. 2. Dull inserts. 	<ol style="list-style-type: none"> 1. Check moisture content and allow to dry if moisture is too high. 2. Rotate/replace inserts (Page 49).
Long lines or ridges that run along the length of the board.	<ol style="list-style-type: none"> 1. Nicked or chipped inserts(s). 	<ol style="list-style-type: none"> 1. Rotate/replace inserts (Page 49).
Uneven insert marks, wavy surface, or chatter marks across the face of the board.	<ol style="list-style-type: none"> 1. Carbide inserts not installed evenly. 2. Worn cutterhead bearings. 	<ol style="list-style-type: none"> 1. Make sure carbide inserts do not have debris under them; make sure inserts are torqued down evenly (Page 49). 2. Replace cutterhead bearings.
Glossy surface. (Planer)	<ol style="list-style-type: none"> 1. Carbide inserts are dull. 2. Cutting depth too shallow. 	<ol style="list-style-type: none"> 1. Rotate/replace inserts (Page 49). 2. Increase the depth of cut.
Chip Marks (inconsistent pattern). (Planer)	<ol style="list-style-type: none"> 1. Chips aren't being properly expelled from the cutterhead. 	<ol style="list-style-type: none"> 1. Use a dust-collection system
Board edge is concave or convex after jointing. (Jointer)	<ol style="list-style-type: none"> 1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes. 	<ol style="list-style-type: none"> 1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on condition of board and depth of cut.



Tensioning/ Replacing V-Belts

Two V-belts transfer power from the motor to the cutterhead. To ensure efficient transfer of power to this system, make sure the V-belts are always properly tensioned and in good condition.

Note: After the first 16 hours of belt life, re-tension the belts, as they will stretch and seat during this time.

If the V-belts are worn, cracked, or damaged, replace them. Always replace the V-belts with a matched set of two, or belt tension may not be equal among the belts, causing premature belt failure.

Consider replacing stock belts with Power Twist V-belts (see **Page 36**) to reduce vibration and noise, and increase belt lifespan.

Items Needed	Qty
Wrench or Socket 10, 12, 14mm	1 Ea.
2 x 4 (Length as Needed)	1

Tensioning V-Belts

1. DISCONNECT MACHINE FROM POWER!
2. Remove motor access panel on back of machine (see **Figure 49**).

Note: A collection of black belt dust inside motor compartment is normal during life of belts.

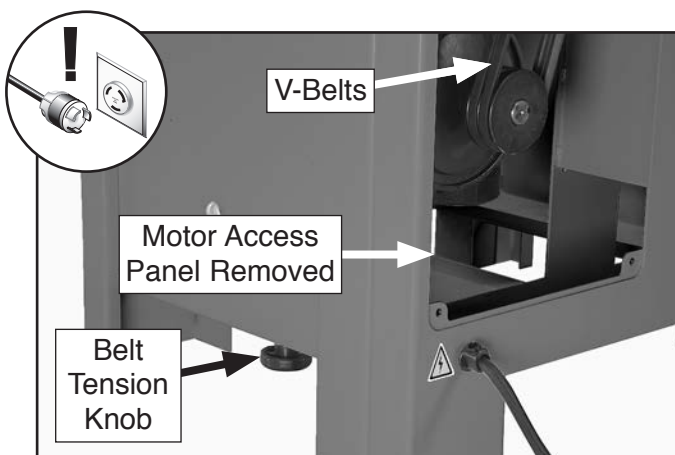


Figure 49. Location of V-belts and belt tension knob.

3. Press each belt with moderate pressure in center to check belt tension. Belt is correctly tensioned when there is approximately $\frac{1}{4}$ "– $\frac{1}{2}$ " deflection when pushed, as shown in **Figure 50**.

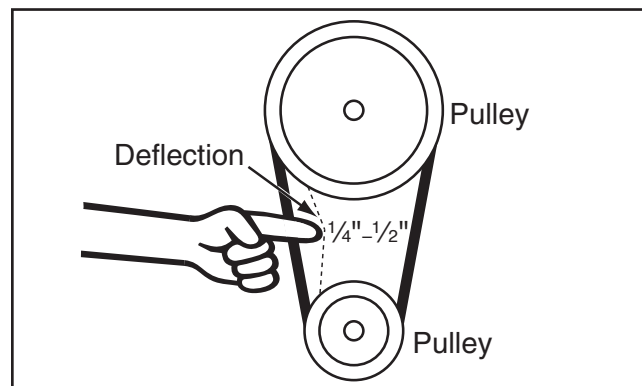


Figure 50. Checking V-belt tension.

4. Use belt tension knob (see **Figure 49**) to adjust V-belt tension until there is approximately $\frac{1}{4}$ "– $\frac{1}{2}$ " deflection when V-belts are pushed with moderate pressure, as shown in **Figure 50**.

5. Reinstall motor access panel.

Replacing V-Belts

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead pulley cover and motor access panel (see **Figure 51**).

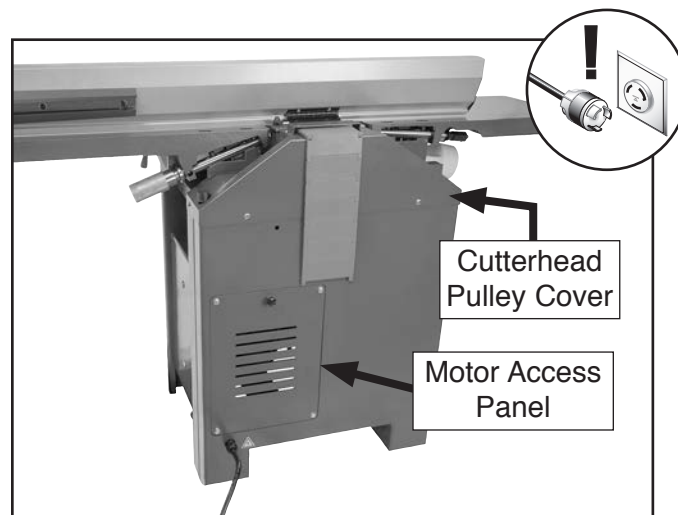


Figure 51. Location of cutterhead pulley cover and motor access panel.



3. Remove belt tension knob (see **Figure 49** on **Page 42**).
4. Loosen (4) motor mount adjustment nuts and raise motor (see **Figure 52**) to completely remove V-belt tension. It may help to use a 2x4 as lever to lift motor.

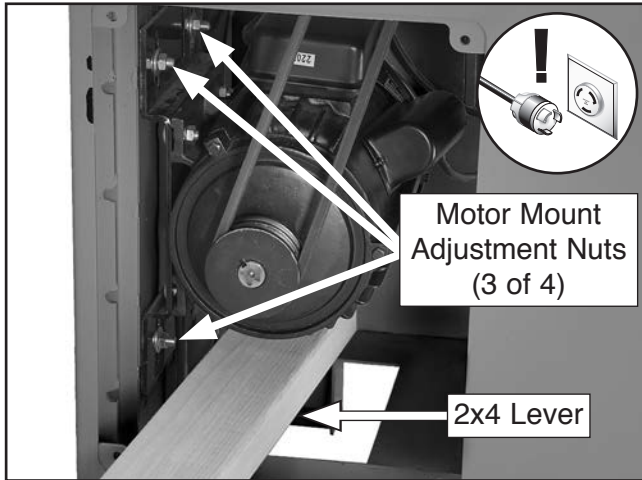


Figure 52. Removing V-belt tension for belt removal/replacement.

5. Remove both belts and replace them with new matched set.
6. Lower motor, retighten motor mount adjustment nuts.
7. Rotate pulleys by hand to ensure V-belts are properly seated in pulleys.
8. Reinstall cutterhead pulley cover and belt tension knob from **Steps 2–3**.
9. Properly tension V-belts according to **Tensioning V-Belts** on **Page 42**.
10. Reinstall motor access panel from **Step 2** on.

Note: After first 16 hours of belt life, re-tension belts, as they will stretch and seat during this time.

Adjusting Pulley Alignment

Items Needed:	Qty
Wrench 10mm, 12mm	1 Ea
Straightedge	1
Hex Wrench 3mm.....	1
C-Clamps	2

Proper motor and cutterhead pulley alignment prevents premature belt wear. The pulleys are properly aligned when they are parallel and in the same plane as each other.

To align pulleys:

1. DISCONNECT MACHINE FROM POWER!
2. Remove fence, cutterhead pulley cover, and motor access panel (see **Figure 53**).

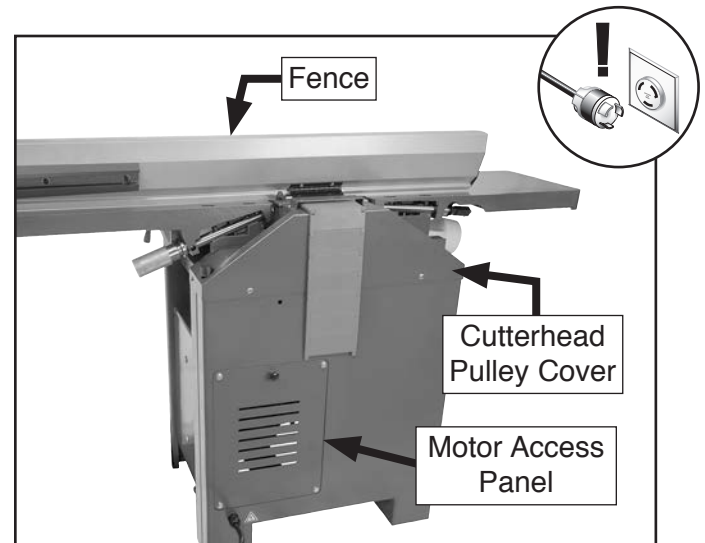


Figure 53. Location of fence, cutterhead pulley cover, and motor access panel.



- Place identical 2" C-clamps on each pulley with adjustment shafts facing out. Place straightedge on clamps, as shown in **Figure 54**, and visually check pulley alignment.

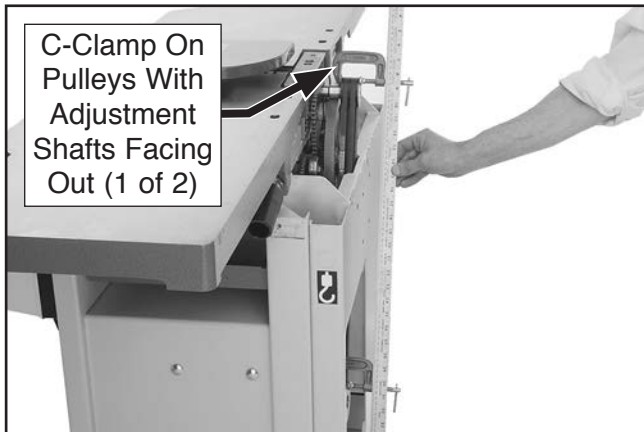


Figure 54. Example of checking belt alignment.

- If pulleys are aligned, then no adjustments are necessary.
- If pulleys are NOT aligned, perform **Steps 3–4**.

- Remove V-belts (see **Page 42**).
- Loosen set screws on end of cutterhead pulley, align cutterhead pulley with motor pulley (see **Figure 55**), then retighten set screws.

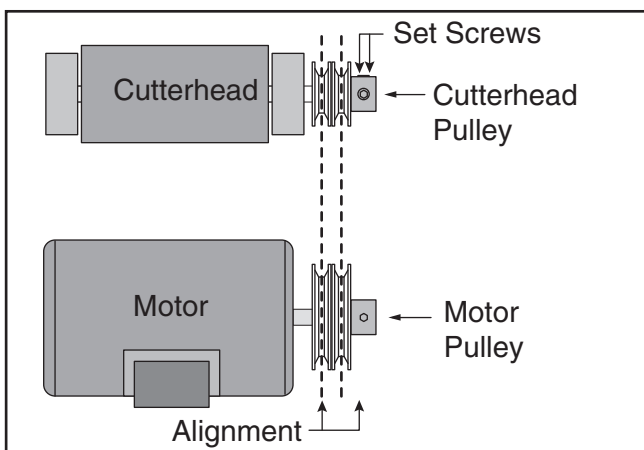


Figure 55. Pulleys properly aligned.

- Repeat **Step 2** and, if necessary, repeat **Step 4** until pulleys are aligned.
- Reinstall all components removed during **Step 1**.

Setting Outfeed Table Height

The outfeed table height **MUST** be level with the carbide inserts when they are at top-dead-center. If the outfeed table is set too low, the workpiece will be tapered from front to back. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

To set outfeed table height:

- DISCONNECT MACHINE FROM POWER!**
- Place straightedge on outfeed table so it extends over cutterhead.
- Open motor access panel and rotate cutterhead pulley until one of carbide inserts is at top-dead-center (TDC), as illustrated in **Figure 56**.

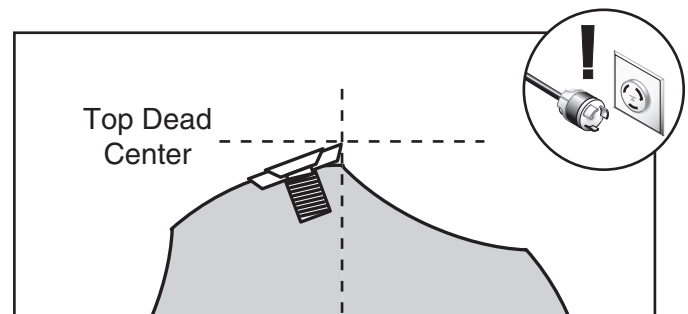


Figure 56. Carbide insert at top-dead-center.

- Raise or lower outfeed table until carbide insert just touches straightedge (see **Figure 57**).

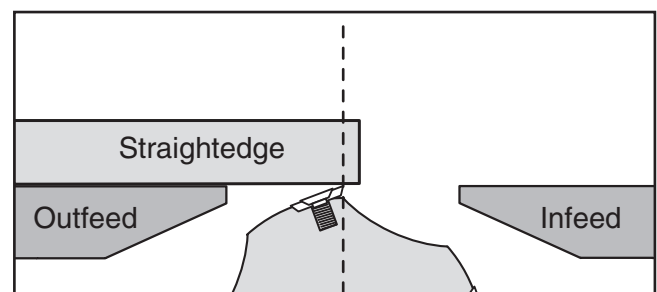


Figure 57. Using straightedge to align outfeed table height with carbide insert at TDC.



Checking Jointer Table Parallelism

The outfeed table is preset by the factory parallel with the cutterhead. However, it is critical to check this setting. If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback can occur.

Items Needed	Qty
Straightedge	1
Adjustable Wrench	1
Heavy Leather Gloves (Pair)	1
Feeler Gauge Set	1

Checking Outfeed Table Parallelism

1. DISCONNECT MACHINE FROM POWER!
2. Put on heavy leather gloves, then remove cutterhead guard and fence.
3. Place straightedge on outfeed table so it hangs over cutterhead in one of the positions shown in **Figure 58**.

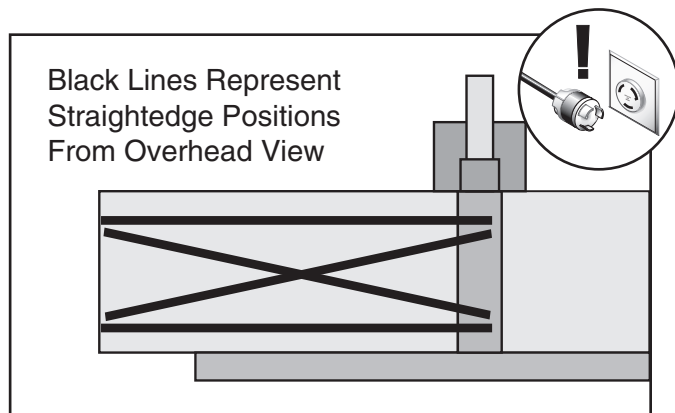


Figure 58. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

4. Try to fit feeler gauge or combination of feeler gauges 0.062" to 0.069" between bottom of ruler and cutterhead body, as shown in **Figure 59**.

- If feeler gauge slides with slight resistance between ruler and cutterhead and no gaps appear, go to **Step 5**.
- If feeler gauge does not slide with slight resistance between ruler and cutterhead, or if gaps appear, go to **Correcting Outfeed Table Parallelism** on **Page 46** before proceeding to **Step 5**.

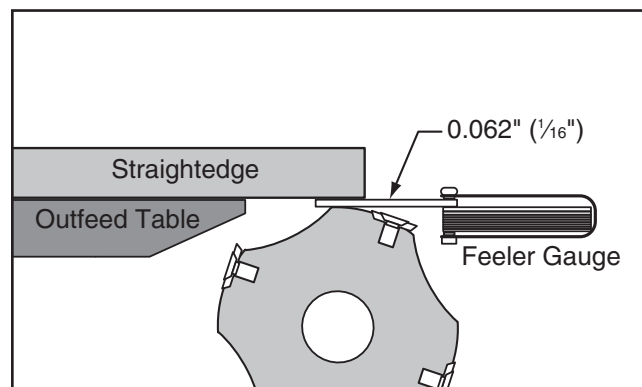


Figure 59. Using feeler gauge to check outfeed table cutterhead height.

5. Continue placing straightedge in remaining positions shown in **Figure 58**. In each position, feeler gauge measurement should be nearly identical.
 - If outfeed table height above cutterhead is equal across table in each position, then outfeed table is already parallel with cutterhead. Go to **Checking Infeed Table Parallelism**, on **Page 46**.
 - If outfeed table height is not equal across table in any of the positions, then outfeed table is not parallel with cutterhead. Correct outfeed table parallelism, then correct infeed table parallelism.



Correcting Outfeed Table Parallelism

This procedure involves turning the table stop bolts to raise or lower the front of the tables until they are parallel with the cutterhead.

To correct outfeed table parallelism:

1. Loosen lock nuts on both stop bolts shown in **Figure 60** at front of table.

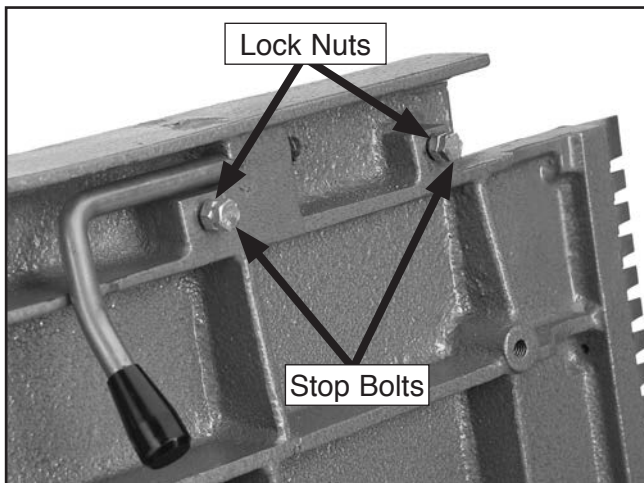


Figure 60. Location of outfeed table stop bolts and lock nuts.

2. Raise stop bolts just enough so front edge of table is higher than cutterhead, then adjust each stop bolt $\frac{1}{6}$ -turn clockwise to gradually lower table.
3. Check outfeed table height again (see **Steps 3–5 on Page 45**).
4. Continue lowering bolts and checking until outfeed table height above cutterhead is equal across table.

Checking Infeed Table Parallelism

1. Follow all steps for checking outfeed table parallelism to first make sure that outfeed table is parallel with cutterhead.
2. Place straightedge halfway across infeed table and halfway over outfeed table, and adjust infeed table even with outfeed table, as shown in **Figure 61**.

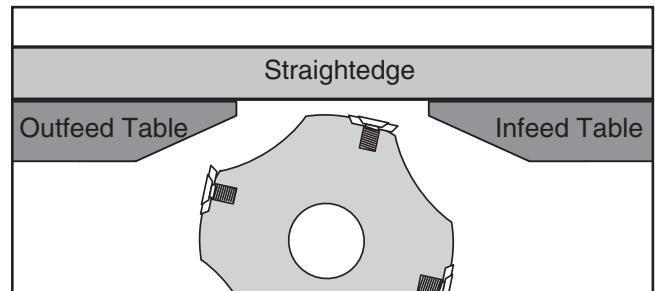


Figure 61. Infeed and outfeed tables set parallel.

- If insert touches straightedge, turn cutterhead so inserts do not interfere.
 - If cutterhead touches straightedge, raise outfeed table higher than cutterhead.
3. Place straightedge in positions shown in **Figure 62**. In each position, straightedge should sit flat against both outfeed table and infeed table.

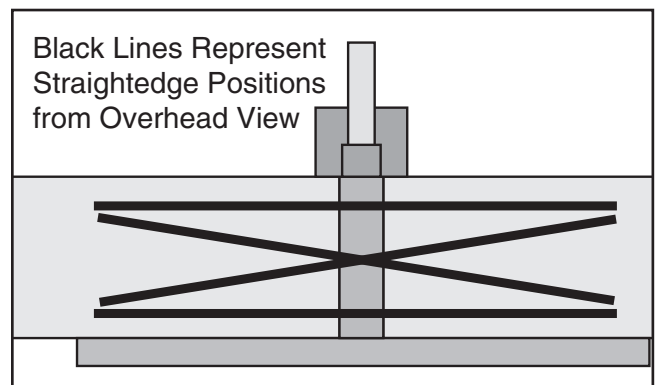


Figure 62. Straightedge positions for checking infeed/outfeed table parallelism.

- If straightedge sits flat against both infeed and outfeed table, then tables are parallel. Set outfeed table height and replace cutterhead guard (**Page 44**).
- If straightedge does not sit flat against both infeed and outfeed table in any of the positions, then follow **Adjusting Table Parallelism** instructions on **Page 47**.



Adjusting Infeed Table Parallelism

For safe and proper cutting results, both jointer tables must be parallel to the cutterhead. The correct order for adjusting table parallelism is to first adjust the outfeed table parallel with the cutterhead, then adjust the infeed table parallel with the outfeed table.

To adjust infeed table parallelism:

1. Check outfeed table parallelism (see **Page 45**), and make any necessary adjustments so cutterhead and outfeed table are parallel.
2. Place straightedge halfway across infeed table and halfway over outfeed table, and adjust infeed table even with outfeed table, as shown in **Figure 63**.

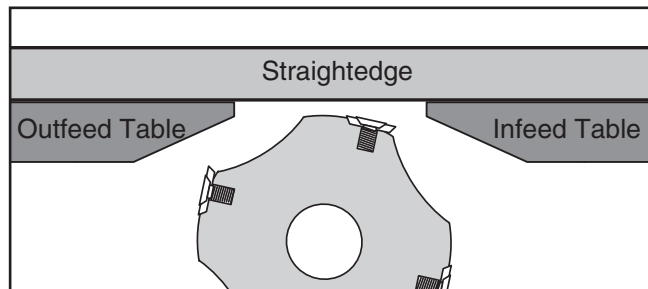


Figure 63. Straightedge placed on jointer tables.

3. Place straightedge in one of the positions shown in **Figure 64**.

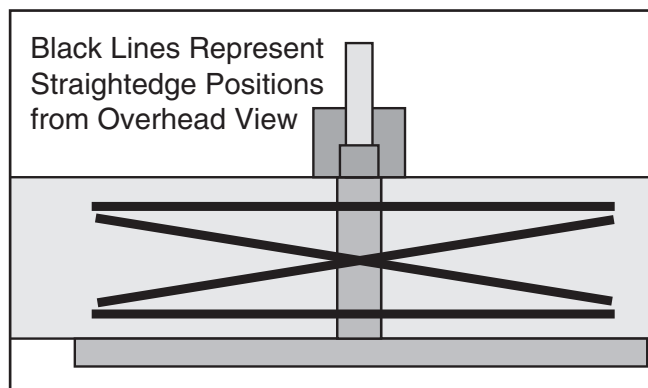


Figure 64. Straightedge positions for checking jointer table parallelism.

- If front of infeed table is higher or lower than outfeed table, adjust infeed table stop bolts (see **Figure 65**).
- If rear of infeed table is higher or lower than outfeed table, shim infeed table to adjust it parallel with outfeed table. Follow **Steps 4–6**.

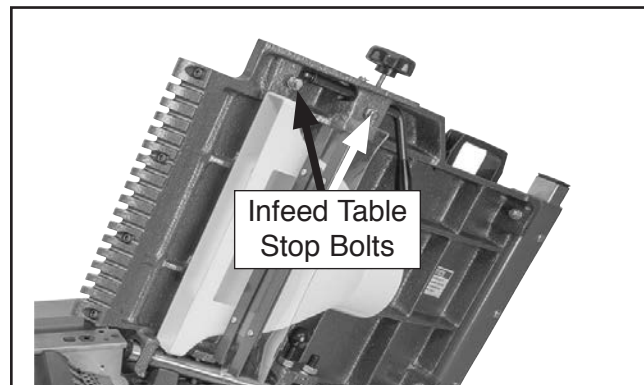


Figure 65. Location of infeed table stop bolts for adjusting infeed table parallelism.

4. Loosen cap screws shown in **Figure 66**.

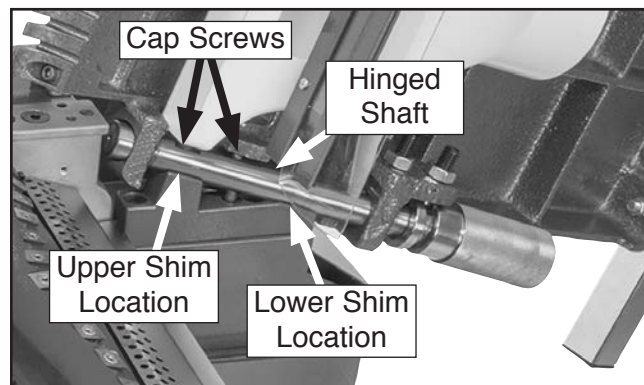


Figure 66. Infeed table hinged shaft. (Jointer table raised for clarity.)

5. While assistant raises infeed table, slip shims between hinged shaft and jointer base, then retighten cap screw. Shimming top position will raise rear cutterhead side of table, shimming lower position will raise rear infeed side.
6. Repeat **Step 3** with each of the remaining straightedge positions and adjust table front to back using shims as many times as necessary until infeed table is parallel with outfeed table.
7. Re-install cutterhead guard.



Checking Planer Table Parallelism

Table parallelism is critical to the operation of the planer. As such, it is essential that the planer table is parallel with the cutterhead (within 0.002") from side-to-side, as illustrated in **Figure 67**.

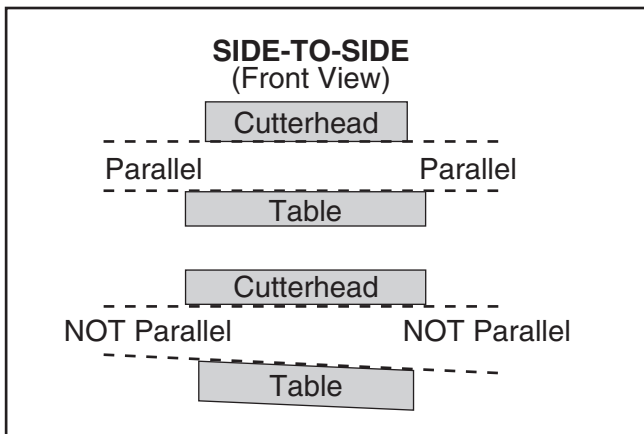


Figure 67. Side-to-side parallelism of table and cutterhead.

Maximum Allowable Tolerances:

Cutterhead/Table Side-to-Side 0.002"
 Head Casting/Table Front/Back 0.020"

How the planer table sits in relation to the head casting from front-to-back is also important (see **Figure 68**). The tolerances on the front-to-back positioning are not as critical as the cutterhead/table side-to-side positioning. Therefore, the maximum allowable tolerance for the front-to-back parallelism is not more than 0.020".

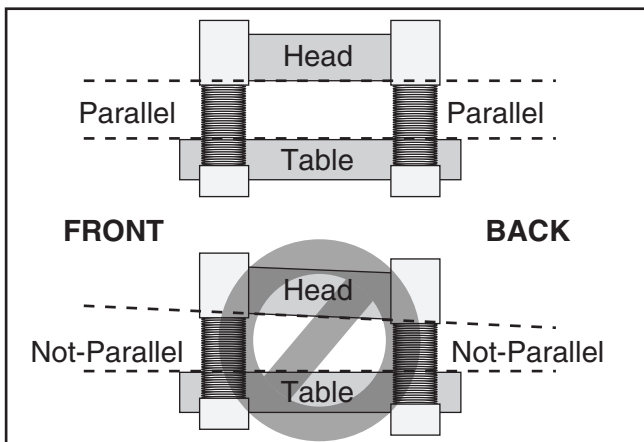


Figure 68. Front-to-back parallelism.

Table Parallelism Inspection

The easiest way to check that your planer table is parallel with the headstock is to plane a workpiece and then measure its thickness in multiple locations. Extra care must be taken to ensure accuracy. If the workpiece is tapered from left-to-right or from front-to-back, then parallelism may be a problem. If the table is not within the maximum allowable tolerances, it must be adjusted.

Table Parallelism Adjustments

Items Needed:

	Qty
Rotacator	1
Wrench 12mm	1
Hex Wrench 4, 8mm.....	1 Ea.

To adjust table parallelism:

1. DISCONNECT MACHINE FROM POWER!
2. Raise planer table as far as possible.
3. Loosen (4) cap screws on cylinder liner, as shown in **Figure 69**.

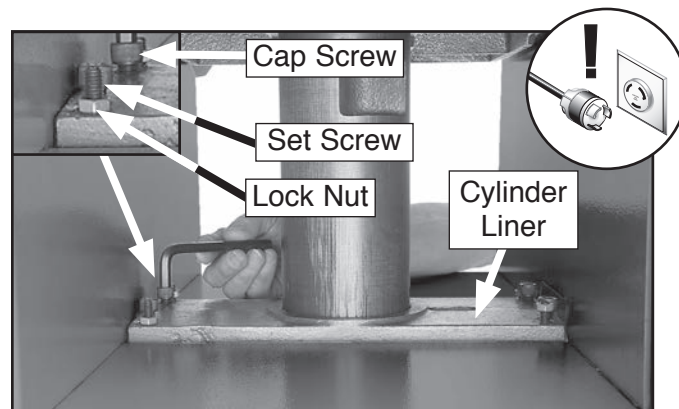


Figure 69. Adjusting table parallelism.

- If table is not parallel to cutterhead side-to-side (see **Figure 69**), loosen (2) lock nuts on right or left side of cylinder liner. Adjust set screws to raise or lower table so it is parallel to cutterhead.
- If table is not parallel to cutterhead front-to-back (see **Figure 69**), loosen (2) lock nuts at front or back of cylinder liner. Adjust set screws to raise or lower front or back of table so it is parallel to cutterhead.

4. Tighten (4) cap screws on cylinder liner.



Replacing Carbide Inserts

Items Needed:	Qty
T-Handle Wrench w/T-20 Torx Bit	1

The cutterhead is equipped with 48 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge (see **Figure 70**).

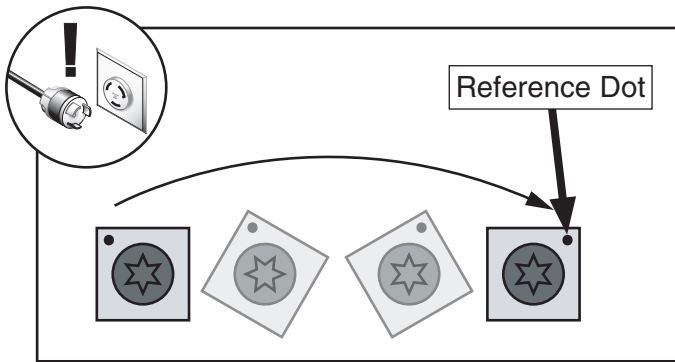


Figure 70. Insert rotating sequence.

In addition, each insert has a reference dot on one corner. As the insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. When the reference dot revolves back around to its starting position, the insert should be replaced.

To rotate or change carbide insert:

1. DISCONNECT MACHINE FROM POWER!
2. Remove any sawdust from head of carbide insert Torx screw.
3. Remove Torx screw and carbide insert.
4. Clean all dust and dirt off insert and cutterhead pocket from which insert was removed, and replace insert so fresh, sharp edge is facing outward.

Note: *Proper cleaning is critical to achieving smooth finish. Dirt or dust trapped between insert and cutterhead will slightly raise insert, and make noticeable marks on workpieces next time you plane.*

5. Lubricate Torx screw threads with light machine oil, wipe excess oil off threads, and torque Torx screw to 48-50 inch/pounds.

Note: *Excess oil may squeeze between insert and cutterhead, thereby lifting insert slightly and affecting workpiece finishes.*

Adjusting Table Lock Levers

The table lock levers can be adjusted if they do not lock.

Tool Needed	Qty
Wrench 14 mm	1

To adjust table lock levers:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard.
3. Raise table on side of lock lever that does not lock.
4. Loosen lock nut on special bolt under table, as shown in **Figure 71**.

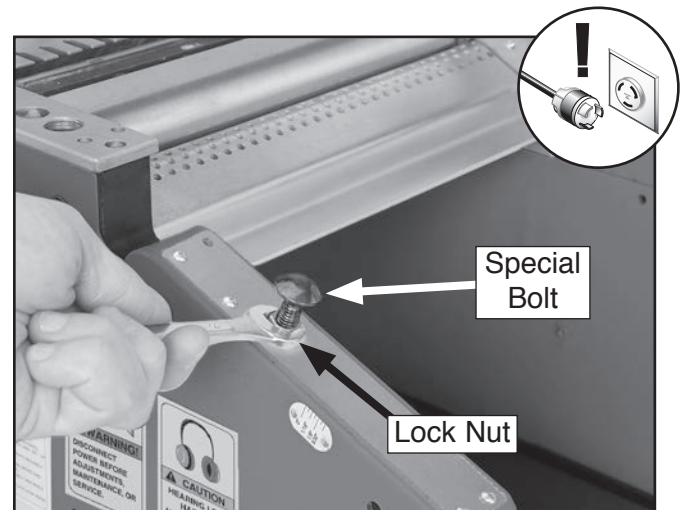


Figure 71. Table lock lever bolt.

5. Adjust bolt height few turns, lower table, and try engaging lock lever.
6. Repeat **Steps 3–5** until lever engages, then secure lock nut.



Calibrating Depth Scale

The depth scale on the infeed table can be calibrated or "zeroed" if it is not correct.

Items Needed	Qty
Straightedge	1
Phillips Screwdriver	1

To calibrate depth scale:

1. DISCONNECT MACHINE FROM POWER!
2. Set outfeed table height as described in **Setting Outfeed Table Height** on **Page 44**.
3. Use straightedge to help adjust infeed table exactly even with outfeed table, as shown in **Figure 72**.

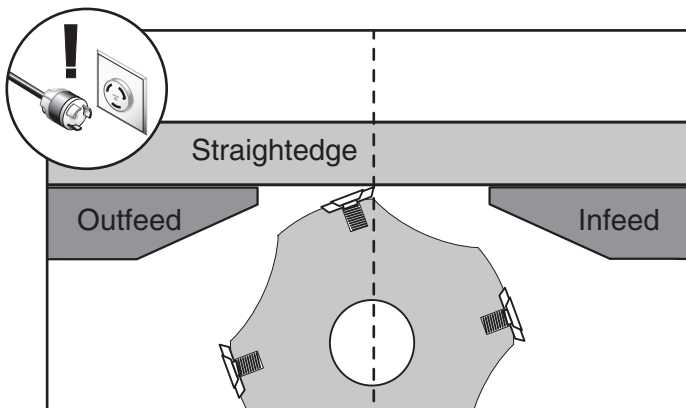


Figure 72. Infeed table even with outfeed table.

4. Using screwdriver, adjust scale pointer to zero (see **Figure 73**).

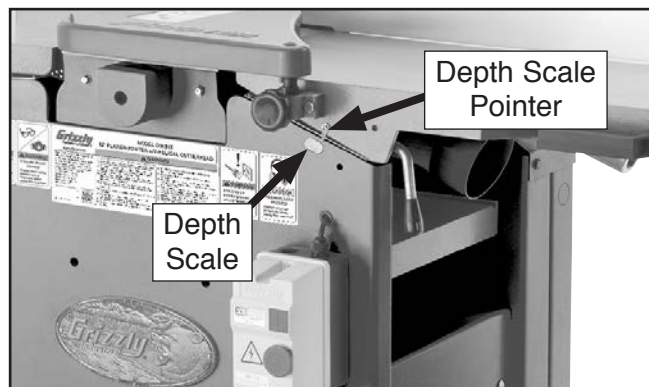


Figure 73. Depth scale adjusted to "0" position.

Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45° and 90°.

Items Needed	Qty
45° Square.....	1
90° Square	1
Sliding Bevel.....	1
Wrench 10mm	1
Wrench 12mm	1
Hex Wrench 3mm.....	1
Hex Wrench 4mm.....	1

Setting 90° Fence Stop

1. Loosen lock nut on 90° fence stop screw shown in **Figure 74**, and loosen fence tilt knob.

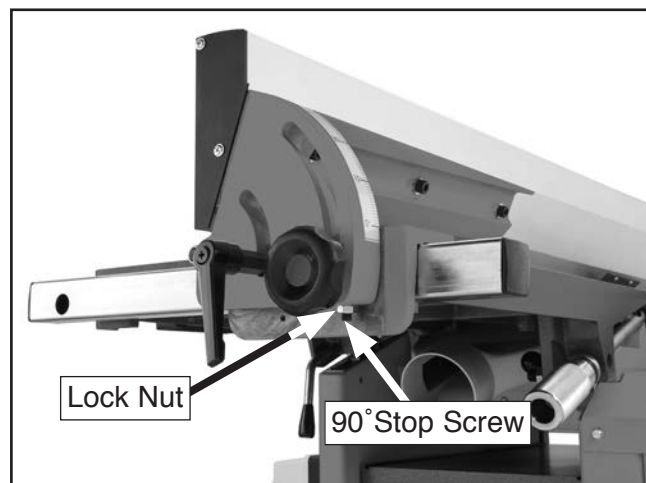


Figure 74. Adjusting fence to 90°.

2. Place 90° square against table and fence, and adjust stop screw so fence is set exactly at 90°.
3. Tighten lock nut.

Setting 45° Fence Stop

1. Loosen fence tilt knob and position fence against 45° stop bolt.



- Loosen lock nut on 45° fence stop screw (see **Figure 75**).

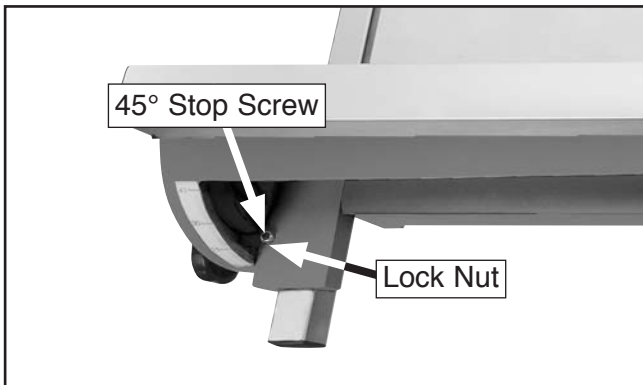


Figure 75. Adjusting fence 45° outward.

- Adjust 45° stop screw until fence is exactly 45° outward while resting on bolt (check angle with sliding bevel set to 135° or with 45° square).
- Re-tighten lock nut loosened in **Step 2**.

Adjusting Gibs

The function of the table gibs is to eliminate excessive play in the table movement. The gibs also control how easy it is to move the tables.

Tools Needed	Qty
Adjustable Wrench	1
Hex Wrench 8mm.....	1

To adjust table gibs:

- Using adjustable wrench, loosen infeed table gib nut under rear of table (see **Figure 76**).

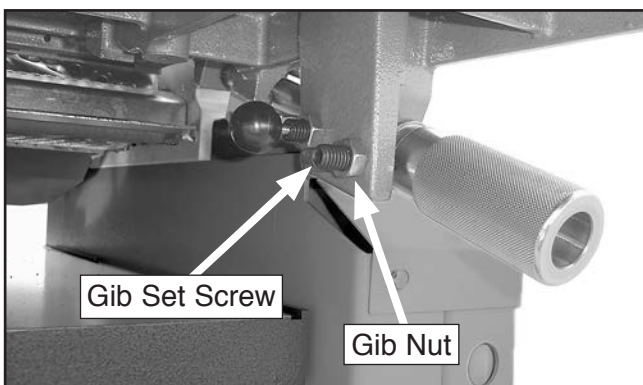


Figure 76. Infeed table gib control.

- Using 8mm hex wrench, tighten gib set screw a small amount, then check table by moving it up and down. Adjust set screw as needed until friction of table movement is balanced between minimal play and ease of movement, then secure gib nut.

Note: Tighter gibs reduce play but make it harder to adjust tables.

- Repeat **Steps 1–2** with outfeed table gib control (see **Figure 77**).

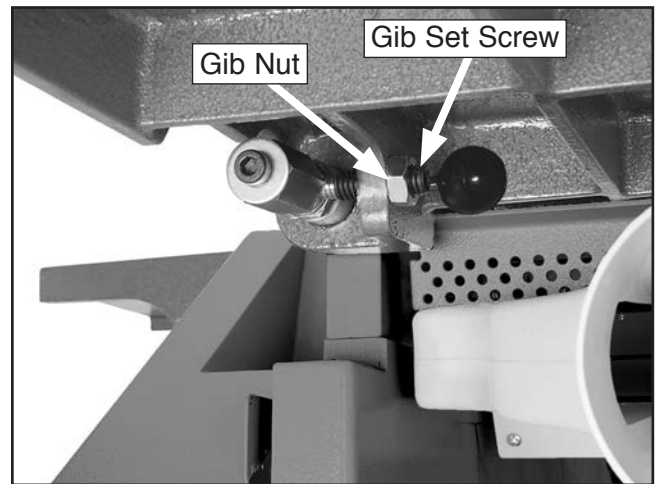


Figure 77. Outfeed table gib control.

- Set outfeed table height as described in **Setting Outfeed Table Height on Page 44**.



Adjusting Roller Spring Tension

Roller spring tension must be adjusted so that feed roller pressure is uniform. Roller spring tension will vary, depending on the type of wood you plane.

Less spring tension is generally more forgiving on workpieces. Therefore, if you plane milled lumber with consistent surface heights, less spring tension is required. Likewise, if you plane rough lumber with inconsistent surface heights, more spring tension is required to keep the workpiece feeding through the planer without stopping.

Tool Needed:	Qty
Hex Wrench 6mm.....	1

To adjust feed roller spring tension:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust tension screws shown in **Figure 78** counterclockwise so that they are 5–7 turns below top of head casting.
 - If workpiece slips when you feed it, turn screws ½–1 turn counterclockwise to increase spring tension.
 - If workpiece is abruptly grabbed when initially fed into planer, turn screws ½–1 turn clockwise to decrease spring tension.

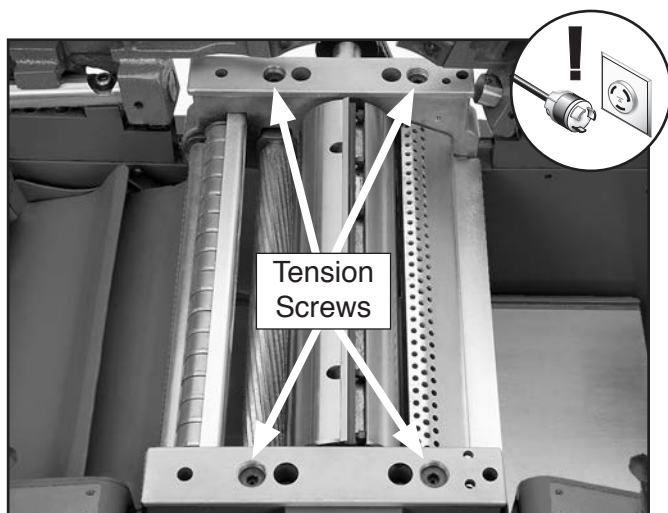


Figure 78. Spring tension screws.

Anti-Kickback Fingers

The anti-kickback fingers are an important safety feature of your planer. The fingers hang from a rod suspended across the head casting and in front of the infeed roller, as shown. This design allows the workpiece to easily enter the planer but reduces the risk of kickback by digging into the workpiece if it moves backward.

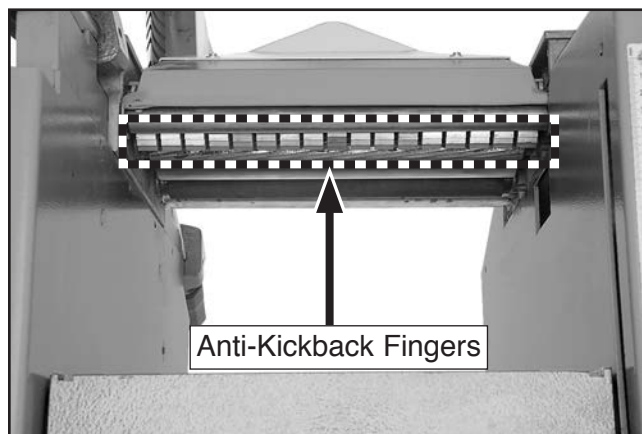


Figure 90. Location of anti-kickback fingers.

Check the anti-kickback fingers regularly to ensure they swing freely and easily. If the fingers do not swing freely and easily, first clean them with a wood-resin solvent, then inspect them for damage. If any of the fingers are damaged, the device must be replaced before using the machine.

Do not apply oil or other lubricants to the anti-kickback fingers that will attract dust and restrict free movement of the fingers.

⚠ WARNING

Proper operation of anti-kickback fingers is critical for safe operation of this planer. **DO NOT** operate planer if anti-kickback fingers are not operating correctly. Failure to heed this warning could result in serious personal injury.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.













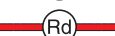

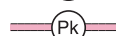
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

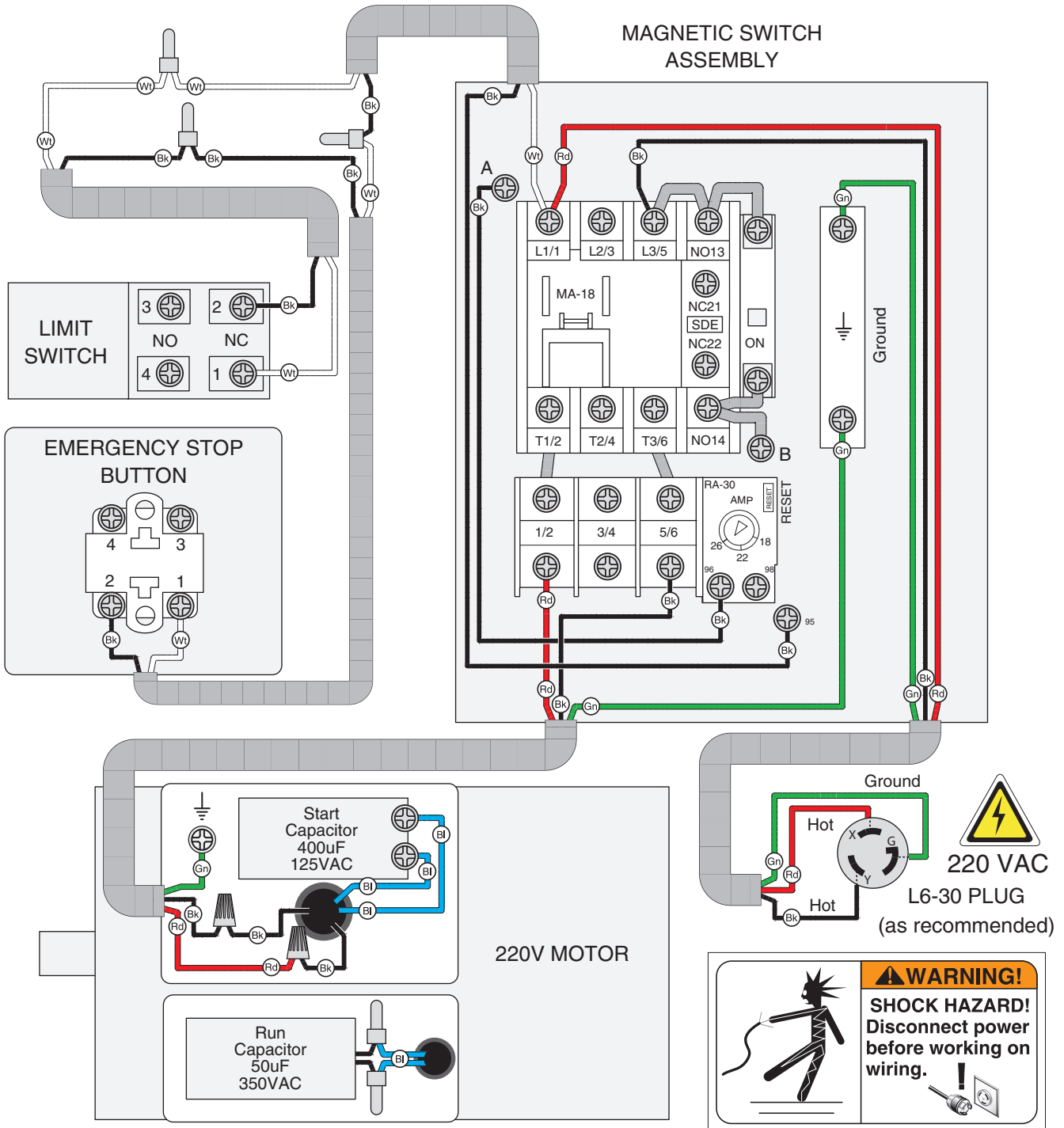
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



Wiring Diagram



Electrical Component Photos



Figure 79. Magnetic switch.



Figure 81. Start capacitor.



Figure 82. Run capacitor.



Figure 80. Emergency Stop button.

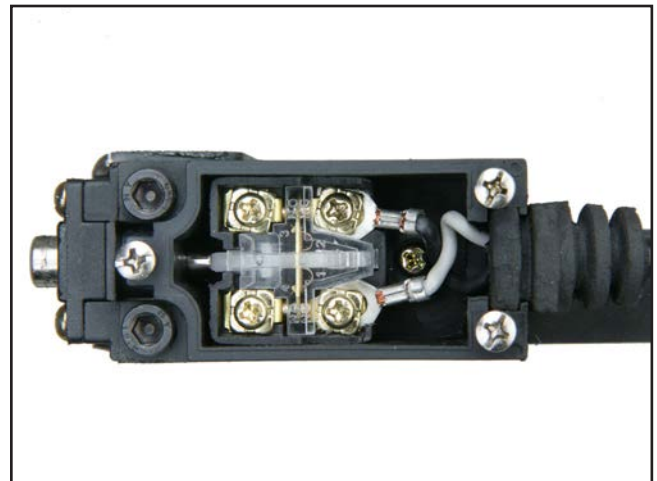
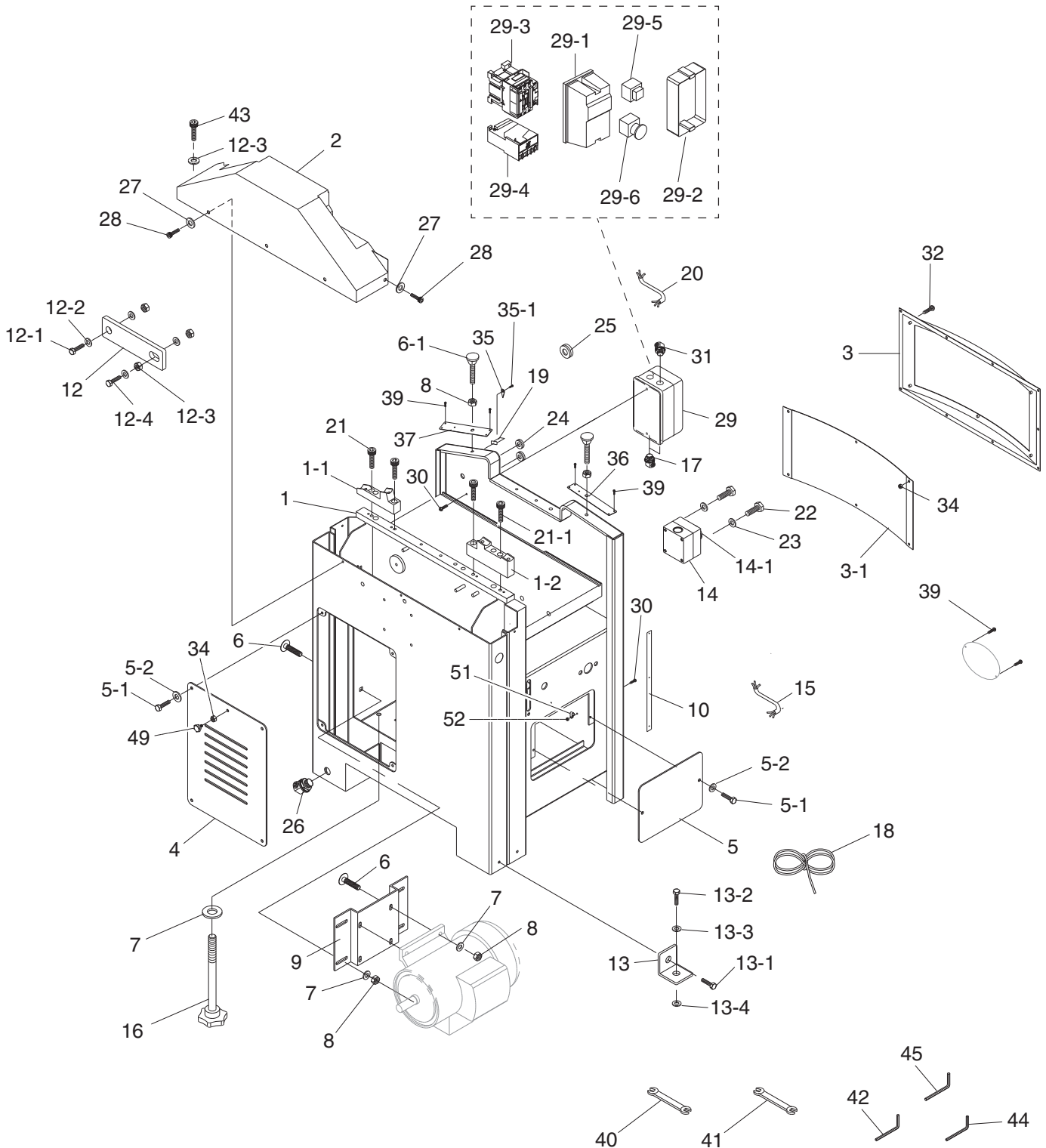


Figure 83. Jointer table limit switch.

SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call (800) 523-4777 or visit www.grizzly.com/parts to check for availability.

Stand



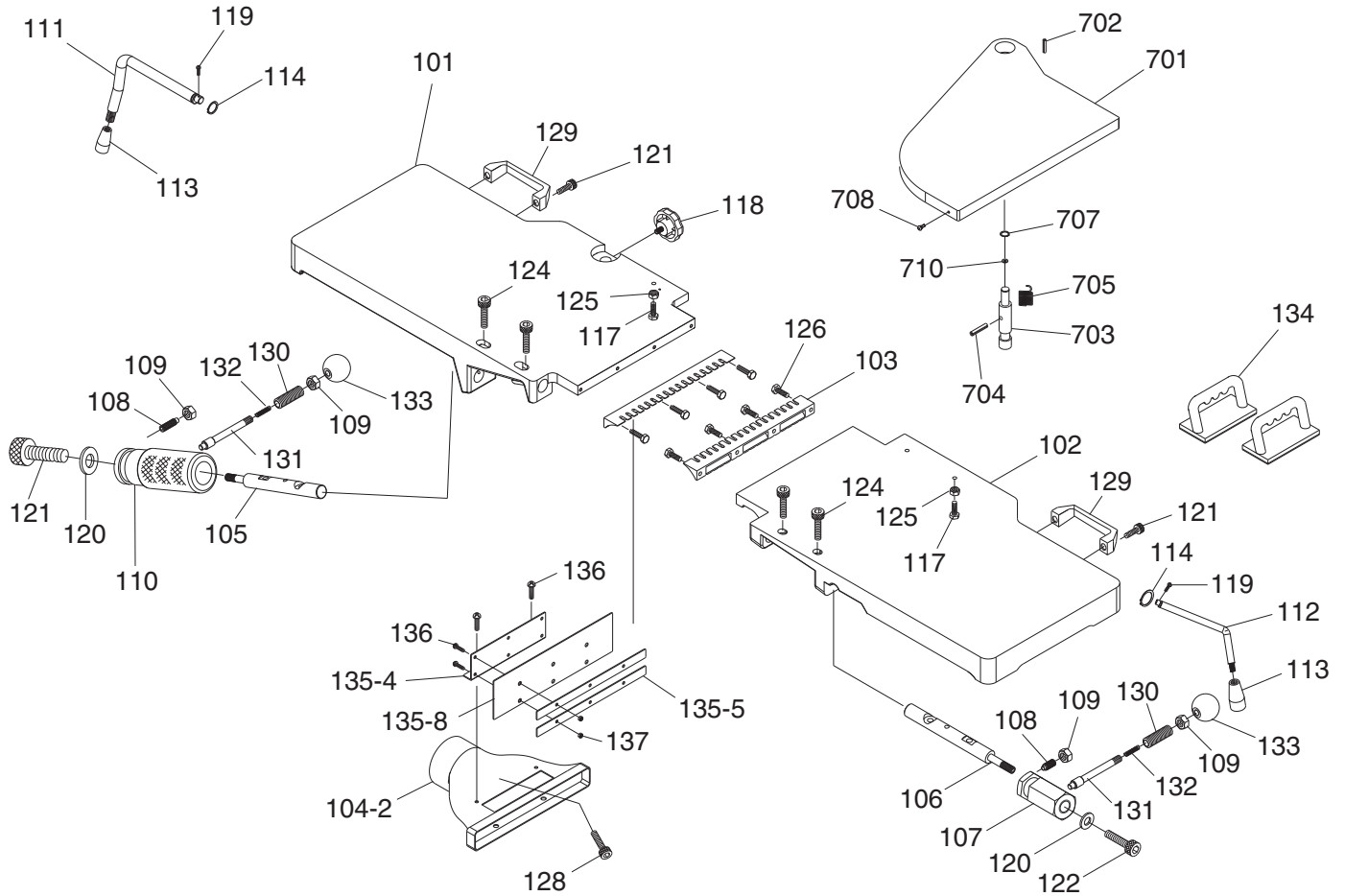
Stand Parts List

REF	PART #	DESCRIPTION
1	P0634X001	FRAME
1-1	P0634X001-1	HINGE SHAFT BRACKET RIGHT
1-2	P0634X001-2	HINGE SHAFT BRACKET LEFT
2	P0634X002	DRIVE SHAFT COVER
3	P0634X003	COVER FRAME
3-1	P0634X003-1	COVER
4	P0634X004	DOOR
5	P0634X005	SIDE OPENING COVER
5-1	P0634X005-1	HEX BOLT 5/16-18 X 1/2
5-2	P0634X005-2	FLAT WASHER 5/16
6	P0634X006	CARRIAGE BOLT 3/8-16 X 1
6-1	P0634X006-1	PLATE SCREW 3/8-16 X 2
7	P0634X007	FLAT WASHER 3/8
8	P0634X008	HEX NUT 3/8-16
9	P0634X009	MOTOR BRACKET
10	P0634X010	PLANER SCALE
12	P0634X012	REINFORCEMENT PLATE
12-1	P0634X012-1	HEX BOLT 5/16-18 X 1
12-2	P0634X012-2	FLAT WASHER 5/16
12-3	P0634X012-3	HEX NUT 5/16-18
12-4	P0634X012-4	HEX BOLT 5/16-18 X 3
13	P0634X013	SQUARE SUPPORT
13-1	P0634X013-1	HEX BOLT 5/16-18 X 3/4
13-2	P0634X013-2	TAP SCREW 5/16 X 2
13-3	P0634X013-3	FLAT WASHER 5/16
13-4	P0634X013-4	FLAT WASHER 3/8
14	P0634X014	SWITCH BOX W/O SWITCH
14-1	P0634X014-1	SWITCH KNOB
15	P0634X015	EMERGENCY STOP SWITCH CORD
16	P0634X016	KNOB BOLT 3/8-16
17	P0634X017	STRAIN RELIEF 3/4"
18	P0634X018	POWER CORD
19	P0634X019	DEPTH SCALE
20	P0634X020	LIMIT SWITCH CORD

REF	PART #	DESCRIPTION
21	P0634X021	CAP SCREW 3/8-16 X 1
21-1	P0634X021-1	CAP SCREW 3/8-16 X 1-1/2
22	P0634X022	HEX BOLT 1/4-20 X 5/8
23	P0634X023	FLAT WASHER 1/4
24	P0634X024	GROMMET
25	P0634X025	GROMMET
26	P0634X026	STRAIN RELIEF 3/4"
27	P0634X027	FLAT WASHER 1/4
28	P0634X028	HEX BOLT 1/4-20 X 3/8
29	P0634X029	MAGNETIC SWITCH ASSY SDE MP-18
29-1	P0634X029-1	MAG SWITCH FRONT COVER
29-2	P0634X029-2	MAG SWITCH BACK COVER
29-3	P0634X029-3	CONTACTOR
29-4	P0634X029-4	OL RELAY SDE RA-30 18-26A
29-5	P0634X029-5	ON BUTTON
29-6	P0634X029-6	OFF BUTTON
30	P0634X030	PHLP HD SCR 10-24 X 5/8
31	P0634X031	STRAIN RELIEF M16 TYPE-6 ST
32	P0634X032	PHLP HD SCR 1/4-20 X 5/16
34	P0634X034	HEX NUT 1/4-20
35	P0634X035	POINTER
35-1	P0634X035-1	PHLP HD SCR 10-24 X 1/4
36	P0634X036	PROTECTION PLATE (LEFT)
37	P0634X037	PROTECTION PLATE (RIGHT)
39	P0634X039	TAP SCREW #5 X 3/8
40	P0634X040	WRENCH 12 X 14MM OPEN-ENDS
41	P0634X041	WRENCH 8 X 10MM OPEN-ENDS
42	P0634X042	HEX WRENCH 3MM
43	P0634X043	COVER SCREW 5/16-18 X 2-1/2
44	P0634X044	HEX WRENCH 3/32
45	P0634X045	HEX WRENCH 4MM
49	P0634X049	KNOB BOLT 1/4-20 X 1/2, 6-LOBE, D7/8
51	P0634X051	CABLE CLAMP
52	P0634X052	HEX NUT 10-24



Jointer Table

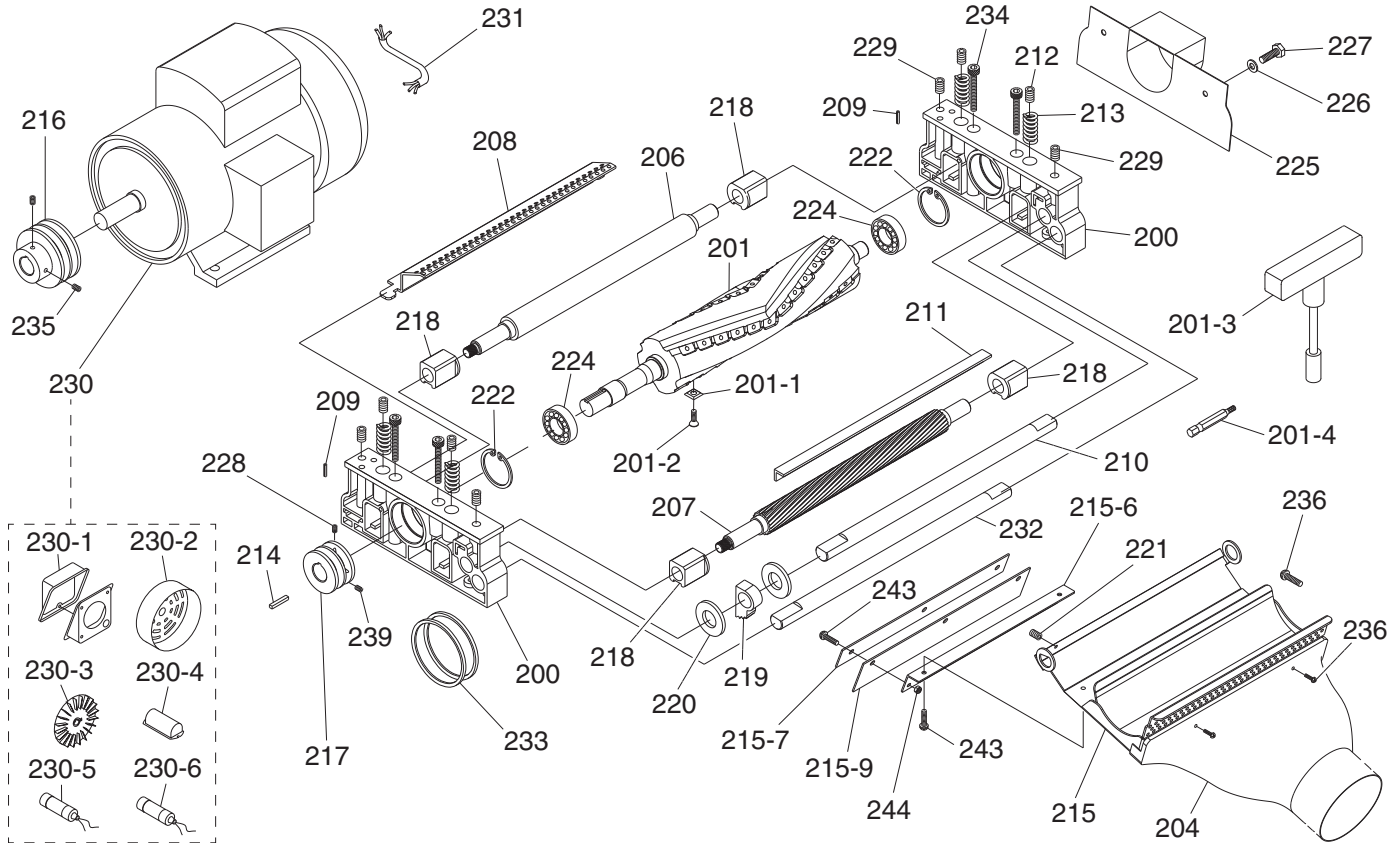


REF	PART #	DESCRIPTION
101	P0634X101	INFEED TABLE
102	P0634X102	OUTFEED TABLE
103	P0634X103	TABLE LIP
104-2	P0634X104-2	JOINTER DUST PORT 4"
105	P0634X105	HINGE SHAFT A
106	P0634X106	HINGE SHAFT B
107	P0634X107	OUTFEED TABLE ADJ KNOB
108	P0634X108	GUIDE SCREW
109	P0634X109	HEX NUT 1/2-12
110	P0634X110	INFEED HANDGRIP
111	P0634X111	INFEED LOCK LEVER
112	P0634X112	OUTFEED LOCK LEVER
113	P0634X113	PLASTIC KNOB
114	P0634X114	EXT RETAINING RING 12MM
117	P0634X117	HEX BOLT 5/16-18 X 1
118	P0634X118	KNOB SCREW 5/16-18 X 1
119	P0634X119	PHLP HD SCR 10-24 X 1/4
120	P0634X120	FLAT WASHER 5/16
121	P0634X121	CAP SCREW 5/16-18 X 3/4
122	P0634X122	CAP SCREW 5/16-18 X 1
124	P0634X124	CAP SCREW 3/8-16 X 1-1/4
125	P0634X125	HEX NUT 5/16-18

REF	PART #	DESCRIPTION
126	P0634X126	CAP SCREW 1/4-20 X 1/2
128	P0634X128	CAP SCREW 5/16-18 X 3/8
129	P0634X129	HANDLE
130	P0634X130	PLUNGER SCREW 1/2
131	P0634X131	PLUNGER
132	P0634X132	COMPRESSION SPRING
133	P0634X133	KNOB
134	P0634X134	PUSH BLOCK-SMALL
135-4	P0634X135-4	L-BRACKET
135-5	P0634X135-5	PLATE
135-8	P0634X135-8	JDP PLASTIC PLATE
136	P0634X136	PHLP HD SCR 10-24 X 1/2
137	P0634X137	HEX NUT 10-24
701	P0634X701	CUTTERHEAD GUARD
702	P0634X702	ROLL PIN 6 X 36
703	P0634X703	GUARD TORSION PIN
704	P0634X704	ROLL PIN 5 X 30
705	P0634X705	TORSION SPRING
707	P0634X707	EXT RETAINING RING 11MM
708	P0634X708	RIVET 4 X 7 PUSH, NYLON
710	P0634X710	WAVY WASHER 12MM



Cutterhead & Motor

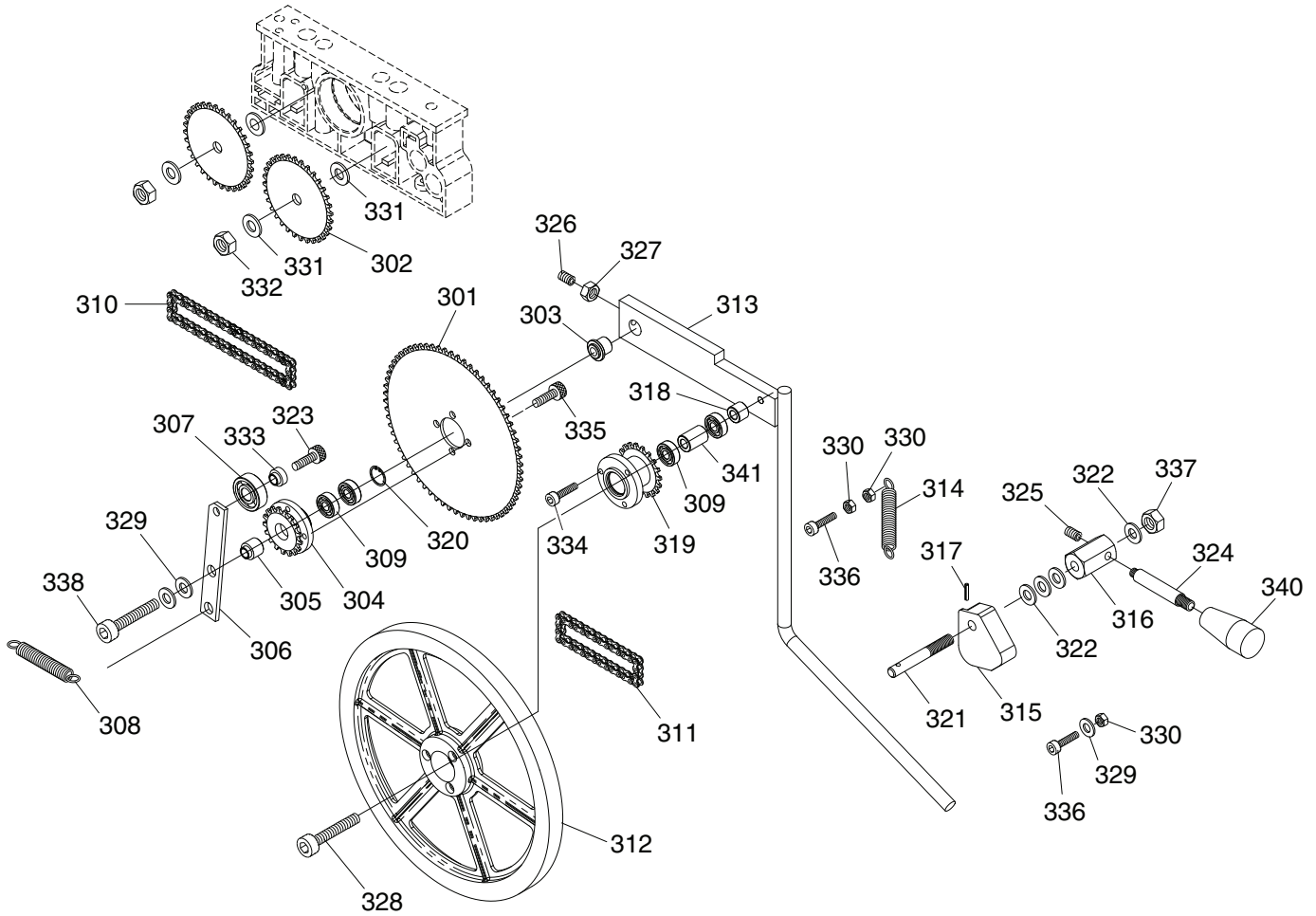


REF	PART #	DESCRIPTION
200	P0634X200	CUTTERHEAD BLOCK
201	P0634X201	V-HELICAL CUTTERHEAD 12"
201-1	P0634X201-1	INSERTS 15 X 15 X 2.5MM-10 PK
201-2	P0634X201-2	FLAT HD TORX SCR T20 M6-1 X 16
201-3	P0634X201-3	T-HANDLE TORX DRIVER T-20
201-4	P0634X201-4	TORX BIT T-20
204	P0634X204	PLANER DUST PORT 4"
206	P0634X206	OUTFEED ROLLER
207	P0634X207	INFEED ROLLER
208	P0634X208	COVER
209	P0634X209	ALIGNMENT PIN
210	P0634X210	PIVOT PIN
211	P0634X211	SQUARE SUPPORT
212	P0634X212	DOWEL
213	P0634X213	COMPRESSION SPRING
214	P0634X214	KEY 5 X 5 X 30
215	P0634X215	DUST CHUTE
215-6	P0634X215-6	BRACKET
215-7	P0634X215-7	PLATE
215-9	P0634X215-9	PDF PLASTIC PLATE
216	P0634X216	MOTOR PULLEY
217	P0634X217	CUTTERHEAD PULLEY
218	P0634X218	SUPPORT
219	P0634X219	ANTI-KICKBACK FINGER
220	P0634X220	SPACER

REF	PART #	DESCRIPTION
221	P0634X221	SET SCREW 1/4-20 X 1/2
222	P0634X222	INT RETAINING RING 52MM
224	P0634X224	BALL BEARING 6205-2RS
225	P0634X225	GUARD
226	P0634X226	FLAT WASHER 1/4
227	P0634X227	HEX BOLT 1/4-20 X 3/8
228	P0634X228	SET SCREW M5-.8 X 4
229	P0634X229	SET SCREW 1/4-20 X 3/4 CONE-PT
230	P0634X230	MOTOR 5HP 220V 1-PH
230-1	P0634X230-1	JUNCTION BOX
230-2	P0634X230-2	FAN COVER
230-3	P0634X230-3	MOTOR FAN
230-4	P0634X230-4	CAPACITOR COVER
230-5	P0634X230-5	S CAPACITOR 400M 125V 1-3/8 X 3-1/8
230-6	P0634X230-6	R CAPACITOR 50M 350V 2 X 3-1/2
231	P0634X231	MOTOR CORD
232	P0634X232	PIVOT PIN
233	P0634X233	V-BELT M52 3L520
234	P0634X234	CAP SCREW 5/16-18 X 3-1/4
235	P0634X235	SET SCREW 1/4-20 X 3/8
236	P0634X236	PHLP HD SCR 10-24 X 1/2
239	P0634X239	SET SCREW M5-.8 X 6
243	P0634X243	FLANGE SCREW 10-24 X 1/2
244	P0634X244	HEX NUT 10-24



Drive Assembly

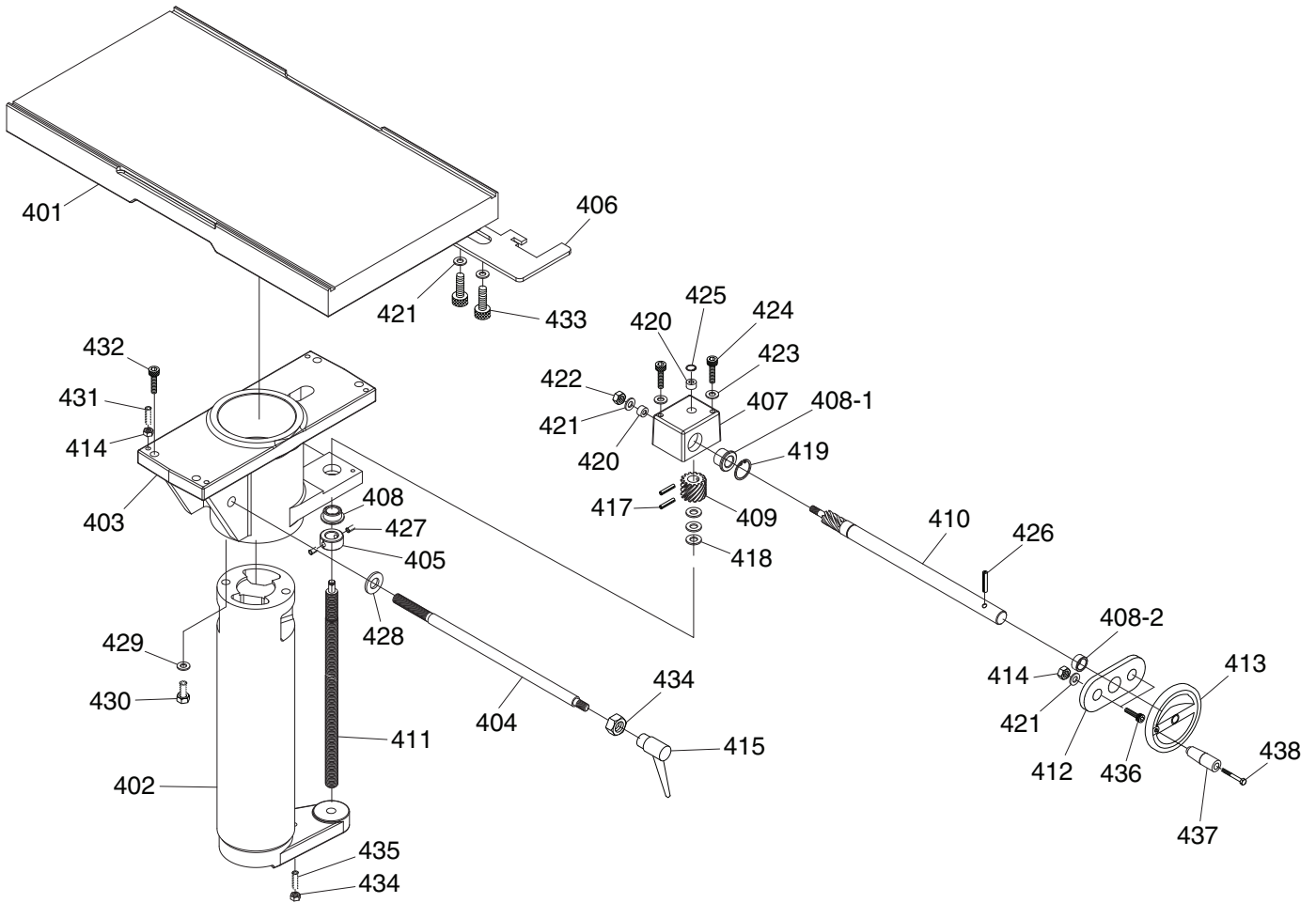


REF	PART #	DESCRIPTION
301	P0634X301	SPROCKET 66T
302	P0634X302	SPROCKET 34T
303	P0634X303	BUSHING
304	P0634X304	SPROCKET 18T
305	P0634X305	SPACER
306	P0634X306	ARM
307	P0634X307	BALL BEARING 6204-2RS
308	P0634X308	TENSION SPRING
309	P0634X309	BALL BEARING 608-2RS
310	P0634X310	ROLLER CHAIN
311	P0634X311	ROLLER CHAIN
312	P0634X312	CONTACT WHEEL
313	P0634X313	LEVER
314	P0634X314	TENSION SPRING
315	P0634X315	CAM
316	P0634X316	CAM SHAFT
317	P0634X317	ROLL PIN
318	P0634X318	SPACER
319	P0634X319	SPROCKET 19T
320	P0634X320	INT RETAINING RING 22MM

REF	PART #	DESCRIPTION
321	P0634X321	SPRING STUD
322	P0634X322	FLAT WASHER 3/8
323	P0634X323	CAP SCREW 3/8-16 X 1/2
324	P0634X324	LEVER
325	P0634X325	SET SCREW 3/8-16 X 3/8
326	P0634X326	SET SCREW 1/4-20 X 1
327	P0634X327	HEX NUT 1/4-20
328	P0634X328	CAP SCREW 5/16-18 X 2
329	P0634X329	FLAT WASHER 5/16
330	P0634X330	HEX NUT 5/16-18
331	P0634X331	FLAT WASHER 1/2
332	P0634X332	HEX NUT 1/2-20
333	P0634X333	BUSHING
334	P0634X334	CAP SCREW 1/4-20 X 3/4
335	P0634X335	CAP SCREW 1/4-20 X 3/8
336	P0634X336	CAP SCREW 5/16-18 X 3/4
337	P0634X337	LOCK NUT 3/8-16
338	P0634X338	CAP SCREW 5/16-18 X 2-1/2
340	P0634X340	PLASTIC KNOB
341	P0634X341	SPACER 8.6 X 15 X 18.6MM



Planer Table

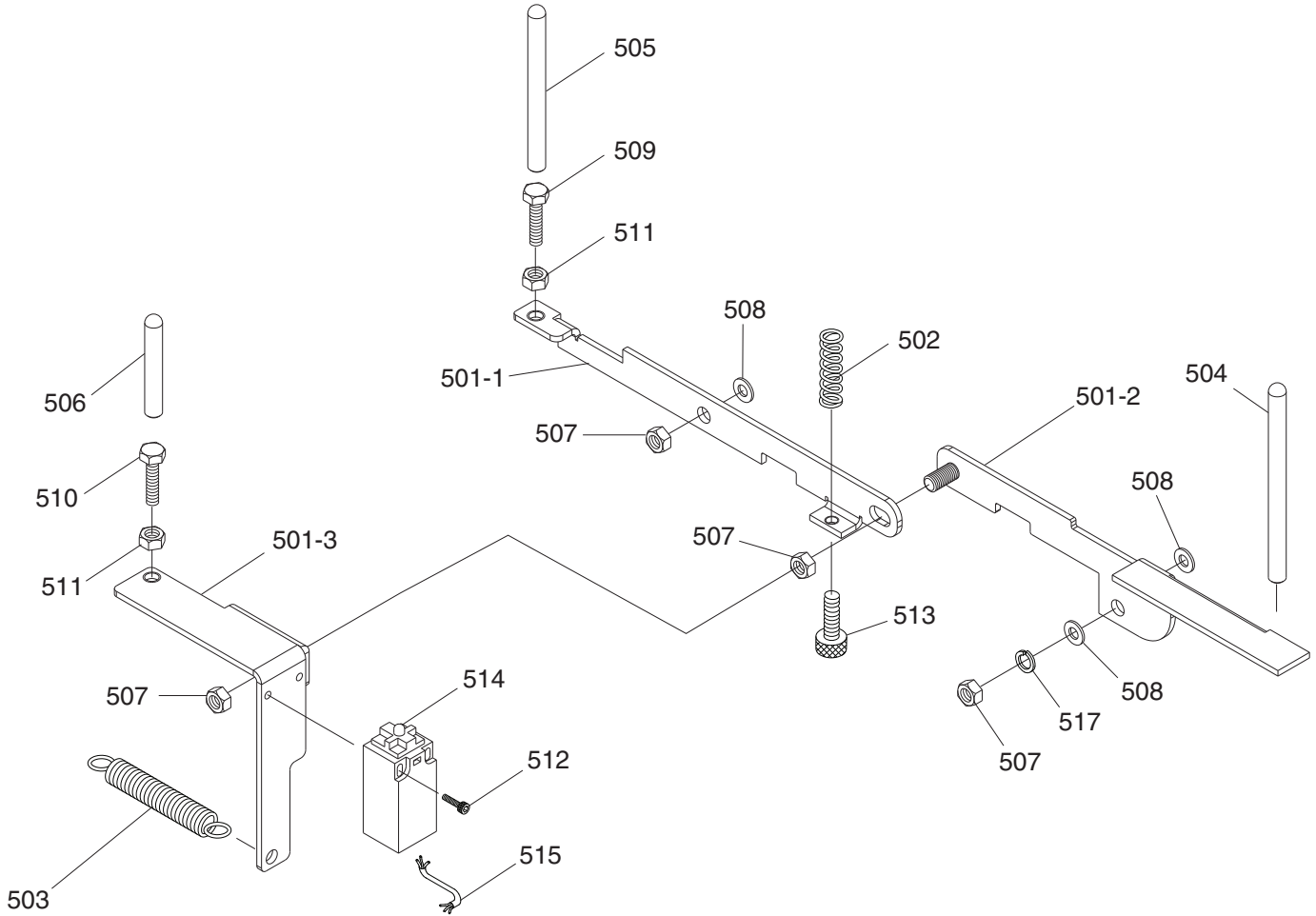


REF	PART #	DESCRIPTION
401	P0634X401	PLANER TABLE
402	P0634X402	COLUMN
403	P0634X403	CYLINDER LINER
404	P0634X404	LOCK SCREW
405	P0634X405	COLLAR
406	P0634X406	THICKNESS POINTER
407	P0634X407	GEAR BOX
408	P0634X408	BUSHING
408-1	P0634X408-1	SELF-LUBRICATING SHLDR BUSHING
408-2	P0634X408-2	SELF-LUBRICATION BUSHING
409	P0634X409	GEAR
410	P0634X410	WORM SHAFT
411	P0634X411	ELEVATION LEAD SCREW
412	P0634X412	SHIELD PLATE
413	P0634X413	HANDWHEEL
414	P0634X414	HEX NUT 5/16-18
415	P0634X415	UNIVERSAL LOCK LEVER
417	P0634X417	ROLL PIN
418	P0634X418	THRUST BEARING NTB1528 +2AS
419	P0634X419	INT RETAINING RING 19MM

REF	PART #	DESCRIPTION
420	P0634X420	BUSHING
421	P0634X421	FLAT WASHER 5/16
422	P0634X422	LOCK NUT 5/16-18
423	P0634X423	LOCK WASHER 1/4
424	P0634X424	CAP SCREW 1/4-20 X 2-1/4
425	P0634X425	INT RETAINING RING 8MM
426	P0634X426	ROLL PIN 5 X 30
427	P0634X427	SET SCREW 5/16-18 X 1/4
428	P0634X428	FLAT WASHER
429	P0634X429	LOCK WASHER 3/8
430	P0634X430	HEX BOLT 3/8-16 X 1-1/2
431	P0634X431	SET SCREW 5/16-18 X 1
432	P0634X432	CAP SCREW 3/8-16 X 1-1/4
433	P0634X433	HEX BOLT 5/16-18 X 1/2
434	P0634X434	HEX NUT 3/8-16
435	P0634X435	SET SCREW 3/8-16 X 2
436	P0634X436	PHLP HD SCR 5/16-18 X 3/4
437	P0634X437	HANDLE
438	P0634X438	HANDLE SCREW 3/8-16 X 3-3/8



Limit Switch



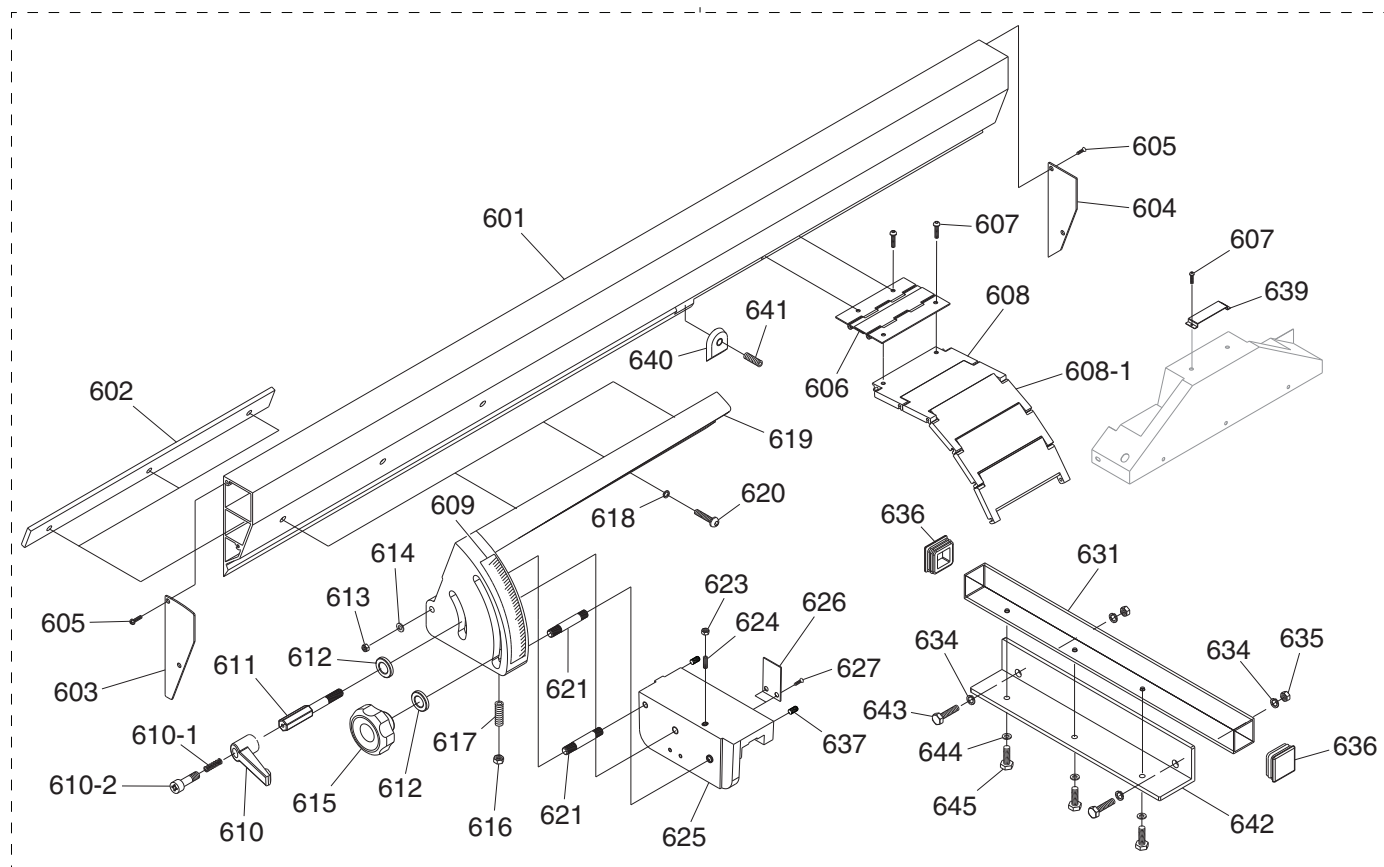
REF	PART #	DESCRIPTION
501-1	P0634X501-1	SWING LEVER (F)
501-2	P0634X501-2	SWING LEVER (M)
501-3	P0634X501-3	LIMIT SWITCH BRACKET
502	P0634X502	COMPRESSION SPRING
503	P0634X503	TENSION SPRING
504	P0634X504	SWITCH ACTIVATION ROD #1
505	P0634X505	SWITCH ACTIVATION ROD #2
506	P0634X506	SWITCH ACTIVATION ROD #3
507	P0634X507	LOCK NUT 5/16-18

REF	PART #	DESCRIPTION
508	P0634X508	FLAT WASHER 5/16
509	P0634X509	HEX BOLT 5/16-18 X 1
510	P0634X510	HEX BOLT 5/16-18 X 1/2
511	P0634X511	HEX NUT 5/16-18
512	P0634X512	CAP SCREW 10-24 X 1-1/4
513	P0634X513	CAP SCREW 1/4-20 X 1
514	P0634X514	LIMIT SWITCH
515	P0634X515	LIMIT SWITCH CONTROL CORD
517	P0634X517	LOCK WASHER 5/16



Fence

600

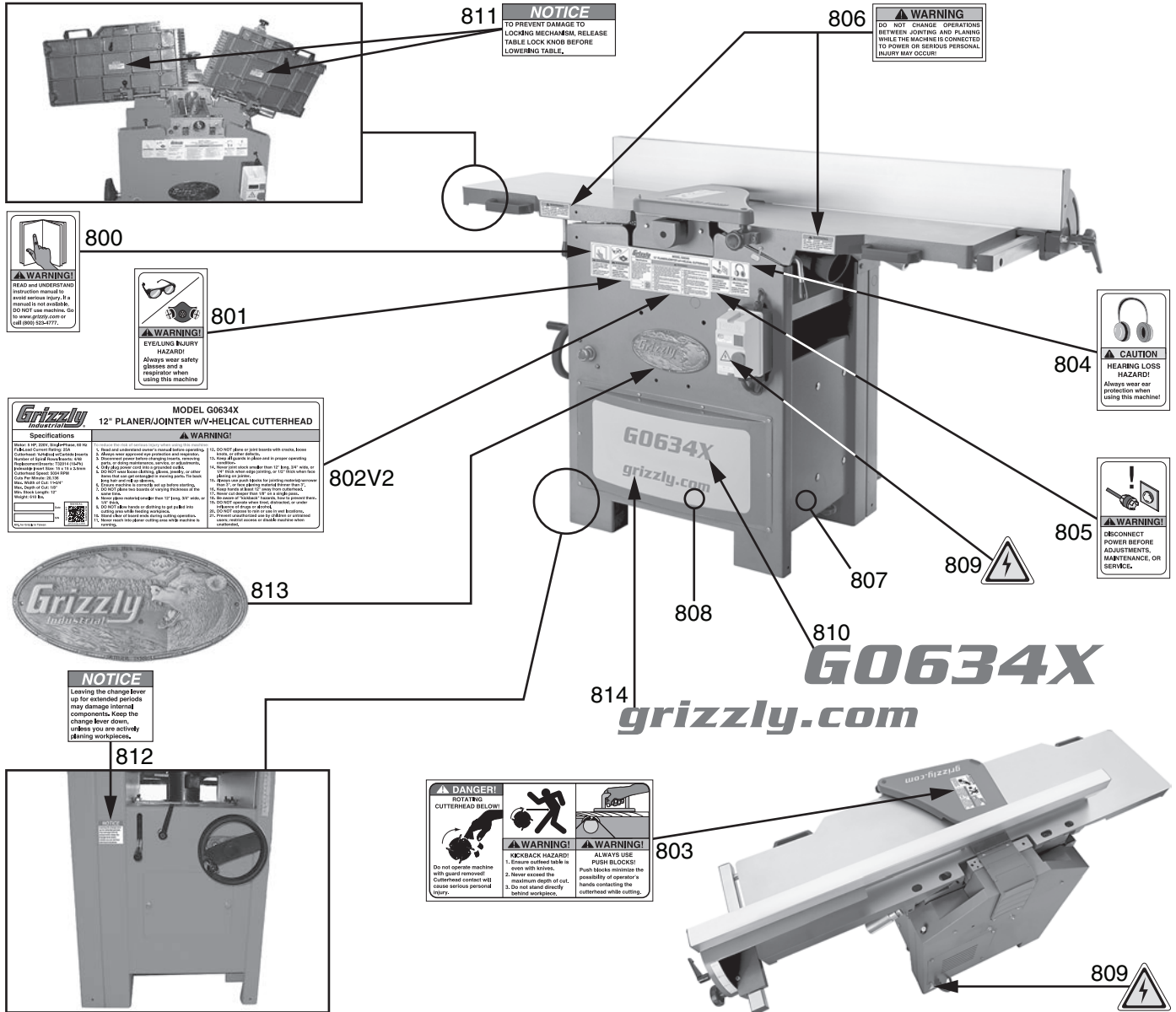


REF	PART #	DESCRIPTION
600	P0634X600	COMPLETE FENCE ASSEMBLY
601	P0634X601	FENCE
602	P0634X602	FENCE FIXED PLATE
603	P0634X603	LEFT FENCE CAP
604	P0634X604	RIGHT FENCE CAP
605	P0634X605	TAP SCREW #10 X 1/2
606	P0634X606	REAR GUARD HINGE
607	P0634X607	PHLP HD SCR M4-.7 X 6
608	P0634X608	REAR GUARD CONNECTOR
608-1	P0634X608-1	REAR GUARD LINK
609	P0634X609	FENCE ANGLE SCALE
610	P0634X610	FENCE LOCK LEVER
610-1	P0634X610-1	COMPRESSION SPRING
610-2	P0634X610-2	PHLP SHOULDER SCR M5-.8 X 15
611	P0634X611	FENCE LOCK LEVER SCREW
612	P0634X612	FENDER WASHER 3/8
613	P0634X613	LOCK NUT 3/8-16
614	P0634X614	FLAT WASHER 3/8
615	P0634X615	ANGLE ADJUSTMENT KNOB 3/8
616	P0634X616	HEX NUT 5/16-18
617	P0634X617	SET SCREW 5/16-18 X 1

REF	PART #	DESCRIPTION
618	P0634X618	FLAT WASHER 5/16
619	P0634X619	FENCE ANGLE SUPPORT
620	P0634X620	CAP SCREW 5/16-18 X 1
621	P0634X621	STUD-UDE 3/8-16 X 2-1/2 1/2 / 3/4RH
623	P0634X623	HEX NUT 1/4-20
624	P0634X624	SET SCREW 1/4-20 X 1
625	P0634X625	FENCE SUPPORT
626	P0634X626	FENCE SUPPORT PLATE
627	P0634X627	FLAT HD SCR 10-24 X 3/8
631	P0634X631	FENCE RAIL W/ HOLES
634	P0634X634	LOCK WASHER 3/8
635	P0634X635	HEX NUT 3/8-16
636	P0634X636	FENCE RAIL END CAP
637	P0634X637	BALL PLUNGER 1/4-20 X 1/2
639	P0634X639	FIXED PLATE
640	P0634X640	PLASTIC PROTECTION SHOE
641	P0634X641	SET SCREW 10-24 X 1/4
642	P0634X642	FENCE RAIL BRACE
643	P0634X643	HEX BOLT 3/8-16 X 1-1/2
644	P0634X644	FLAT WASHER 1/4
645	P0634X645	HEX BOLT 1/4-20 X 1/2



Labels & Cosmetics



REF	PART #	DESCRIPTION
800	P0634X800	READ MANUAL LABEL
801	P0634X801	RESPIRATOR/GLASSES LABEL
802V2	P0634X802V2	MACHINE ID LABEL V2.04.22
803	P0634X803	CUTTERHEAD WARNING LABEL
804	P0634X804	EAR PROTECTION LABEL
805	P0634X805	DISCONNECT POWER LABEL
806	P0634X806	CHANGING OPERATIONS WARNING LABEL
807	P0634X807	TOUCH-UP PAINT, GRIZZLY GREEN

REF	PART #	DESCRIPTION
808	P0634X808	TOUCH-UP PAINT, BEIGE
809	P0634X809	ELECTRICITY LABEL
810	P0634X810	MODEL NUMBER LABEL
811	P0634X811	TABLE LOCK KNOB NOTICE
812	P0634X812	CHANGE LEVER LABEL
813	P0634X813	GRIZZLY NAMEPLATE-SMALL
814	P0634X814	GRIZZLY.COM LABEL

⚠ WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.



WARRANTY & 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.

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.

In the event you need to use 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.

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.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/forms/warranty>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.



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