

Grizzly *Industrial, Inc.*®

MODEL G0834 **12" X 84" JOINTER** **w/PARALLELOGRAM BEDS** **OWNER'S MANUAL** *(For models manufactured since 12/17)*



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

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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:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure safety glasses and respirator are properly adjusted/setup and	
Specification:		4. 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 under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
		Manufactured for Grizzly in Taiwan	

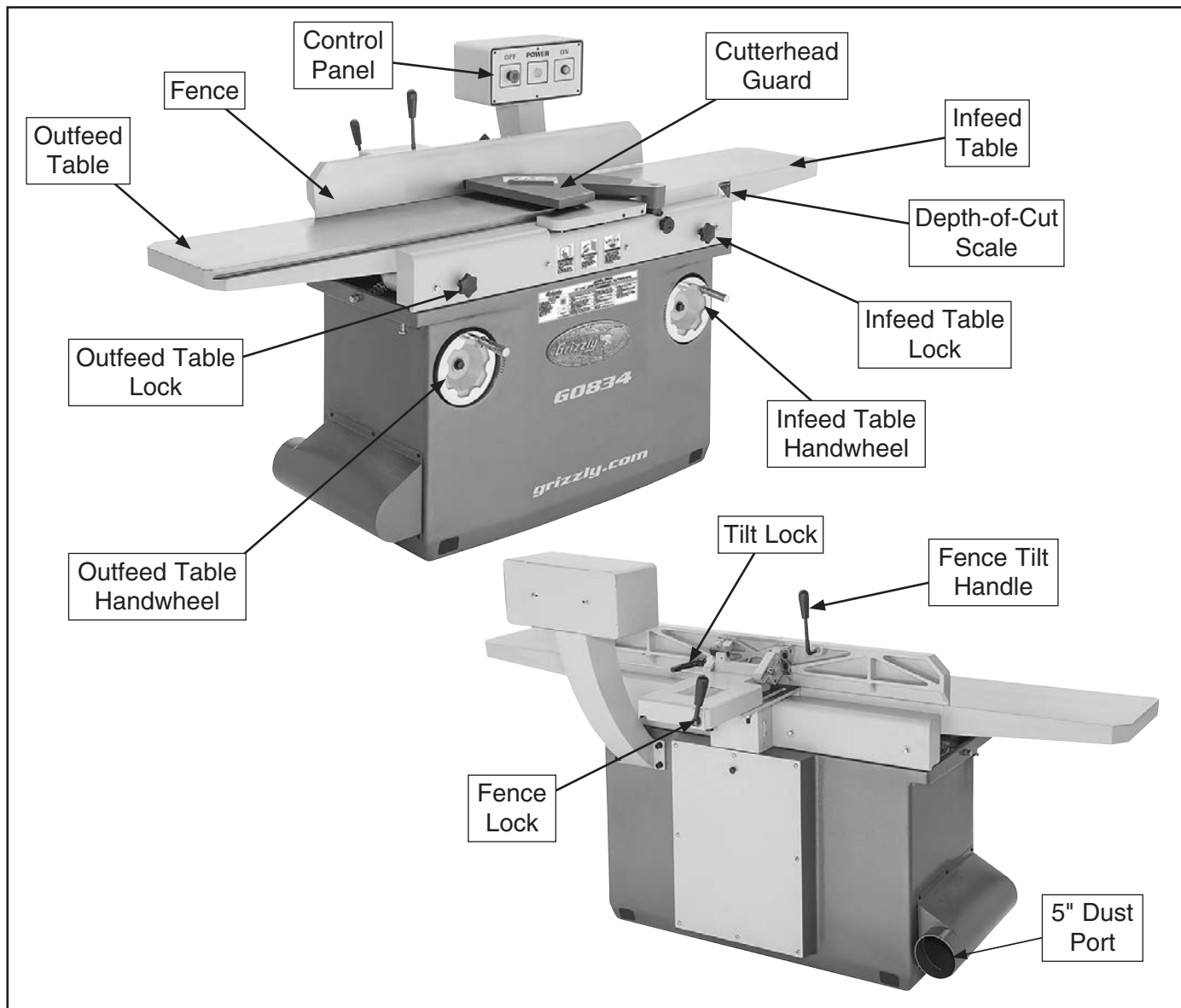
Manufacture Date []

Serial Number []



Identification

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



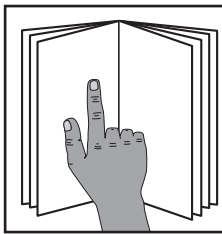
⚠️ WARNING

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. **ALWAYS** replace cutterhead guard after rabbeting operations.
- c) Never make jointing or rabbeting cuts deeper than $\frac{1}{8}$ " or planing cuts deeper than $\frac{1}{16}$ ".
- d) Always use hold-down or push blocks when jointing material narrower than 3" or planing material thinner than 3".
- e) Never perform jointing, planing, or rabbeting cuts on pieces shorter than 14" in length.



Controls & Components



!WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

Refer to **Figures 1–6** and the following 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 stay safe when operating this machine.

Control Panel

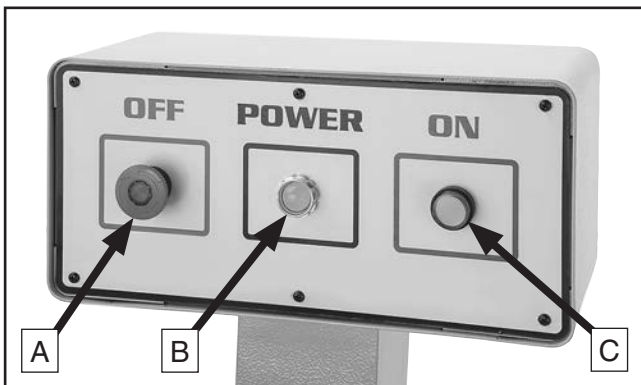


Figure 1. Location of ON/OFF buttons.

- A. OFF Button:** Stops motor when pressed and disables ON button. Remains depressed until manually reset. Reset by twisting OFF button clockwise until it springs outward.
- B. Power Lamp:** Illuminates when machine is connected to power.
- C. ON Button:** Starts motor when pressed (only if OFF button is not in depressed position).

Table Controls

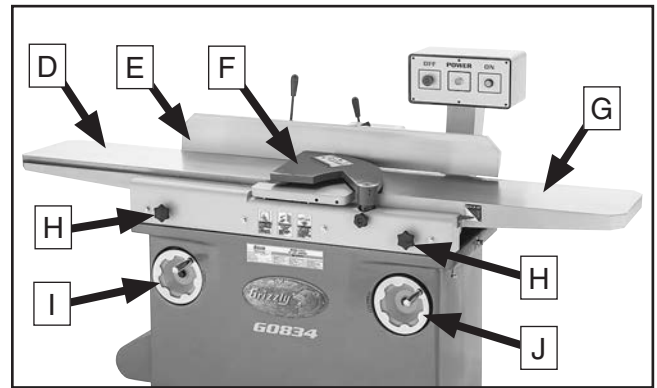


Figure 2. Location of main table controls.

- D. Outfeed Table:** Supports workpiece after it passes over cutterhead. For safety purposes and optimum cutting results, the outfeed table must be properly adjusted so it is even with highest point of cutterhead insert rotation (aka TDC). Refer to **Page 37** for more details.
- E. Fence:** Supports workpiece laterally as it moves across cutterhead; determines angle of cut when edge or bevel jointing.
- F. Cutterhead Guard:** Covers cutterhead until pushed out of the way by workpiece during operation. When workpiece leaves cutterhead, guard springs back to its starting position.
- G. Infeed Table:** Supports workpiece before it reaches cutterhead. Position of infeed table relative to cutterhead inserts determines depth of cut.
- H. Table Locks:** Tighten to secure position of infeed and outfeed tables; loosen to allow vertical table movement with adjustment handwheels.
- I. Outfeed Table Adjustment Handwheel:** Adjusts outfeed table position (when outfeed table lock and positive stop bolts are loosened).
- J. Infeed Table Adjustment Handwheel:** Adjusts position of infeed table (when infeed table lock is loosened).



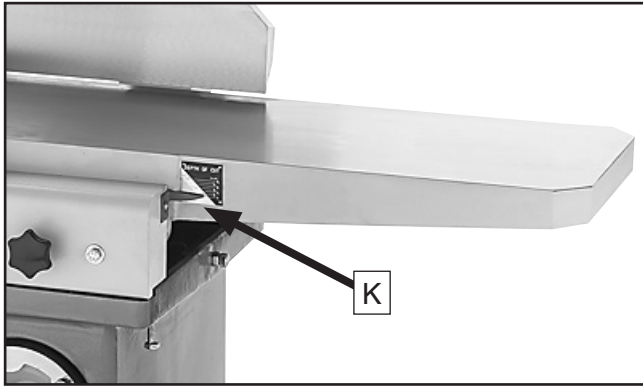


Figure 3. Location of depth-of-cut scale indicator.

K. Depth-of-Cut Scale: Indicates depth of cut (per pass).

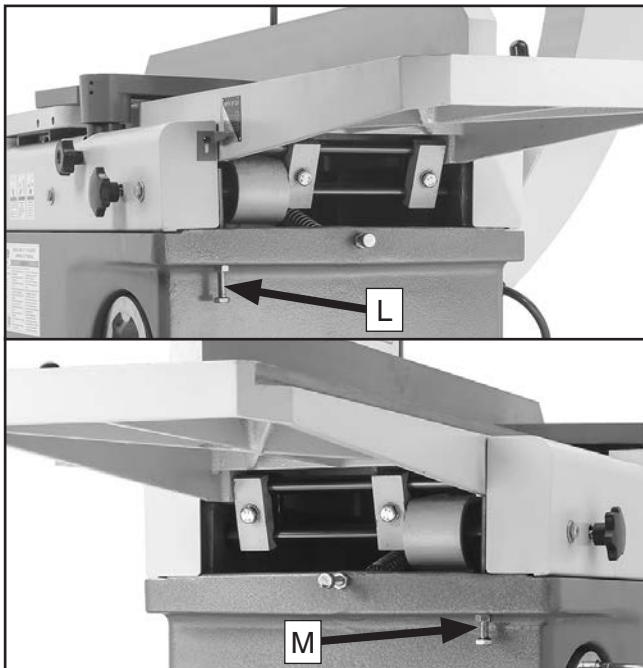


Figure 4. Location of positive stops bolts.

L. Infeed Positive Stop Bolt: Allows operator to quickly adjust the infeed table to perform heavy or light cuts. It controls the bottom range of infeed table movement. A jam nut locks the positive stop bolt in position so it will not move during operation.

M. Outfeed Positive Stop Bolt: Adjusts the outfeed table height. It controls the bottom range of outfeed table movement. A jam nut locks the positive stop bolt in position so it will not move during operation.

Fence Controls

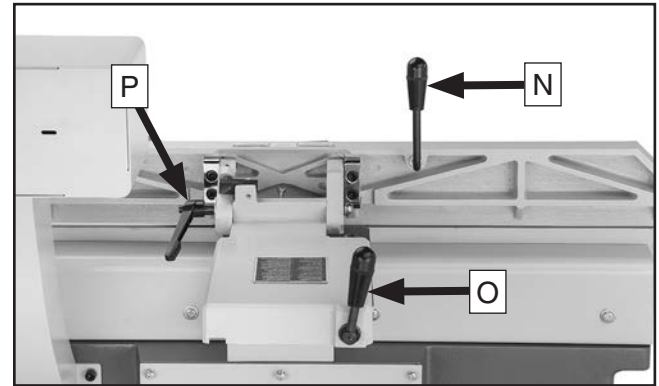


Figure 5. Location of fence controls.

N. Fence Tilt Handle: Tilts fence throughout its range of motion from 45° inward to 45° outward (135°).

O. Fence Lock Lever: Tightens to secure fence position along width of tables; loosens to allow lateral adjustment.

P. Fence Tilt Lock: Secures fence at any position in available tilt range.

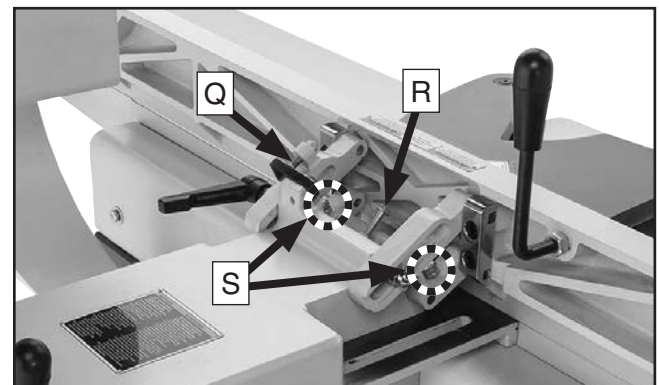


Figure 6. Location of fence tilt locks.

Q. 90° Fence Tilt Stop: Stops fence at 90°.

R. 45° Outward Fence Tilt Stops: Stop fence at 45° outward (135°).

S. 45° Inward Fence Tilt Stop: Stops fence at 45° inward.

Note: *Even when fence is resting against stops, fence tilt lock must be tightened before starting machine.*





MACHINE DATA SHEET

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

MODEL G0834 12" X 84" JOINTER WITH SPIRAL CUTTERHEAD

Product Dimensions:

Weight..... 1080 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 84 x 39 x 47 in.
 Footprint (Length x Width)..... 41 x 19-1/2 in.

Shipping Dimensions:

Type..... Wood Crate
 Content..... Machine
 Weight..... 1278 lbs.
 Length x Width x Height..... 89 x 38 x 41 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 230V, Single-Phase, 60 Hz
 Prewired Voltage..... 230V
 Full-Load Current Rating..... 19A
 Minimum Circuit Size..... 30A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 12 AWG
 Plug Included..... Yes
 Included Plug Type..... L6-30
 Switch Type..... Control Panel w/Magnetic Switch Protection

Motors:

Main

Horsepower..... 5 HP
 Phase..... Single-Phase
 Amps..... 19A
 Speed..... 3450 RPM
 Type..... TEFC Capacitor-Start Induction
 Power Transfer V-Belt Drive
 Bearings..... Shielded & Permanently Lubricated
 Centrifugal Switch/Contacts Type..... External

Main Specifications:

Main Specifications

Jointer Size..... 12 in.
 Bevel Jointing..... 0-45 deg. L/R
 Maximum Width of Cut..... 12 in.
 Maximum Depth of Cut..... 1/8 in.
 Minimum Workpiece Length..... 14 in.
 Minimum Workpiece Thickness..... 1/2 in.
 Maximum Rabbeting Depth..... 3/8 in.
 Number of Cuts Per Minute..... 39,600



Fence Information

Fence Length..... 47 in.
Fence Width..... 1-1/2 in.
Fence Height..... 5-3/8 in.
Fence Stops..... 45, 90, 135 deg.

Cutterhead Information

Cutterhead Type..... Spiral
Cutterhead Diameter..... 3-7/8 in.
Number of Cutter Rows..... 8
Number of Indexable Cutters..... 96
Cutterhead Speed..... 4950 RPM

Cutter Insert Information

Cutter Insert Type..... Indexable Carbide
Cutter Insert Length..... 15mm
Cutter Insert Width..... 15mm
Cutter Insert Thickness..... 2.5mm

Table Information

Table Length..... 84 in.
Table Width..... 12-3/4 in.
Table Thickness..... 1-7/8–3-1/4 in.
Floor to Table Height..... 32-1/8 in.
Table Adjustment Type..... Handwheel
Table Movement Type..... Parallelogram

Construction

Base..... Cast Iron
Body Assembly..... Cast Iron
Cabinet..... Cast Iron
Fence Assembly..... Cast Iron
Guard..... Cast Aluminum
Table..... Precision-Ground Cast Iron
Paint Type/Finish..... Powder Coated

Other Information

Number of Dust Ports..... 1
Dust Port Size..... 5 in.

Other Specifications:

Country of Origin China
Warranty 1 Year
Approximate Assembly & Setup Time 45 Minutes
Serial Number Location ID Label on Front of Cabinet
ISO 9001 Factory Yes

Features:

- Parallelogram Table Adjustment
- Handwheel Adjusted Tables with Depth Scale
- Pedestal-Mounted Switch for Easy Access
- Center-Mounted Fence with Angle Gauge
- Fence Stops at 45, 90, and 135 Degrees
- Spiral Cutterhead with 96 German-Made Indexable Carbide Inserts
- Precision-Ground Cast-Iron Tables
- Solid Cabinet Stand
- Rabbeting Table
- Green and Putty Powder-Coated Paint



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 blindness or eye injuries. 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. Warped workpieces must be surface planed first 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 14" long, $\frac{3}{4}$ " wide, or $\frac{1}{2}$ " thick.

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.

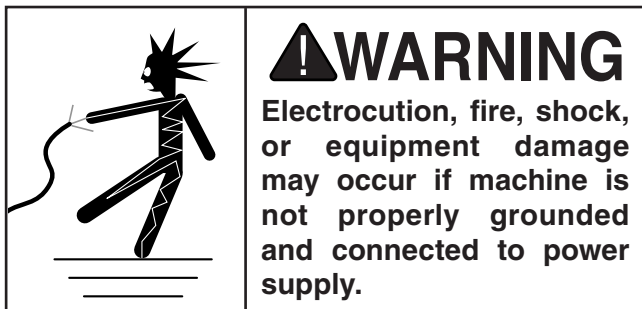
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can be thrown from cutterhead with dangerous force. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than $\frac{1}{8}$ " (0.125") from cutterhead body.



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 19 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.

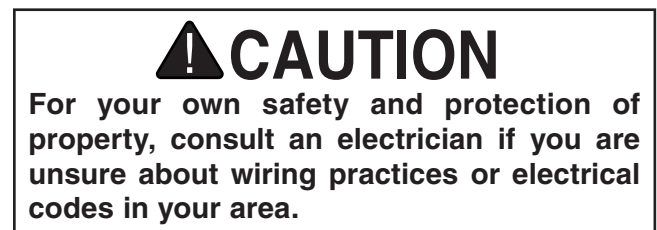
If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets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

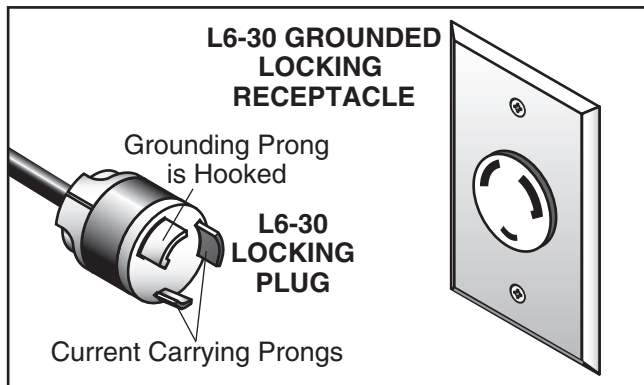
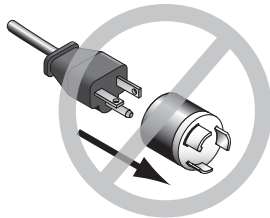


Figure 7. Typical L6-30 plug and receptacle.

⚠️ 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.

⚠️ 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.

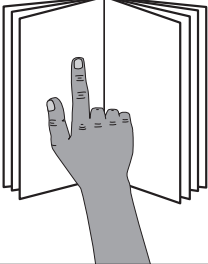
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 Size12 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.



!WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials shipped with this machine.

Needed for Setup

The following are needed to complete the setup process:

Description	Qty
• Additional People	1
• Safety Glasses	1 Ea.
• Leather Gloves	1 Pair Ea.
• Cleaner/Degreaser (Page 15)	As Needed
• Disposable Shop Rags.....	As Needed
• Lifting Equipment (Min. 1500 lb. Rating):	
—Forklift or Hoist	1
—Lifting Slings	2
• Wrenches or Sockets 19mm	1
• Precision Level	1
• Phillips Screwdriver #2	1
• Straightedge 4'	1
• Dust Collection System	1
• Dust Hose 5"	1
• Hose Clamps 5"	2

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.

Inventory (Figures 8–10)	Qty
A. Jointer.....	1
B. Control Panel Pedestal Assembly.....	1
C. Fence Assembly.....	1
D. Cutterhead Guard.....	1
E. Push Blocks.....	2
F. Hardware Bag (Not Shown)	
• Cap Screws M10-1.5 x 30 (Pedestal).....	4
• Lock Washers 10mm (Pedestal).....	4
• Flat Washers 10mm (Pedestal)	4
• Lock Nut M12-1.75 (Fence)	1
• Flat Washer 12mm (Fence)	1
• Open-End Wrench 12/14mm	1
• Open-End Wrench 17/19mm	1
• Hex Wrenches 3, 4, 5, 8mm.....	1 Each
• Torx Driver Bit T20.....	2
• Torx L-Wrench T20	2
• Flat Head Torx Screws T20 M6-1 x 15 ...	3
• Carbide Inserts 15 x 15 x 2.5mm.....	5



Figure 8. Jointer assembly.

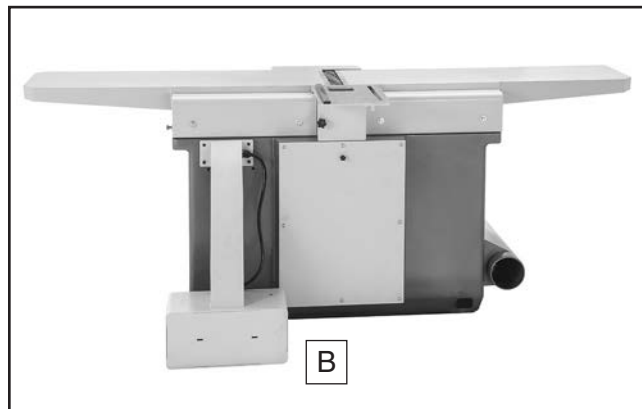


Figure 9. Control panel pedestal assembly.

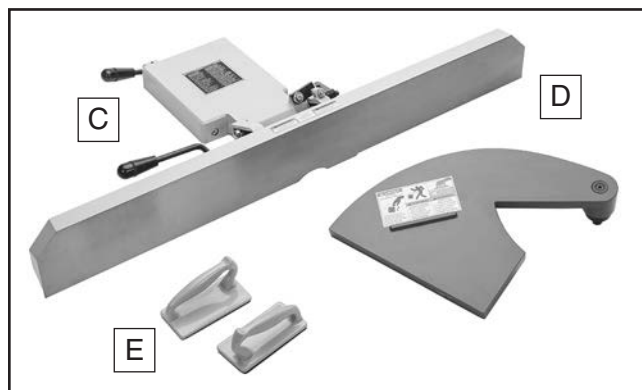


Figure 10. Additional crate contents.

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.



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.

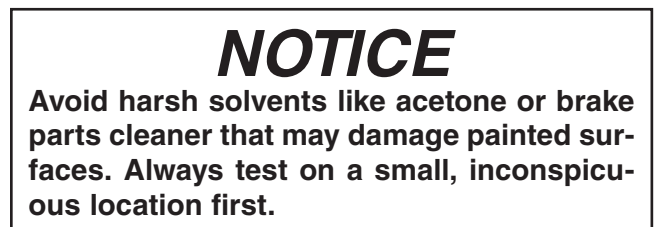
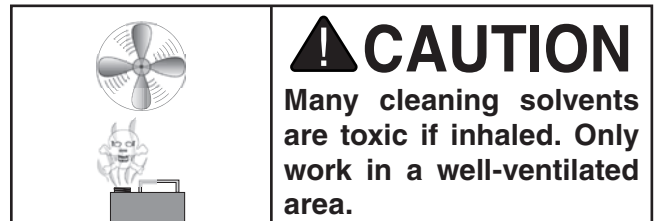
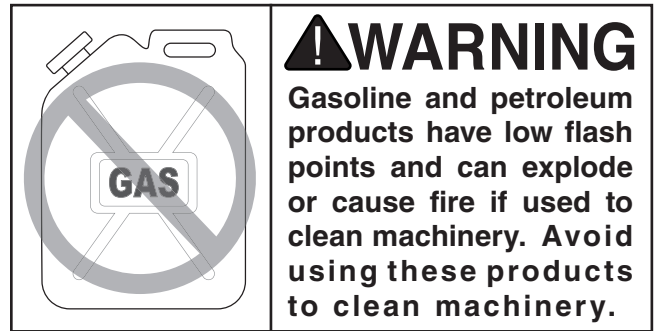
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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
T23692—Orange Power Degreaser is a heavy-duty cleaning product for removing the waxy, shipping grease from the **non-painted** parts of the machine during clean up.



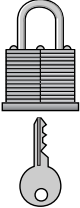
Site Considerations

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.

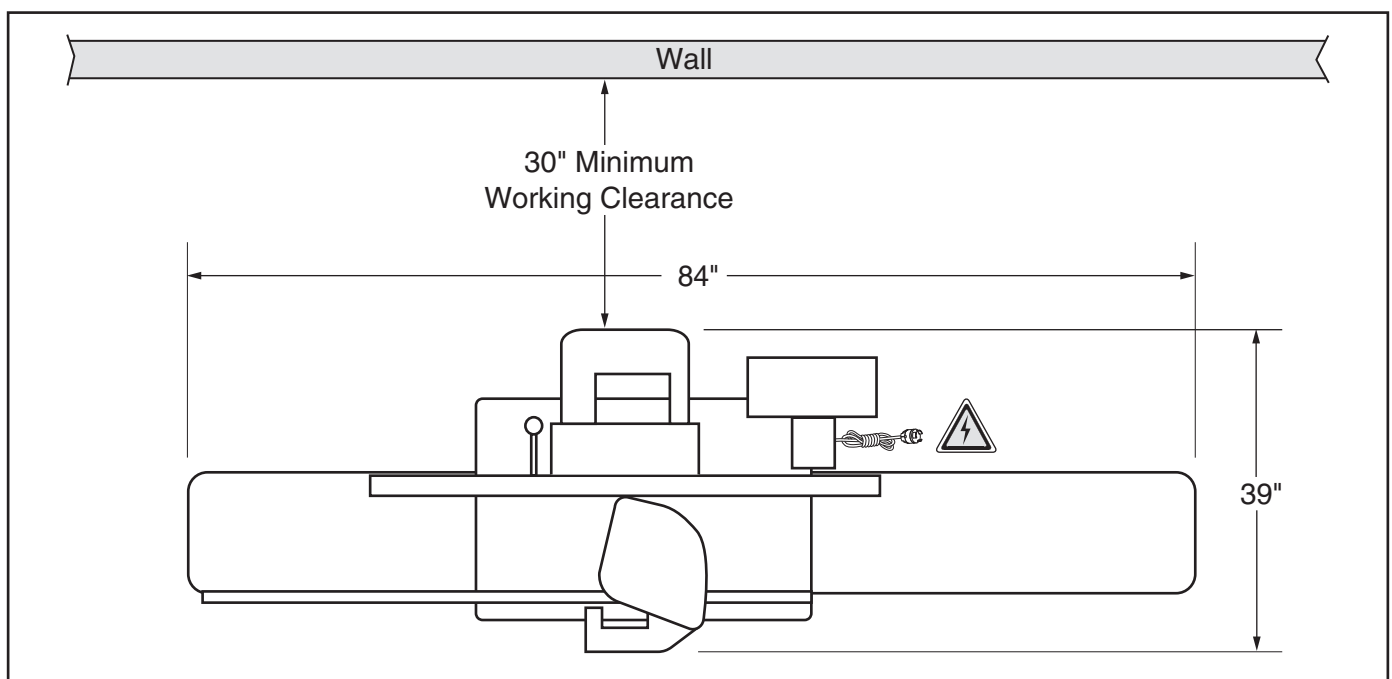
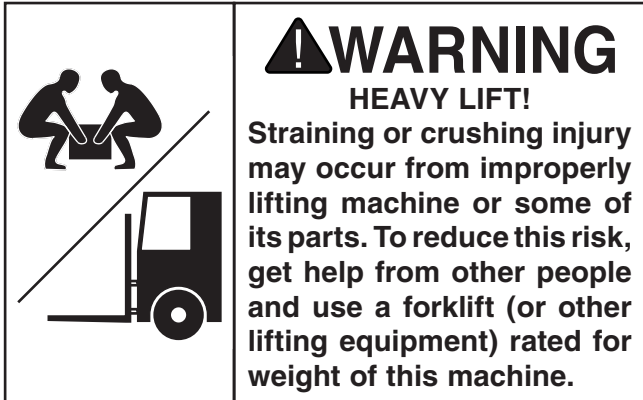


Figure 12. Minimum working clearances.



Moving & Placing Jointer



DO NOT attempt to lift or move jointer without using proper lifting equipment (such as forklift or crane) or necessary assistance from other people. Each piece of lifting equipment must be rated for **at least 1500 lbs.** to support dynamic loads that may be applied while lifting.

Review the **Power Supply** section beginning on **Page 11**, then prepare permanent location for the jointer.

IMPORTANT: *Make sure prepared location is clean and level.*

To move and place jointer:

1. Move jointer near its prepared location while still inside shipping crate.
2. Remove top and sides of shipping crate, then place small items aside in safe location.

IMPORTANT: *To avoid damaging control panel pedestal, secure it in upright position prior to moving and placing jointer (refer to **Step 1** in **Assembly** on **Page 18** for instructions).*

NOTICE

Make sure lifting straps do not touch control panel pedestal in next step.

3. Attach lifting slings to infeed and outfeed tables, as shown in **Figure 13**. Position slings as close to base as possible and tighten table locks to prevent damaging tables.

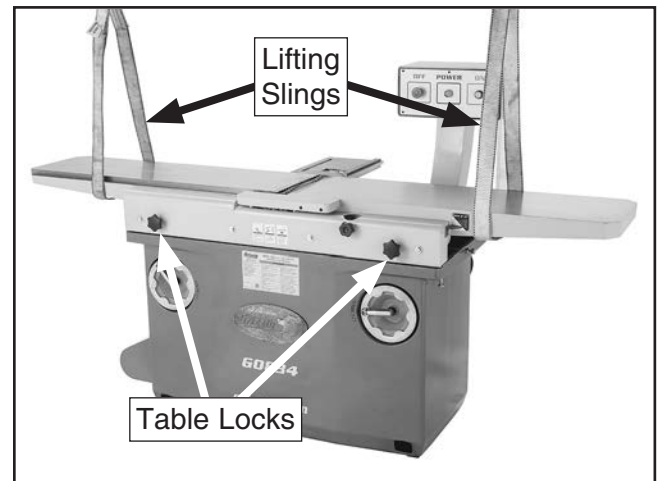


Figure 13. Lifting slings properly positioned.

4. Tension lifting slings with forklift to make sure they stay in place, then unbolt jointer from shipping pallet.
5. Raise jointer enough to just clear shipping pallet and any floor obstacles and check balance of load. Have your assistant carefully steady jointer to prevent it from swinging.

— If load is not safely balanced, immediately lower jointer and resolve issue before attempting to lift it again.
6. With help to steady load, raise jointer and move it to prepared location.

Note: *In next step, use shims between base and floor to avoid warping or cracking cast-iron base.*



7. Lower jointer into position.

IMPORTANT: Before jointer was shipped from factory, infeed table was fully raised and stop bolt was threaded up against bottom of it to safely secure it during transit. You **MUST** adjust position of infeed stop bolt before attempting to lower infeed table.

8. Loosen jam nut (see **Figure 14**) on infeed stop bolt, then unthread stop bolt until table can be lowered to $\frac{1}{8}$ " on depth-of-cut scale, then adjust infeed stop bolt back against infeed table casting and tighten jam nut.

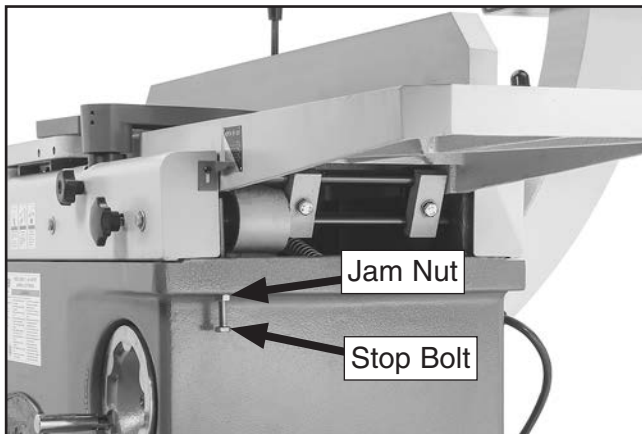


Figure 14. Infeed table stop bolt set to stop infeed table at $\frac{1}{8}$ " maximum depth of cut.

NOTICE

NEVER force table handwheels if you feel resistance. Check positions of stop bolts or for obstructions.

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).

To assemble jointer:

1. Secure control panel pedestal to jointer with (4) M10-1.5 x 30 cap screws, (4) 10mm lock washers, and (4) 10mm flat washers, as shown in **Figure 15**.



Figure 15. Securing control panel pedestal.



2. Lift fence assembly over fence carriage, slip sliding bushing into the fence carriage slot, ensuring key fits snugly into key slot, as shown in **Figure 16**.

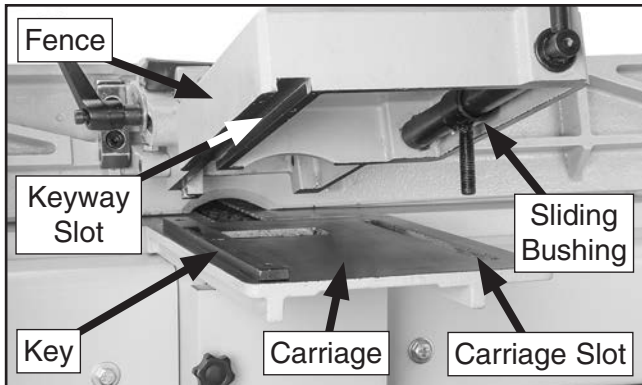


Figure 16. Aligning fence assembly and fence carriage.

3. Secure sliding bushing with (1) M12-1.75 lock nut and (1) 12mm flat washer, as shown in **Figure 17**.

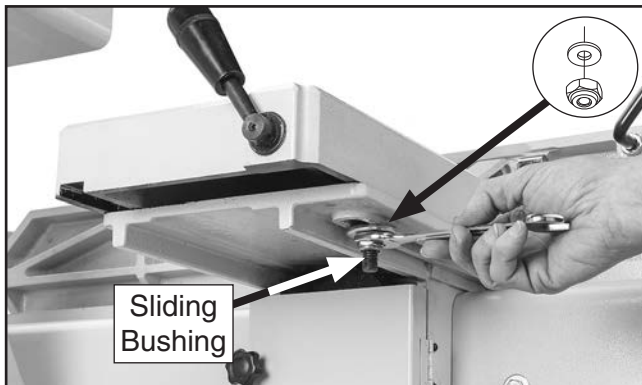


Figure 17. Securing sliding bushing.

4. Position and tighten fence tilt handle, as shown in **Figure 18**.

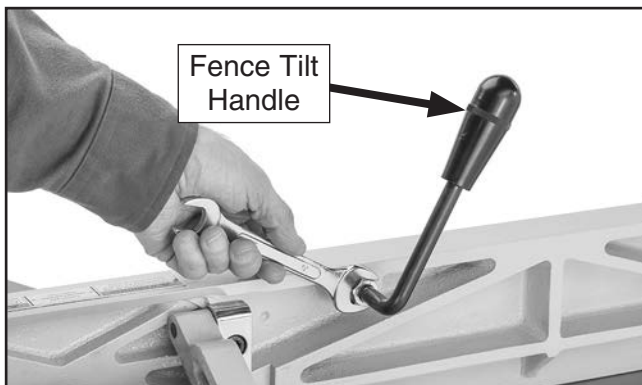


Figure 18. Positioning and tightening fence tilt handle.

5. Install cutterhead guard shaft into mounting hole, as shown in **Figure 19**, then secure it using lock knob.

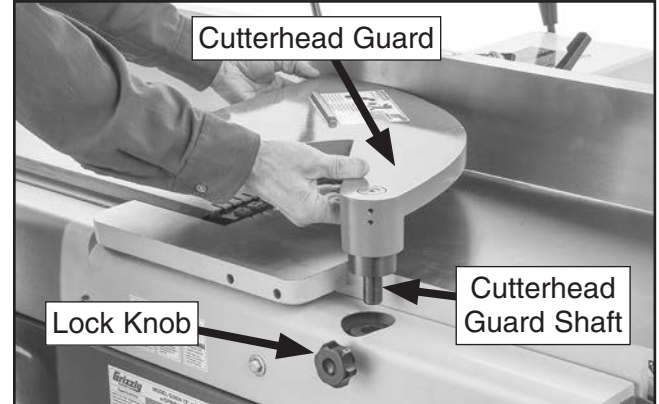


Figure 19. Installing cutterhead guard.

⚠️ WARNING

Cutterhead guard is a critical safety feature of this jointer. You MUST install and verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

6. Move fence all the way to back of table, then pull cutterhead guard back and let it go. It should spring back over cutterhead and contact fence.

— If cutterhead guard *does not* spring back over cutterhead and contact fence, then cutterhead guard tension must be adjusted (refer to **Adjusting Cutterhead Guard Tension** on **Page 44** for instructions).

7. Perform **Setting Outfeed Table Height** on **Page 37**.



Dust Collection

! CAUTION

DO NOT operate your jointer without an adequate dust collection system. This machine creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended 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 a dust collection hose:

1. Fit 5" dust hose over dust port, as shown in **Figure 20**, then secure it in place with hose clamp.

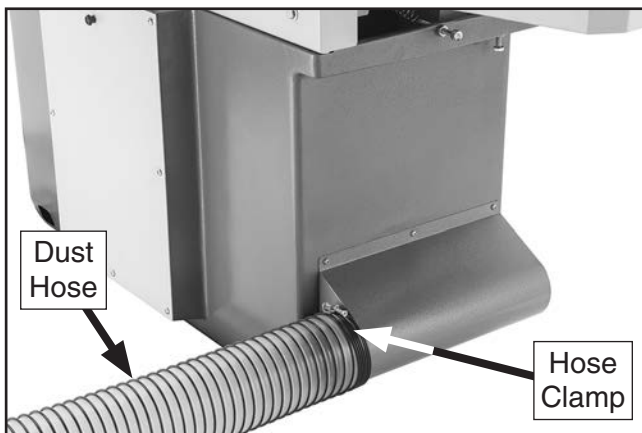


Figure 20. Dust hose attached to dust port.

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

Note: A tight fit is necessary for proper performance.

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 verifies that safety features stop the machine when needed, and that the machine operates properly prior to regular operation.

! 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. Push OFF button (see **Figure 21**).

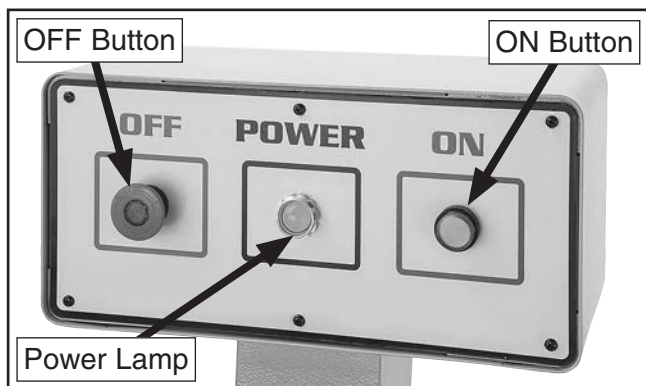


Figure 21. Control panel components.

3. Connect machine to power source. Power lamp will illuminate (see **Figure 21**).
4. Twist OFF button clockwise until it pops out (see **Figure 22**). This resets button so machine will start.

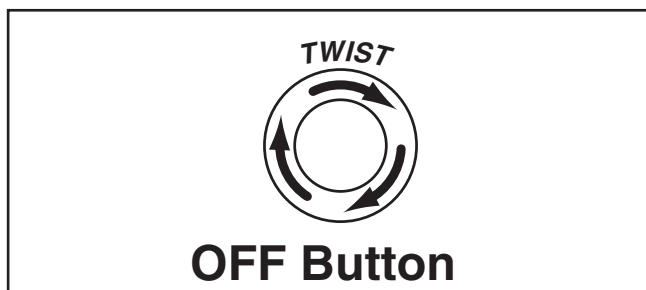


Figure 22. Resetting the OFF button.

5. Push ON button to turn machine **ON**. A correctly operating machine will run smoothly with little or no vibration or rubbing noises.
6. Press OFF button to turn machine **OFF**.
7. **WITHOUT** resetting OFF button, press ON button. Machine should not start.
 - If machine *does not* start, the OFF button safety feature is working correctly. Congratulations! The Test Run is complete.
 - If machine *does* start (with OFF button pushed in), immediately disconnect power to machine. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

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, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

Factory adjustments that should be verified:

- Outfeed Table Height (refer to **Page 37**).
- Depth Scale Calibration (refer to **Page 38**).
- Table Parallelism (refer to **Page 39**).
- Fence Stop Accuracy (refer to **Page 43**).

Tightening Belts

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belt will stretch and seat into the pulley grooves. After this time, you must re-tension the belt to avoid slippage and burn out. Refer to **Page 35** when you are ready to perform this important adjustment.

Note: *Pulleys and belt 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 a problem with the machine or belt.

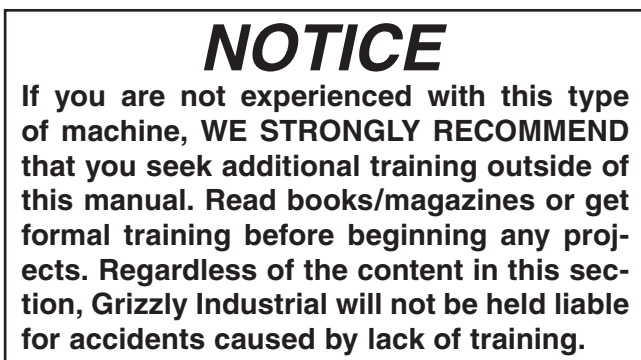
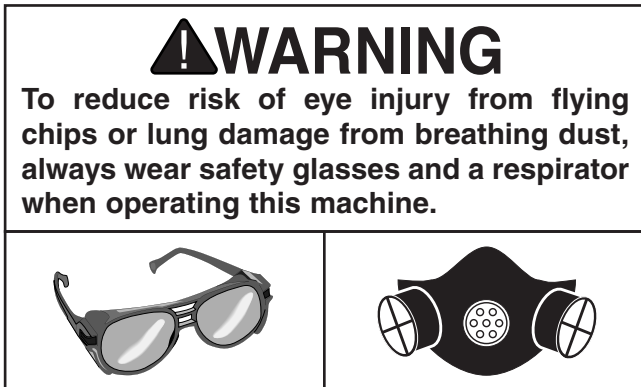


SECTION 4: OPERATIONS

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.



To complete a typical operation with the jointer, the operator does the following:

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



Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

- **DO NOT joint or surface plane stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.
- **DO NOT joint or surface plane against the grain direction.** Cutting against the grain increases the likelihood of kickback, as well as tear-out on the workpiece.
- **Jointing and surface planing with the grain produces a better finish and is safer for the operator.** Cutting with the grain is described as feeding the stock on the jointer so the grain points down and toward you as viewed on the edge of the stock (see **Figure** below).

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

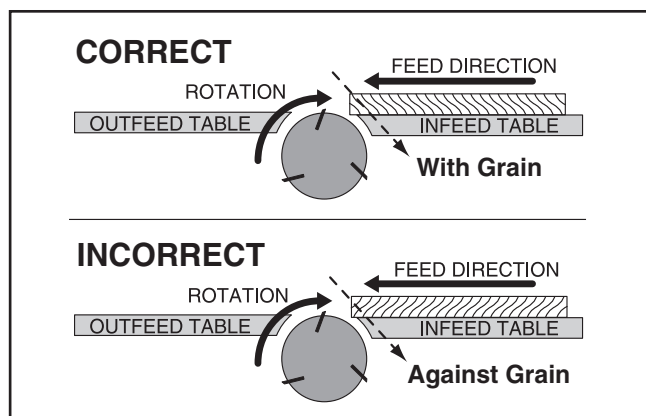


Figure 23. Proper grain alignment with the cutterhead.

- **Only process natural wood fiber through your jointer.** Your jointer is designed to cut only natural wood stock. This machine is NOT designed to cut metal, glass, stone, tile, products with lead-based paint, or products that contain asbestos—cutting these materials with a jointer may lead to injury.

- **Scrape all glue off the workpiece before jointing.** Glue deposits on the workpiece, hard or soft, will gum up the cutterhead and produce poor results.
- **Remove foreign objects from the workpiece.** Make sure that any stock you process with the jointer is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects that could damage the cutterhead. These particles could also cause a spark as they strike the cutterhead and create a fire hazard.

IMPORTANT: Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.

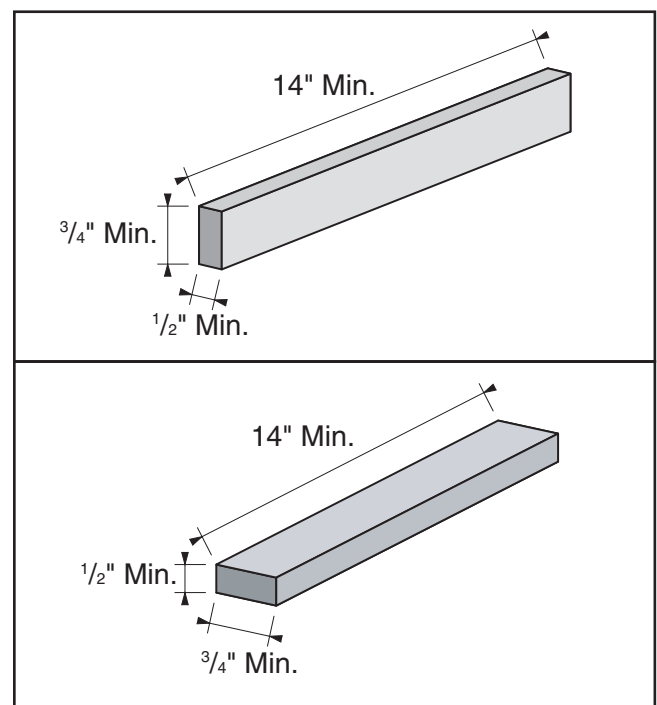


Figure 24. Minimum stock dimensions for jointer.



Squaring Stock

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

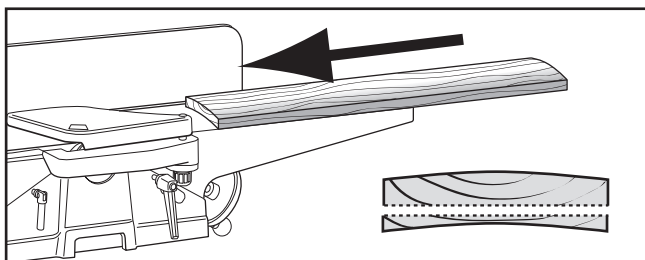
The purpose of squaring stock is to prepare it for accurate cuts and construction later on.

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.

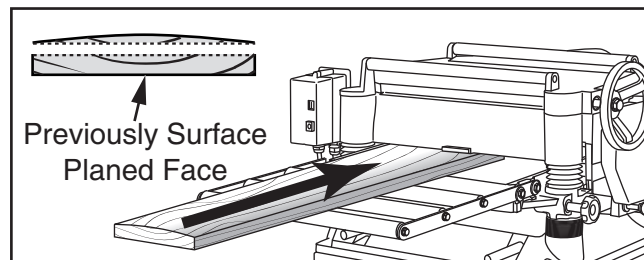
Items Needed	Qty
Jointer	1
Planer	1
Table Saw	1

Squaring stock involves four steps performed in the order below:

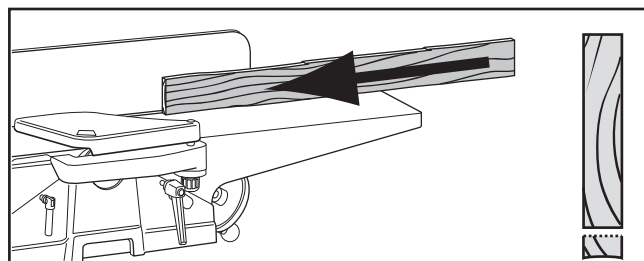
- 1. Surface Plane on Jointer**—Concave face of workpiece is surface planed flat with jointer.



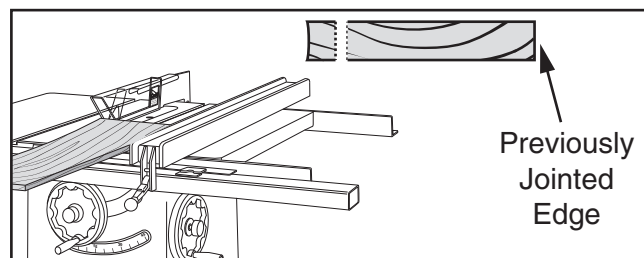
- 2. Surface Plane on a Thickness Planer**—Opposite face of workpiece is surface planed flat with a thickness planer.



- 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

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!

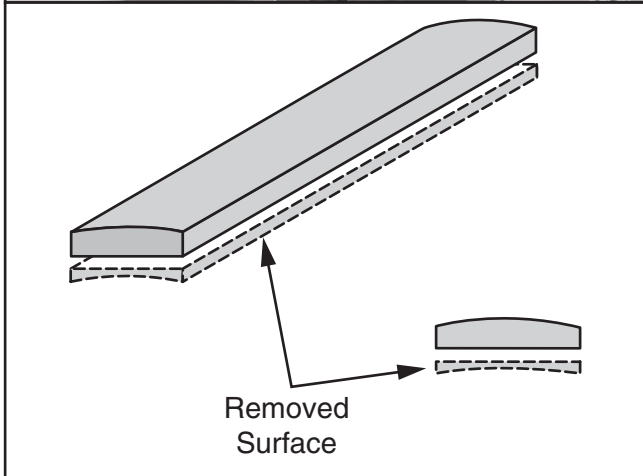


Figure 25. Example photo of a surface planing operation.

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 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.

IMPORTANT: To minimize risk of kickback, do not exceed a cutting depth of $\frac{1}{8}$ " per pass when surface planing.

3. Set fence to 90°.
4. Start jointer.
5. Place workpiece firmly against fence and infeed table.

IMPORTANT: 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.

IMPORTANT: 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.

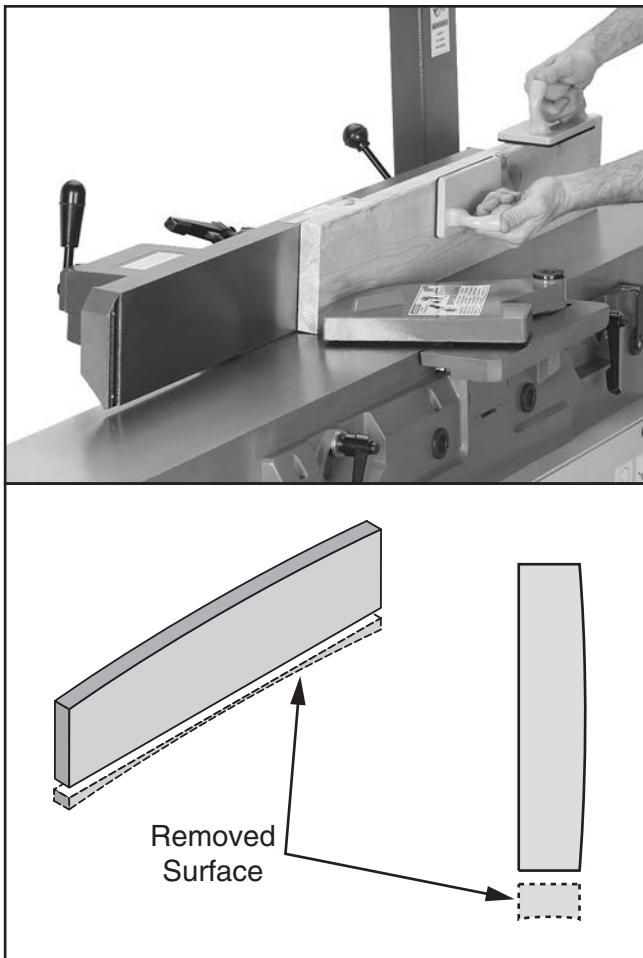


Figure 26. Example photo of an edge jointing operation.

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. 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.
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 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

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.

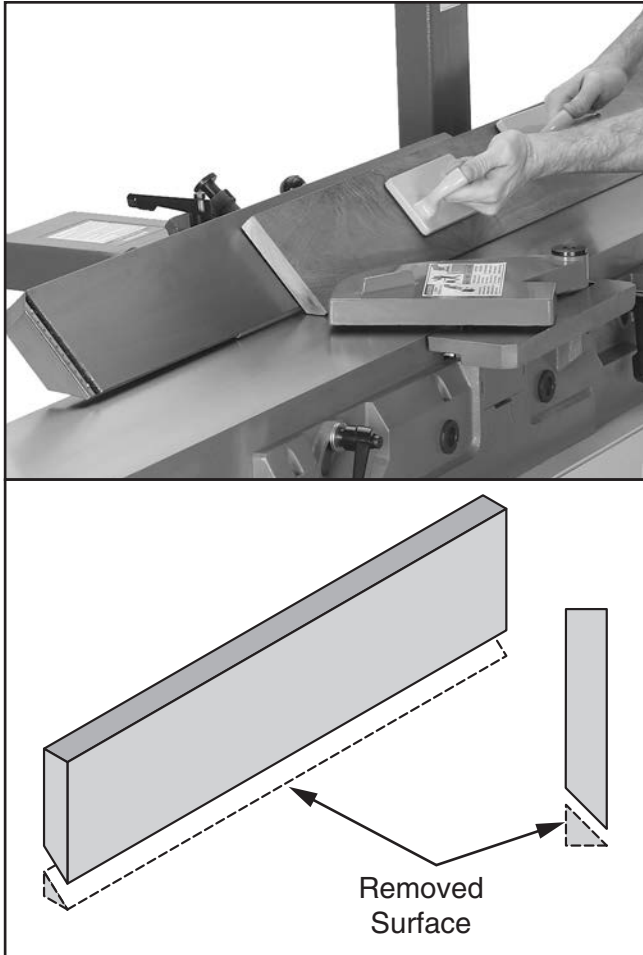


Figure 27. Example photo of fence set up for a bevel cut of 45°.

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. 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.
3. Set fence tilt to desired angle of cut.
4. Place workpiece against fence and infeed table with concave side face down.
5. Start jointer.
6. 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!

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



Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge (see example **Figures** below). When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

⚠ WARNING

When cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes operator to moving cutterhead. To minimize risk of injury and unnecessary exposure to cutterhead, always keep cutterhead guard installed when possible, and **ALWAYS** immediately replace it after performing rabbet cuts.

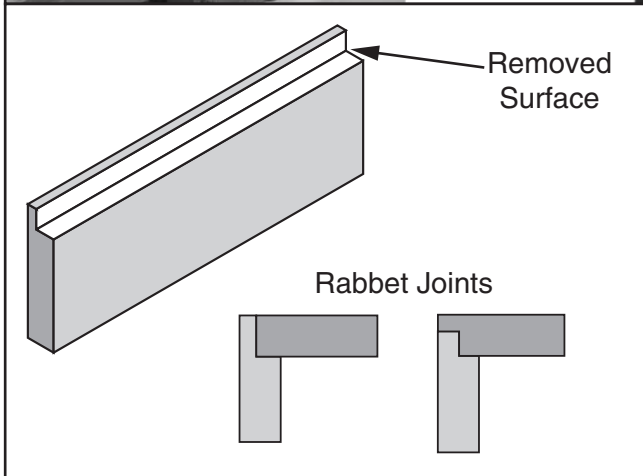
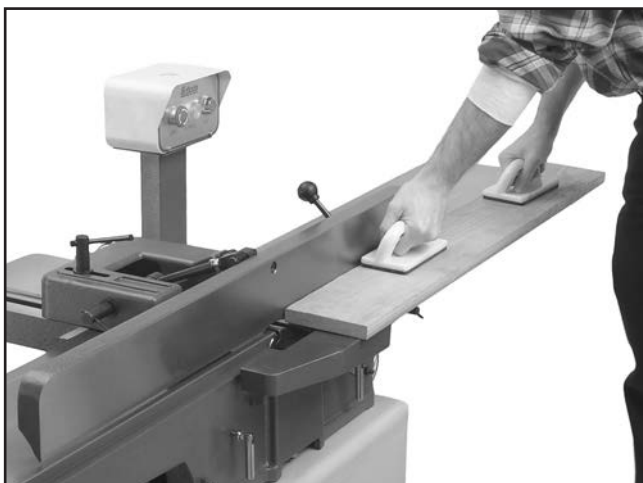


Figure 28. Example photo of typical rabbet cutting operation.

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 rabbet cut 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: For safety reasons, cutting depth should never exceed $\frac{1}{8}$ " per pass.
3. Remove cutterhead guard if necessary to perform operation (see **Figures** below.)
4. Set fence to 90° and near front of jointer, so amount of exposed cutterhead in front of fence matches size of desired rabbet.
5. Start jointer.
6. 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.
7. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during 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.



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.

H7354—Indexable Carbide Inserts, 10 Pk.

15 x 15 x 2.5mm replacement indexable carbide inserts.

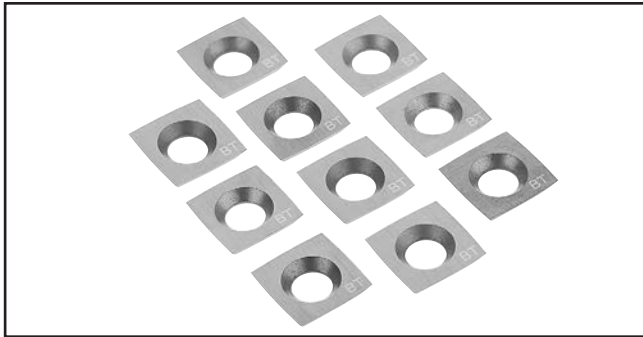


Figure 29. Shelix® replacement indexable carbide inserts.

H2993—4-Pc Machinist Square Set

2", 3", 4" & 6" finely ground stainless steel squares.

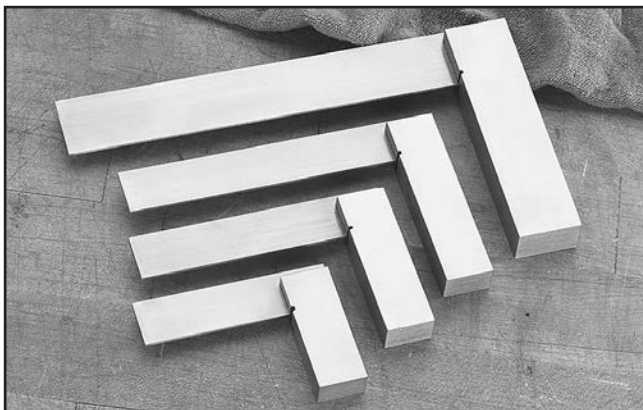


Figure 30. H2993 4-Pc. Square Set.

G0777—1.5 HP Ultra-Quiet Cyclone Dust Collector

Features a compact profile on a sturdy mobile frame, a pleated filter system, an internal filter-cleaning brush system, 880 CFM airflow, a built-in remote control switch, and a mobile 35-gallon collection drum.



Figure 31. G0777 Ultra-Quiet Cyclone Dust Collector.

D4218—Black Flexible Hose 5" x 10'

W1318—Wire Hose Clamp 5"

W1008—Plastic Blast Gate 5"

We've hand picked a selection of commonly used dust collection components for the Model G0834.

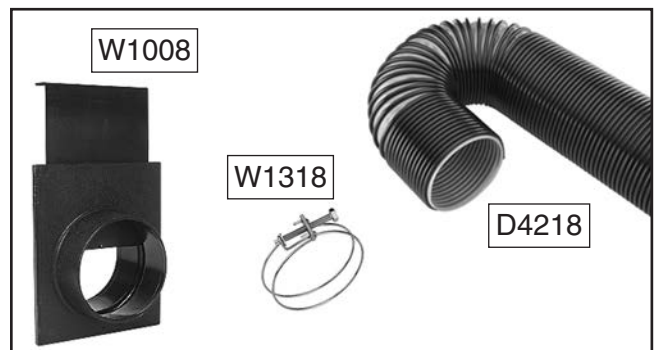


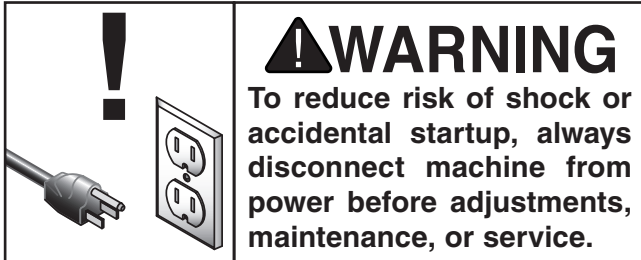
Figure 32. Recommended dust collection accessories.

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

- Loose mounting bolts.
- Dust or debris on and around machine.
- Dull or damaged cutterhead inserts.
- Unprotected cast-iron surfaces.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check

- V-belt tension, damage, or wear (**Page 35**).
- Clean/vacuum dust buildup from inside stand and off of motor.

Cleaning & Protecting

Cleaning the Model G0834 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 the unpainted cast-iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9.

Recommended Metal Protectants

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



Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more grease to them will not yield smooth moving components.

Clean the components below with mineral spirits or other oil/grease solvent cleaner and shop rags.

Fence & Carriage

Lube Type.. Model SB1365 or ISO 68 Equivalent
Lube Amount As Needed
Lubrication Frequency..... Daily

Place one or two drops of oil on the fence pivot points (see **Figure 35**) as needed. Before lubricating the fence carriage ways, clean them with mineral spirits. Apply a thin coat of oil along the length of the ways (see **Figure 36**). Move the fence back and forth to distribute the oil.

SB1365—South Bend Way Oil-ISO 68

Engineered for the high pressure exerted on horizontal or vertical ways and slides. Protects against rust and corrosion. Ensures stick-free, smooth motion which maximizes finishes and extends the life of your machine. Won't gum up!
12 oz. AMGA#2 (ISO 68 Equivalent)



Figure 34. SB1365 Way Oil.

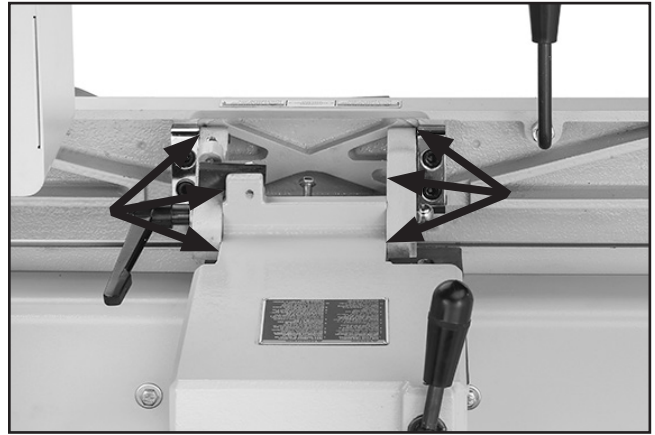


Figure 35. Fence lubrication locations.

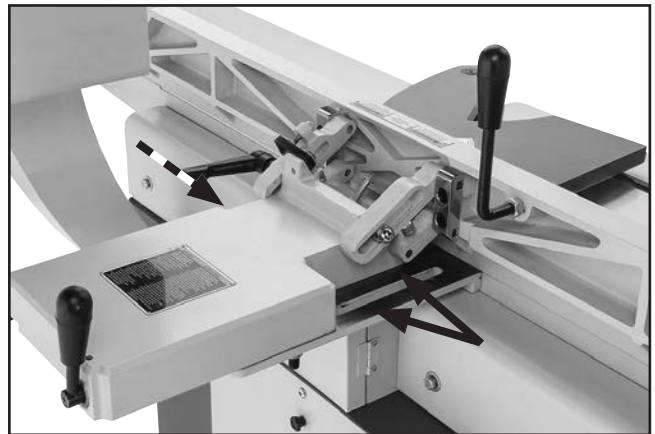


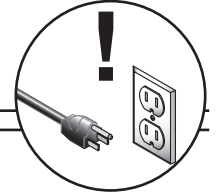
Figure 36. Fence carriage slide lubrication locations.



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
Machine does not start or power-supply fuse/breaker trips immediately after startup.	<ol style="list-style-type: none"> OFF button depressed/at fault. Incorrect power supply voltage or circuit size. Power supply circuit breaker tripped/fuse blown. Thermal overload relay has tripped. Motor wires connected incorrectly. Wiring open/has high resistance. ON button at fault. Start capacitor at fault. Contactors not energized/has poor contacts. Centrifugal switch at fault. Motor at fault. 	<ol style="list-style-type: none"> Rotate OFF button head to reset. Replace if at fault. Ensure correct power supply voltage and circuit size. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. Reset; adjust trip load dial if necessary; replace. Correct motor wiring connections. Check/fix broken, disconnected, or corroded wires. Replace ON button. Test/replace if at fault. Test all legs for power; replace. Adjust centrifugal switch/contact points; replace if necessary. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> Workpiece material not suitable. Feed rate too fast. Excessive depth of cut. Dull inserts. Belts slipping or pulleys misaligned. Dust collection blockage. Motor overheated Pulley slipping on shaft. Run capacitor at fault. Contactors not energized/has poor contacts. Motor bearings at fault. 	<ol style="list-style-type: none"> Ensure workpiece is suitable for jointing (Page 23). Reduce feed rate. Reduce depth of cut. Rotate/replace inserts (Page 34). Tension/replace belts (Page 35); ensure pulleys are aligned (Page 36). Clear blockages, seal leaks, use smooth wall duct, eliminate bends, close other branches. Clean motor, let cool, and reduce workload. Tighten/replace loose pulley/shaft (Page 36), replace shaft key; tighten pulley set screw. Test/repair/replace. Test all legs for power; replace. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> Motor or component loose. Belts worn or loose. Motor fan rubbing on fan cover. Pulley loose. Dull inserts. Machine incorrectly resting on floor. Cutterhead bearings at fault. 	<ol style="list-style-type: none"> Inspect/replace damaged bolts/nuts, and re-tighten with thread-locking fluid. Inspect/tension or replace belts (Page 35). Fix/replace fan cover; replace loose/damaged fan. Re-align/replace shaft, pulley, set screw, and key (Page 36). Relocate/shim machine. Rotate/replace inserts (Page 34). Relocate/shim machine. Replace bearings/re-align cutterhead.



Operations

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	<ol style="list-style-type: none"> 1. Table lock is engaged/partially engaged. 2. Table stop bolts blocking movement. 	<ol style="list-style-type: none"> 1. Completely loosen table locks (Page 4). 2. Loosen/reset table stop bolts (Page 5).
Excessive snipe (gouge in end of board that is uneven with rest of cut).	<ol style="list-style-type: none"> 1. Outfeed table is set too low. 2. Operator pushing down too much on trailing end (infeed side) of workpiece as it leaves cutterhead. 	<ol style="list-style-type: none"> 1. Align outfeed table with cutterhead inserts at top dead center (Page 37). 2. Focus pressure against outfeed table while cutting, but avoid excessive pressure against trailing end of workpiece.
Workpiece stops in middle of cut.	<ol style="list-style-type: none"> 1. Outfeed table set too high. 	<ol style="list-style-type: none"> 1. Align outfeed table with cutterhead inserts at top dead center (Page 37).
Workpiece chipping, tear-out, indentations, or overall rough cuts.	<ol style="list-style-type: none"> 1. Workpiece not suitable for jointing. 2. Operator not feeding workpiece to cut "with" the grain. 3. Feed rate too fast. 4. Excessive depth of cut. 5. Dull inserts. 6. Dust collection problems. 	<ol style="list-style-type: none"> 1. Ensure workpiece is suitable for jointing (Page 23). 2. Turn the workpiece 180° before feeding again. 3. Reduce feed rate. 4. Reduce depth of cut. 5. Rotate/replace inserts (Page 34). 6. Clear blockages, seal leaks, move machine closer to dust collector, upgrade dust collector.
Fuzzy grain left in workpiece.	<ol style="list-style-type: none"> 1. Wood has high moisture content. 2. Dull inserts. 	<ol style="list-style-type: none"> 1. Ensure wood moisture content is less than 20%. Allow to dry if necessary. 2. Rotate/replace inserts (Page 34).
Long lines or ridges that run along the length of the board.	<ol style="list-style-type: none"> 1. Nicked or chipped inserts. 2. Loose or incorrectly installed insert(s). 3. Dirt or debris under inserts. 	<ol style="list-style-type: none"> 1. Rotate/replace inserts (Page 34). 2. Remove/replace insert(s) and install properly (Page 34). 3. Remove inserts, properly clean mounting pocket and re-install (Page 34).
Uneven cutter marks, wavy surface, or chatter marks across face of workpiece.	<ol style="list-style-type: none"> 1. Excessive feed rate. 2. Inserts not consistently tightened/torqued. 3. Dirt or debris under inserts. 	<ol style="list-style-type: none"> 1. Reduce feed rate. 2. Tighten/torque all inserts consistently when securing (Page 34). 3. Remove inserts, properly clean mounting pocket and re-install (Page 34).
Glossy surface; scorching or burn marks on workpiece.	<ol style="list-style-type: none"> 1. Dull inserts. 2. Feed rate too slow. 	<ol style="list-style-type: none"> 1. Rotate/replace inserts (Page 34). 2. Increase feed rate.
Workpiece is concave or convex along its length after jointing.	<ol style="list-style-type: none"> 1. Workpiece not fed with even pressure against outfeed table during cut. 2. Tables are not parallel with cutterhead and each other. 3. Workpiece excessively bowed or warped, not suitable for jointing. 	<ol style="list-style-type: none"> 1. Apply even downward pressure against workpiece throughout entire travel along outfeed side during cut. 2. Check/adjust table parallelism (Page 39). 3. Ensure workpiece is suitable for jointing (Page 23).
Workpiece edges not square; tapered cut produced.	<ol style="list-style-type: none"> 1. Fence not square to table(s); fence tilt unlocked. 2. Warped infeed or outfeed table. 3. Inserts not consistently tightened/torqued. 	<ol style="list-style-type: none"> 1. Square fence to table(s) (Page 43); lock fence. 2. Regrind/replace table. 3. Tighten/torque all inserts consistently when securing (Page 34).



Rotating/Replacing Cutterhead Inserts

The spiral cutterhead is equipped with 4-sided indexable carbide inserts. Each insert can be removed, rotated, and re-installed to use any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° (as shown below) to use a sharp cutting edge.

The inserts have a reference dot on one corner. The position of the reference dot on installed inserts can be used to track which edges are sharp/unused and which edges are dull or damaged. Replace inserts once the reference dot has been rotated back to its original position.

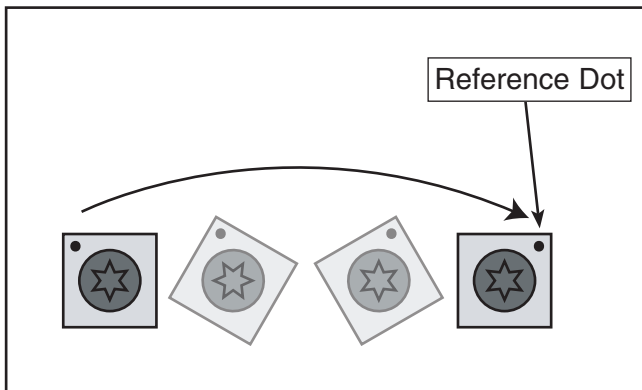


Figure 37. Insert rotating sequence.

Items Needed	Qty
Phillips Screwdriver #2	1
Torque Wrench	1
T-20 Torx Bit	1
Precision Straightedge	1

To rotate or replace spiral cutterhead insert:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard from table, and lower infeed table as far down as it will go.
3. Remove cover to get access to cutterhead pulley.
4. Taking care not to pinch your hand between belt and pulley, rotate pulley as needed to make inserts accessible for removal.

5. Put on heavy leather gloves to protect fingers and hands.
6. Carefully clean away all sawdust or debris from top of insert, Torx screw, and surrounding area **Figure 38**).

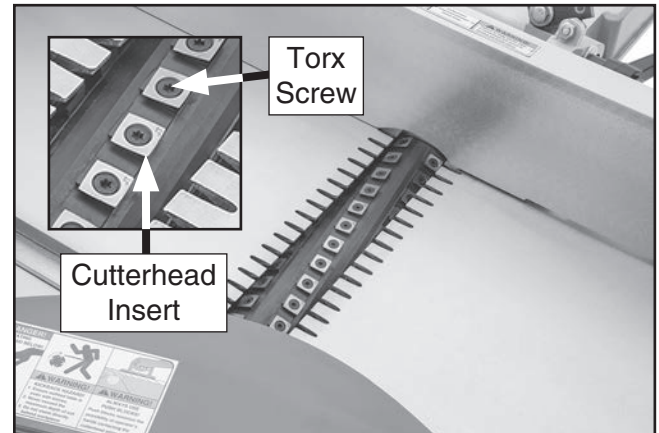


Figure 38. Location of cutterhead inserts and Torx screws.

7. Remove Torx screw and insert, then carefully clean away all dust and debris from insert and insert pocket in cutterhead.

IMPORTANT: This step is critical for achieving a smooth finish with cutting operations. Dirt or dust trapped under insert during installation will slightly raise insert in cutterhead, which will leave marks on workpiece after jointing.

Tip: Use low-pressure compressed air or a vacuum nozzle to clean cutterhead pocket.

8. Re-install insert with a sharp cutting edge facing outward. Make sure insert is properly seated in cutterhead pocket before securing.

—If all four insert cutting edges have been used, replace insert with a new one. Always position reference dot in same position when installing a new insert to aid in rotational sequencing.

9. Lubricate Torx screw threads with a small amount of light machine oil, wipe excess off, and torque screw to 48–50 inch/pounds.

IMPORTANT: If too much oil is applied to the threads, excess will attempt to squeeze out of threaded hole as you install insert and force it



Tensioning/ Replacing V-Belts

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

NOTICE

After approximately 16 hours of operation, V-belts will stretch and seat into pulley grooves. The V-belts need to be re-tensioned after this initial break-in period to ensure optimum power transfer and maximum overall life of the V-belts.

If the V-belts are worn, cracked, or damaged, replace them. Always replace the V-belts with a matched set, or belt tension may not be even among both belts, resulting in sub-optimal power transfer and premature belt failure.

Tensioning V-Belts

Items Needed	Qty
Hex Wrench 5mm.....	1
Wrench or Socket 19mm.....	1

CAUTION

V-belts and pulleys will be hot after operation. Allow them to cool before handling.

1. DISCONNECT MACHINE FROM POWER!
2. Remove rear access panel and open cutterhead pulley cover (see **Figure 39**).



Figure 39. Location of rear access panel.

3. Check belt tension: Each belt is correctly tensioned when there is approximately 1/4" deflection when it is pushed with moderate pressure, as shown in **Figure 40**.

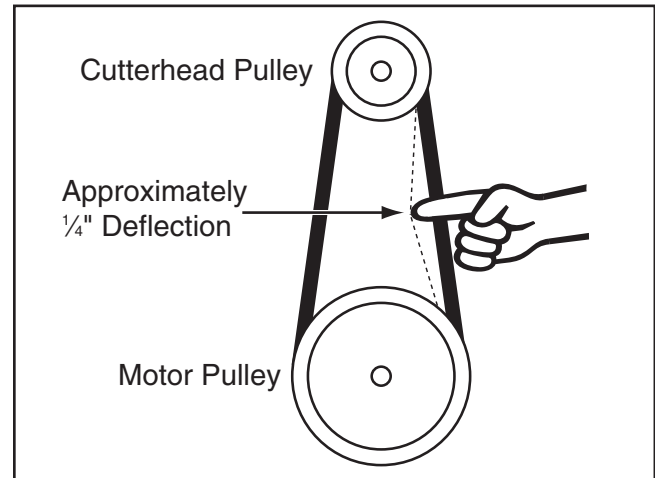


Figure 40. Correct belt deflection when properly tensioned.

- If there *is* approximately 1/4" deflection when V-belts are pushed with moderate pressure, V-belts are properly tensioned and no adjustment is necessary. Proceed to **Step 6**.
- If there is *not* approximately 1/4" deflection when V-belts are pushed with moderate pressure, V-belts are not properly tensioned. Proceed to **Step 4**.

4. Loosen hex nuts on motor tension rods (see **Figure 41**).

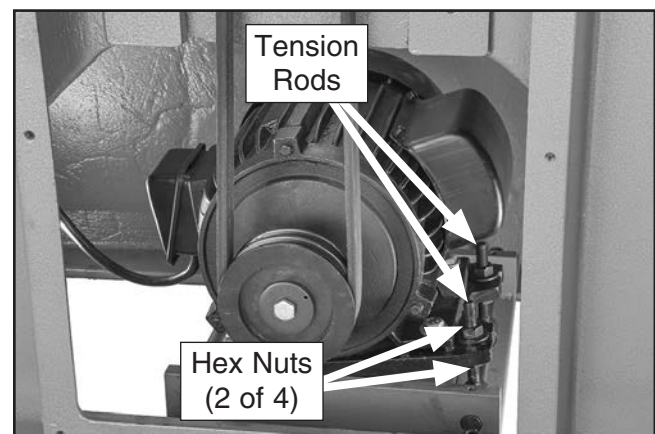


Figure 41. Location of motor tension rods and hex nuts.



5. Press down on motor until there is proper tension on V-belts. While holding motor down, tighten hex nuts on tension rods (see **Figure 41** on **Page 35**).
6. Replace rear access panel and close cutterhead pulley cover.

Replacing V-Belts

Items Needed	Qty
New V-Belts.....	2
Hex Wrench 5mm.....	1
Wrench or Socket 19mm.....	1

! CAUTION

V-belts and pulleys will be hot after operation. Allow them to cool before handling.

1. DISCONNECT MACHINE FROM POWER!
2. Remove rear access panel and open cutterhead pulley cover.
3. Loosen hex nuts on motor tension rods (see **Figure 41** on **Page 35**).
4. Have another person lift motor as you remove belts and replace them with new ones. It may help to use a 2x4 as a lever to raise motor. Make sure ribs of belt are seated in pulley grooves.
5. Press down on motor until there is proper tension on V-belts. While holding motor down, tighten hex nuts on tension rods (see **Figure 41** on **Page 35**).
6. Check belt tension (refer to **Step 3** of **Tensioning V-Belts** on **Page 35** for instructions).
7. Replace rear access motor cover and close cutterhead pulley cover.

Checking/Adjusting Pulley Alignment

Proper pulley alignment is important for optimum power transfer and belt life. Pulley alignment is adjusted by slightly repositioning the motor on the motor mounting plate.

Items Needed	Qty
Hex Wrench 5mm.....	1
Wrench or Socket 19mm.....	1

To check and align pulleys:

1. DISCONNECT MACHINE FROM POWER!
2. Remove rear access panel and open pulley cover.
3. Visually check alignment of both pulleys to make sure they are aligned and V-belts are straight up and down, as shown in **Figure 42**.

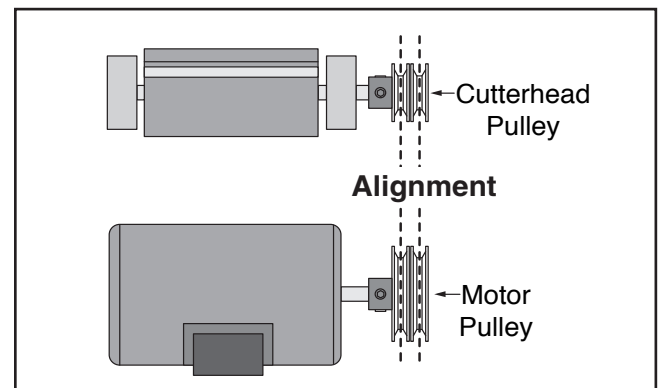


Figure 42. Pulleys aligned.

- If pulleys *are* aligned, no adjustment is necessary.
- If pulleys *are not* aligned, proceed to **Step 4**.



- Loosen hex nuts on motor tension rods (see **Figure 43**).

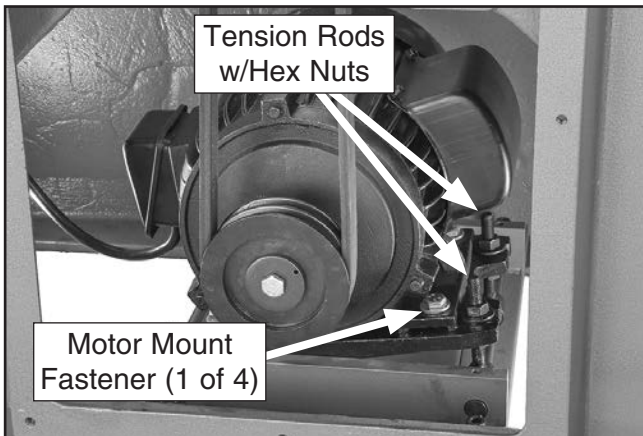


Figure 43. Location of motor tension rods, hex nuts, and motor mount fasteners.

- Loosen motor mount fasteners (see **Figure 43**).
- Position motor as needed to align motor pulley with cutterhead pulley.
- Tighten motor mount fasteners. V-belts should be parallel and aligned, as illustrated in **Figure 42** on **Page 36**.
- Press down on motor until there is proper tension on V-belts. While holding motor down, tighten hex nuts on tension rods (see **Figure 43**).
- Check belt tension (refer to **Step 3** of **Tensioning V-Belts** on **Page 35** for instructions).
- Replace rear access motor cover and close cutterhead pulley cover.

Setting Outfeed Table Height

The outfeed table height must be even with the top of the cutterhead knives when they are positioned at top dead center. If the outfeed table is set too low, there will be snipe. 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.

Items Needed	Qty
Open-End Wrench 17mm	1
Precision Straightedge	1

To set outfeed table height:

- DISCONNECT MACHINE FROM POWER!
- Remove cutterhead guard and fence assembly.
- Loosen outfeed table lock and positive stop bolt jam nut (see **Figure 44**).

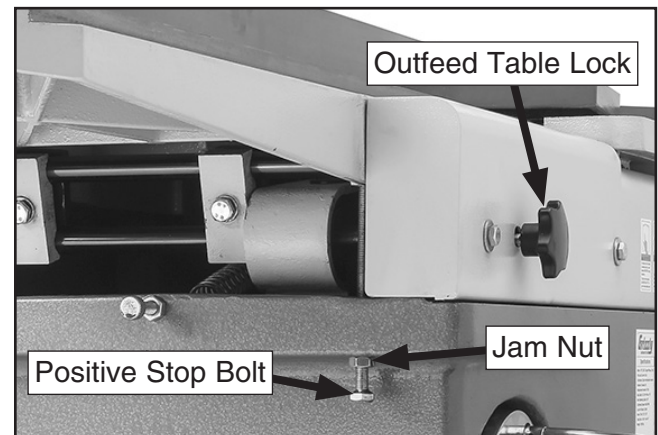


Figure 44. Location of outfeed table lock, positive stop bolt, and jam nut.



- Open cutterhead pulley cover and rotate cutterhead pulley until one cutterhead insert is at top dead center (its highest point during rotation), as shown in **Figure 45**.

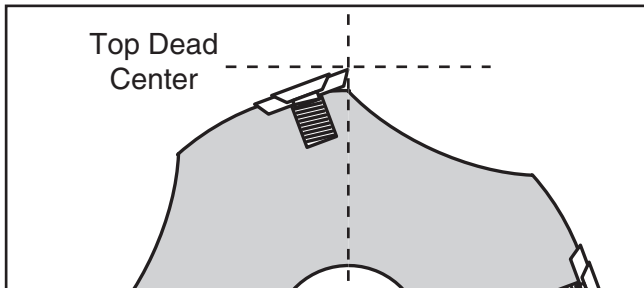


Figure 45. Cutterhead insert at top dead center.

- Place straightedge over center of outfeed table so it hangs over cutterhead.

When correctly set, cutterhead insert will barely touch straightedge when cutterhead is rotated back and forth with pulley, as shown in **Figure 46**.

— If your outfeed table is correctly set, no adjustments are necessary.

— If cutterhead insert lifts straightedge off the table or it is below straightedge, then outfeed table height must be reset.

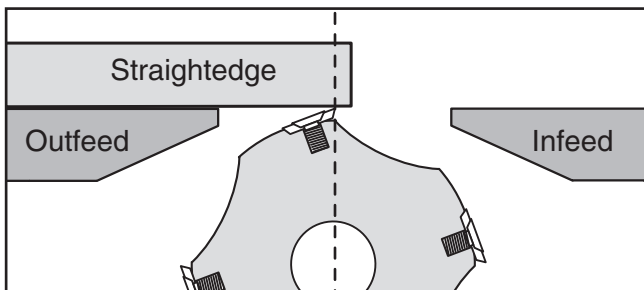


Figure 46. Using straightedge to check outfeed table height.

- Use outfeed table adjustment handwheel to set outfeed table height so cutterhead insert barely touches straightedge, as shown in **Figure 46**.
- Tighten outfeed table lock, and tighten outfeed positive stop bolt and jam nut so outfeed table will not move during operation.
- Re-install cutterhead guard and fence assembly, and close cutterhead pulley cover.

Calibrating Depth-of-Cut Scale

The depth scale can be calibrated or "zeroed" to make sure the cutting depth shown on the scale matches the actual cutting depth (per pass).

Items Needed	Qty
Phillips Screwdriver #2	1
Precision Straightedge	1

To calibrate depth-of-cut scale:

- DISCONNECT MACHINE FROM POWER!
- Perform **Setting Outfeed Table Height** on **Page 37**.
- Place a straightedge across infeed and outfeed tables.
- Adjust infeed table until even with outfeed table, as shown in **Figure 47**.

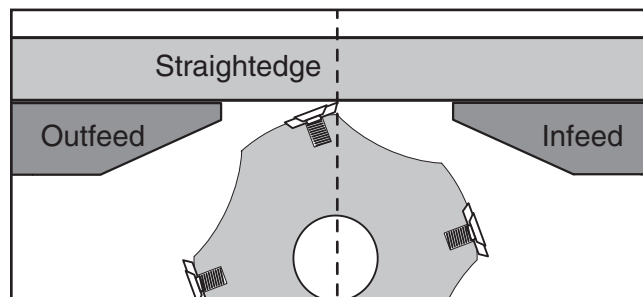


Figure 47. Infeed table even with outfeed table.

- Precisely adjust scale pointer to "0", as shown in **Figure 48**.

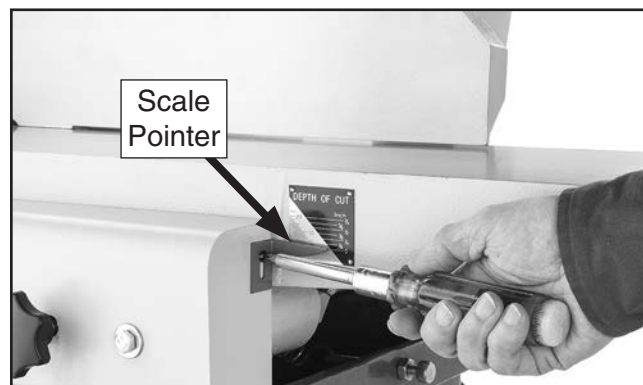


Figure 48. Adjusting scale pointer to "0".



Checking/Adjusting Table Parallelism

If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback can occur.

Items Needed	Qty
Additional Person	1
Adjustable Spanner Wrench.....	1
Small Hammer.....	1
Center Punch.....	1
Wrench or Socket 14mm	1
Hex Wrench 5mm.....	1
Hex Wrench 4mm.....	1
Precision Straightedge	1

Checking Outfeed Table

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard, and with help from an additional person, remove fence assembly.
3. Loosen outfeed table lock and positive stop bolt jam nut (see **Figure 49**).

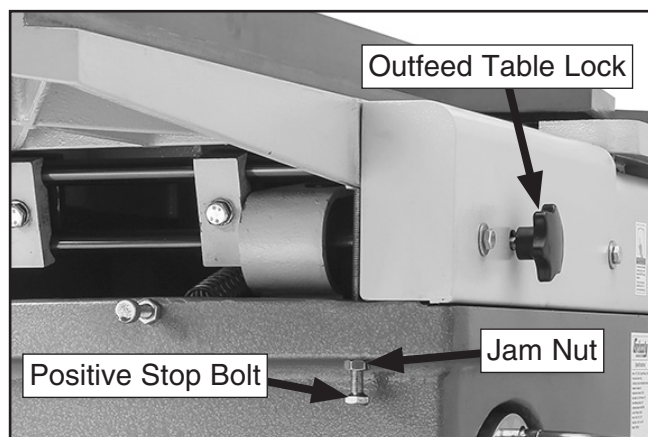


Figure 49. Location of outfeed table lock, positive stop bolt, and jam nut.

4. Place straightedge on outfeed table so it hangs over cutterhead, rotate motor pulley so straightedge is between inserts, then lower outfeed table until straightedge just touches cutterhead body, as shown in **Figure 50**.

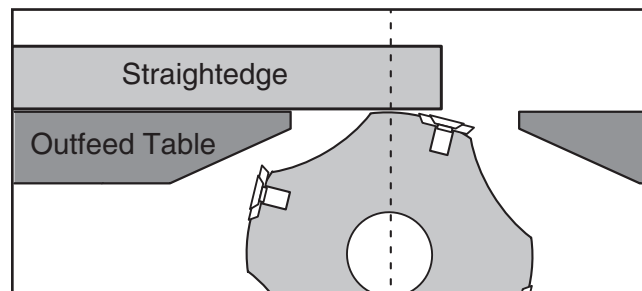


Figure 50. Adjusting outfeed table even with cutterhead body.

5. Place straightedge in positions shown in **Figure 51**. In each position, straightedge should touch cutterhead and sit flat on outfeed table.

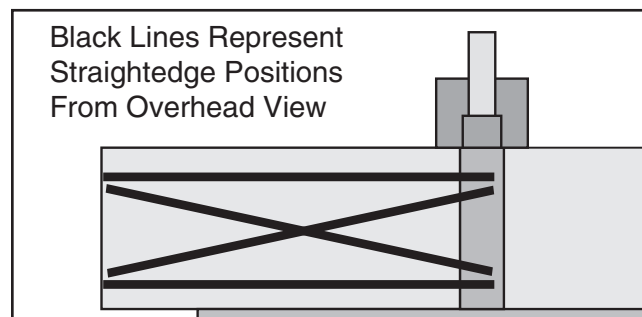


Figure 51. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

- If straightedge touches cutterhead body and sits flat across outfeed table in each position, then outfeed table is already parallel with cutterhead. Perform **Checking Infeed Table** on **Page 40**.
- If straightedge *does not* touch cutterhead and sit flat on outfeed table in any of the positions, then outfeed table is *not* parallel with cutterhead. Perform **Adjusting Table Parallelism** on **Page 40**.



Checking Infeed Table

1. DISCONNECT MACHINE FROM POWER!
2. Complete all steps in **Checking Outfeed Table** on **Page 39**.
3. Perform **Setting Outfeed Table Height** on **Page 37**.
4. Rotate cutterhead so inserts will not interfere, then place straightedge across infeed and outfeed tables, and adjust infeed table so it is even with the outfeed table, as shown in **Figure 52**.

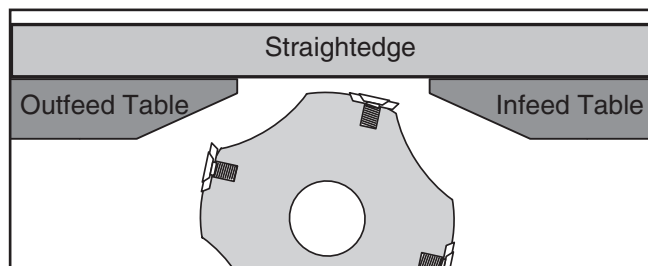


Figure 52. Infeed and outfeed tables set evenly.

5. Place straightedge in positions shown in **Figure 53**. In each position, straightedge should sit flat against both outfeed table and infeed table.

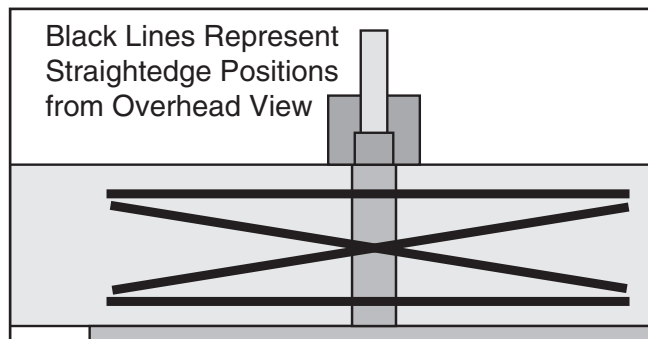


Figure 53. Straightedge positions for checking infeed/outfeed table parallelism.

— If straightedge sits flat against infeed and outfeed tables, then tables are parallel. Replace cutterhead guard and fence assembly, and close cutterhead pulley cover.

— If straightedge *does not* sit flat against infeed and outfeed tables in any of the positions, perform **Adjusting Table Parallelism** on this page.

Adjusting Table Parallelism

For safe and proper cutting results, tables must be parallel to cutterhead. Adjusting them to be parallel is a task of precision and patience, and may take up to one hour to complete. Luckily, this is considered a permanent adjustment and should not need to be repeated for the life of the machine.

Due to the complex nature of this task, we recommend that you double check the current table positions to make sure that they really need to be adjusted before starting.

Each table has four eccentric bushings that sit on top of the base and underneath the table that allow the table to be adjusted parallel. These eccentric bushings are locked in place by shaft collars with set screws and adjust when these shaft collars are removed.

The correct order for adjusting the table parallelism is to first adjust the outfeed table parallel with the cutterhead, then adjust the infeed table parallel with the outfeed table.

When setting the outfeed table, all measurements **MUST** be made from the cutterhead body—not the inserts or the results may be skewed.

IMPORTANT: *The following steps are intended to be performed directly after the steps involved in checking outfeed and infeed table parallelism. DO NOT continue until you have performed those steps.*

To adjust table parallelism:

1. DISCONNECT MACHINE FROM POWER!
2. Complete all steps in **Checking Outfeed Table** on **Page 39** and **Checking Infeed Table** on **This Page**.
3. Remove cutterhead guard lock and table locks. (Cutterhead guard and fence assembly should already be removed.)



- Remove front and rear table covers to expose eccentric bushings, as shown in **Figures 54–55**.

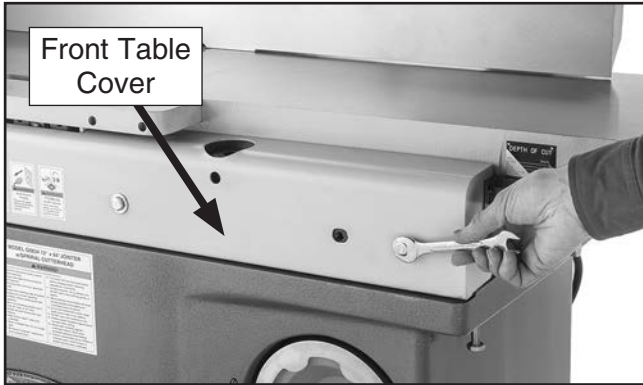


Figure 54. Removing front table cover.

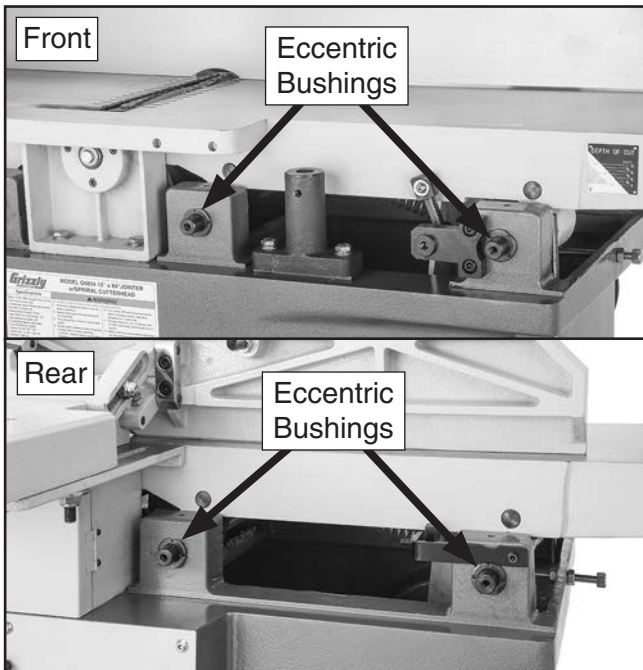


Figure 55. Locations of front and rear eccentric bushings.

- Loosen set screw on each eccentric bushing (see **Figure 56**).

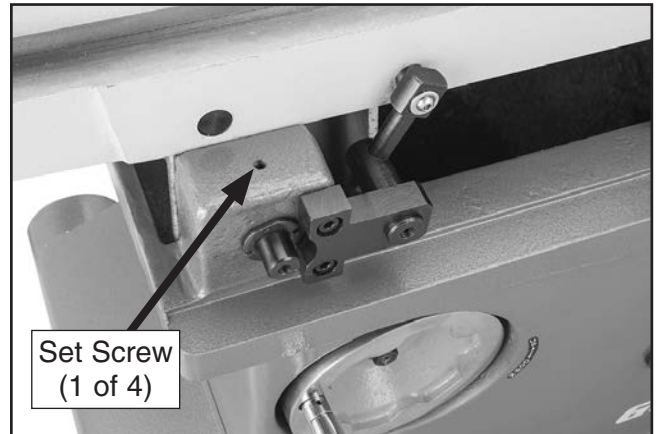


Figure 56. Location of eccentric bushing set screw.

- Place straightedge on outfeed table so it hangs over cutterhead, rotate motor pulley so straightedge is between inserts, then lower outfeed table until straightedge just touches cutterhead body, as shown in **Figure 57**.

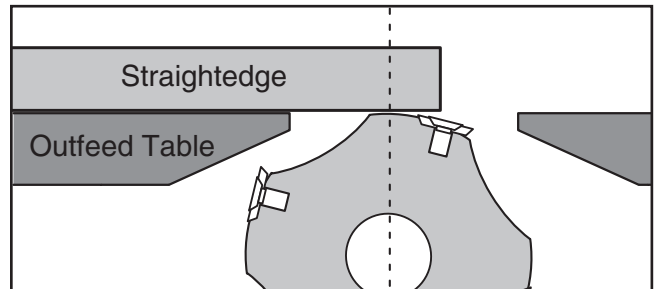


Figure 57. Adjusting outfeed table even with cutterhead body.



- Place straightedge in each position shown in **Figure 58**, and adjust eccentric bushings under outfeed table so straightedge touches cutterhead body while lying flat across outfeed table.

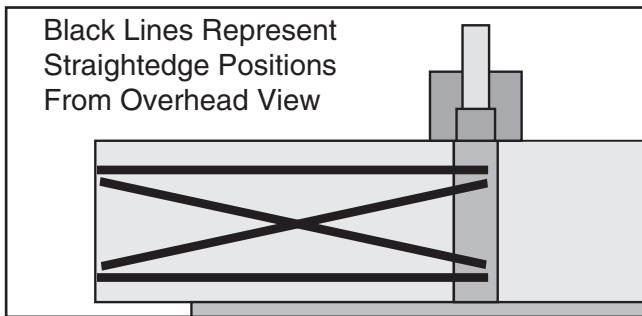


Figure 58. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

- Repeat **Step 7** as many times as necessary until outfeed table is parallel with cutterhead.
- Tighten set screws on each eccentric bushing on outfeed table.
- Place straightedge halfway across infeed and outfeed table, and adjust infeed table even with outfeed table, as shown in **Figure 59**.

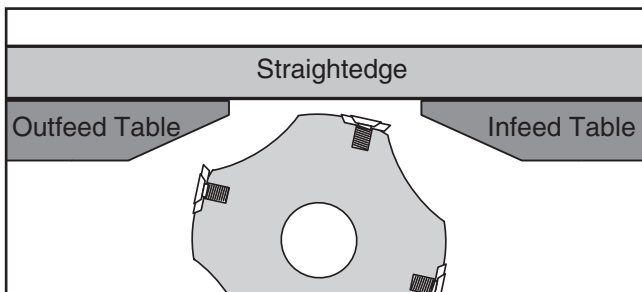


Figure 59. Infeed and outfeed tables set evenly.

- Place straightedge in each position shown in **Figure 60**, and adjust eccentric bushings under infeed table so straightedge lies flat against both tables.

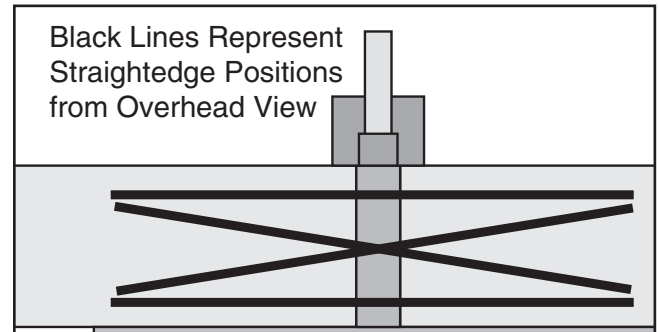


Figure 60. Straightedge positions for checking infeed/outfeed table parallelism.

- Repeat **Step 10** as many times as necessary until infeed table is parallel with outfeed table.
- Tighten set screws on each eccentric bushing on infeed table.
- Re-install front and rear table covers, table locks, and cutterhead lock, and close cutterhead pulley cover.
- Perform **Setting Outfeed Table Height** on **Page 37**.



Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45° inward, 90°, and 45° outward (135°).

Items Needed	Qty
Open-End Wrench 14mm.....	1
90° Square	1
Sliding Bevel.....	1

Setting 45° Inward

1. DISCONNECT MACHINE FROM POWER!
2. Loosen fence tilt lock, rotate stop block upward, and position fence approximately 45° inward onto positive stop bolt (see **Figure 61**).

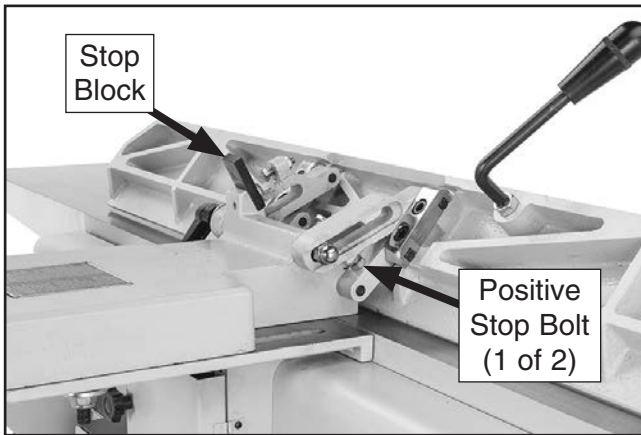


Figure 61. Fence set to 45° inward.

3. Place sliding bevel set to 45° inward against fence and table, as shown in **Figure 62**.



Figure 62. Adjusting fence to 45° inward.

4. Loosen jam nut on 45° inward positive stop bolt and adjust stop bolt until fence is exactly 45° inward while resting on bolt .
5. Verify angle with sliding bevel set to 45° inward, as shown in **Figure 62**, then retighten jam nut.

Setting 45° Inward

1. DISCONNECT MACHINE FROM POWER!
2. Loosen fence tilt lock, rotate stop block down, and position fence approximately 90° onto positive stop bolt (see **Figure 63**).

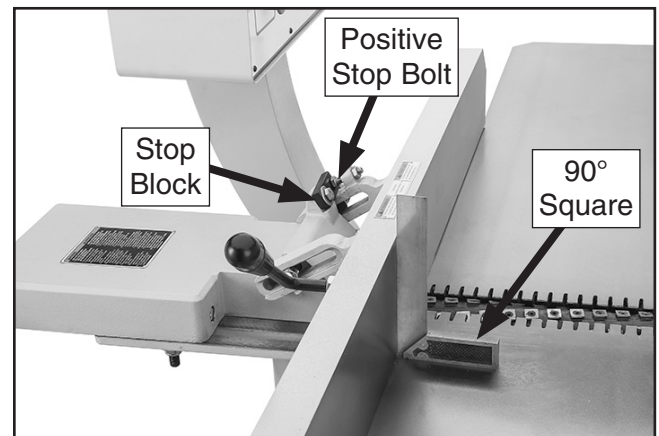


Figure 63. Adjusting fence to 90°.

3. Place 90° square against fence and table.
4. Loosen jam nut on 90° positive stop bolt and adjust stop bolt until fence is exactly 90° while resting on bolt.
5. Verify angle with 90° square, as shown in **Figure 63**, then retighten jam nut.



Setting 45° Outward (135°)

1. DISCONNECT MACHINE FROM POWER!
2. Loosen fence tilt lock, rotate stop block up, and position fence approximately 45° outward (135°) onto positive stop bolt (see **Figure 64**).

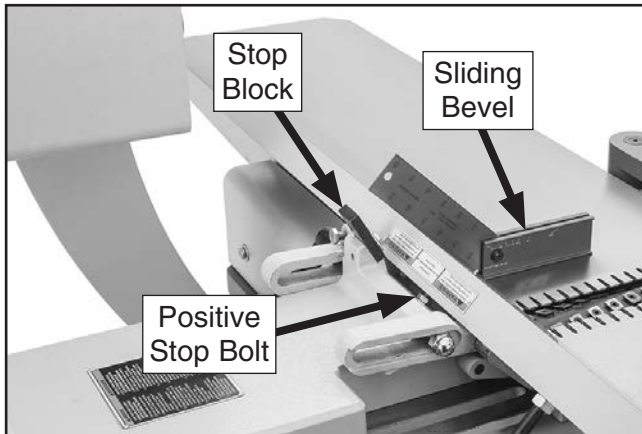


Figure 64. Adjusting fence 45° outward (135°).

3. Place sliding bevel set to 45° outward (135°) against fence and table.
4. Loosen jam nut on 45° outward (135°) positive stop bolt and adjust stop bolt until fence is exactly 45° outward (135°) while resting on bolt.
5. Verify angle with sliding bevel set to 45° outward (135°), as shown in **Figure 64**, then retighten jam nut.

Adjusting Cutterhead Guard Tension

⚠️ WARNING

The cutterhead guard is a critical safety feature of this jointer. You **MUST** install and verify its operation before using the jointer! Failure to properly install this guard will greatly increase the risk of serious personal injury.

To adjust cutterhead guard tension:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen lock knob (see **Figure 65**) that secures cutterhead guard shaft.

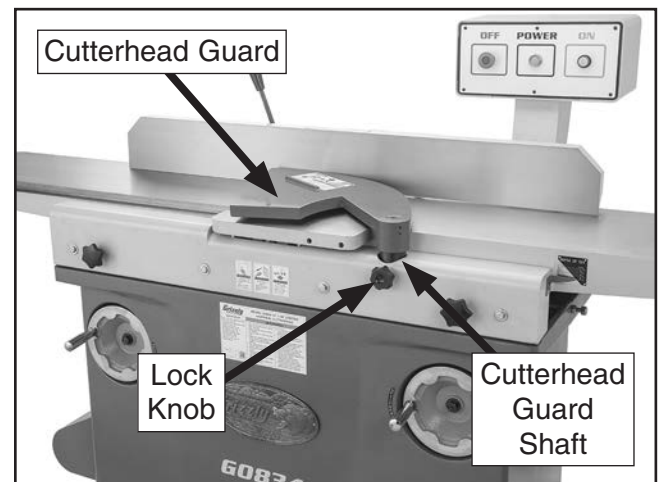


Figure 65. Cutterhead guard lock knob location.

3. Make sure fence is out of way, then pull cutterhead guard back and let it go. It should spring back over cutterhead.
 - If cutterhead guard does not return swiftly toward fence, loosen lock knob, lift guard so shaft clears hole, rotate guard clockwise, then re-install it and lock it in place.
4. Re-test and, if necessary, repeat **Step 3** until cutterhead guard has correct tension.



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. 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.

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 	



Electrical Components

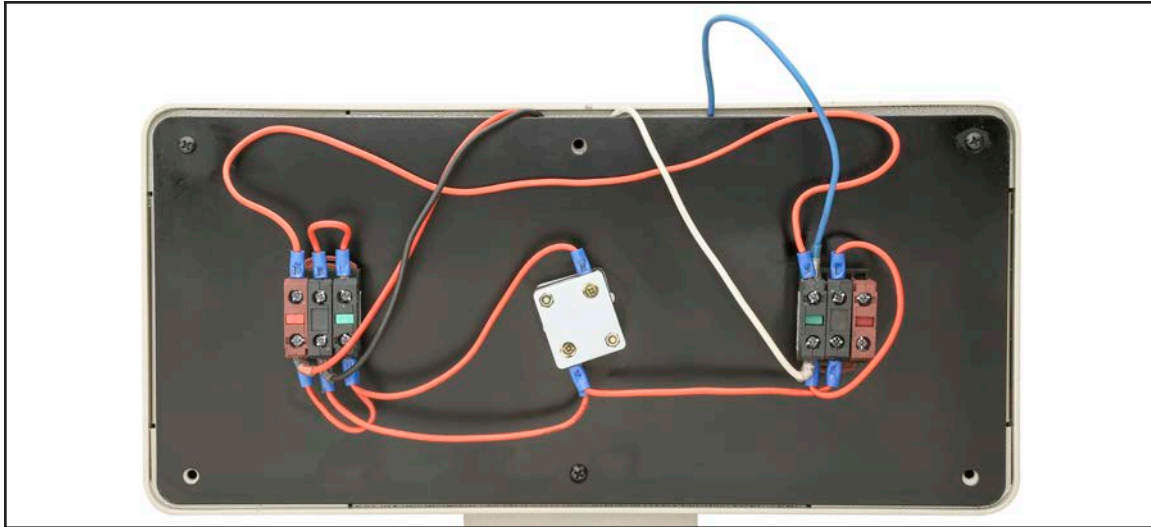


Figure 66. Control panel.



Figure 67. Magnetic Switch (behind control panel).



Figure 68. Motor junction box.

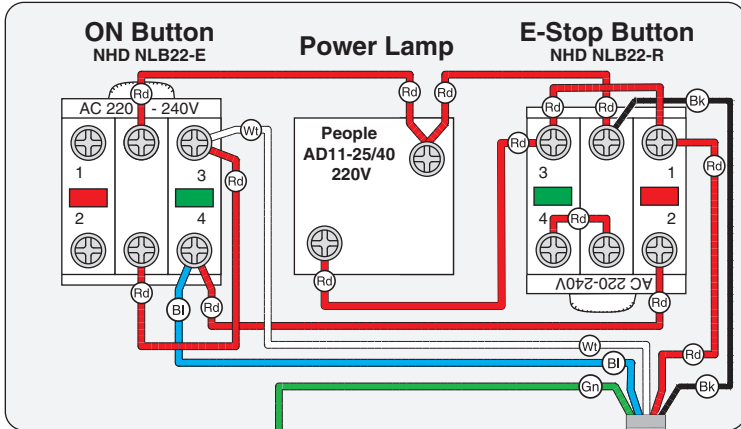


Figure 69. Capacitors.

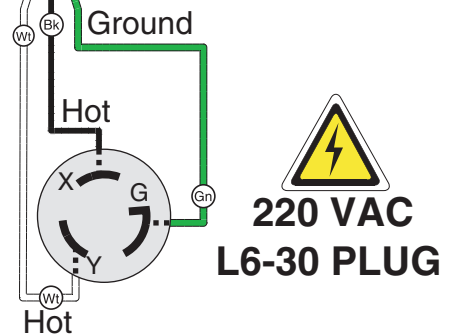
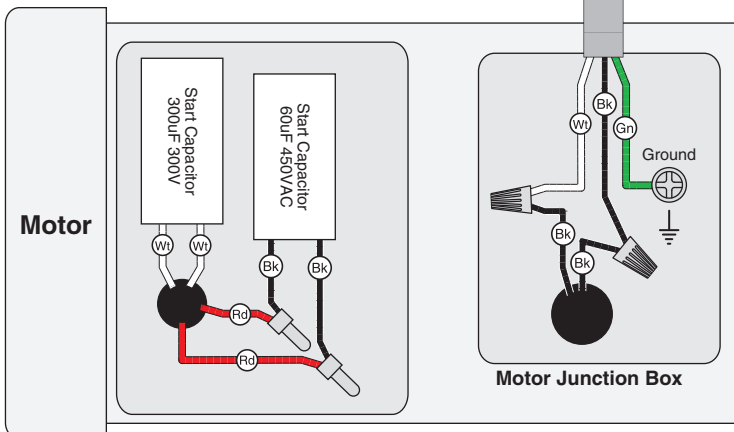
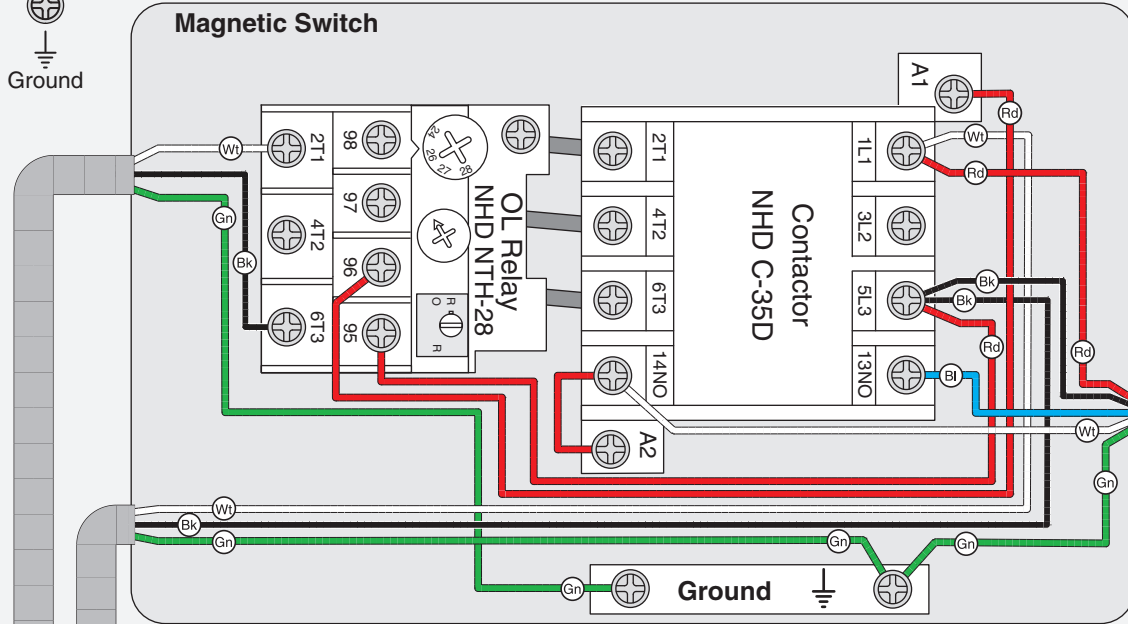


Wiring Diagram

Control Panel
(viewed from behind)

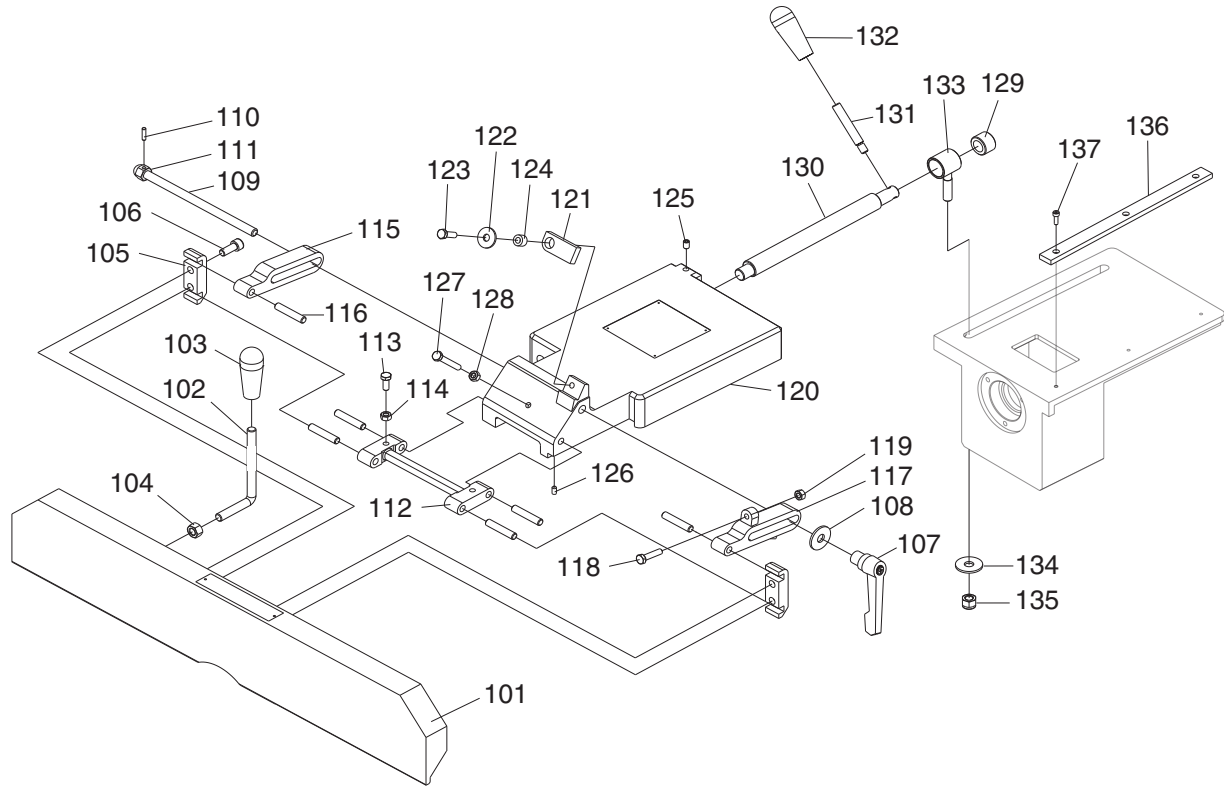


Electrical Pedestal
(viewed from behind)



SECTION 9: PARTS

Fence



REF PART # DESCRIPTION

101	P0834101	FENCE
102	P0834102	ANGLE STUD 32MM X 82MM
103	P0834103	TAPERED HANDLE M12-1.75
104	P0834104	HEX NUT M12-1.75
105	P0834105	CLAMP
106	P0834106	CAP SCREW M10-1.5 X 25
107	P0834107	ADJUSTABLE HANDLE 110L, M10-1.5
108	P0834108	FLAT WASHER 35MM
109	P0834109	STUD-DE M12 X 1.75
110	P0834110	ROLL PIN 5 X 20
111	P0834111	HEX NUT M12-1.75
112	P0834112	SUPPORT BRACKET
113	P0834113	HEX BOLT M8-1.25 X 20
114	P0834114	HEX NUT M8-1.25
115	P0834115	BRACKET (LEFT)
116	P0834116	ROLL PIN 10 X 52
117	P0834117	BRACKET (RIGHT)
118	P0834118	HEX BOLT M8-1.25 X 35
119	P0834119	HEX NUT M8-1.25

REF PART # DESCRIPTION

120	P0834120	FENCE CARRIAGE
121	P0834121	STOP BLOCK
122	P0834122	FLAT WASHER 8MM
123	P0834123	HEX BOLT M8-1.25 X 25
124	P0834124	BUSHING 8.5MM X 12MM
125	P0834125	SET SCREW M8-1.25 X 12
126	P0834126	SET SCREW M6-1 X 12
127	P0834127	HEX BOLT M8-1.25 X 55
128	P0834128	HEX NUT M8-1.25
129	P0834129	COLLAR
130	P0834130	ECCENTRIC SHAFT
131	P0834131	STUD-UDE M12-1.75 X 20, M10-1.5 X 15, 80L
132	P0834132	TAPERED HANDLE M12-1.75
133	P0834133	SLIDING BUSHING
134	P0834134	FLAT WASHER 12MM
135	P0834135	LOCK NUT M12-1.75
136	P0834136	FENCE KEY
137	P0834137	CAP SCREW M5-.8 X 14



Table

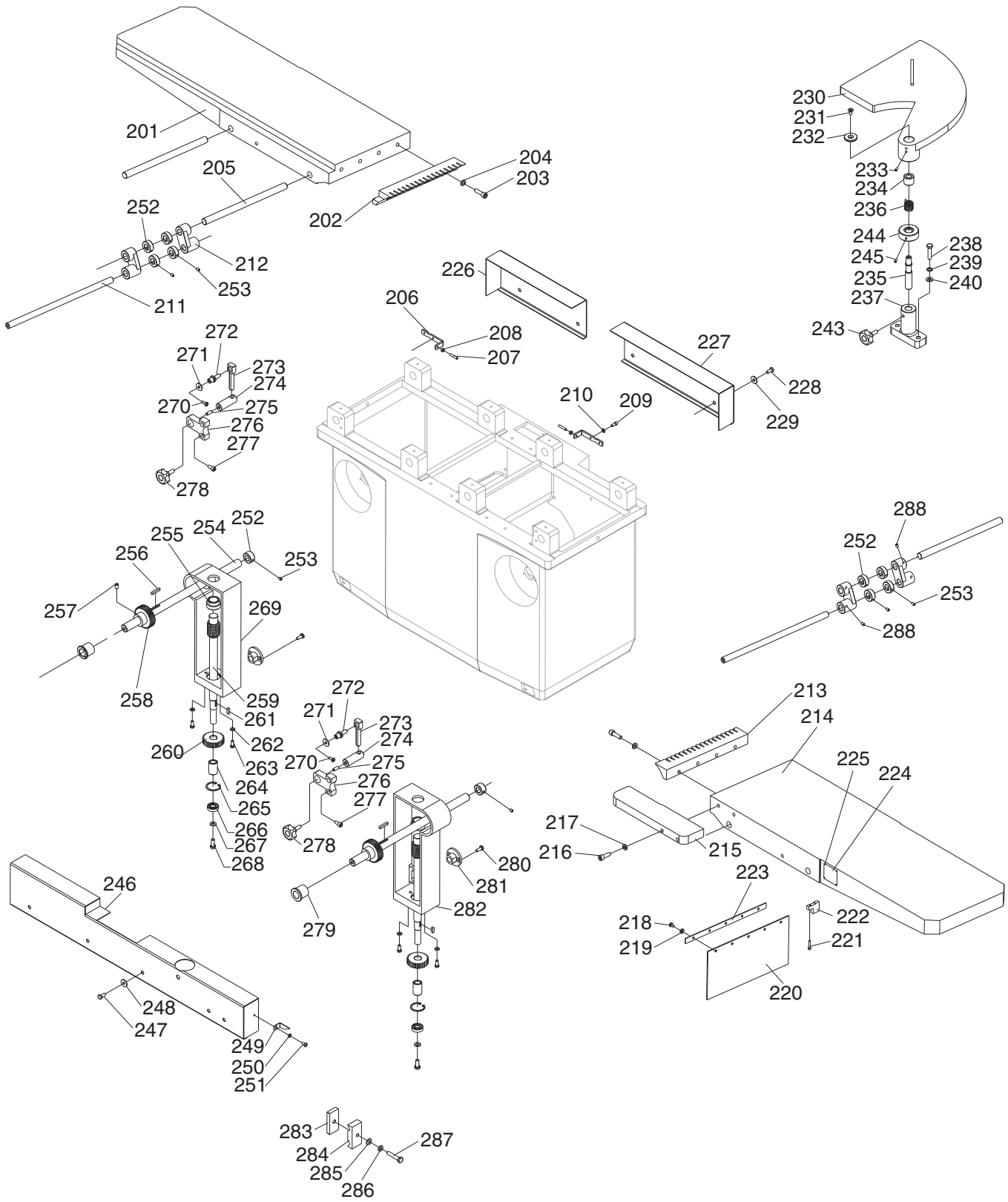


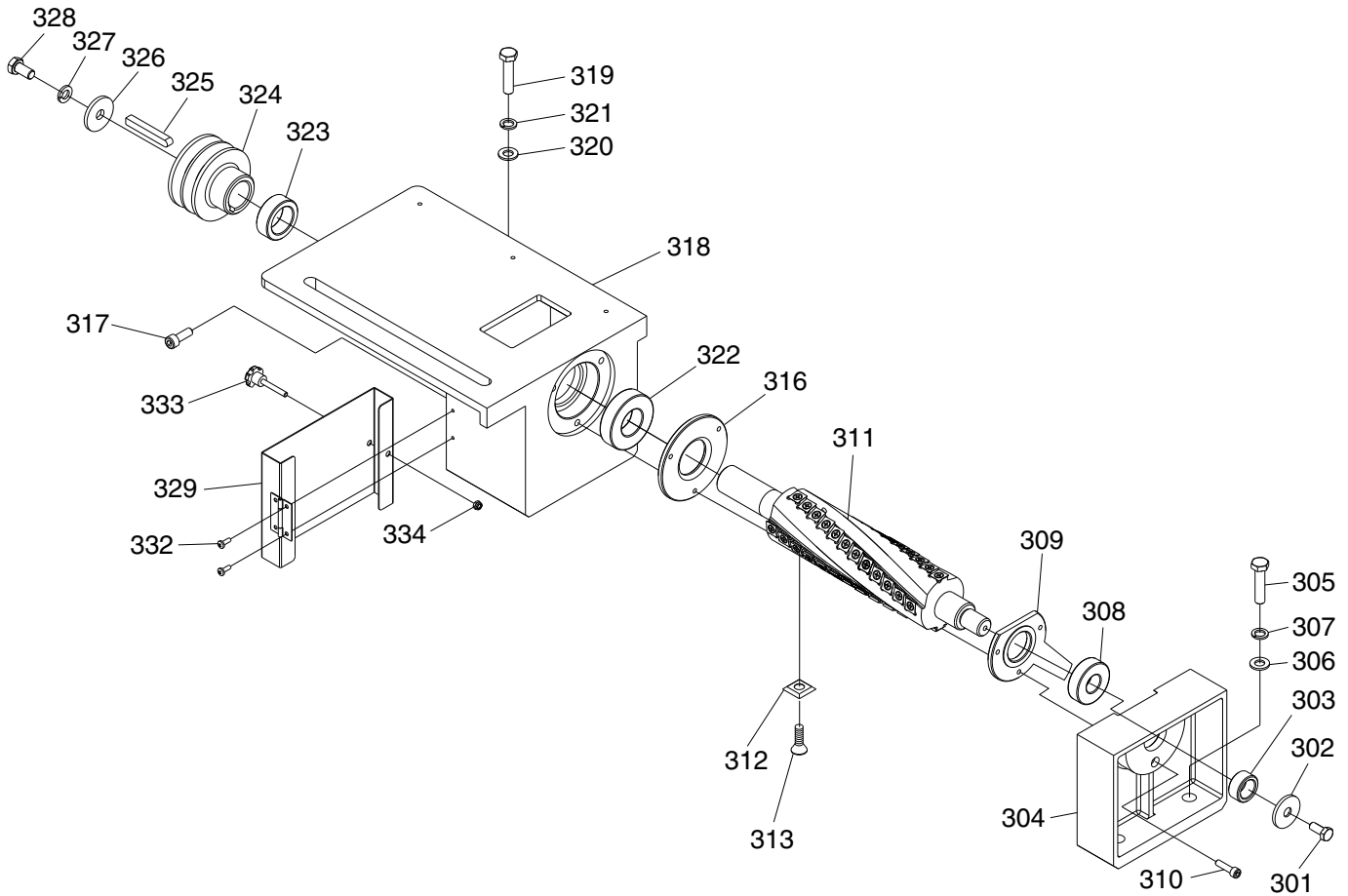
Table Parts List

REF	PART #	DESCRIPTION
201	P0834201	OUTFEED TABLE
202	P0834202	OUTFEED TABLE LIP
203	P0834203	CAP SCREW M10-1.5 X 35
204	P0834204	LOCK WASHER 10MM
205	P0834205	TABLE SPINDLE 20 X 330MM
206	P0834206	STOP PLATE
207	P0834207	SET SCREW M8-1.25 X 25
208	P0834208	HEX NUT M8-1.25
209	P0834209	CAP SCREW M6-1 X 16
210	P0834210	FLAT WASHER 6MM
211	P0834211	TABLE HEIGHT SPINDLE 20 X 470MM
212	P0834212	SMALL TABLE SUPPORT
213	P0834213	INFEED TABLE LIP
214	P0834214	INFEED TABLE
215	P0834215	RABBETING ARM
216	P0834216	CAP SCREW M10-1.5 X 30
217	P0834217	LOCK WASHER 10MM
218	P0834218	CAP SCREW M6-1 X 10
219	P0834219	FLAT WASHER 6MM
220	P0834220	DUST DEFLECTOR
221	P0834221	CAP SCREW M5-.8 X 25
222	P0834222	STOP BLOCK
223	P0834223	MOUNTING BAR
224	P0834224	DEPTH OF CUT SCALE
225	P0834225	NAMEPLATE RIVET 2 X 4
226	P0834226	OUTFEED TABLE REAR COVER
227	P0834227	INFEED TABLE REAR COVER
228	P0834228	HEX BOLT M8-1.25 X 12
229	P0834229	FLAT WASHER 8MM
230	P0834230	CUTTERHEAD GUARD
231	P0834231	FLAT HD SCR M8-1.25 X 16
232	P0834232	GUARD WASHER 15MM
233	P0834233	SET SCREW M6-1 X 12
234	P0834234	ADAPTER BUSHING
235	P0834235	SHAFT
236	P0834236	TORSION SPRING
237	P0834237	GUARD MOUNT
238	P0834238	CAP SCREW M10-1.5 X 35
239	P0834239	FLAT WASHER 10MM
240	P0834240	LOCK WASHER 10MM
243	P0834243	KNOB M10-1.5 X 25 6-LOBE
244	P0834244	SHAFT COLLAR
245	P0834245	SET SCREW M6-1 X 12

REF	PART #	DESCRIPTION
246	P0834246	FRONT TABLE COVER
247	P0834247	HEX BOLT M8-1.25 X 12
248	P0834248	FLAT WASHER 8MM
249	P0834249	POINTER
250	P0834250	FLAT WASHER 6MM
251	P0834251	PHLP HD SCR M6-1 X 12
252	P0834252	SLIDE STOP BLOCK 20 x 35
253	P0834253	SET SCREW M6-1 X 12
254	P0834254	SHAFT GEAR
255	P0834255	STOP BLOCK
256	P0834256	KEY 5 X 5 X 30
257	P0834257	SET SCREW M8-1.25 X 10
258	P0834258	WORM GEAR 46T
259	P0834259	DOUBLE-END WORM GEAR
260	P0834260	GEAR 24T
261	P0834261	KEY 4 X 4 X 16
262	P0834262	FLAT WASHER 6MM
263	P0834263	HEX BOLT M6-1 X 12
264	P0834264	BUSHING
265	P0834265	INT RETAINING RING 35MM
266	P0834266	BALL BEARING 6202ZZ
267	P0834267	FLAT WASHER 8MM
268	P0834268	HEX BOLT M8-1.25 X 12
269	P0834269	WORM GEAR HOUSING (LEFT)
270	P0834270	CAP SCREW M6-1 X 10
271	P0834271	FLAT WASHER 6MM
272	P0834272	SHOULDER SCREW M10-1.5 X 25
273	P0834273	TABLE LOCK ROD SHAFT
274	P0834274	TABLE LOCK ROD BLOCK
275	P0834275	ROLL PIN 8 X 40
276	P0834276	TABLE LOCK HOUSING
277	P0834277	CAP SCREW M8-1.25 X 25
278	P0834278	KNOB M10-1.5 X 16 6-LOBE
279	P0834279	ECCENTRIC BUSHING
280	P0834280	FLAT HD SCR M16-2 X 1
281	P0834281	SLIDING STOP BLOCK
282	P0834282	WORM GEAR HOUSING (RIGHT)
283	P0834283	CLAMPING BLOCK (OUTER)
284	P0834284	CLAMP BLOCK (INNER)
285	P0834285	FLAT WASHER 10MM
286	P0834286	LOCK WASHER 10MM
287	P0834287	HEX BOLT M10-1.5 X 50
288	P0834288	SET SCREW M6-1 X 10



Cutterhead

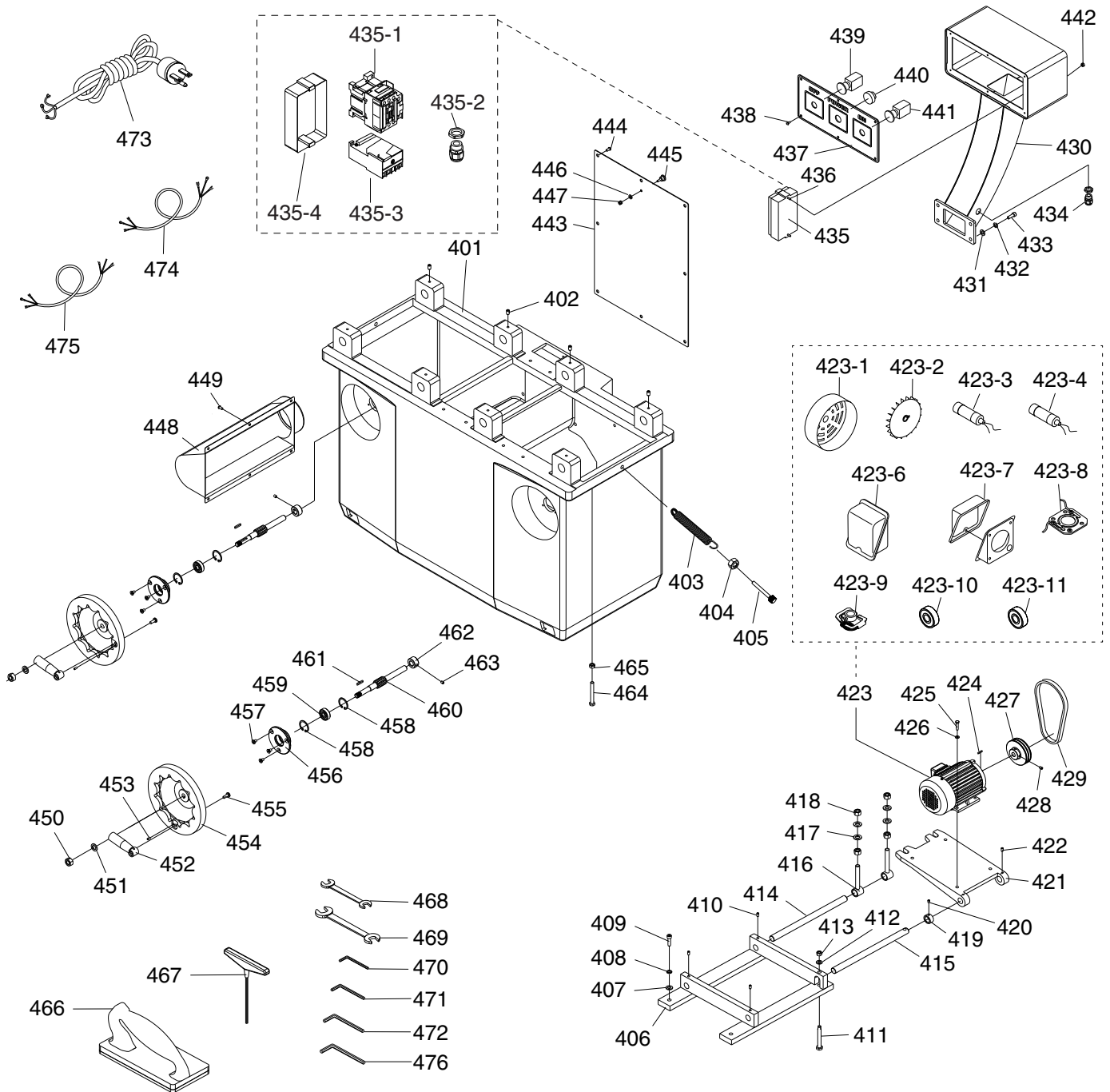


REF	PART #	DESCRIPTION
301	P0834301	HEX BOLT M8-1.25 X 20
302	P0834302	FENDER WASHER 8MM
303	P0834303	FRONT CUTTERHEAD BUSHING
304	P0834304	FRONT BEARING SUPPORT
305	P0834305	HEX BOLT M10-1.5 X 35
306	P0834306	FLAT WASHER 10MM
307	P0834307	LOCK WASHER 10MM
308	P0834308	BALL BEARING 6204ZZ
309	P0834309	FRONT BEARING COVER
310	P0834310	CAP SCREW M6-1 X 25
311	P0834311	CUTTERHEAD 12" SPIRAL
312	P0834312	INDEXABLE INSERT 15 X 15 X 2.5MM
313	P0834313	FLAT HD TORX T20 M6-1 X 15
316	P0834316	REAR BEARING SUPPORT
317	P0834317	CAP SCREW M6-1 X 25

REF	PART #	DESCRIPTION
318	P0834318	CARRIAGE MOUNT
319	P0834319	HEX BOLT M10-1.5 X 35
320	P0834320	FLAT WASHER 10MM
321	P0834321	LOCK WASHER 10MM
322	P0834322	BALL BEARING 6206ZZ
323	P0834323	REAR CUTTERHEAD BUSHING
324	P0834324	CUTTERHEAD PULLEY
325	P0834325	KEY 8 X 8 X 60
326	P0834326	FENDER WASHER 10MM
327	P0834327	LOCK WASHER 10MM
328	P0834328	HEX BOLT M10-1.5 X 20
329	P0834329	REAR CUTTERHEAD DOOR
332	P0834332	TAP SCREW M4 X 10
333	P0834333	KNOB BOLT M5-.8 X 60
334	P0834334	LOCK NUT M5-.8



Stand & Tools



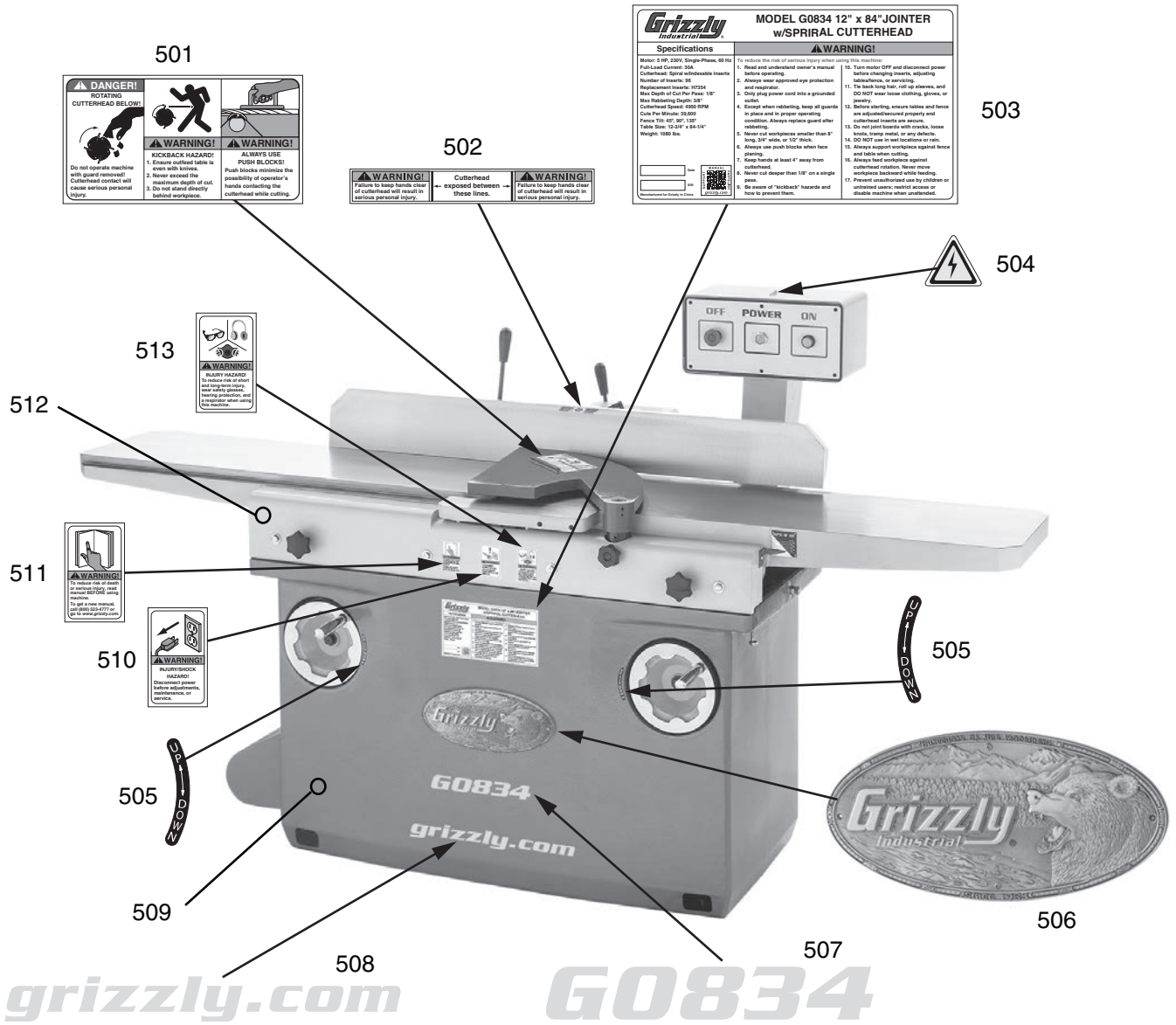
Stand & Tools Parts List

REF	PART #	DESCRIPTION
401	P0834401	CABINET
402	P0834402	SET SCREW M8-1.25 X 12
403	P0834403	EXTENSION SPRING
404	P0834404	HEX NUT M10-1.5
405	P0834405	KNURLED KNOB BOLT M10-1.5 X 48
406	P0834406	MOTOR BRACKET
407	P0834407	FLAT WASHER 10MM
408	P0834408	LOCK WASHER 10MM
409	P0834409	CAP SCREW M8-1.25 X 12
410	P0834410	SET SCREW M8-1.25 X 12
411	P0834411	ELEVATION BOLT M10-1.5 X 80
412	P0834412	FLAT WASHER 10MM
413	P0834413	HEX NUT M10-1.5
414	P0834414	PLATE CONNECTING ROD (LEFT)
415	P0834415	PLATE CONNECTING ROD (RIGHT)
416	P0834416	TENSION ROD M12-1.75 X 85
417	P0834417	FLAT WASHER 12MM
418	P0834418	HEX NUT M12-1.75
419	P0834419	COLLAR
420	P0834420	SET SCREW M6-1 X 8
421	P0834421	MOTOR MOUNT PLATE
422	P0834422	SET SCREW M6-1 X 12
423	P0834423	MOTOR 5HP 240V 1-PH
423-1	P0834423-1	MOTOR FAN COVER
423-2	P0834423-2	MOTOR FAN
423-3	P0834423-3	S CAPACITOR 300UF 300V 2-1/4" X 3-3/4"
423-4	P0834423-4	R CAPACITOR 60UF 450V 2-1/4" X 5"
423-6	P0834423-6	CAPACITOR BOX
423-7	P0834423-7	MOTOR JUNCTION BOX
423-8	P0834423-8	CONTACT PLATE
423-9	P0834423-9	CENTRIFUGAL SWITCH
423-10	P0834423-10	BALL BEARING 6204ZZ
423-11	P0834423-11	BALL BEARING 6206ZZ
424	P0834424	KEY 8 X 8 X 40
425	P0834425	HEX BOLT M10-1.5 X 30
426	P0834426	FLAT WASHER 10.5 X 24 X 3
427	P0834427	MOTOR PULLEY
428	P0834428	SET SCREW M10-1.5 X 12
429	P0834429	V-BELT A1194
430	P0834430	CONTROL PANEL PEDESTAL
431	P0834431	CAP SCREW M10-1.5 X 25
432	P0834432	LOCK WASHER 10MM
433	P0834433	FLAT WASHER 10MM
434	P0834434	STRAIN RELIEF TYPE-3 M20-1.5
435	P0834435	MAGNETIC SWITCH

REF	PART #	DESCRIPTION
435-1	P0834435-1	CONTACTOR NHD C-35D
435-2	P0834435-2	STRAIN RELIEF TYPE-3 M16 X 1.5
435-3	P0834435-3	OL RELAY NHD NTH-28 24-28A
435-4	P0834435-4	MAGNETIC SWITCH BACK COVER
436	P0834436	PHLP HD SCR M5-.8 X 10
437	P0834437	CONTROL PANEL FACEPLATE
438	P0834438	PHLP HD SCR M5-.8 X 10
439	P0834439	STOP BUTTON NHD NLB22-R
440	P0834440	POWER LIGHT PEOPLE AD11-25/40
441	P0834441	START BUTTON NHD NLB22-E
442	P0834442	ACORN NUT M5-.8
443	P0834443	REAR ACCESS PANEL
444	P0834444	BUTTON HD CAP SCR M6-1 X 10
445	P0834445	KNOB BOLT M5-.8 X 16 5-LOBE
446	P0834446	FLAT WASHER 6MM
447	P0834447	HEX NUT M5-.8
448	P0834448	DUST PORT 5"
449	P0834449	BUTTON HD CAP SCR M6-1 X 10
450	P0834450	HEX NUT M12-1.75
451	P0834451	FLAT WASHER 12MM
452	P0834452	FOLDING HANDWHEEL HANDLE
453	P0834453	ROLL PIN 4 X 10
454	P0834454	HANDWHEEL TYPE-11 184D X 12B X M6
455	P0834455	FLANGE SCREW M6-1 X 16
456	P0834456	BEARING SUPPORT
457	P0834457	FLAT HD SCR M6-1 X 8
458	P0834458	INT RETAINING RING 35MM
459	P0834459	BALL BEARING 6201ZZ
460	P0834460	SPIRAL GEAR SHAFT
461	P0834461	KEY 4 X 4 X 20
462	P0834462	LOCK COLLAR 14 X 428 X 15MM
463	P0834463	SET SCREW M8-1.25 X 8
464	P0834464	HEX BOLT M10-1.5 X 130
465	P0834465	HEX NUT M10-1.5
466	P0834466	PUSH BLOCK
467	P0834467	T-HANDLE WRENCH 4MM
468	P0834468	WRENCH 12 X 14 OPEN-ENDS
469	P0834469	WRENCH 17 X 19 OPEN-ENDS
470	P0834470	HEX WRENCH 3MM
471	P0834471	HEX WRENCH 4MM
472	P0834472	HEX WRENCH 5MM
473	P0834473	POWER CORD 12G 3W 72" L6-30P
474	P0834474	CONTROL PANEL CORD 14G 5W 24"
475	P0834475	MOTOR CORD 12G 3W 48"
476	P0834476	HEX WRENCH 8MM



Labels & Cosmetics



REF	PART #	DESCRIPTION
501	P0834501	MACHINE HAZARDS LABEL
502	P0834502	CUTTERHEAD WARNING LABEL
503	P0834503	MACHINE ID LABEL
504	P0834504	ELECTRICITY LABEL
505	P0834505	UP-DOWN LABEL
506	P0834506	GRIZZLY NAME PLATE (LARGE)
507	P0834507	MODEL NUMBER LABEL

REF	PART #	DESCRIPTION
508	P0834508	GRIZZLY.COM LABEL
509	P0834509	TOUCH-UP PAINT, GRIZZLY GREEN
510	P0834510	INJURY/SHOCK HAZARD LABEL
511	P0834511	READ MANUAL LABEL
512	P0834512	TOUCH-UP PAINT, GREY PUTTY
513	P0834513	EYE/HEARING/LUNG WARNING LABEL

⚠ WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

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

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	

3. What is your annual household income?

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

4. What is your age group?

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

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

0-2 Years 2-8 Years 8-20 Years 20+ Years

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

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

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

Note: We never use names more than 3 times. Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place Stamp Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

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.

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

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

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

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

grizzly.com[®]

TOOL WEBSITE

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