Grizzly Industrial, Inc.®

MODEL G0958/G0959
8" & 12" JOINTER/PLANER
W/HELICAL CUTTERHEAD

OWNER'S MANUAL

(For models manufactured since 03/23)

#MNLW22292 PRINTED IN CHINA V2.03.23

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

⚠ WARNING!

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

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

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Contact Info

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

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

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

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

Machine Differences

Models G0958 and G0959 are 1½ HP jointer/planers with the following differences:

- **Model G0958** has an 8" helical cutterhead with 18 indexable carbide inserts, 29¼" x 8¼" infeed/outfeed tables, and a 2½" dust port.
- **Model G0959** has a 12" helical cutterhead with 28 indexable carbide inserts, 42⅜" x 12" infeed/outfeed tables, and a 4" dust port.

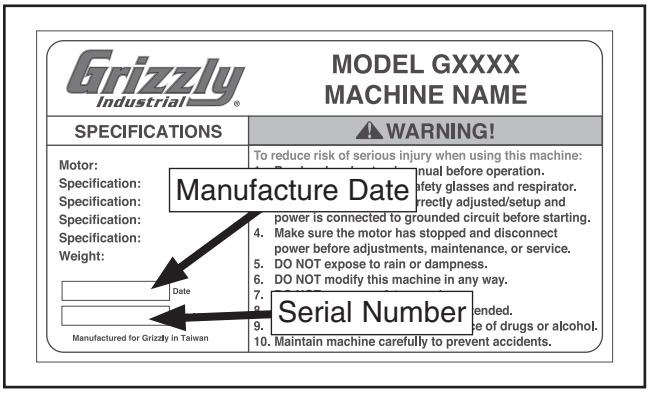
Manual Accuracy

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**.

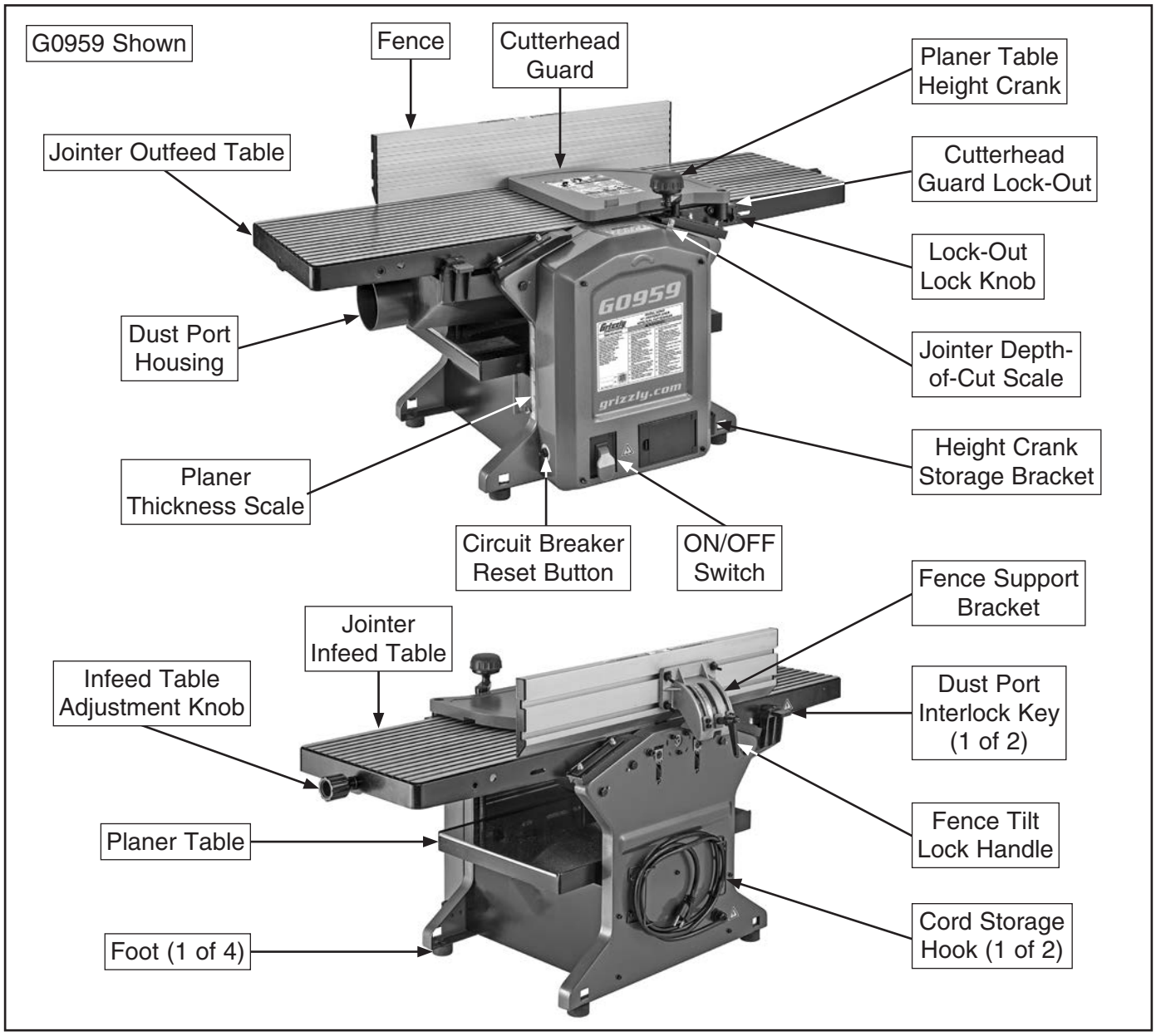
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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.



Identification

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

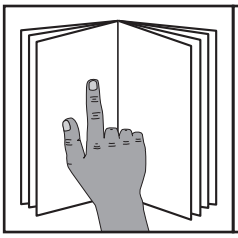


⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

a) Wear eye protection.
b) Always keep cutterhead and drive guards in place and in proper operating condition.
c) Never cut deeper than ⅛" in one pass.
d) Always use hold-down or push blocks when jointing material narrower than 3" or planing material thinner than 3".
e) Never perform cuts on pieces shorter than 8" in length.

Controls & Components



⚠WARNING

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

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

Main Controls & Components

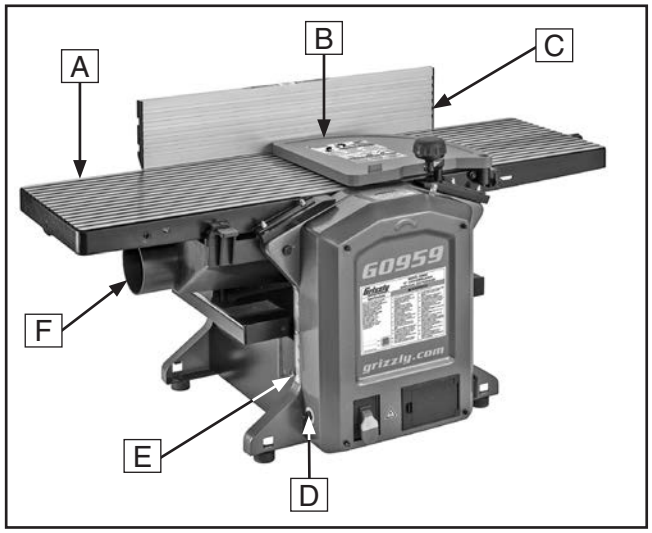


Figure 1. Main controls & components (left).

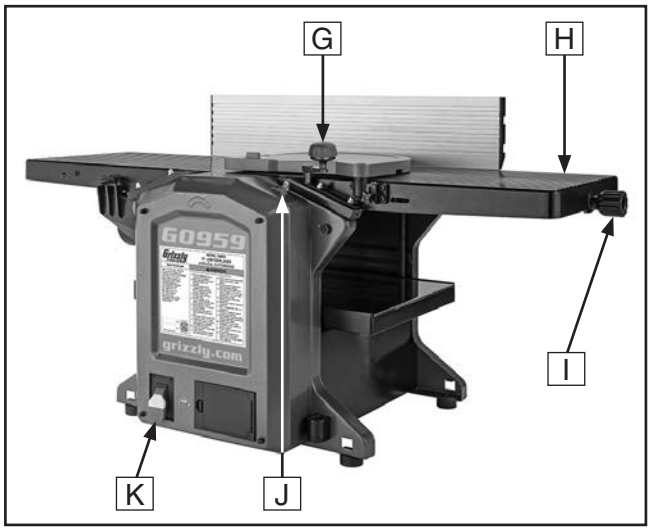


Figure 2. Main controls & components (right).

A. Jointer Outfeed Table: Supports workpiece after it passes over cutterhead.

B. Cutterhead Guard: Covers cutterhead until pushed out of the way by workpiece during jointing operations. When workpiece leaves cutterhead, guard springs back to its starting position.

C. Fence: Guides workpiece as it moves across cutterhead; determines angle of cut.

D. Circuit Breaker Reset Button: Allows machine to be restarted after thermal overload protection has tripped. To reset, place ON/OFF switch in OFF position, wait a few minutes for motor to cool, then press reset button. If button does not *stay* depressed, allow motor to cool longer, then try again.

E. Planer Thickness Scale: Shows height of cutterhead above planer table. Measurement indicated by red line shows effective thickness of board *after* planing.

F. Dust Port Housing: Installs *beneath* outfeed table for jointer operations; installs *above* outfeed table for planer operations. Two keys secure dust port to table.

Note: *Machine will not start if keys on dust port housing are not installed in slots on outfeed table.*

G. Planer Table Height Crank: Raises and lowers planer table to accommodate different workpiece thicknesses. Each full rotation changes height approximately ⅛".

H. Jointer Infeed Table: Supports workpiece before it reaches cutterhead. Position of infeed table relative to cutterhead determines depth of cut.

I. Infeed Table Adjustment Knob: Adjusts height of infeed table to control depth of cut.

J. Jointer Depth-of-Cut Scale: Indicates depth of cut per pass.

K. ON/OFF Switch: Turns motor ***ON*** when moved up; turns motor ***OFF*** when moved down. Removal of yellow key disables switch, preventing motor from starting.

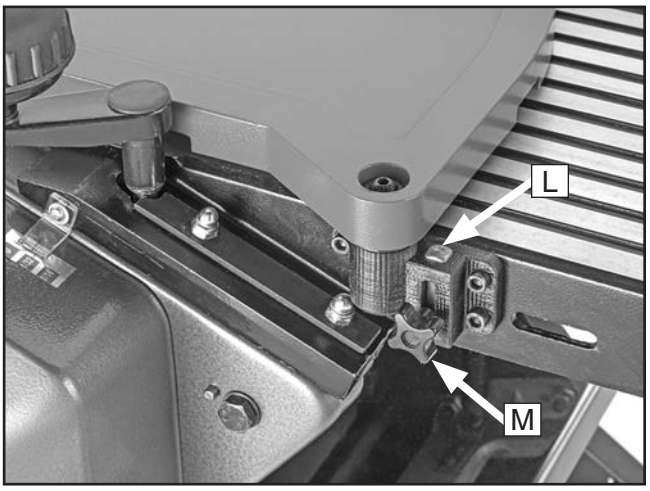


Figure 3. Cutterhead guard lock-out components.

L. Cutterhead Guard Lock-Out: Prevents guard from springing into position over cutterhead during planing operations.

M. Lock-Out Lock Knob: Tighten to secure position of lock-out; loosen to raise or lower lock-out.

G0958 Fence Controls

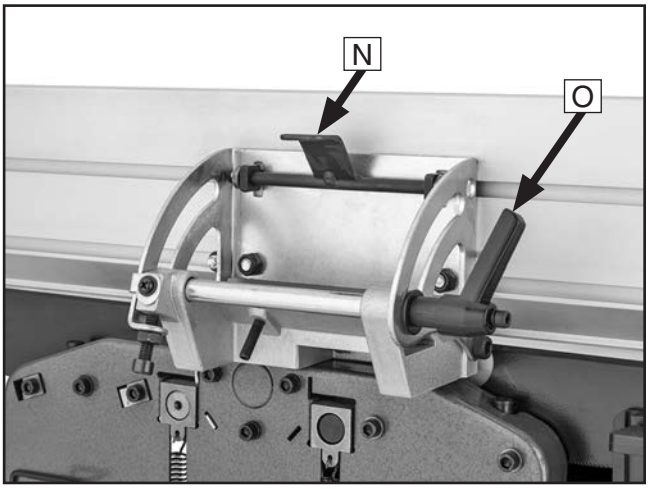


Figure 4. G0958 fence controls.

N. Fence Slide Lock Handle: Secures position of fence over tables. Move up to tighten; move down to loosen.

O. Fence Tilt Lock Handle: Secures fence tilt angle. Fence tilt can be adjusted between 0°–45°. Always tighten lock before beginning operations.

G0959 Fence Controls

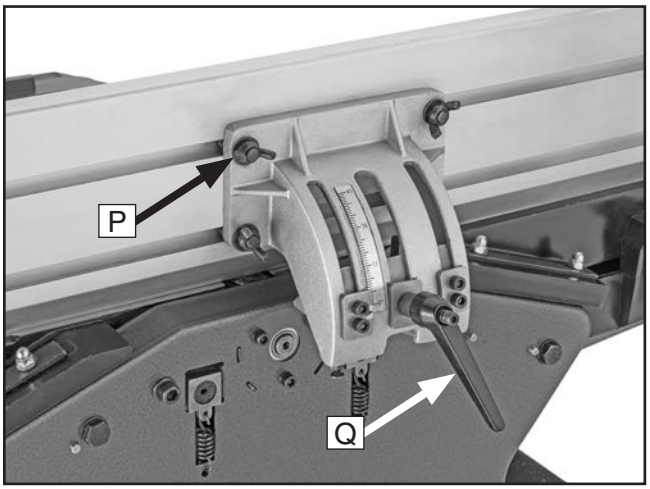


Figure 5. G0959 fence controls.

P. Fence Slide Wing Bolts: Secure position of fence over tables. Loosen to move fence; tighten to secure position.

Q. Fence Tilt Lock Handle: Secures fence tilt angle. Fence tilt can be adjusted between 0°–45°. Always tighten lock before beginning operations.

Internal Components (Planer)

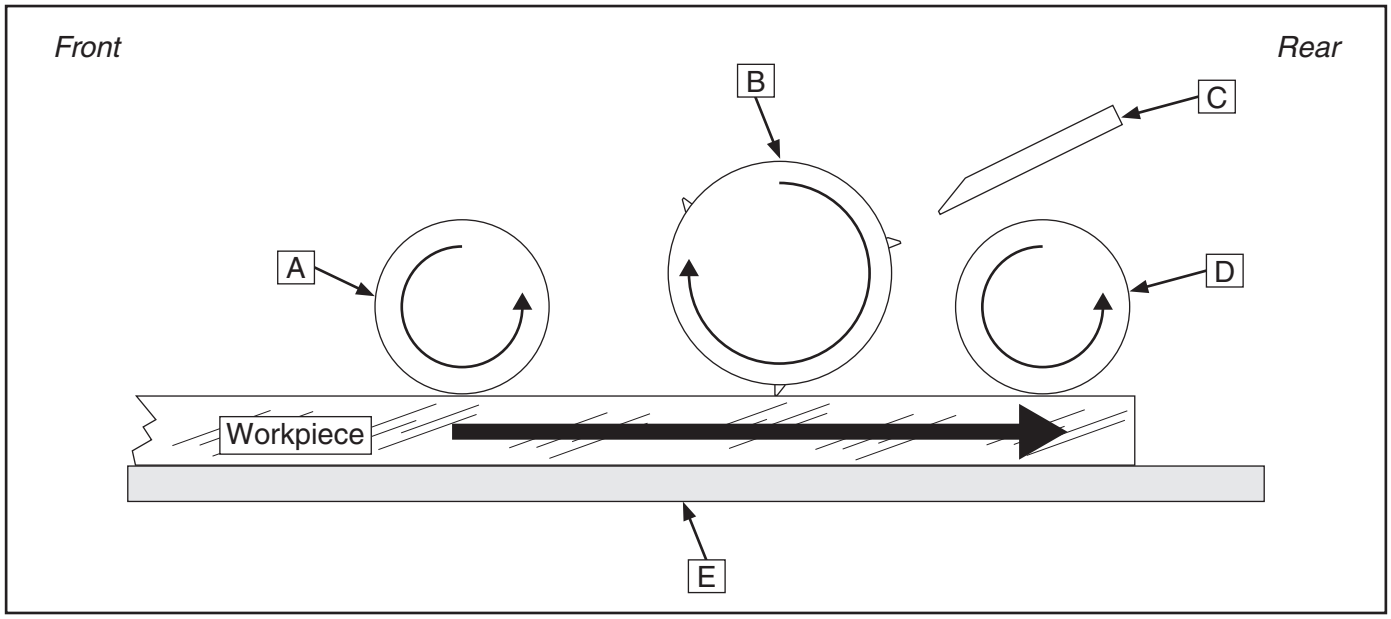


Figure 6. Workpiece path and major planing components (side cutaway view).

A. Infeed Roller: Rotates with direction of feed to pull workpiece toward cutterhead.

B. Cutterhead: Holds inserts that remove material from workpiece. Rotates opposite direction of feed.

C. Chip Deflector: Directs chips into dust port.

D. Outfeed Roller: Rotates with direction of feed to pull workpiece through planer.

E. Planer Table: Provides a smooth, flat surface for workpiece to slide against as it moves through planer.

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

MACHINE DATA SHEET

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

MODEL G0958
8" JOINTER/PLANER WITH HELICAL CUTTERHEAD

Product Dimensions:

Weight	48 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	31 x 17-1/2 x 18-1/2 in.
Footprint (Length x Width)	15-1/2 x 10-1/2 in.

Shipping Dimensions:

Type	Cardboard Box
Content	Machine
Weight	57 lbs.
Length x Width x Height	34 x 19 x 18 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	120V, Single-Phase, 60 Hz
Full-Load Current Rating	15A
Minimum Circuit Size	20A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	72 in.
Power Cord Gauge	14 AWG
Plug Included	Yes
Included Plug Type	5-15
Switch Type	Paddle Safety Switch w/Removable Key

Motor:

Main

Horsepower	1-1/2 HP
Phase	Single-Phase
Amps	15A
Speed	15,000 RPM
Type	Universal
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Cutting Capacities (Jointer)

Jointer Size	8 in.
Bevel Jointing	0 - 45 deg.
Maximum Width of Cut	8 in.
Maximum Depth of Cut	1/16 in.
Minimum Workpiece Length	6 in.
Minimum Workpiece Thickness	1/4 in.
Number of Cuts Per Minute	17,000

Cutting Capacities (Planer)

Planer Size	8 in.
Maximum Width of Cut	8 in.
Minimum Stock Length	6 in.
Minimum Stock Thickness	1/4 in.
Number of Cuts Per Inch	64
Number of Cuts Per Minute	17,000
Planing Feed Rate	22 FPM
Maximum Cut Depth Planing Full Width	3/64 in.
Maximum Cut Depth Planing 6-Inch Wide Board	1/16 in.

Fence Information

Fence Length	21 in.
Fence Width	1/2 in.
Fence Height	4 in.
Fence Stops	0, 45 deg.

Cutterhead Information

Cutterhead Type	Helical
Cutterhead Diameter	2 in.
Number of Cutter Rows	2
Number of Indexable Cutters	18
Cutterhead Speed	8500 RPM

Cutterhead Insert Information

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

Table Information (Jointer)

Table Length	29-1/4 in.
Table Width	8-1/4 in.
Table Thickness	1-1/2 in.
Floor to Table Height	14 in.
Table Adjustment Type	Knob
Table Movement Type	Swing

Table Information (Planer)

Table Length	13-3/4 in.
Table Width	8 in.
Table Thickness	3/4 in.
Floor to Table Height	7-1/2 in.

Construction

Body Assembly	Steel
Cutterhead	Steel
Infeed Roller	Rubber
Outfeed Roller	Rubber
Fence Assembly	Aluminum
Guard	Plastic
Table (Jointer)	Die-Cast Aluminum
Table (Planer)	Die-Cast Aluminum
Paint Type/Finish	Powder Coated

Other Information

Number of Dust Ports	1
Dust Port Size	2-1/2 in.
Measurement Scale (Jointer)	Inch
Measurement Scale (Planer)	Inch

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label
Sound Rating	88 - 90 dB
ISO 9001 Factory	Yes

Features:

Helical Cutterhead with 18 Indexable Carbide Inserts
Die-Cast Aluminum Infeed and Outfeed Tables
One Push Block and One Push Stick
Torx T-20 T-Handle Driver
Quick-Release Fence
2-1/2" Dust Port

MACHINE DATA SHEET

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

MODEL G0959
12" JOINTER/PLANER WITH HELICAL CUTTERHEAD

Product Dimensions:

Weight	86 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	45 x 23-1/2 x 22-1/2 in.
Footprint (Length x Width)	19 x 15-1/2 in.

Shipping Dimensions:

Type	Cardboard Box
Content	Machine
Weight	95 lbs.
Length x Width x Height	47 x 26 x 26 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	120V, Single-Phase, 60 Hz
Full-Load Current Rating	15A
Minimum Circuit Size	20A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	72 in.
Power Cord Gauge	14 AWG
Plug Included	Yes
Included Plug Type	5-15
Switch Type	Paddle Safety Switch w/Removable Key

Motor:

Main

Horsepower	1-1/2 HP
Phase	Single-Phase
Amps	15A
Speed	15,000 RPM
Type	Universal
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Cutting Capacities (Jointer)

Jointer Size	12 in.
Bevel Jointing	0 - 45 deg.
Maximum Width of Cut	12 in.
Maximum Depth of Cut	1/16 in.
Minimum Workpiece Length	6 in.
Minimum Workpiece Thickness	1/4 in.
Number of Cuts Per Minute	17,000

Cutting Capacities (Planer)

Planer Size	12 in.
Maximum Width of Cut	12 in.
Minimum Stock Length	6 in.
Minimum Stock Thickness	1/4 in.
Number of Cuts Per Inch	64
Number of Cuts Per Minute	17,000
Planing Feed Rate	22 FPM
Maximum Cut Depth Planing Full Width	3/64 in.
Maximum Cut Depth Planing 6-Inch Wide Board	1/16 in.

Fence Information

Fence Length	25 in.
Fence Width	3/4 in.
Fence Height	5 in.
Fence Stops	0, 45 deg.

Cutterhead Information

Cutterhead Type	Helical
Cutterhead Diameter	2 in.
Number of Cutter Rows	2
Number of Indexable Cutters	28
Cutterhead Speed	8500 RPM

Cutterhead Insert Information

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

Table Information (Jointer)

Table Length	42-3/8 in.
Table Width	12 in.
Table Thickness	1-3/4 in.
Floor to Table Height	17-1/2 in.
Table Adjustment Type	Knob
Table Movement Type	Dovetail

Table Information (Planer)

Table Length	19-3/4 in.
Table Width	12 in.
Table Thickness	1-1/2 in.
Floor to Table Height	9-1/2 in.

Construction

Body Assembly	Steel
Cutterhead	Steel
Infeed Roller	Rubber
Outfeed Roller	Rubber
Fence Assembly	Aluminum
Guard	Plastic
Table (Jointer)	Die-Cast Aluminum
Table (Planer)	Die-Cast Aluminum
Paint Type/Finish	Powder Coated

Other Information

Number of Dust Ports	1
Dust Port Size	4 in.
Measurement Scale (Jointer)	Inch
Measurement Scale (Planer)	Inch

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label
Sound Rating	88 - 90 dB
ISO 9001 Factory	Yes

Features:

Helical Cutterhead with 28 Indexable Carbide Inserts
Die-Cast Aluminum Infeed and Outfeed Tables
One Push Block and One Push Stick
Torx T-20 T-Handle Driver
Quick-Release Fence
4" Dust Port

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Jointers

⚠WARNING

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

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

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

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

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

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

MAXIMUM CUTTING DEPTH. To reduce risk of kickback, never cut deeper than 1/16" per pass.

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

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

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

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

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

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

Additional Safety for Planers

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

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 120V ..... 15 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.

⚠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.

Circuit Requirements

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

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps

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.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

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 & Plug Requirements

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.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

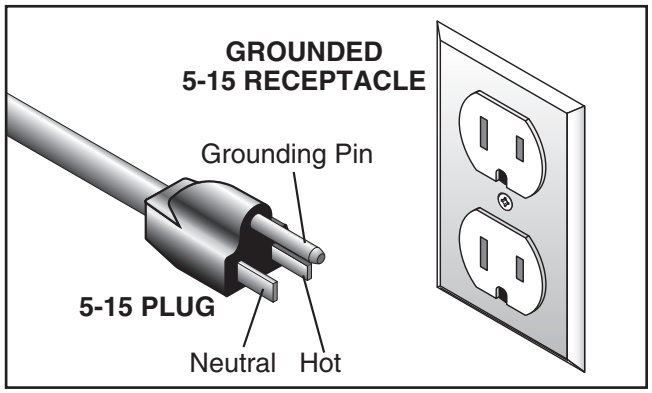
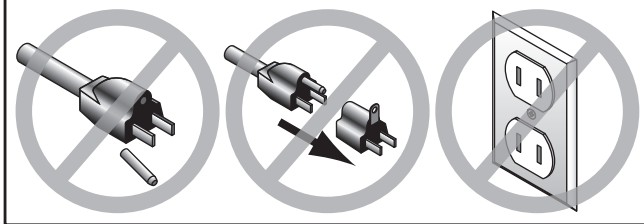


Figure 7. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

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 Size .....12 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

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.*

Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags	As Needed
• Disposable Gloves	As Needed
• Phillips Screwdriver #2 (G0959)	1
• Dust Hose (G0958–2½", G0959–4")	1
• Hose Clamp (G0958–2½", G0959–4")	1
• Dust Collection System	1

Inventory

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

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

NOTICE

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

Box 1 (Figure 8)	Qty
A. Jointer/Planer Unit (Not Shown)	1
B. Fence Assembly	1
C. Planer Table Height Crank	1
D. Dust Port Assembly	1
E. Push Block	1
F. Lock Plate (G0959 Fence)	1
G. Adjustable Handle (G0959 Fence)	1
H. Push Stick	1
I. Spare Feed Belt (G0958)	1
J. T-Handle Torx Wrenches T-20	2
K. Hex Wrench 4mm	1
L. Indexable Carbide Inserts 15 x 15 x 2.5mm	5
M. Flat Head Torx Screws T-20 M5-.8 x 12	5
N. Cap Screws M5-.8 x 20 (G0958 Fence)	2
O. Flat Washers 6mm (G0959 Fence)	2
P. Button Head Cap Screws M6-1 x 16 (G0959 Fence)	2

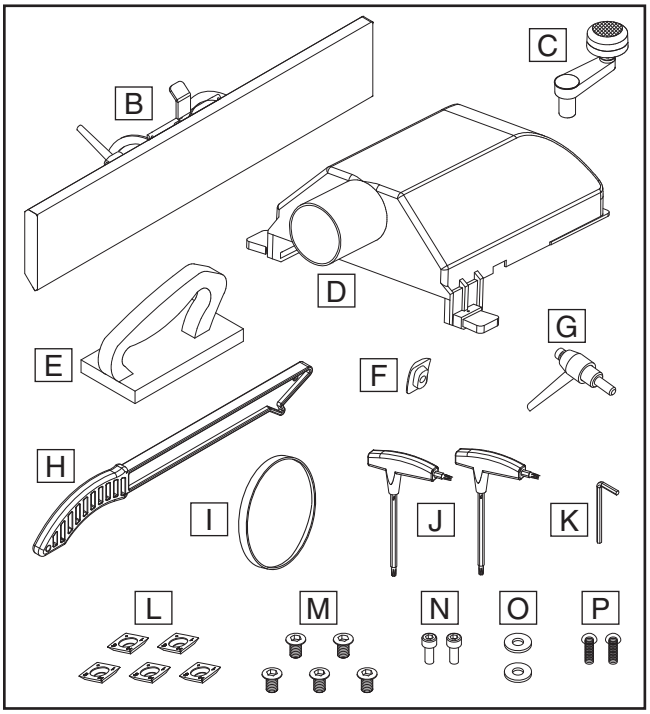


Figure 8. Model G0958/G0959 inventory.

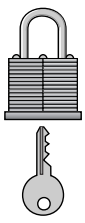
Site Considerations

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.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

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.

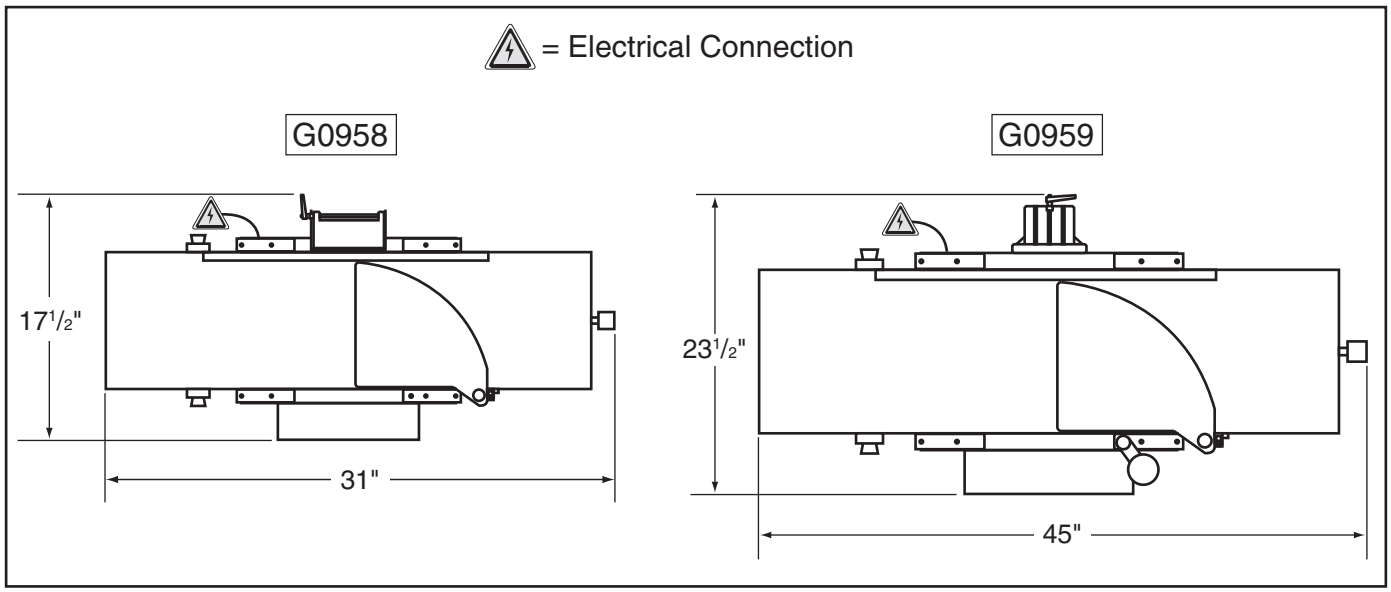


Figure 9. Minimum working clearances.

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 machine:

1. **G0958 Only:** Remove (4) support brackets connecting infeed/outfeed tables to base. These are for shipping only and must be removed before machine can be used.

2. Install planer table height crank as shown in **Figure 10**. Turn counterclockwise to lower planer table, and remove fence assembly sandwiched between tables. When finished, place crank in storage bracket.

   Note: *On G0958, cutterhead guard must be rotated forward to create room for planer table height crank to be installed. See* ***Jointer/Planer Conversion, Step 4, Page 35*** *for instructions.*

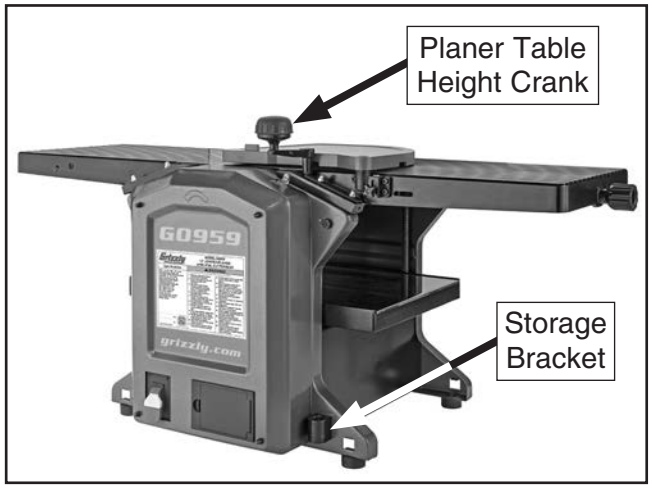


Figure 10. Planer table height crank installed (G0959 shown).

3. **G0958 Only:** Install fence assembly (see **Figure 11**) on back of machine frame with (2) M5-.8 x 20 cap screws.

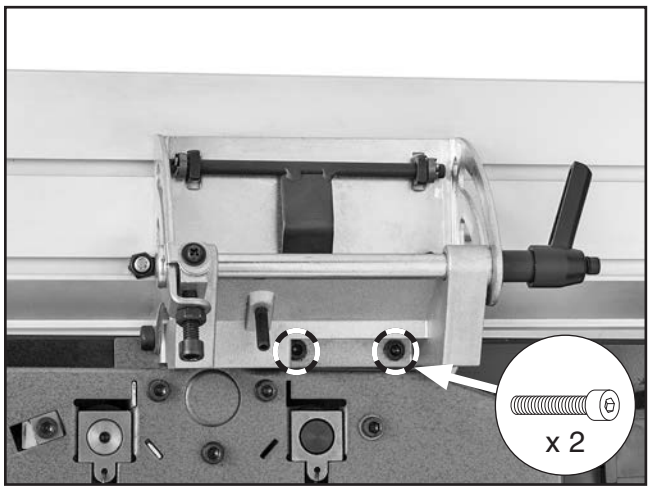


Figure 11. Fence assembly installed on machine frame (G0958).

4. **G0959 Only:** Install fence assembly (see **Figure 12**) on back of machine frame with (2) M6-1 x 16 button head cap screws and 6mm flat washers, then thread adjustable handle and lock plate into fence support.

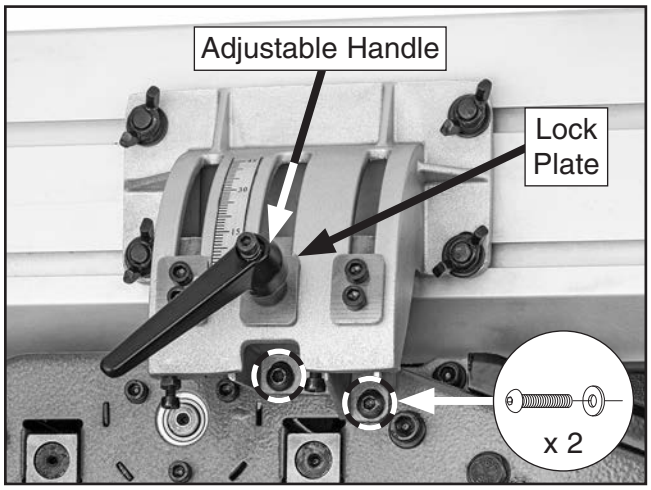


Figure 12. Fence assembly installed on machine frame (G0959).

5. Install dust port housing *beneath* outfeed table (see **Figure 13**), and secure by inserting interlock keys in slots on each side of table.

Note: *Machine will not start if keys on dust port housing are not installed in slots on outfeed table.*

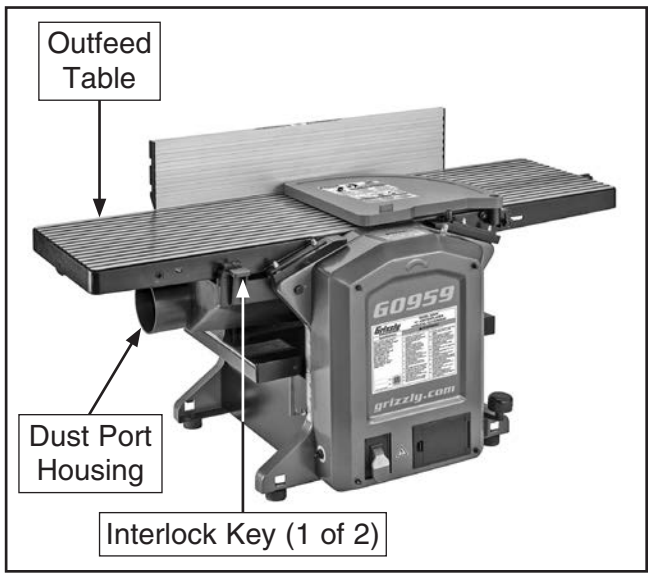


Figure 13. Dust port housing installed beneath outfeed table.

Dust Collection

⚠CAUTION

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

G0958 2½" Dust Port.....150 CFM
G0959 4" Dust Port.....400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect dust collection hose:

1. Fit 2½" (G0958) or 4" (G0959) dust hose over dust port and secure with hose clamp (see **Figure 14**).

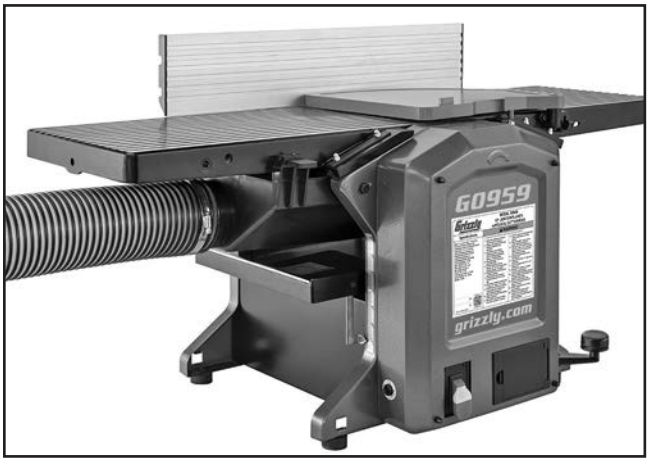


Figure 14. Dust hose installed on dust port.

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 consists of verifying the following: 1) The motor powers up and runs correctly, 2) the safety disabling feature on the ON/OFF switch works correctly, and 3) the safety disabling feature on the interlock switch works correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Make sure all tools and objects used during setup are cleared away from machine.

2. Connect machine to power source.

3. Turn machine ***ON***, verify motor operation, then turn machine ***OFF***. Motor should run smoothly and without unusual problems or noises.

4. Remove ON/OFF switch disabling key, as shown in **Figure 15**.

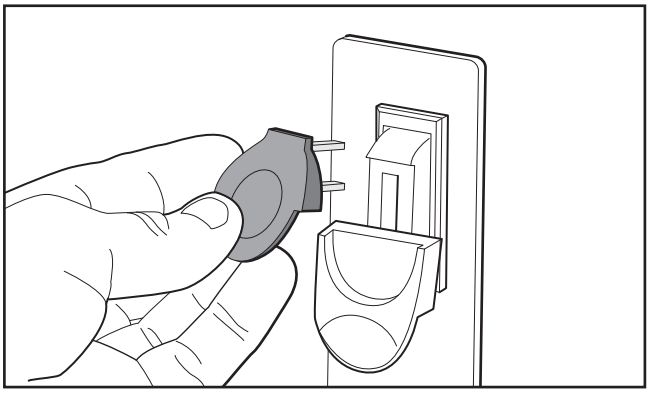


Figure 15. Removing key from paddle switch to disable switch and prevent unauthorized use.

5. Try to start machine.

— If machine does *not* start, switch disabling feature is working as designed. Proceed to **Step 6**.

— If machine starts, immediately turn machine ***OFF*** and disconnect from power. Switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

6. Re-install disabling key in ON/OFF switch.

7. Remove dust port housing.

8. Try to start machine.

— If machine does *not* start, interlock switch disabling feature is working as designed. Congratulations, test run is now complete!

— If machine starts, immediately turn machine ***OFF*** and disconnect from power. Interlock switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you verify the adjustments to ensure the best possible results from your new machine.

Step-by-step instructions for these adjustments can be found in the SERVICE section starting on **Page 43**.

Factory adjustments that should be verified:

- Tensioning/replacing V-belts (**Page 46**).
- Calibrating jointer depth-of-cut scale (**Page 48**).
- Calibrating planer thickness scale (**Page 48**).

NOTICE

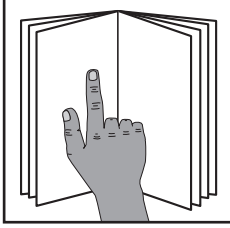
After approximately 16 hours of operation, motor V-belt will stretch and seat into pulley grooves and need to be properly tensioned to avoid severely reducing life of V-belt. Refer to Tensioning/Replacing V-Belts on Page 46 for detailed instructions.

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.



⚠WARNING

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

⚠WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.

NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Typical Jointing Operation

1. Examine workpiece to verify it is safe and suitable for cutting.
2. Adjust fence tilt, if necessary, and lock fence in place.
3. Adjust infeed table height to set depth of cut per pass.
4. Install dust port housing *beneath* outfeed table and insert interlock keys in table slots.
5. Put on safety glasses or face shield, a respirator, and ear protection.
6. Start jointer.
7. Using push blocks as needed, hold workpiece firmly against infeed table and fence, and feed 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. Repeat cutting process described above until desired results are achieved.
9. Stop jointer.

Typical Planing Operation

1. Examine workpiece to make sure it is suitable for planing.

2. Put on safety glasses or face shield, a respirator, and ear protection.

3. Rotate cutterhead guard over jointer infeed table and secure with lock-out.

4. Install dust port housing on *top* of jointer outfeed table and insert interlock keys in table slots.

5. Place workpiece on planer table with flat side down and correctly adjust table height for workpiece thickness and depth of cut.

   — If workpiece is bowed, surface plane workpiece on jointer until one side is flat. Doing so ensures that it will sit solidly on planer table during operation.

6. When all safety precautions have been taken, turn planer ***ON***.

7. Stand to one side of planer path to reduce risk of kickback injuries, then feed workpiece into planer until infeed roller grabs it.

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

   — If cut is too deep and bogs down planer, immediately reduce depth of cut.

8. Once workpiece is clear of outfeed roller and stops moving, remove workpiece from outfeed table and measure workpiece thickness. If further planing is required, raise table approximately ¼ to ½ turn of the height crank, then feed workpiece into front of planer again.

9. Continue process until desired thickness is achieved, then turn machine ***OFF***.

Stock Inspection & Requirements

Follow these rules when choosing stock for jointing or planing:

- **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.

- **Always joint with cupped side of workpiece facing down.** Otherwise workpiece could rock during cut, increasing likelihood of kickback.

- **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 so the grain points down and toward you on the jointer (see **Figure 16**) or away from you on the planer (see **Figure 17**) as viewed on the edge of the stock.

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

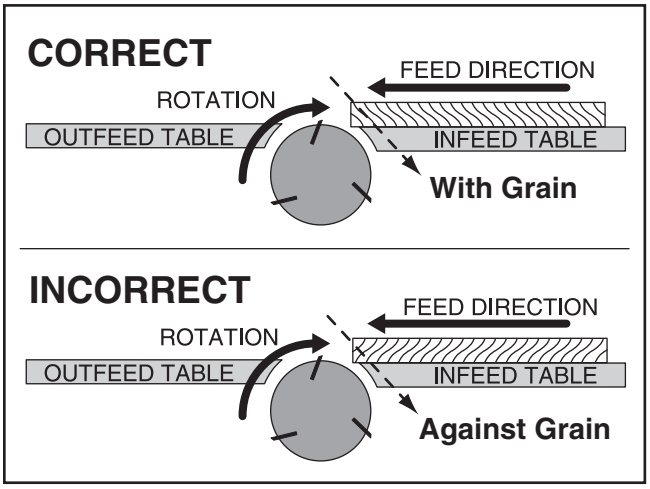


Figure 16. Proper grain alignment with cutterhead (jointer).

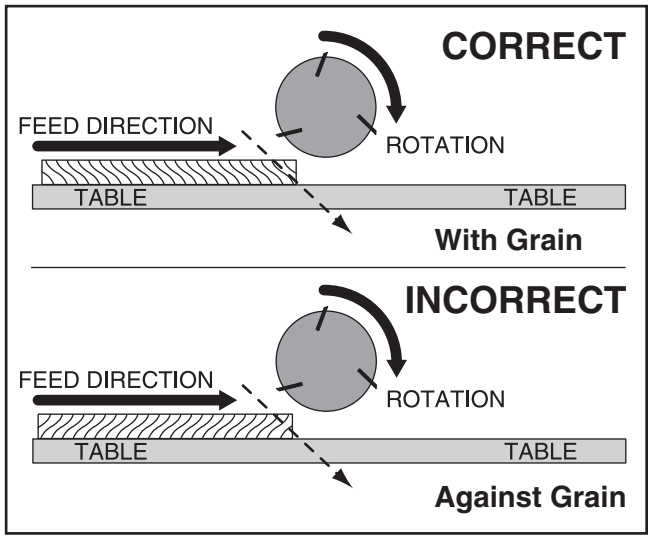


Figure 17. Proper grain alignment with cutterhead (planer).

- **Only cut natural wood.** This machine is only designed for cutting natural wood stock. Never use it to cut MDF, particle board, plywood, laminates, drywall, backer board, metals, glass, stone, tile, products with lead-based paint, or products that contain asbestos. Cutting these may lead to injury or machine damage.

- **Scrape all glue off the workpiece before jointing or planing.** 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/planer 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.

⚠WARNING

Make sure your workpiece exceeds the minimum dimension requirements shown below before processing it through the jointer/planer, or the workpiece may break or kick back during the operation.

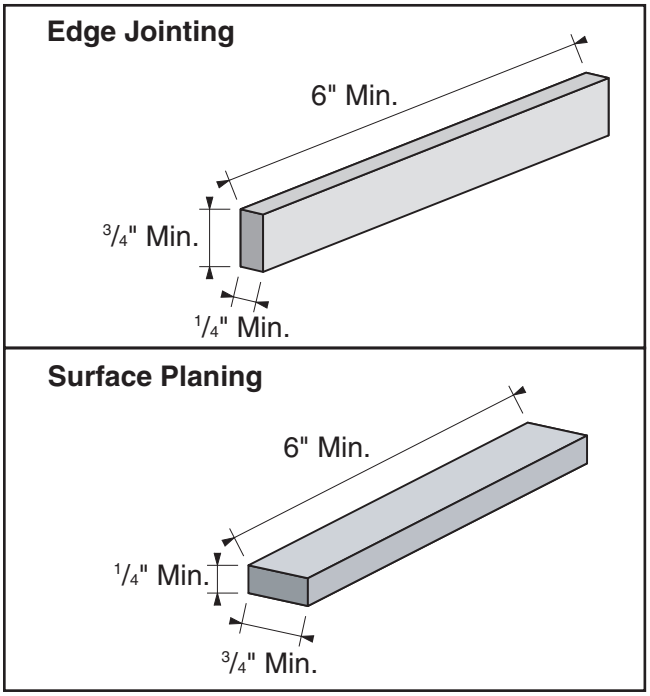


Figure 18. Minimum stock dimensions for jointer.

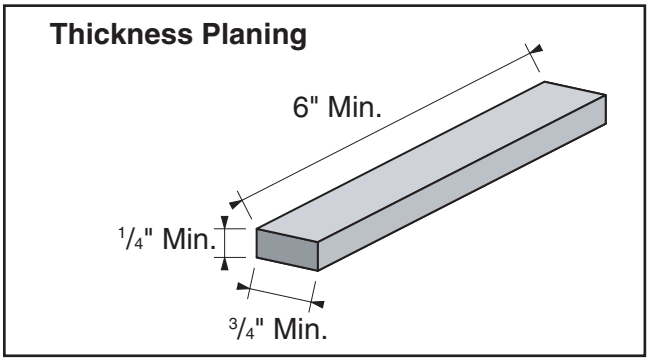


Figure 19. Minimum stock dimensions for planer.

Planing Tips

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

Cutting Problems

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

Chipped Grain

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

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

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

Fuzzy Grain

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

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

Snipe

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

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

Pitch & Glue Build-Up

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

Solution: Clean the rollers and cutterhead.

Chip Marks or Indentations

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

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

Solution:

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

Wood Types

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

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

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

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

Figure 20. Janka Hardness Rating for some common wood species.

Setting Jointer Depth of Cut

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

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

The depth-of-cut scale (see **Figure 22**) goes up to 5/64", but the maximum depth of cut should never exceed 1/16".

⚠CAUTION

Do NOT exceed recommended 1/16" depth of cut per pass or kickback and serious injury may occur.

Adjusting Infeed Table Height

The infeed table adjustment knob (see **Figure 21**) raises and lowers the infeed table. Turn the knob clockwise to raise the table, and counterclockwise to lower the table.

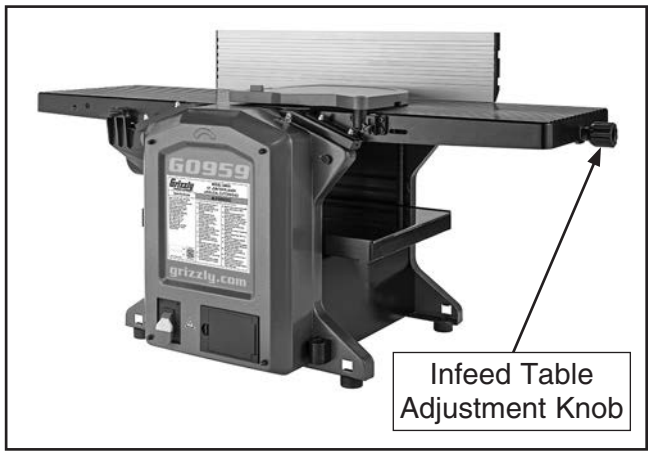


Figure 21. Location of infeed table adjustment knob.

Depth-of-Cut Scale

The depth of cut can be referenced directly from the depth scale located on the front of the machine (see **Figure 22**).

Note: *Depth scale on G0959 can be calibrated or "zeroed" if it is not correct. Refer to* ***Calibrating Jointer Depth-of-Cut Scale (G0959 Only)*** *on* ***Page 48*** *for more information.*

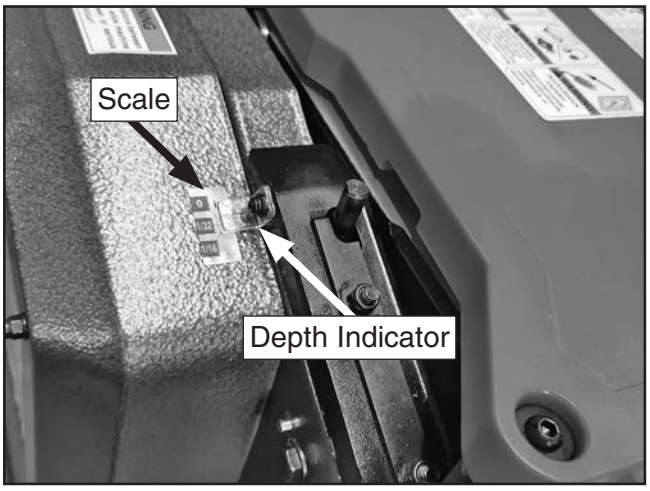


Figure 22. Location of depth-of-cut scale (G0959 shown).

Squaring Stock for Jointing

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

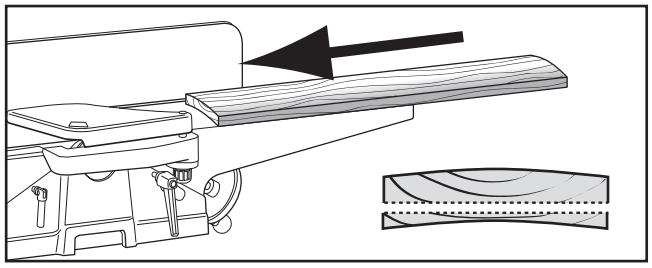
The purpose of squaring stock is to prepare it for accurate cuts and construction later on.

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

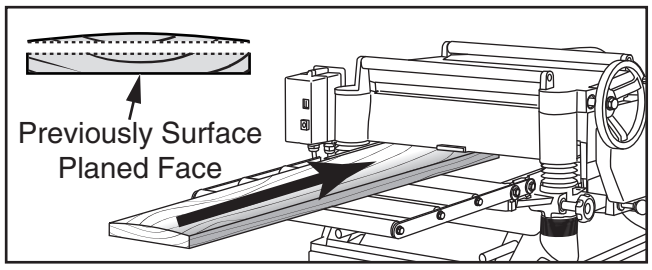
Items Needed	**Qty**
Jointer	1
Planer	1
Table Saw	1

Squaring stock involves four steps performed in the order below:

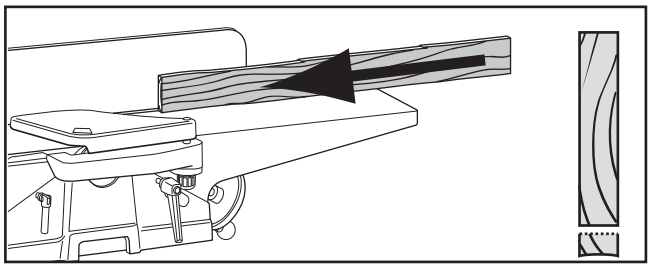
1. **Surface Plane on Jointer**—Concave face of workpiece is surface planed flat with jointer.



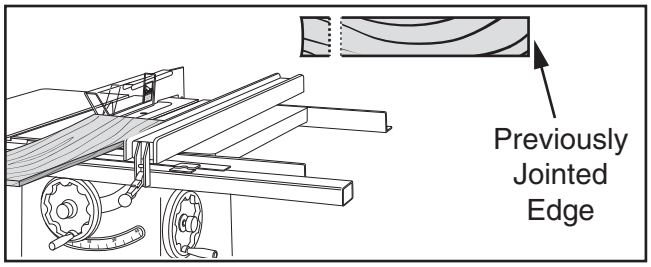
2. **Surface Plane on a Thickness Planer**—Opposite face of workpiece is surface planed flat with a thickness planer.



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



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



Surface Planing on Jointer

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

⚠WARNING

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

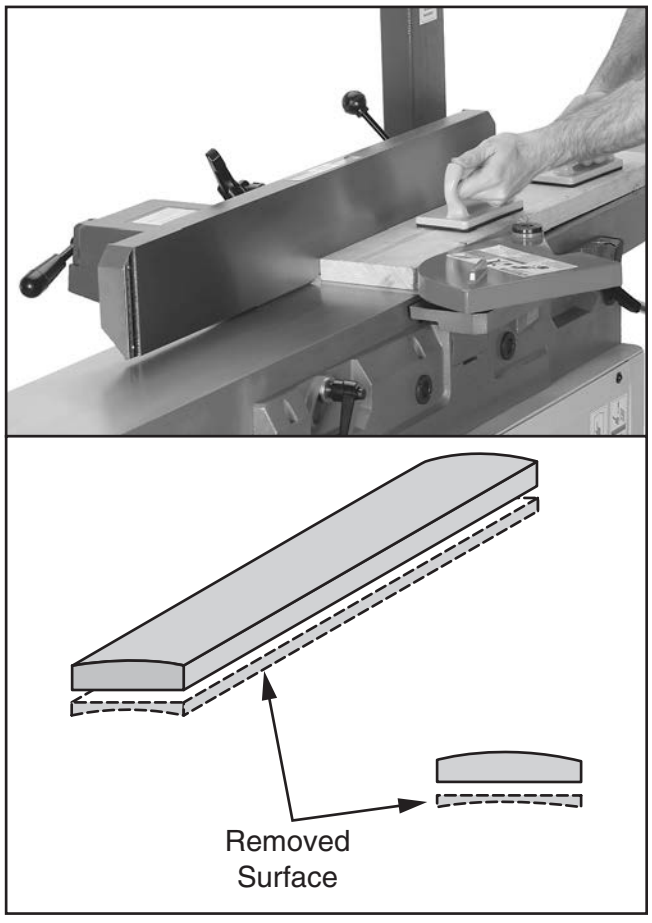


Figure 23. Example photo of a surface planing operation.

To surface plane on jointer:

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

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

   ⚠ **CAUTION:** To minimize risk of kickback, do not exceed a cutting depth of 1/16" per pass when surface planing.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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

Edge Jointing on Jointer

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.

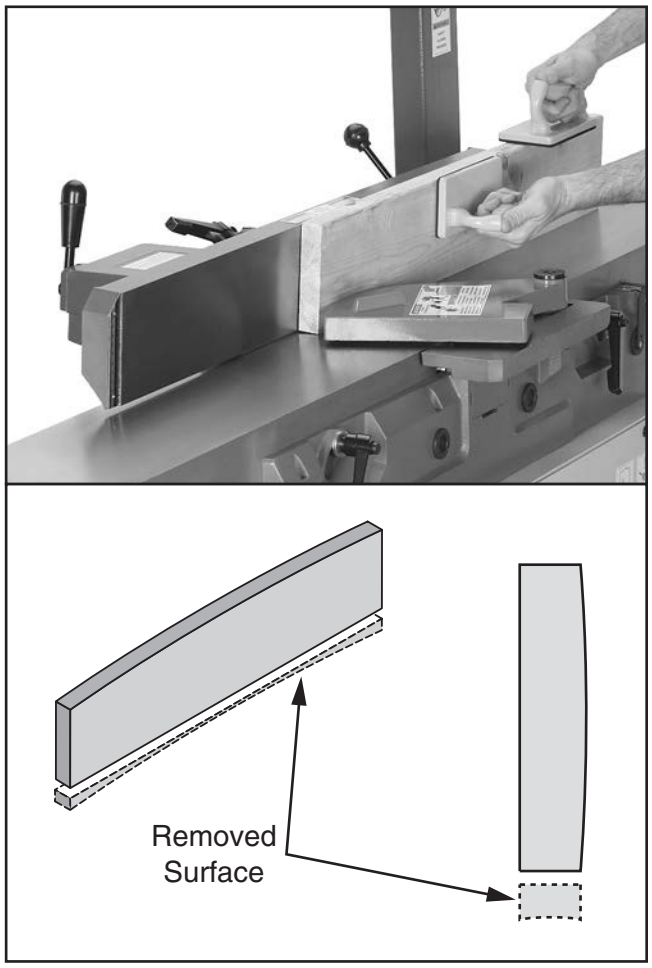


Figure 24. Example photo of an edge jointing operation.

To edge joint on jointer:

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

2. Surface plane workpiece (see **Surface Planing on Jointer** section).

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

   ⚠ **CAUTION:** To minimize risk of kickback, do not exceed a cutting depth of 1/16" per pass.

4. Set fence to 90°.

5. Start jointer.

6. Place workpiece firmly against fence and infeed table with concave side facing down.

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

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

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

8. Repeat **Step 6** until the entire edge is flat.

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

Bevel Cutting on Jointer

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

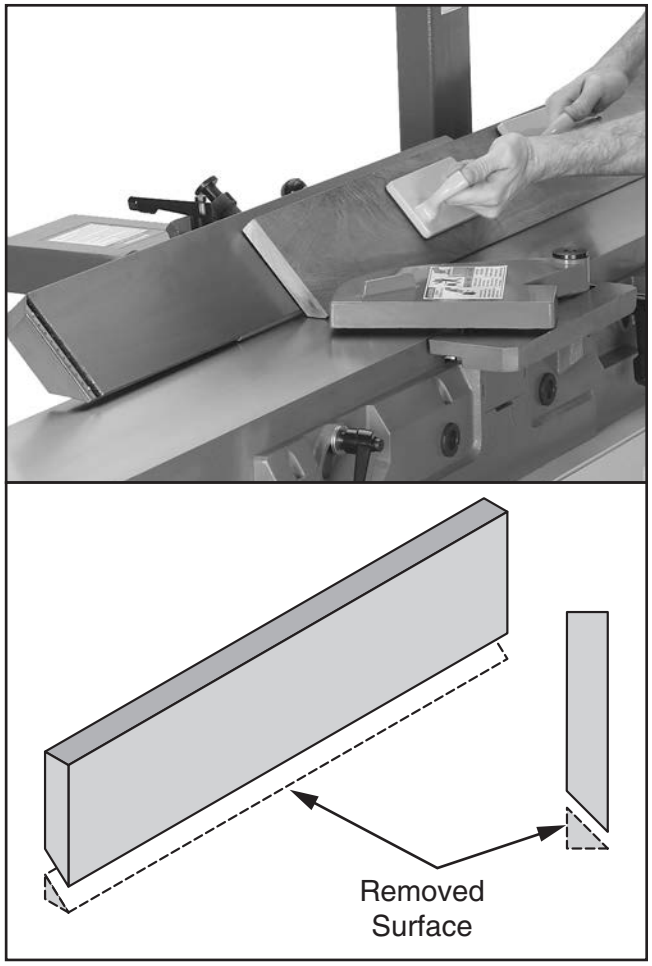


Figure 25. Example photo of fence setup for a bevel cut of 45°.

To bevel cut on jointer:

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

2. Surface plane workpiece (see **Surface Planing on Jointer** section).

3. Edge joint workpiece (see **Edge Jointing on Jointer** section).

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

   ⚠ **CAUTION:** Do not exceed cutting depth of 1/16" per pass.

5. Set fence tilt to desired angle of cut.

6. Place workpiece against fence and infeed table with concave side face down.

7. Start jointer.

8. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

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

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

Jointer/Planer Conversion

After completing the **Assembly** section on **Page 21**, the machine is set up for jointer operations. To prepare the machine for planer operations, the following conversion must be performed: The dust port housing must be moved from the *bottom* of the outfeed table to the *top* of the table, and the cutterhead guard lock-out must be engaged to prevent the guard from springing into position over the cutterhead during planer operations.

To perform jointer/planer conversion:

1. DISCONNECT MACHINE FROM POWER!

2. **G0958 Only:** Move fence all the way right, tilt to 45° outward, and lock in position.

   G0959 Only: Remove fence from support bracket, tilt bracket to 45° outward, and lock in position.

3. Release interlock keys on both sides of outfeed table, and remove dust port housing.

⚠CAUTION

Carbide inserts are very sharp and can quickly cut hands. ALWAYS use caution when working around these parts to reduce risk of personal injury.

4. Rotate cutterhead guard over infeed table and secure with lock-out (see **Figures 26–27**).

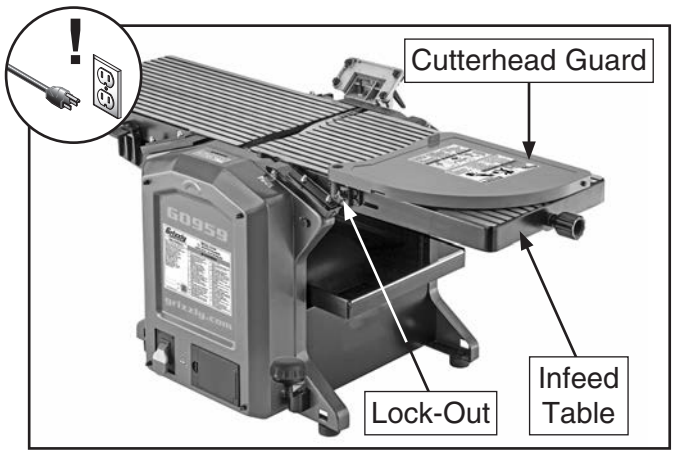


Figure 26. Guard positioned over infeed table (G0959 shown).

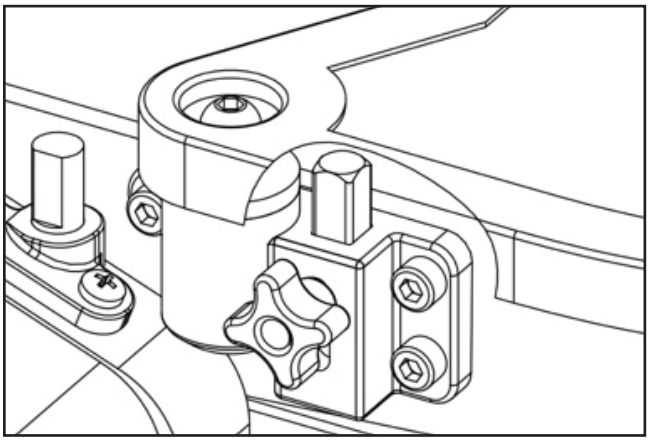


Figure 27. Illustration of cutterhead guard lock-out in raised position.

5. Position dust port housing on top of outfeed table (see **Figure 28**), and secure position by inserting interlock keys in table slots.

6. **G0959 Only:** Thread lock knob into hole in face of infeed table (see **Figure 28**).

7. Install planer table height crank (see **Figure 28**).

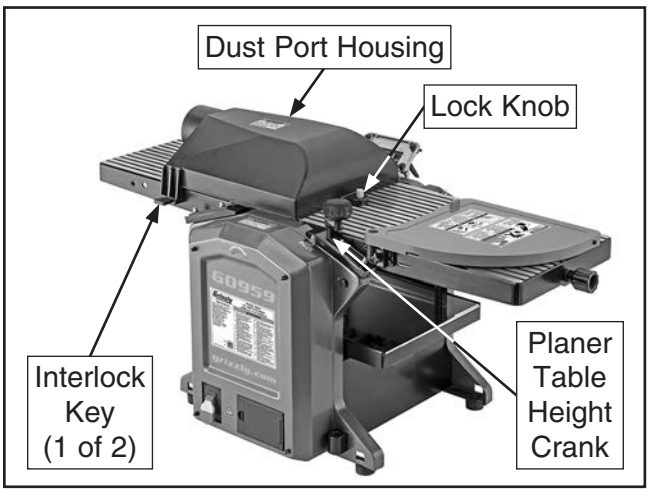


Figure 28. Dust port housing installed on top of outfeed table (G0959 shown).

8. Connect machine to dust collector.

Setting Planer Depth of Cut

Table Movement per Handwheel Revolution
One Full Revolution ..... 1/8"

Material Thickness Range (G0958)..... 1/4"–4 3/4"
Material Thickness Range (G0959)..... 1/4"–6"

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

The depth of cut is set by adjusting the distance of the table beneath the cutterhead. This distance is the thickness of the workpiece minus the depth of cut. The planing depth of cut is controlled by using the planer table height crank on the right side of the machine (see **Figure 29**). Rotating the crank clockwise raises the table.

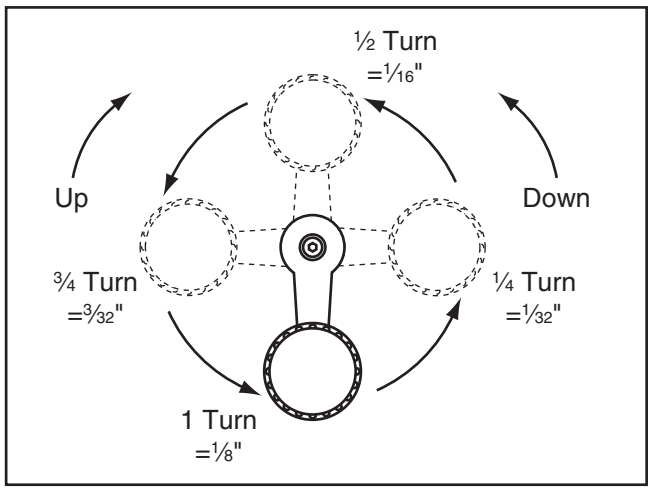


Figure 29. Crank height increments.

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend the maximum depth of cut (per pass) be no more than 3/64". A series of light cuts will give better end results and put less stress on the planer than trying to take off too much material in a single pass.

The thickness scale functions as a general guide only, and is not intended for low-tolerance, precision results. A small amount of backlash may be present with the planer table height crank after switching height directions. Switching height direction may cause slightly less than 1/16" backlash during the first crank turn. As the crank is turned more rotations in the same direction, backlash will not be a factor.

Thickness Scale

The thickness scale (see **Figure 30**) on the right-hand side panel at the front of the machine shows workpiece thickness after it leaves the planer. The thickness measurement is indicated by the arrow.

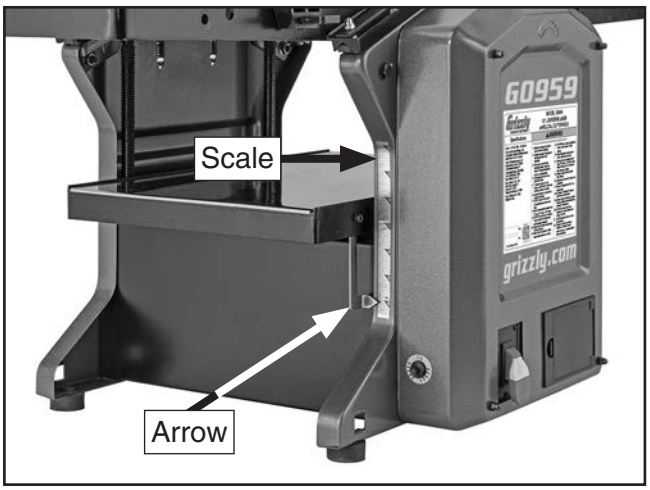


Figure 30. Planer thickness scale components.

Note: *The thickness scale does not provide a precise measurement and should only be used for approximate measurements. If precise workpiece thicknesses are needed, use calipers to ensure your workpieces meet your standards.*

Feeding Workpiece

The feed rate on this planer is automatically set at 22 FPM. Infeed and outfeed rollers move the workpiece through the planer while keeping it firmly against the table and providing a consistent rate of movement.

To feed workpiece into planer:

1. Place first 3"–4" of workpiece flat on planer table, then raise planer table until workpiece just touches depth bar on bottom of jointer outfeed table (see **Figures 31–32**).

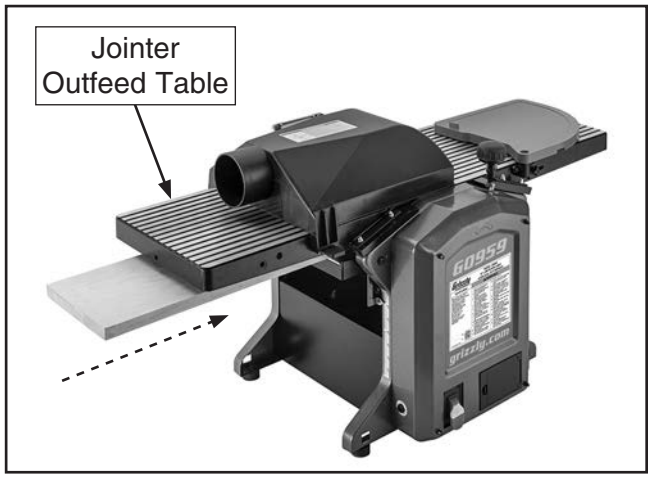


Figure 31. Basic planing operation setup.

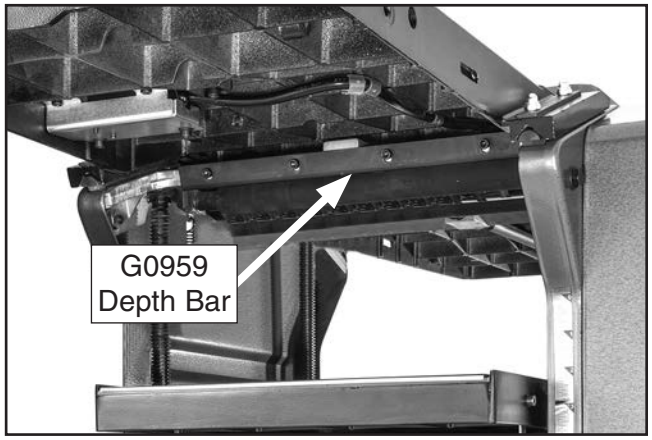


Figure 32. Location of depth bar (G0959 shown).

Note: *On Model G0958, depth bar is incorporated into bottom of jointer outfeed table.*

2. Rotate planer table height crank ¾ turn counterclockwise to lower table approximately 3/32". This will set depth of cut to 1/32". Remove workpiece from planer.

   Note: *Any time you switch directions with planer table height crank, there will be a small amount of backlash—so the first full turn of the crank after switching directions will be slightly less than 1/8". However, as long as you move crank in same direction during operation, backlash will not be a factor.*

3. Turn planer ***ON***.

4. Place workpiece on planer table with side to be planed facing *up* toward cutterhead.

   Note: *Boards more than 24" long should be supported on both sides of planer.*

5. Feed workpiece into front of planer (beneath jointer outfeed table), making sure not to stand directly in front of or behind workpiece to reduce risk of kickback injury.

   — If cut is too deep and bogs down planer, turn planer ***OFF*** immediately and allow it to stop. Lower table, remove workpiece, reduce depth of cut, then repeat **Step 5**.

   Note: *Infeed and outfeed rollers will automatically pull workpiece through planer during operation. Do not push or pull on workpiece once feed rollers have engaged it.*

6. Once workpiece is clear of outfeed roller, measure workpiece thickness. If further planing is needed, raise table another ¼ turn (1/32") of height crank, and repeat cutting operation.

7. Continue process described above until desired workpiece thickness is reached. Thickness scale shows approximate thickness of workpiece *after* it has been cut. Use this indicator to judge when thickness is approximately correct. For more precise applications, measure workpiece thickness with calipers during cutting operation.

Rotating/Replacing Cutterhead Inserts

The helical cutterhead is equipped with indexable carbide inserts that can be rotated to reveal any one of their four cutting edges. If one edge of the insert becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge, as shown in **Figure 33**.

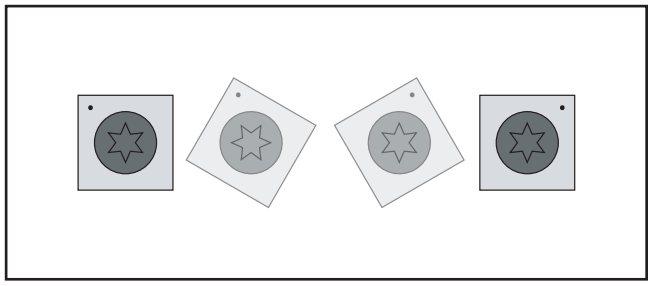


Figure 33. Insert rotating sequence.

Items Needed	Qty
Torque Wrench	1
T-Handle Torx Wrench T-20	1
Heavy Leather Gloves	1 Pair
Light Machine Oil	As Needed
Replacement Inserts	As Needed

To rotate/replace cutterhead insert:

1. DISCONNECT MACHINE FROM POWER!

2. Remove dust port housing if installed on *top* of outfeed table (see **Figure 34**), rotate cutterhead guard over infeed table, and secure with lock-out.

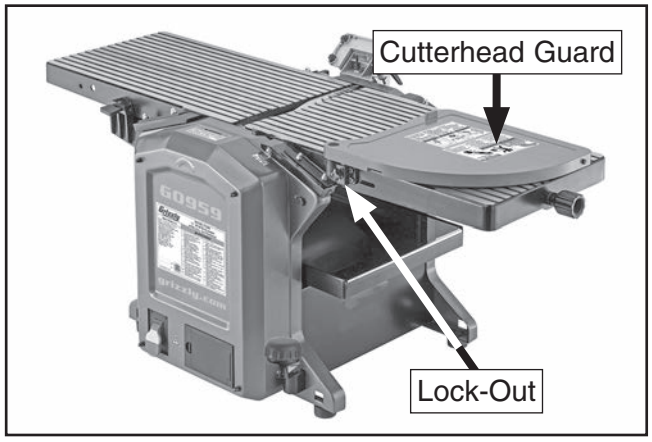


Figure 34. Dust port housing removed, and cutterhead guard lock-out engaged (fence removed for clarity).

3. Put on heavy leather gloves to protect your fingers and hands.

⚠CAUTION

Carbide inserts are very sharp and can quickly cut hands. ALWAYS use caution and heavy leather gloves when handling these parts to reduce risk of personal injury.

4. Remove any sawdust or debris from head of insert, Torx screw, and surrounding area.

5. Remove Torx screw and insert, then clean all dust and debris from both parts and pocket they were removed from.

Note: *Proper cleaning of insert, Torx screw, and cutterhead pocket is critical to achieving a smooth finish. Dirt or dust trapped between insert and cutterhead will raise insert, and make marks on your workpiece when jointing/planing.*

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

6. Rotate insert 90° and install so that a fresh cutting edge faces outward (see **Figure 33**).

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

7. Lubricate Torx screw threads with a very small amount of light machine oil, wipe excess off, and torque screw to 50–55 inch/pounds.

Note: *If too much oil is applied to threads, excess oil will attempt to squeeze out of threaded hole and raise insert during installation, bringing it out of height alignment.*

8. When finished, re-install dust port housing and release lock-out so guard will swing back over 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.

H9893—Carbide Replacement Inserts
Solid carbide indexable inserts for G0958/G0959. Size: 15 x 15 x 2.5mm (10 pack).

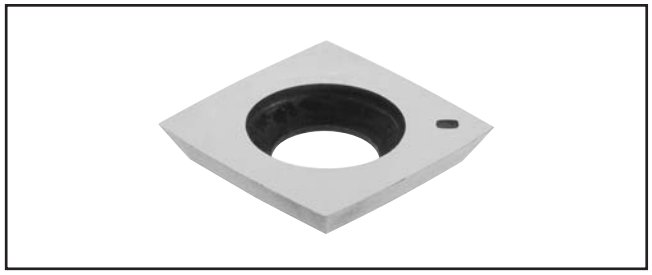


Figure 35. Replacement inserts for Model G0958/G0959.

SB1365—South Bend Way Oil-ISO 68

Figure 36. Recommended product for machine lubrication.

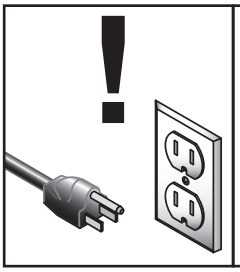
T26419—NLGI#2 Syn-O-Gen Synthetic Grease
Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.

Figure 37. T26419 Syn-O-Gen Synthetic Grease.

G4682—Dry Coating Lube
Spray on saw blades, router bits, shaper cutters - even table tops - to form a low-friction coating that works great, even under high temperature and pressure. Contains no silicone or oil, so it won't stain or damage paint or wood finishes. 9.5 oz.

Figure 38. G4682 Dry Coating Lube.

SECTION 6: MAINTENANCE



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Schedule

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

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.
- Damaged inserts.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check

- Clean chains and sprockets of dust, wood chips, and old grease.
- Lightly coat chains and sprockets with NLGI#2 grease (see **Page 39**).
- Lubricate table height leadscrews with spray lubricant (see **Page 39**).
- Check belt for tension, damage, or wear (see **Page 46**). Also, ensure belt is clean and free of oil or grease that could cause it to slip.
- Clean builtup sawdust and chips underneath machine and around motor.

Cleaning & Protecting

Cleaning the Model G0958/G0959 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.

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.

Items Needed	Qty
Stiff Brush	1
Shop Rags	As Needed
Mineral Spirits	As Needed
T26419 or NLGI#2 Grease Equiv.	As Needed
SB1365 or ISO 68 Equiv.	As Needed
G4682 or Dry Coat Lube Equivalent	As Needed
Open-End Wrench 8mm	1
Open-End Wrench 10mm (G0959 Only)	1

Infeed Table Ways (G0959 Only)

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

Raise infeed table all the way up, remove planer table height crank, remove (2) lock nuts, and set cover aside. Place a couple of drops of oil at top of each way, as needed, and move table up and down to distribute (see **Figure 39**). Re-install cover and lock nuts, and wipe off excess oil. Repeat on opposite side of table.

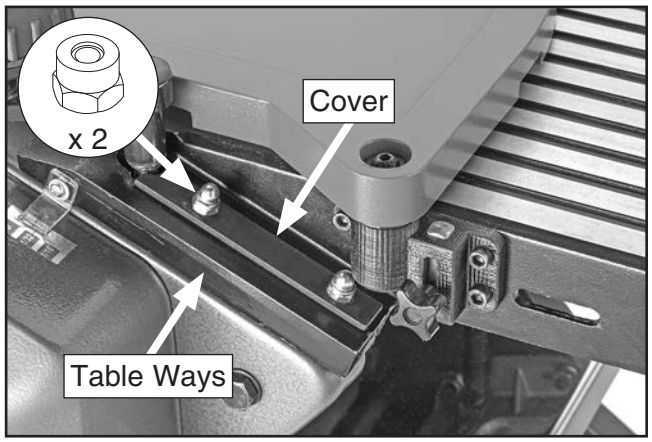


Figure 39. Location of infeed table ways on front of machine.

Infeed Table Adjustment Shaft

Oil Type ..... SB1365 or ISO 68 Equivalent
Oil Amount..... Thin Coat
Frequency..... As Needed

Lubricate threaded portion of infeed table adjustment shaft with light machine oil, as needed (see **Figure 40**). Wipe off excess oil and sawdust with a cloth.

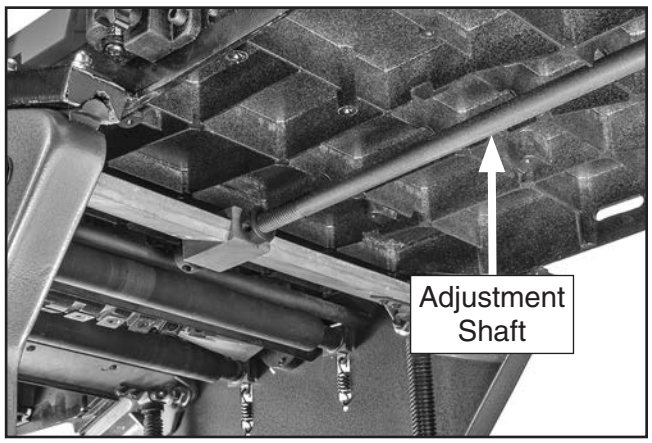


Figure 40. Location of infeed table adjustment shaft.

Table Height Leadscrews

Oil Type ..... G4682 Dry Coating Lube
Oil Amount..... As Needed
Lubrication Frequency..... Monthly

Raise infeed table all the way up. Use mineral spirits and shop rags to clean away any debris and grime, then spray a light coat of dry lube onto the leadscrew threads (see **Figure 41**).

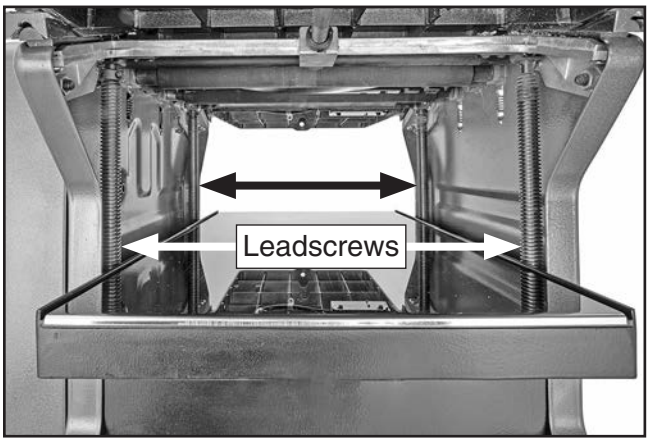


Figure 41. Location of table height leadscrews.

Feed Roller Drive Chain

Grease Type..... T26419 or NLGI#2 or Equiv.
Amount ..... Light Coat
Lubrication Frequency..... Monthly

The infeed and outfeed rollers receive the transferred power from the cutterhead through the drive chain system on the front of the machine (see **Figure 42**). Remove the cover. Use mineral spirits and shop rags to clean away any debris and grime, then brush a light coat of grease onto the chain and sprockets.

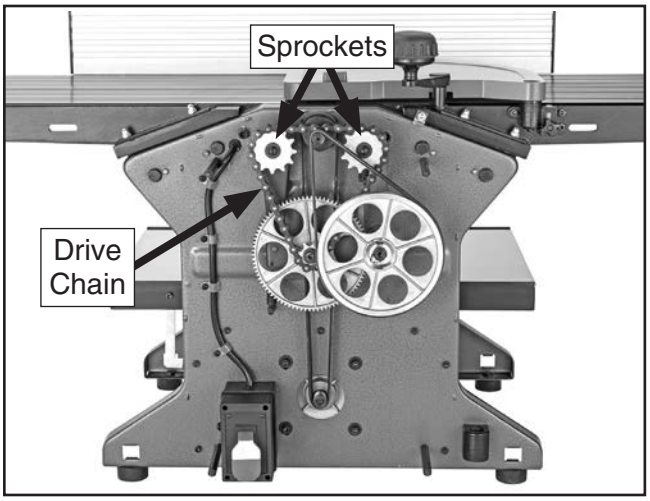


Figure 42. Location of drive chain and sprockets.

Table Height Chain & Sprockets

Oil Type .....T26419 or NLGI#2 or Equiv.
Oil Amount.....Light Coat
Frequency..... As Needed

The table height leadscrews are synchronized by the table height chain and sprockets (see **Figure 43**) located beneath the base of the machine. Lay the machine on its back to access these components. Use mineral spirits and shop rags to clean away any debris and grime, then brush a light coat of grease onto the chain and sprockets. Move table up and down to distribute grease.

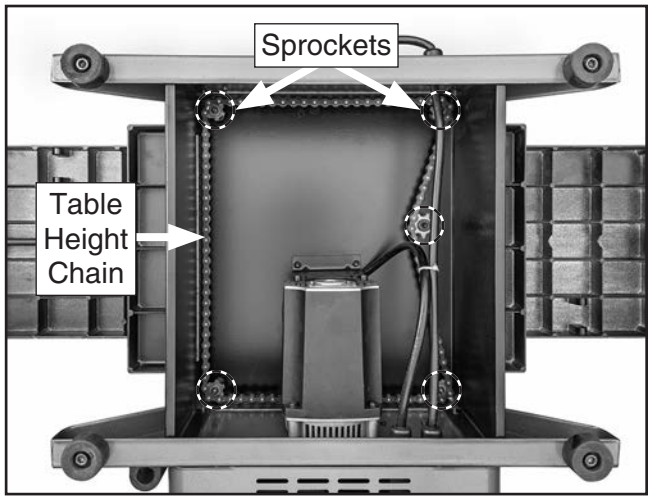
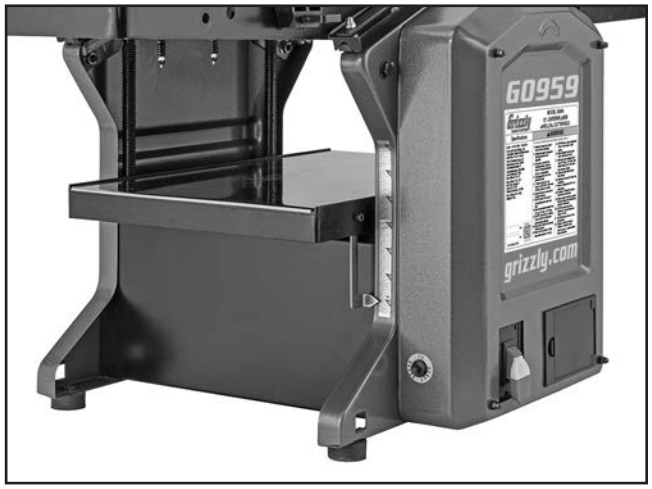


Figure 43. Location of table height chain and sprockets.



Cleaning Infeed & Outfeed Rollers

Saw dust and workpiece grime can accumulate on the infeed and outfeed rollers, creating inconsistent pressure on the workpiece as it is fed through the cutterhead.

Items Needed	Qty
Solvent	1
Shop Rags	As Needed

⚠CAUTION

Carbide inserts are very sharp and can quickly cut hands. ALWAYS use caution and heavy leather gloves when working near these parts to reduce risk of personal injury.

To clean infeed and outfeed rollers:

1. DISCONNECT MACHINE FROM POWER!

2. Lower planer table completely to expose infeed and outfeed rollers (see **Figure 44**).

3. Clean rubber infeed and outfeed rollers with solvent to remove any pitch or stuck-on chips (see **Figure 44**).

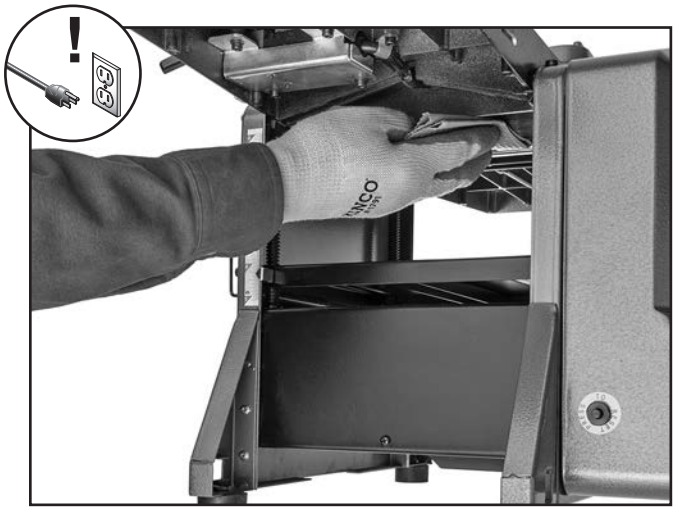


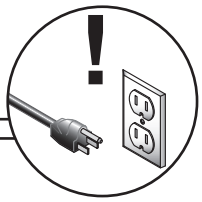
Figure 44. Cleaning infeed roller.

4. Use a vacuum and clean brush to remove any trapped material from between roller and headstock.

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 breaker immediately trips after startup.	1. ON/OFF switch disabling key removed. 2. Interlock switch disabling key(s) removed. 3. Machine circuit breaker tripped or at fault. 4. Incorrect power supply voltage or circuit size. 5. Power supply circuit breaker tripped or fuse blown. 6. Wiring broken, disconnected, or corroded. 7. Motor brushes worn out. 8. ON/OFF or circuit breaker switch at fault. 9. Interlock switch at fault. 10. Motor or motor bearings at fault.	1. Install ON/OFF switch disabling key. 2. Install interlock switch disabling key(s). 3. Reset circuit breaker on switch. 4. Ensure correct power supply voltage and circuit size. 5. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 6. Fix broken wires or disconnected/corroded connections (**Page 54**). 7. Remove/replace brushes (**Page 52**). 8. Replace switch/circuit breaker. 9. Replace switch. 10. Replace motor.
Machine stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Feed rate/cutting speed too fast. 3. Excessive depth of cut. 4. Machine undersized for task. 5. Belt(s) slipping/pulleys misaligned. 6. Motor brushes worn out. 7. Pulley/sprocket slipping on shaft. 8. Motor overheated, tripping machine circuit breaker. 9. Extension cord too long. 10. Motor or motor bearings at fault.	1. Only cut wood/ensure moisture is below 20% (**Page 27**). 2. Decrease feed rate/cutting speed (jointer). 3. Decrease depth of cut (**Pages 30** & **36**). 4. Use correct/sharp inserts (**Page 38**). Reduce feed rate or depth of cut (**Pages 30** & **36**). 5. Clean/tension/replace belt(s); ensure pulleys are aligned (**Page 46**). 6. Replace motor brushes (**Page 52**). 7. Tighten/replace loose pulley/shaft. 8. Clean motor, let cool, and reduce workload. Reset breaker. 9. Move machine closer to power supply; use shorter extension cord. 10. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Feet not adjusted properly. 3. V-belt(s) worn, loose, pulleys misaligned or belt slapping cover. 4. Insert(s) at fault. 5. Pulley loose. 6. Motor mount loose/broken. 7. Cutterhead bearings at fault. 8. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Adjust feet to stabilize machine. 3. Inspect/replace belts with a new matched set. Re-align pulleys if necessary (**Page 46**). 4. Replace/rotate insert(s) (**Page 38**). 5. Secure pulley on shaft. 6. Tighten/replace. 7. Replace bearing(s)/realign cutterhead. 8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Jointer Operations

Symptom	Possible Cause	Possible Solution
Table is hard to adjust.	1. Table height shaft is dirty or lock collars are misaligned. 2. Infeed table lock screws too tight.	1. Clean shaft and properly align collars (**Page 51**). 2. Loosen screws on both sides just enough to allow table to move smoothly.
Excessive snipe (gouge in end of board that is uneven with rest of cut); back of workpiece is concave.	1. Operator pushing down on trailing end (infeed side) of workpiece as it leaves cutterhead.	1. Focus most of the workpiece pressure against outfeed table while cutting.
Workpiece chipping, tear-out, indentations, or overall rough cuts.	1. Workpiece is rough or has loose knots/ surface flaws; not suitable for jointing 2. Not feeding workpiece to cut "with" the grain. 3. Dull insert(s). 4. Nicked or chipped insert(s). 5. Feeding workpiece too fast. 6. Excessive depth of cut. 7. Lack of proper dust collection or clogged dust port.	1. Inspect workpiece (**Page 26**). Use smooth stock without loose knots/surface flaws. 2. Flip workpiece 180° before feeding again. 3. Rotate/replace insert(s) (**Page 38**). 4. Rotate/replace insert(s) (**Page 38**). 5. Reduce feed rate. 6. Reduce depth of cut. 7. Clear blockages, ensure dust collection is operating efficiently; upgrade dust collector.
Fuzzy grain left in workpiece.	1. Wood has high moisture content. 2. Dull insert(s).	1. Ensure wood moisture content is less than 20%. Allow to dry if necessary. 2. Replace/rotate insert(s) (**Page 38**).
Long lines or ridges that run along the length of the board.	1. Nicked or chipped insert(s). 2. Loose or incorrectly installed insert(s). 3. Dirt or debris under insert(s).	1. Replace/rotate insert(s) (**Page 38**). 2. Remove/replace insert(s) and install properly. 3. Remove insert(s), clean bottom of insert/cutterhead mounting pocket, and re-install (**Page 38**).
Uneven cutter marks, wavy surface, or chatter marks across face of workpiece.	1. Feeding workpiece too fast. 2. Insert(s) not adjusted at even heights in cutterhead. 3. Dirt or debris under insert(s).	1. Reduce feed rate. 2. Remove, clean, and re-install any inserts that are "raised" in cutterhead (**Page 38**). 3. Remove insert(s), clean bottom of insert/cutterhead mounting pocket, and re-install (**Page 38**).
Glossy surface; scorching or burn marks on workpiece.	1. Dull insert(s). 2. Feed rate too slow.	1. Rotate/replace insert(s) (**Page 38**). 2. Increase feed rate.
Workpiece is concave or convex along its length after jointing.	1. Workpiece not held with even pressure against outfeed table during cut. 2. Workpiece too uneven at start of operation.	1. Apply even downward pressure against workpiece throughout entire travel along outfeed side during cut. 2. Take partial cuts to remove extreme high spots before doing a full pass.
Workpiece edges not square; tapered cut produced.	1. Fence not square to table; fence tilt unlocked. 2. Warped infeed or outfeed table. 3. Insert(s) not adjusted at even heights in cutterhead.	1. Square fence to table; lock fence. 2. Replace table. 3. Remove, clean, and re-install any inserts that are "raised" in cutterhead (**Page 38**).

Planer Operations

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge at the end of the workpiece that is uneven with the rest of the cut). **Note:** *A small amount of snipe is inevitable with all types of planers—the key is to minimize it.*	1. Workpiece not supported as it leaves planer. 2. Some snipe is inevitable.	1. Hold workpiece up slightly as it leaves outfeed end of planer. 2. Plane lumber longer than your intended workpiece length, then cut off excess after planing complete.
Workpiece stops/slows in middle of cut.	1. Excessive depth of cut. 2. Pitch and glue buildup on planer components.	1. Reduce depth of cut (**Page 36**). Reduce cutting depth when planing hard woods. 2. Clean internal cutterhead components with pitch/resin dissolving solvent.
Chipping (consistent pattern).	1. Knots or conflicting grain direction in wood. 2. Taking too deep of a cut. 3. Nicked, chipped, or dull inserts.	1. Inspect workpiece for knots and grain direction; only use clean stock, and cut WITH the grain (**Page 26**). 2. Reduce depth of cut. (Reduce cutting depth when planing hard woods.) (**Page 36**) 3. Rotate/replace insert(s) (**Page 38**).
Chipping/indentation in workpiece surface (inconsistent pattern).	1. Chips aren't being properly expelled from cutterhead.	1. Use proper dust collection system.
Fuzzy grain.	1. Wood may have high moisture content or surface wetness. 2. Dull insert(s).	1. Check moisture content is below 20% and allow to dry if moisture is too high (**Page 27**). 2. Rotate/replace insert(s) (**Page 38**).
Long lines or ridges that run along length of board.	1. Nicked or chipped insert(s).	1. Rotate/replace insert(s) (**Page 38**).
Uneven cutting marks, wavy surface, or chatter marks across face of board.	1. Insert(s) not properly installed. 2. Worn cutterhead bearings.	1. Remove insert(s), properly clean mounting pocket, and re-install (**Page 38**). 2. Check/replace cutterhead bearings.
Glossy surface.	1. Dull insert(s). 2. Cutting depth too shallow.	1. Rotate/replace insert(s) (**Page 38**). 2. Increase depth of cut (**Page 36**).
Infeed/outfeed rollers not rotating.	1. Chain and sprockets are worn, misadjusted, disconnected, or broken.	1. Adjust chain and sprockets (**Page 52**); replace if necessary.
Vibration when running or cutting.	1. Loose/damaged insert(s). 2. Damaged V-belt. 3. Worn cutterhead bearings. 4. Loose/damaged cutterhead.	1. Tighten/replace insert(s) (**Page 38**). 2. Replace belt (**Page 46**). 3. Check/replace cutterhead bearings. 4. Tighten/replace cutterhead.

Tensioning/ Replacing V-Belts

The Model G0958/G0959 uses two V-belts. The drive belt transfers power from the motor to the cutterhead, and the feed belt transfers power from the cutterhead to the infeed and outfeed rollers. To ensure efficient transfer of power to these systems, make sure the belts are always properly tensioned and in good condition.

If the belts are worn, cracked, or damaged, replace them immediately.

Items Needed	Qty
Hex Wrenches 4mm	1 Ea.
Open-End Wrench or Socket 8mm	1
Replacement Feed Belt	
G0958 (PN P0958123)	1
G0959 (PN P0959167)	1
Replacement Drive Belt	
G0958 (PN P0958124)	1
G0959 (PN P0959166)	1

⚠CAUTION

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

Replacing Feed Belt

Due to the design of the machine, the feed belt can be replaced, but there is not a mechanism for tensioning the belt. When installed correctly, the belt will be properly tensioned.

To replace feed belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove front cover.
3. Roll belt off pulleys and install new belt (see **Figure 45**).

   Note: *The elasticity of the feed belt makes it possible to easily stretch it over the pulleys.*

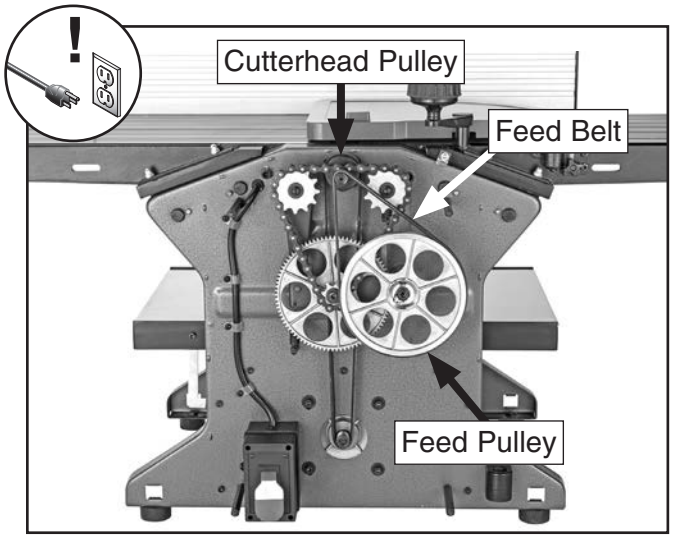


Figure 45. Feed belt components.

4. When belt is fully on both pulleys, rotate it several times to make sure belt ribs are fully seated in pulley grooves.
5. Re-install front cover.

Tensioning/Replacing Drive Belt

In order to remove the drive belt, the feed belt must first be removed.

To tension/replace drive belt:

1. DISCONNECT MACHINE FROM POWER!

2. Remove front cover.

3. If drive belt needs to be replaced, roll feed belt off pulleys (see **Figure 46**).

4. Loosen (do not remove) (4) motor mount screws (see **Figure 46**) to release tension on drive belt, then roll belt off pulleys and install new belt.

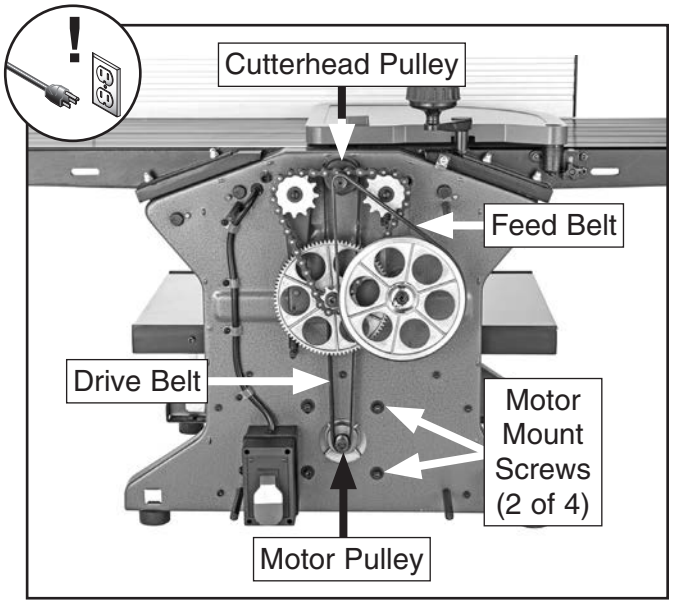


Figure 46. Drive belt components.

5. Once belt is installed on both pulleys, rotate it several times to make sure belt ribs are fully seated in pulley grooves.

6. To adjust belt tension, press down on motor to maintain tension on belt.

7. Press belt with moderate pressure in center to check belt tension. Belt is correctly tensioned when there is approximately ¼" deflection when pushed, as shown in **Figure 47**.

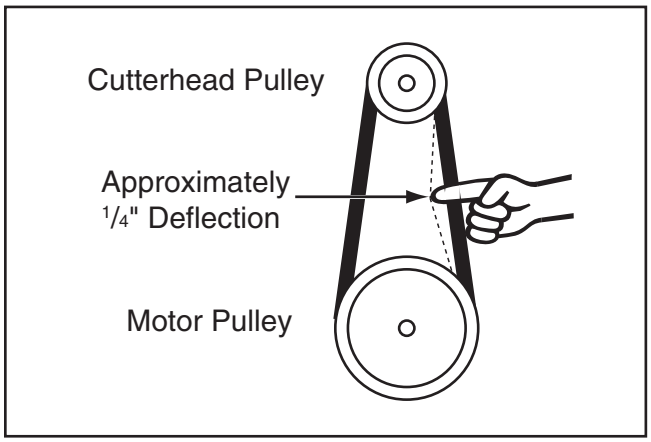


Figure 47. Correct amount of belt deflection.

8. Once belt tension is correct, tighten motor mount screws, re-install feed belt, and re-install front cover.

Calibrating Jointer Depth-of-Cut Scale (G0959 Only)

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

Tools Needed	Qty
Straightedge	1
Phillips Head Screwdriver #2	1

To calibrate jointer depth-of-cut scale:

1. DISCONNECT MACHINE FROM POWER!

2. Use a straightedge to ensure infeed table is exactly even with outfeed table, as shown in **Figure 48**.

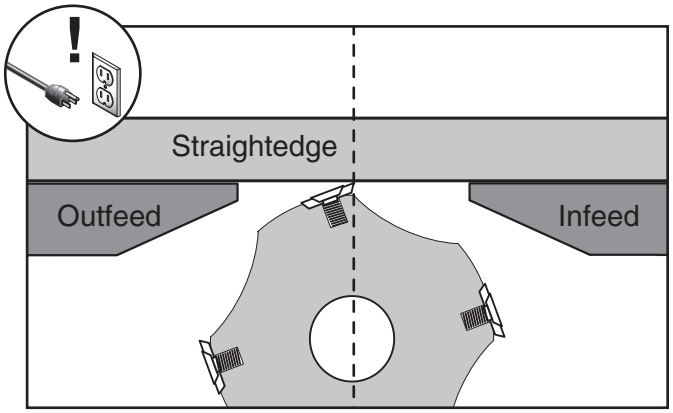


Figure 48. Infeed table even with outfeed table.

3. Loosen Phillips head screw (see **Figure 49**), adjust scale pointer to zero, then tighten screw.

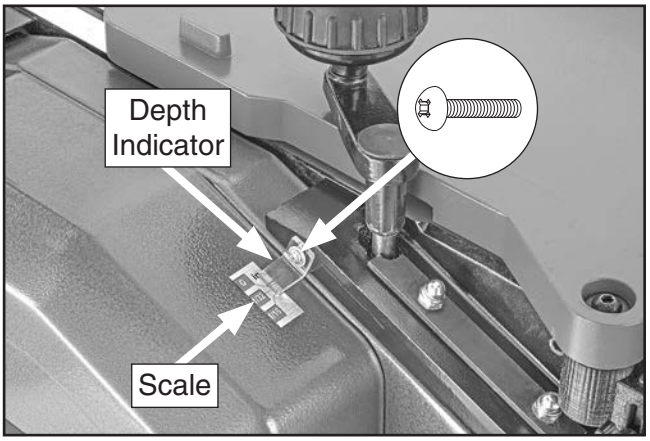


Figure 49. Scale adjusted to "0" position.

Calibrating Planer Thickness Scale

Although correctly set at the factory, the scale can be adjusted for accuracy if it becomes necessary. The steps below reference Model G0959, but the steps for adjusting the scale on Model G0958 are very similar.

Items Needed	Qty
Phillips Head Screwdriver #2 (G0958)	1
Hex Wrench 4mm (G0959)	1
Scrap Piece of Stock	1
Calipers	1

To calibrate planer thickness scale:

1. Plane scrap piece of stock until it is flat on both sides and has even thickness along its length.

   Note: *Turn scrap board over between each pass to make surfaces parallel.*

2. Use calipers to measure board thickness.

3. If there is a discrepancy between board thickness and reading on height scale, loosen cap screw shown in **Figure 50**, adjust position of arrow to indicate correct thickness, then tighten screw.

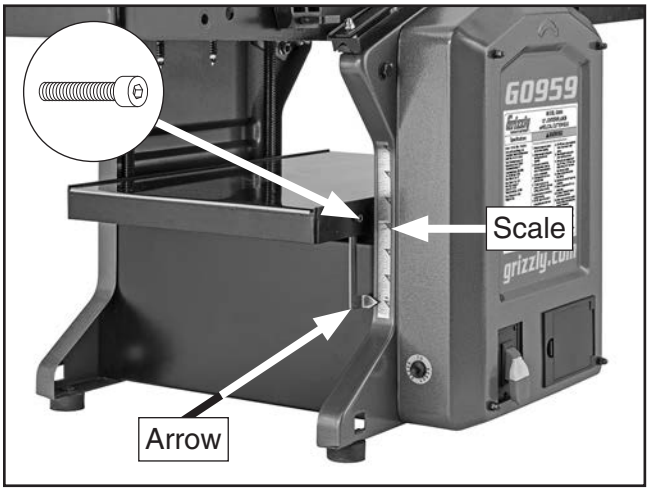


Figure 50. Scale components used to calibrate thickness reading.

Setting Fence Stops

The fence on the Model G0958/G0959 has adjustable stops at the 90º and 45º outward (135º) positions for quickly and accurately setting the desired fence angle.

Note: *To ensure accurate results when jointing, check the accuracy of these settings frequently (every month at a minimum).*

Tools Needed	Qty
Hex Wrenches 2.5, 4, 5mm	1 Ea.
Open-End Wrench 7, 8, 10mm	1 Ea.
Combination Square	1
Phillips Head Screwdriver #2	1

Setting 90º Fence Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock handle (see **Figures 51–52**) and adjust fence to 90º position (0º on fence scale), then tighten handle.

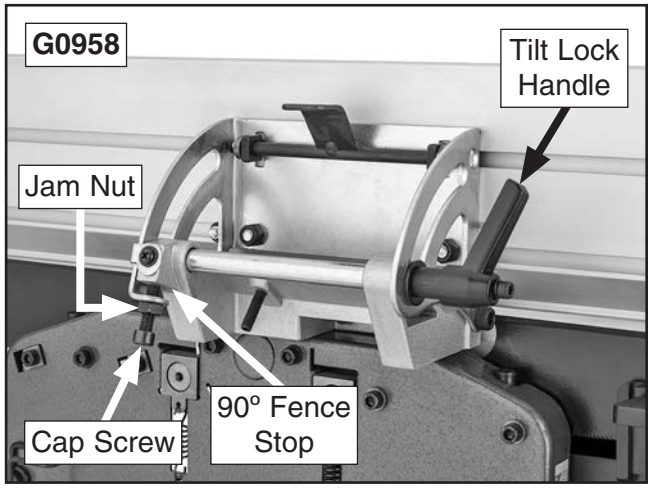


Figure 51. Components for setting 90º fence angle (G0958).

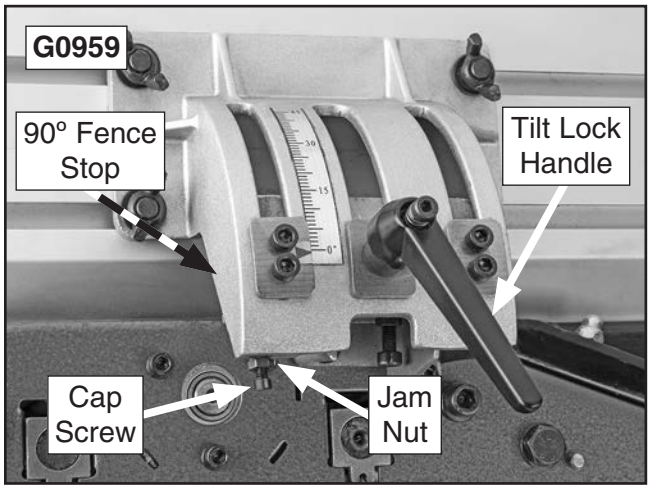


Figure 52. Components for setting 90º fence angle (G0959).

3. Place combination square on jointer table with 90º side against fence (see **Figure 53**).

— If fence *is* flush against combination square, 90º fence stop is set correctly. No adjustment is necessary.

— If fence *is not* flush against combination square, proceed to **Step 4**.

Figure 53. Example of checking 90º fence angle with square.

4. Loosen jam nut and cap screw shown in **Figures 51–52**.

5. Loosen fence tilt lock handle, adjust fence until it is flush against combination square, then tighten handle.

6. Adjust cap screw until it just touches 90º fence stop, then tighten jam nut without letting cap screw move.

Setting 45° Outward (135°) Fence Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock handle (see **Figures 54–55**) and adjust fence to 45° outward position, then tighten handle.

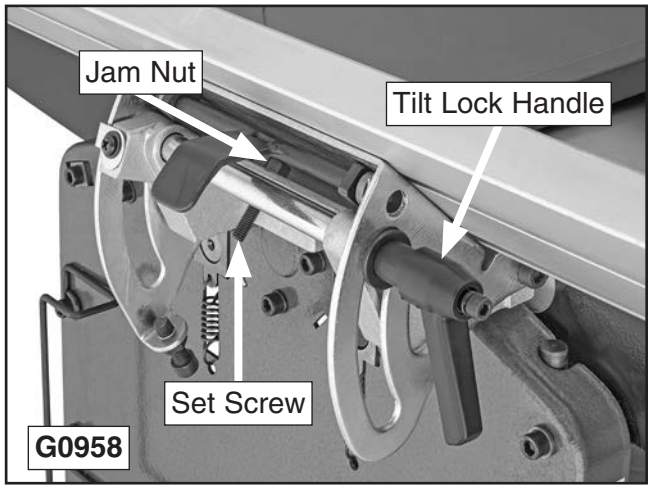


Figure 54. Components for setting 45° fence angle (G0958).

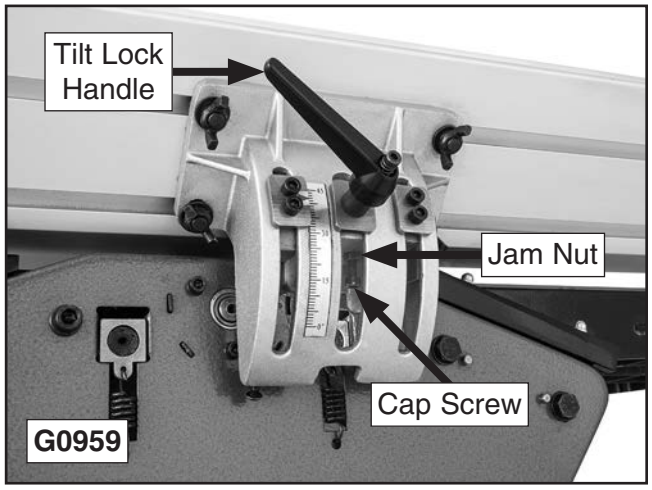


Figure 55. Components for setting 45° fence angle (G0959).

3. Place combination square on jointer table with 45° side against fence (see **Figure 56**).

   — If fence *is* flush against combination square, 45° fence stop is set correctly. No adjustment is necessary.

   — If fence *is not* flush against combination square, proceed to **Step 4**.

Figure 56. Example of checking 45° fence angle with square.

4. Loosen fence tilt lock handle, adjust fence until it is flush against combination square, then tighten handle.

5. **G0958 Only:** Loosen jam nut (see **Figure 54**), adjust set screw until it just touches back of fence, then tighten jam nut without letting set screw move.

   G0959 Only: Loosen jam nut (see **Figure 55**), adjust cap screw until it just touches back of fence, then tighten jam nut without letting cap screw move.

Setting Infeed Table Positive Stops

The infeed tables on the Model G0958/G0959 include positive stops that can be adjusted to allow the operator to quickly adjust table height between cuts.

We recommend setting the minimum depth of cut to 1/32", and the maximum depth of cut to 1/16" for most operations.

⚠WARNING

Do not exceed 1/16" cut per pass on this machine or the risk of kickback and serious injury will be greatly increased!

Each positive stop controls the top or bottom range of movement for the infeed table. The jam nuts on the G0958 (see **Figure 57**) and the set screws on the G0959 (see **Figure 58**) lock the stops in position so they will not move during operations.

Tools Needed	**Qty**
Hex Wrench 3mm (G0959 Only)	1
Open-End Wrench 10mm (G0958 Only)	1

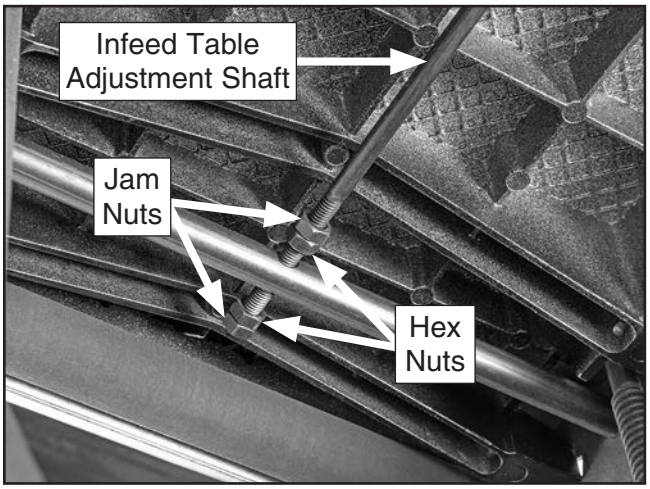


Figure 57. Location of infeed table positive stops (G0958).

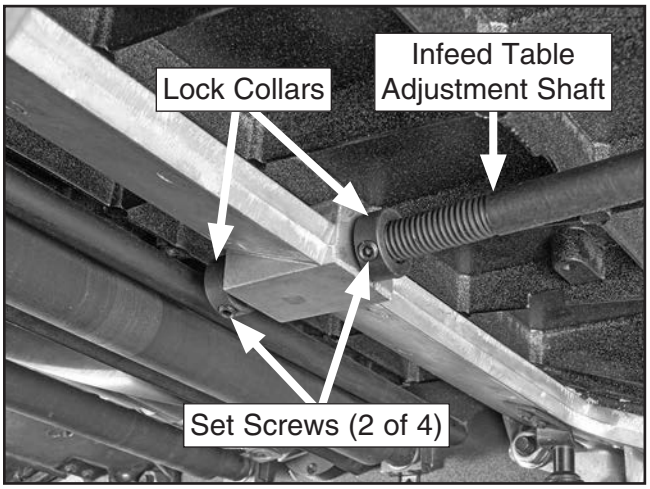


Figure 58. Location of infeed table positive stops (G0959).

Adjusting Table Height Chain

The table height chain transfers movement from the planer table height crank to the columns that control table height. The chain drive can be adjusted to remove slack if the chain stretches over time.

Tool Needed	Qty
Hex Wrench 6mm	1

To adjust table height chain:

1. DISCONNECT MACHINE FROM POWER!

2. Gently lay machine on its back to expose table height chain beneath machine base.

> ***NOTICE***
> **Do not let chain fall off sprockets. It can be very difficult to return chain to its proper location on sprockets without changing table adjustments.**

3. Loosen cap screw shown in **Figure 59**, then push idler sprocket against chain with moderate pressure. Maintain pressure on sprocket and tighten cap screw.

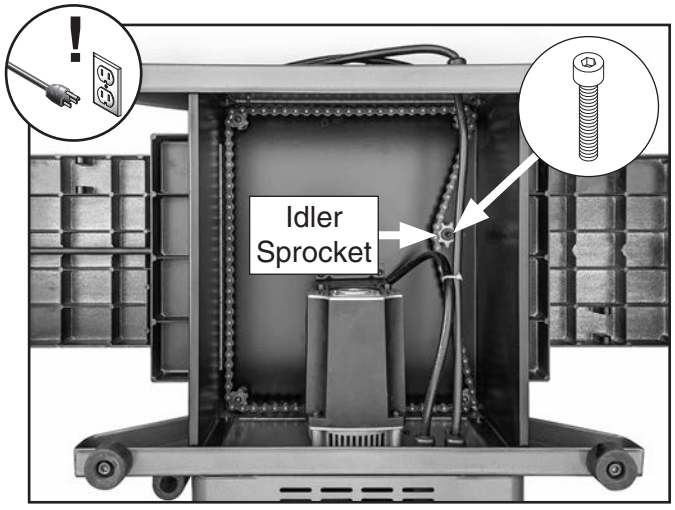


Figure 59. Location of table height chain and idler sprocket.

Checking/Replacing Motor Brushes

The motor on the G0958/G0959 is equipped with two long-life carbon brushes—one on each side of the motor. The brush life is affected by motor loads and usage. Worn brushes will result in intermittent operation and difficulty starting the motor. If either brush is worn down to ¼" (6mm) or less, replace both brushes as a set.

Items Needed	Qty
Flat Head Screwdriver 3⁄16"	1
Motor Brushes (PN P0958084-1)	2

To check/replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!

2. Gently lay machine on its back to expose motor beneath machine base.

3. Unscrew plastic brush covers, and remove motor brush assemblies (see **Figure 60**).

   Note: *As you remove brush assembly, make note of carbon tip orientation. If found acceptable, re-install in same way.*

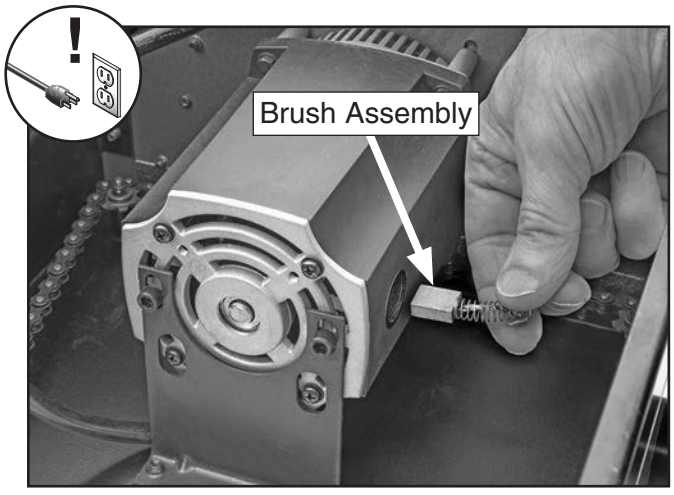


Figure 60. Removing motor brush.

4. Measure length of carbon tip. If carbon tip is worn down to ¼" (6mm) or less, replace both brush assemblies with new ones.

5. Insert brush assemblies back into motor, re-install plastic caps, and position machine right-side up.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket 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	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram

Figure 61. Interlock switch wiring.

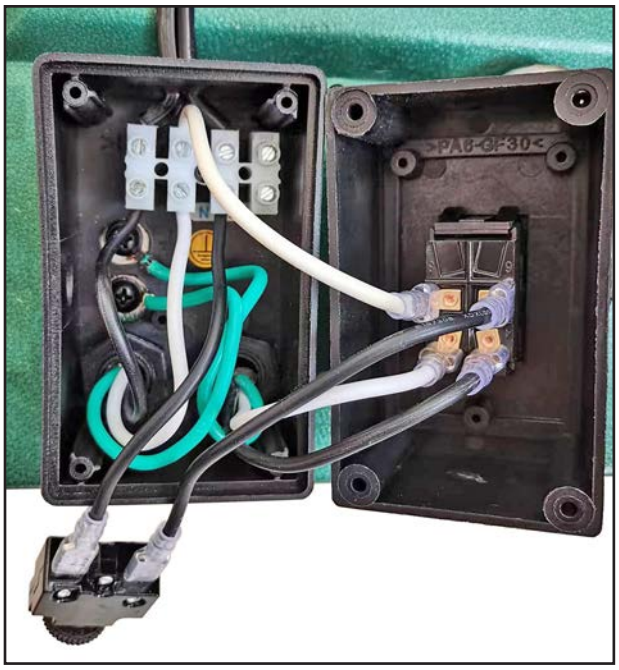
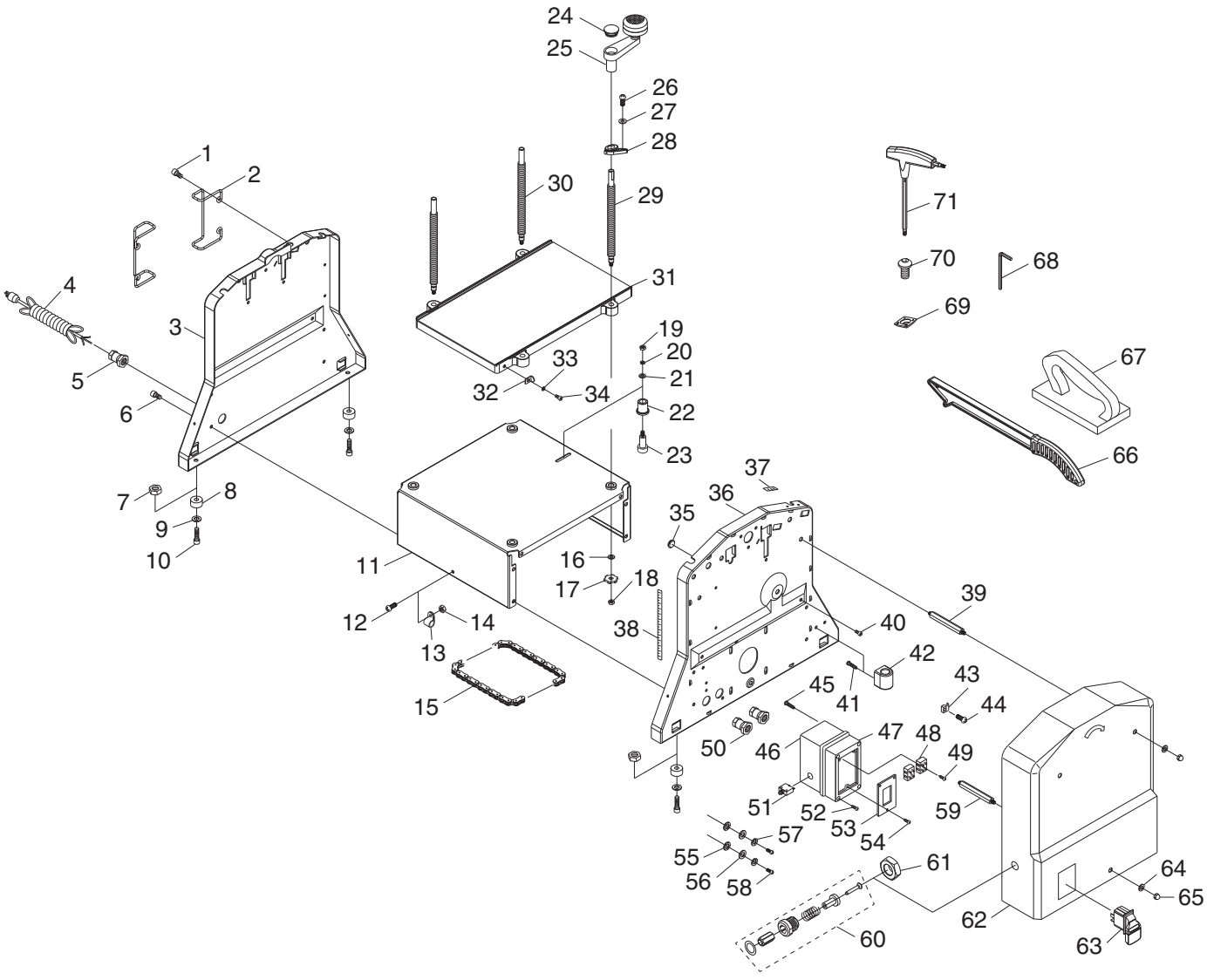


Figure 62. Switch box wiring.

SECTION 9: PARTS

Please Note: *We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call* ***(800) 523-4777*** *or visit our online parts store at* ***www.grizzly.com*** *to check for availability.*

G0958 Planer Table & Frame

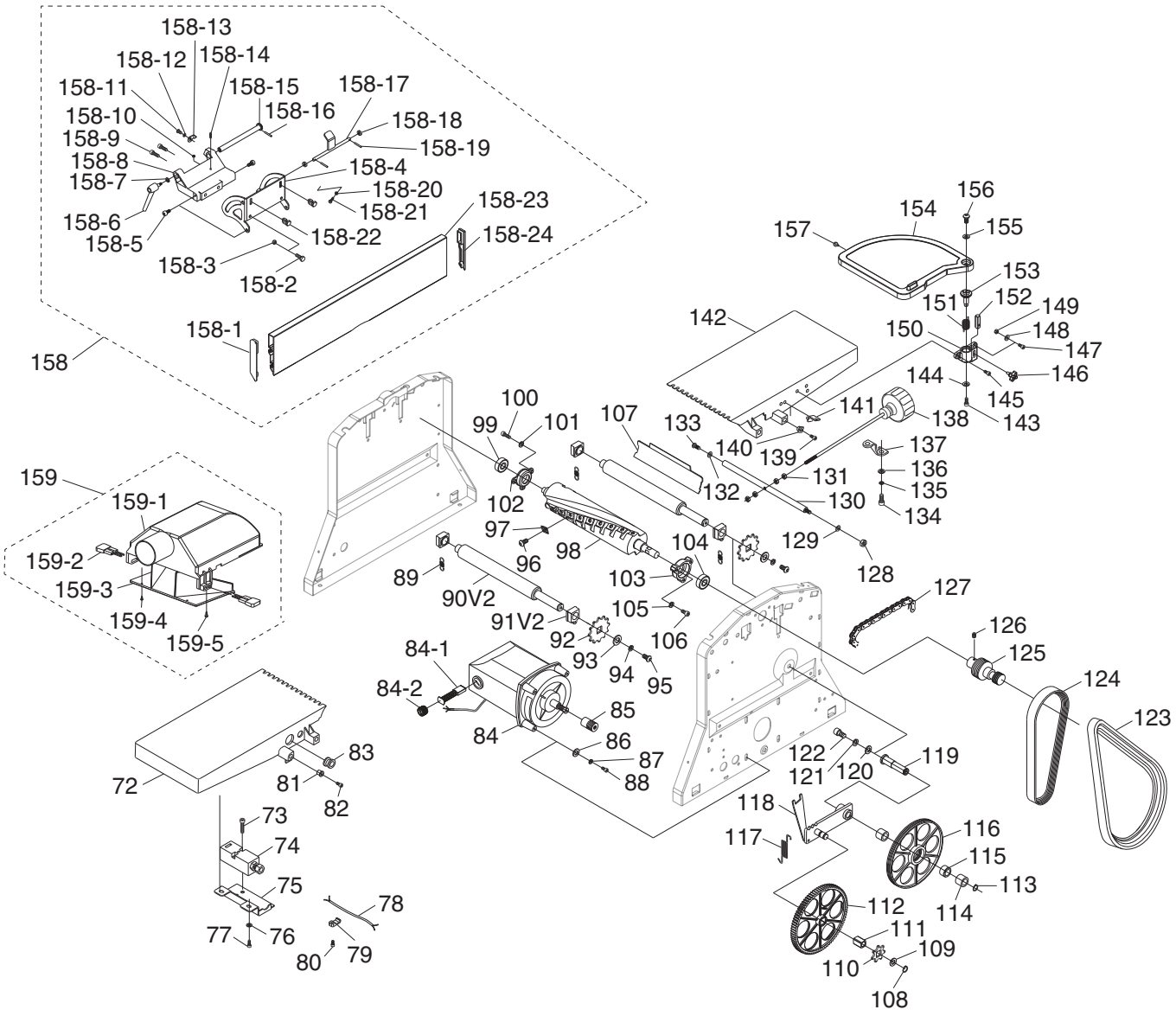


G0958 Planer Table & Frame Parts List

REF	PART #	DESCRIPTION
1	P0958001	CAP SCREW M5-.8 X 10
2	P0958002	CORD HOOK
3	P0958003	REAR SUPPORT PANEL
4	P0958004	POWER CORD 14G 3W 72" 5-15P
5	P0958005	STRAIN RELIEF TYPE-3 M16-1.5
6	P0958006	CAP SCREW M5-.8 X 10
7	P0958007	HEX NUT M8-1.25
8	P0958008	FOOT (RUBBER)
9	P0958009	FLAT WASHER 8MM
10	P0958010	CAP SCREW M8-1.25 X 16
11	P0958011	BASE
12	P0958012	PHLP HD SCR M5-.8 X 14
13	P0958013	CORD CLAMP
14	P0958014	HEX NUT M5-.8
15	P0958015	CHAIN 78L X 12.7 TYPE 081
16	P0958016	FLAT WASHER 8MM
17	P0958017	SPROCKET 6T
18	P0958018	LOCK NUT M5-.8
19	P0958019	HEX NUT M5-.8
20	P0958020	LOCK WASHER 5MM
21	P0958021	FLAT WASHER 5MM
22	P0958022	CHAIN TENSION WHEEL
23	P0958023	SHOULDER SCREW M5-.8 X 10, 10 X 21.5
24	P0958024	HANDLE CAP
25	P0958025	PLANER TABLE ELEVATION CRANK
26	P0958026	PHLP HD SCR M4-.7 X 8
27	P0958027	FLAT WASHER 4MM
28	P0958028	GUIDE BLOCK
29	P0958029	LEADSCREW (PRIMARY)
30	P0958030	LEADSCREW (SECONDARY)
31	P0958031	PLANER TABLE
32	P0958032	POINTER
33	P0958033	FLAT WASHER 5MM
34	P0958034	PHLP HD SCR M5-.8 X 12
35	P0958035	BUSHING (RUBBER)
36	P0958036	FRONT SUPPORT PANEL

REF	PART #	DESCRIPTION
37	P0958037	DEPTH-OF-CUT SCALE (JOINTER)
38	P0958038	THICKNESS SCALE (PLANER)
39	P0958039	STANDOFF-HEX MM M5-.8 X 8, 78
40	P0958040	CAP SCREW M5-.8 X 6
41	P0958041	TAP SCREW M3.5 X 13
42	P0958042	CRANK HANDLE BRACKET
43	P0958043	CORD CLAMP
44	P0958044	PHLP HD SCR M5-.8 X 10
45	P0958045	TAP SCREW M3.5 X 13
46	P0958046	JUNCTION BOX (BACK)
47	P0958047	JUNCTION BOX (FRONT)
48	P0958048	TERMINAL BAR 4P
49	P0958049	TAP SCREW 2.9 X 19
50	P0958050	STRAIN RELIEF TYPE-3 M16-1.5
51	P0958051	CIRCUIT BREAKER ZHONGZUI 15A 125/250V
52	P0958052	TAP SCREW 2.9 X 19
53	P0958053	SWITCH MOUNTING PLATE
54	P0958054	TAP SCREW 2.9 X 9.5
55	P0958055	EXT TOOTH WASHER 5MM
56	P0958056	FLAT WASHER 5MM
57	P0958057	LOCK WASHER 5MM
58	P0958058	PHLP HD SCR M5-.8 X 10
59	P0958059	STANDOFF-HEX MM M5-.8 X 8, 78
60	P0958060	RESET BUTTON
61	P0958061	HEX NUT M14-2
62	P0958062	FRONT COVER
63	P0958063	PADDLE SWITCH DKLD AN17 20A 125V
64	P0958064	FLAT WASHER 5MM
65	P0958065	ACORN NUT M5-.8
66	P0958066	PUSH STICK
67	P0958067	PUSH BLOCK
68	P0958068	HEX WRENCH 4MM
69	P0958069	CARBIDE INSERT 15 X 15 X 2.5MM-5PK
70	P0958070	FLAT HD TORX SCR T20 M5-.8 X 12
71	P0958071	T-HANDLE TORX DRIVE T-20

G0958 Jointer Table & Fence

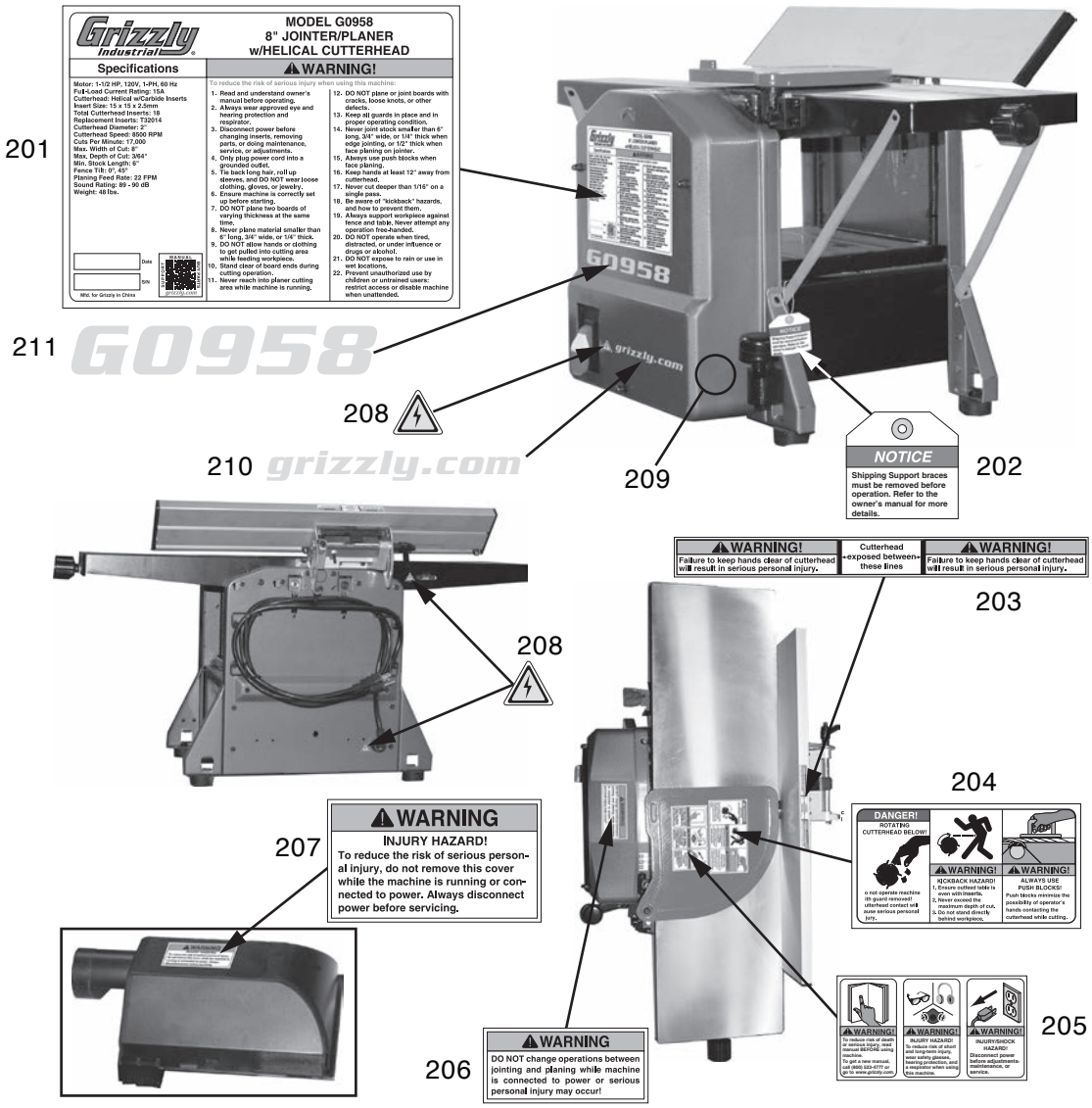


G0958 Jointer Table & Fence Parts List

REF	PART #	DESCRIPTION
72	P0958072	OUTFEED TABLE
73	P0958073	CAP SCREW M4-.7 X 28
74	P0958074	INTERLOCK SWITCH KEDU QKS8 14A 250V
75	P0958075	INTERLOCK SWITCH BRACKET
76	P0958076	FLAT WASHER 5MM
77	P0958077	CAP SCREW M5-.8 X 8
78	P0958078	INTERLOCK SWITCH CORD 14G 2W 23"
79	P0958079	CORD CLAMP
80	P0958080	CAP SCREW M5-.8 X 10
81	P0958081	OUTFEED TABLE BUSHING GUIDE
82	P0958082	CAP SCREW M5-.8 X 20
83	P0958083	BUSHING (RUBBER)
84	P0958084	MOTOR 1.5 HP 120V 1-PH
84-1	P0958084-1	MOTOR BRUSH
84-2	P0958084-2	MOTOR BRUSH CAP
85	P0958085	MOTOR PULLEY
86	P0958086	FLAT WASHER 5MM
87	P0958087	LOCK WASHER 5MM
88	P0958088	CAP SCREW M5-.8 X 12
89	P0958089	EXTENSION SPRING 1.2 X 9 X 28
90V2	P0958090V2	FEED ROLLER V2.03.23
91V2	P0958091V2	MOUNTED SLEEVE BEARING V2.03.23
92	P0958092	SPROCKET 12T
93	P0958093	FLAT WASHER 6MM
94	P0958094	LOCK WASHER 6MM
95	P0958095	CAP SCREW M6-1 X 12
96	P0958096	FLAT HD TORX SCR M5-.8 X 12
97	P0958097	CARBIDE INSERT 15 X 15 X 2.5MM
98	P0958098	HELICAL CUTTERHEAD 8"
99	P0958099	BALL BEARING 6000ZZ
100	P0958100	CAP SCREW M5-.8 X 10
101	P0958101	LOCK WASHER 5MM
102	P0958102	CUTTERHEAD BEARING HOUSING (REAR)
103	P0958103	CUTTERHEAD BEARING HOUSING (FRONT)
104	P0958104	BALL BEARING 6001ZZ
105	P0958105	LOCK WASHER 5MM
106	P0958106	CAP SCREW M5-.8 X 12
107	P0958107	CHIP DEFLECTOR
108	P0958108	EXT RETAINING RING 9MM
109	P0958109	FLAT WASHER 8MM
110	P0958110	SPROCKET 7T
111	P0958111	SQUARE BUSHING
112	P0958112	GEAR 86T
113	P0958113	EXT RETAINING RING 9MM
114	P0958114	NEEDLE BEARING HK1010
115	P0958115	BUSHING 10.2 X 14 X 9.5
116	P0958116	FEED PULLEY
117	P0958117	EXTENSION SPRING 1.5 X 10.5 X 58
118	P0958118	PULLEY SUPPORT BRACKET ASSEMBLY
119	P0958119	SHAFT
120	P0958120	CAP SCREW M8-1.25 X 16
121	P0958121	LOCK WASHER 8MM
122	P0958122	FLAT WASHER 8MM
123	P0958123	V-BELT 4V X 470 RIBBED
124	P0958124	V-BELT PJ230
125	P0958125	CUTTERHEAD SPINDLE PULLEY
126	P0958126	SET SCREW M6-1 X 8
127	P0958127	CHAIN 36L X 12.7 TYPE 081
128	P0958128	HEX NUT M8-1.25
129	P0958129	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
130	P0958130	CONNECTING ROD
131	P0958131	HEX NUT M6-1
132	P0958132	FLAT WASHER 8MM
133	P0958133	CAP SCREW M8-1.25 X 16
134	P0958134	CAP SCREW M5-.8 X 12
135	P0958135	LOCK WASHER 5MM
136	P0958136	FLAT WASHER 5MM
137	P0958137	TABLE ADJUSTING SCREW BRACKET
138	P0958138	TABLE ADJUSTING SCREW W/ KNOB
139	P0958139	CAP SCREW M5-.8 X 20
140	P0958140	INFEED TABLE BUSHING GUIDE
141	P0958141	POINTER
142	P0958142	INFEED TABLE
143	P0958143	CAP SCREW M5-.8 X 10
144	P0958144	FLAT WASHER 5MM
145	P0958145	CAP SCREW M5-.8 X 16
146	P0958146	KNOB BOLT M5-.8 X 9, D17
147	P0958147	CAP SCREW M5-.8 X 16
148	P0958148	FLAT WASHER 5MM
149	P0958149	HEX NUT M5-.8
150	P0958150	CUTTERHEAD GUARD SUPPORT BRACKET
151	P0958151	TORSION SPRING
152	P0958152	SQUARE BAR
153	P0958153	CUTTERHEAD GUARD SHAFT
154	P0958154	CUTTERHEAD GUARD
155	P0958155	FLAT WASHER 6MM
156	P0958156	BUTTON HD CAP SCR M6-1 X 12
157	P0958157	BUMPER
158	P0958158	FENCE ASSEMBLY
158-1	P0958158-1	FENCE COVER (LEFT)
158-2	P0958158-2	HEX BOLT M6-1 X 10
158-3	P0958158-3	LOCK NUT M6-1
158-4	P0958158-4	ANGLE SUPPORT PLATE
158-5	P0958158-5	SHOULDER SCREW M5-.8 X 7, 6 X 3
158-6	P0958158-6	ADJUSTABLE HANDLE M6-1 X 9, 43L
158-7	P0958158-7	FLAT WASHER 6MM
158-8	P0958158-8	FENCE SUPPORT
158-9	P0958158-9	CAP SCREW M5-.8 X 20
158-10	P0958158-10	HEX NUT M5-.8
158-11	P0958158-11	PHLP HD SCR M4-.7 X 8
158-12	P0958158-12	FLAT WASHER 4MM
158-13	P0958158-13	POINTER
158-14	P0958158-14	HEX BOLT M5-.8 X 25
158-15	P0958158-15	ROD
158-16	P0958158-16	ROLL PIN 3 X 10
158-17	P0958158-17	LOCK LEVER
158-18	P0958158-18	SPACER
158-19	P0958158-19	ROLL PIN 1.6 X 14
158-20	P0958158-20	HEX NUT M5-.8
158-21	P0958158-21	CAP SCREW M5-.8 X 20
158-22	P0958158-22	LOCK LEVER SLIDING BRACKET
158-23	P0958158-23	FENCE
158-24	P0958158-24	FENCE COVER (RIGHT)
159	P0958159	DUST PORT ASSEMBLY
159-1	P0958159-1	DUST PORT HOUSING
159-2	P0958159-2	INTERLOCK SWITCH KEY
159-3	P0958159-3	DUST PORT BASE
159-4	P0958159-4	TAP SCREW M3.5 X 13
159-5	P0958159-5	TAP SCREW M3.5 X 13

G0958 Labels & Cosmetics



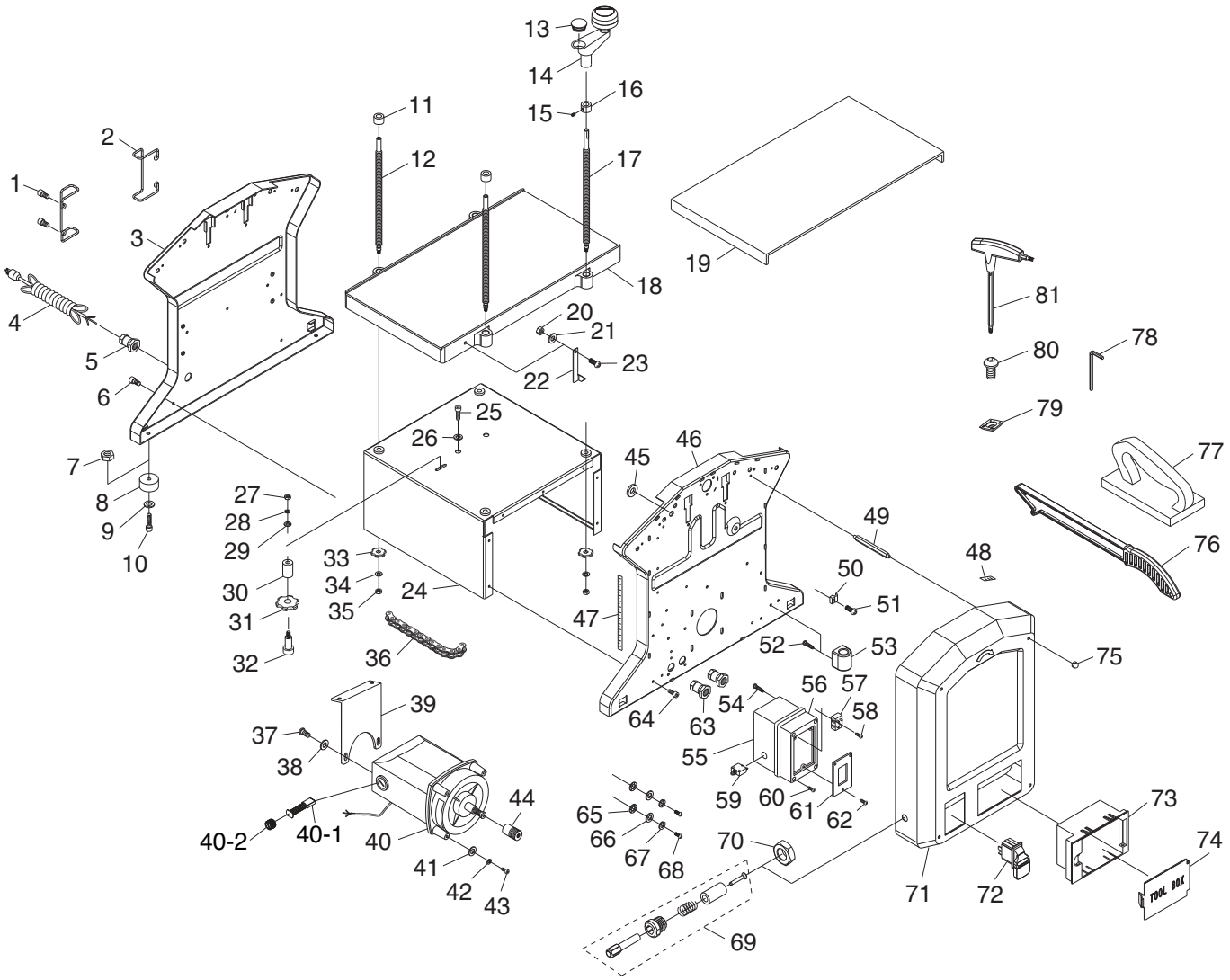
REF	PART #	DESCRIPTION
201	P0958201	MACHINE ID LABEL
202	P0958202	NOTICE HANGING TAG
203	P0958203	CUTTERHEAD WARNING LABEL
204	P0958204	CUTTERHEAD GUARD LABEL
205	P0958205	COMBO WARNING LABEL
206	P0958206	MACHINE CONVERSION LABEL

REF	PART #	DESCRIPTION
207	P0958207	DUST PORT WARNING LABEL
208	P0958208	ELECTRICITY LABEL
209	P0958209	TOUCH-UP PAINT, GRIZZLY GREEN
210	P0958210	GRIZZLY.COM LABEL
211	P0958211	MODEL NUMBER LABEL

⚠WARNING

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

G0959 Planer Table & Frame

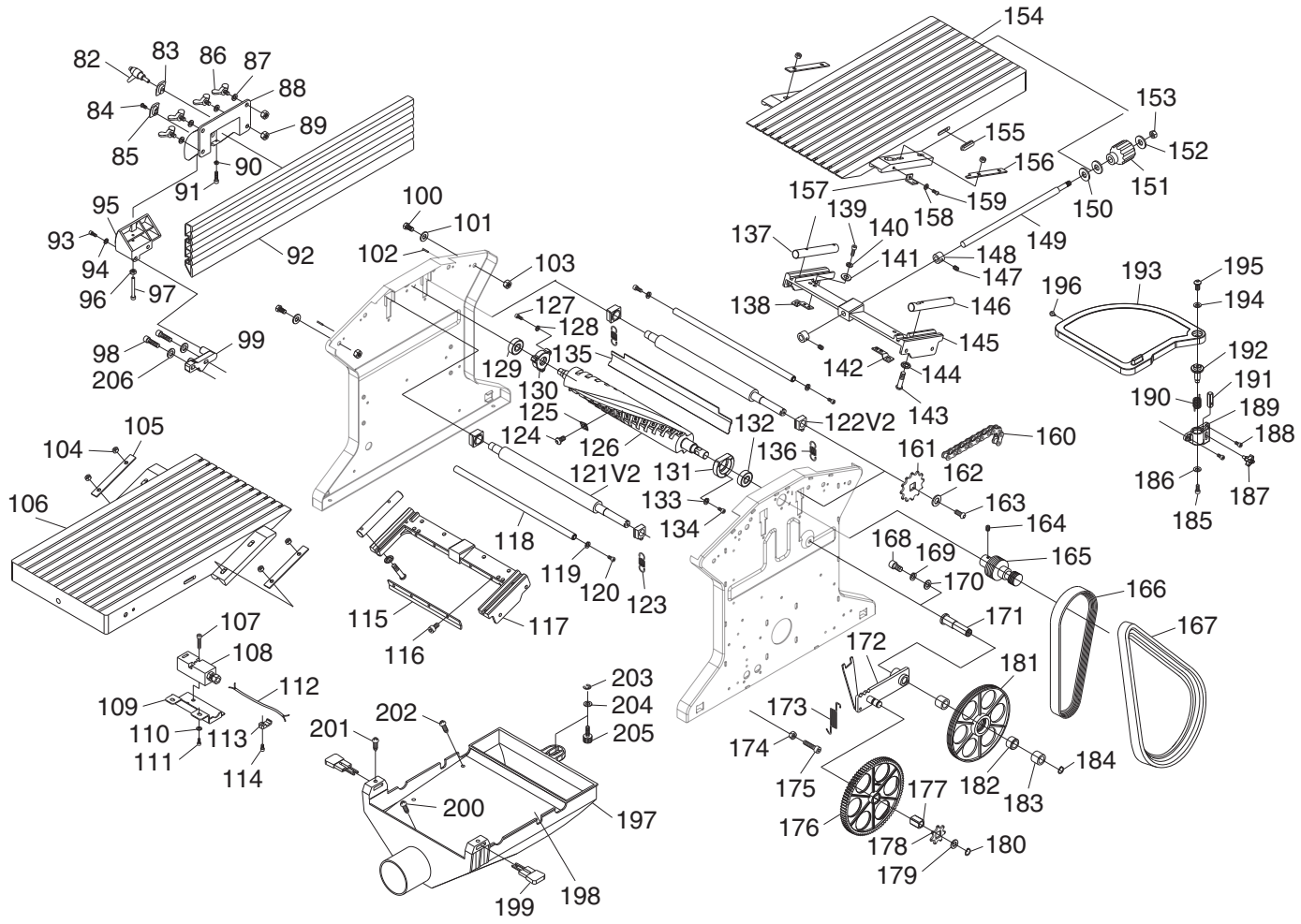


G0959 Planer Table & Frame Parts List

REF	PART #	DESCRIPTION
1	P0959001	PHLP HD SCR M5-.8 X 10
2	P0959002	CORD HOOK
3	P0959003	REAR SUPPORT PANEL
4	P0959004	POWER CORD 14G 3W 36" 5-15P
5	P0959005	STRAIN RELIEF TYPE-3 M16-1.5
6	P0959006	CAP SCREW M5-.8 X 10
7	P0959007	HEX NUT M8-1.25
8	P0959008	FOOT (RUBBER)
9	P0959009	FLAT WASHER 8MM
10	P0959010	CAP SCREW M8-1.25 X 16
11	P0959011	SPACER
12	P0959012	LEADSCREW (SECONDARY)
13	P0959013	HANDLE CAP
14	P0959014	PLANER TABLE ELEVATION CRANK
15	P0959015	SET SCREW M6-1 X 4
16	P0959016	SPACER
17	P0959017	LEADSCREW (PRIMARY)
18	P0959018	PLANER TABLE
19	P0959019	TABLE COVER PLATE
20	P0959020	HEX NUT M5-.8
21	P0959021	FLAT WASHER 5MM
22	P0959022	POINTER
23	P0959023	CAP SCREW M5-.8 X 16
24	P0959024	BASE
25	P0959025	PHLP HD SCR M6-1 X 12
26	P0959026	FLAT WASHER 6MM
27	P0959027	HEX NUT M6-1
28	P0959028	LOCK WASHER 6MM
29	P0959029	FLAT WASHER 6MM
30	P0959030	BUSHING
31	P0959031	SPROCKET 7T
32	P0959032	SHOULDER SCREW M6-1 X 15, 6 X 27.5
33	P0959033	SPROCKET 6T
34	P0959034	FLAT WASHER 5MM
35	P0959035	LOCK NUT M5-.8
36	P0959036	CHAIN 102L X 12.7 TYPE 081
37	P0959037	CAP SCREW M6-1 X 10
38	P0959038	FLAT WASHER 6MM
39	P0959039	MOTOR SUPPORT BRACKET
40	P0959040	MOTOR 1.5 HP 120V 1-PH
40-1	P0959040-1	MOTOR BRUSH
40-2	P0959040-2	MOTOR BRUSH CAP

REF	PART #	DESCRIPTION
41	P0959041	FLAT WASHER 5MM
42	P0959042	LOCK WASHER 5MM
43	P0959043	CAP SCREW M5-.8 X 10
44	P0959044	MOTOR PULLEY
45	P0959045	BUSHING (RUBBER)
46	P0959046	FRONT SUPPORT PANEL
47	P0959047	THICKNESS SCALE (PLANER
48	P0959048	DEPTH-OF-CUT SCALE (JOINTER)
49	P0959049	STANDOFF-HEX MM M5-.8 X 96, 7
50	P0959050	CORD CLAMP
51	P0959051	CAP SCREW M5-.8 X 10
52	P0959052	TAP SCREW M3.5 X 13
53	P0959053	CRANK HANDLE BRACKET
54	P0959054	TAP SCREW M3.5 X 13
55	P0959055	JUNCTION BOX (BACK)
56	P0959056	JUNCTION BOX (FRONT)
57	P0959057	TERMINAL BAR 4P
58	P0959058	TAP SCREW M2.9 X 16
59	P0959059	CIRCUIT BREAKER ZHONGZUI 15A 125/250V
60	P0959060	TAP SCREW 2.9 X 19
61	P0959061	SWITCH MOUNTING PLATE
62	P0959062	TAP SCREW M2.9 X 9.5
63	P0959063	STRAIN RELIEF TYPE-3 M16-1.5
64	P0959064	CAP SCREW M5-.8 X 10
65	P0959065	INT TOOTH WASHER 5MM
66	P0959066	FLAT WASHER 5MM
67	P0959067	LOCK WASHER 5MM
68	P0959068	PHLP HD SCR M5-.8 X 10
69	P0959069	RESET BUTTON
70	P0959070	HEX NUT M14-2
71	P0959071	FRONT COVER
72	P0959072	PADDLE SWITCH DKLD AN17 20A 125V
73	P0959073	TOOL BOX
74	P0959074	TOOL BOX COVER
75	P0959075	ACORN NUT M5-.8
76	P0959076	PUSH STICK
77	P0959077	PUSH BLOCK
78	P0959078	HEX WRENCH 4MM
79	P0959079	CARBIDE INSERTS 15 X 15 X 2.5-5PK
80	P0959080	FLAT HD TORX T20 M5-.8 X 12
81	P0959081	T-HANDLE TORX TORX DRIVE T-20

G0959 Jointer Table & Fence



REF	PART #	DESCRIPTION
82	P0959082	ADJUSTABLE HANDLE M8-1.25 X 64, 20L
83	P0959083	LOCK PLATE
84	P0959084	CAP SCREW M5-.8 X 10
85	P0959085	STOP PLATE
86	P0959086	WING BOLT M8-1.25 X 18
87	P0959087	FLAT WASHER 8MM
88	P0959088	ANGLE SUPPORT PLATE
89	P0959089	HEX NUT M8-1.25
90	P0959090	HEX NUT M4-.7
91	P0959091	CAP SCREW M4-.7 X 16
92	P0959092	FENCE
93	P0959093	BUTTON HD CAP SCR M6-1 X 16
94	P0959094	FLAT WASHER 6MM
95	P0959095	FENCE SUPPORT
96	P0959096	HEX NUT M5-.8
97	P0959097	CAP SCREW M5-.8 X 50
98	P0959098	CAP SCREW M6-1 X 16
99	P0959099	MOUNTING BRACKET
100	P0959100	HEX BOLT M8-1.25 X 20
101	P0959101	FLAT WASHER 8MM
102	P0959102	ROLL PIN 5 X 12

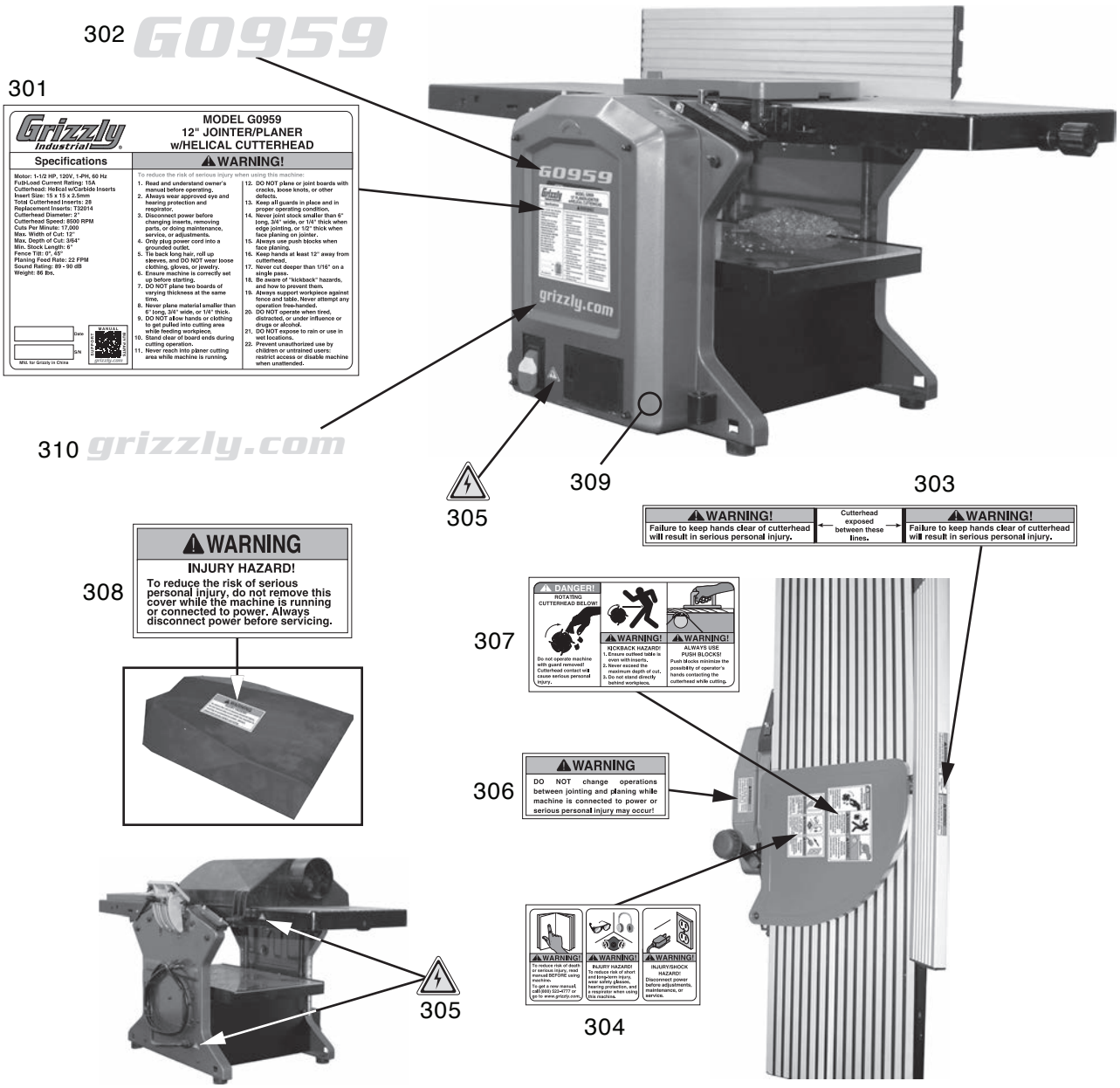
REF	PART #	DESCRIPTION
103	P0959103	FLANGE NUT M8-1.25
104	P0959104	LOCK NUT M6-1
105	P0959105	COVER
106	P0959106	OUTFEED TABLE
107	P0959107	CAP SCREW M4-.7 X 28
108	P0959108	INTERLOCK SWITCH KEDU QKS8 14A 250V
109	P0959109	INTERLOCK SWITCH BRACKET
110	P0959110	FLAT WASHER 5MM
111	P0959111	CAP SCREW M5-.8 X 8
112	P0959112	CORD 14G 2W 34"
113	P0959113	CORD CLAMP
114	P0959114	CAP SCREW M5-.8 X 10
115	P0959115	CUTTING GUARD
116	P0959116	CAP SCREW M5-.8 X 10
117	P0959117	OUTFEED TABLE SUPPORT
118	P0959118	CONNECTING ROD
119	P0959119	FLAT WASHER 8MM
120	P0959120	CAP SCREW M8-1.25 X 12
121V2	P0959121V2	FEED ROLLER V2.03.23
122V2	P0959122V2	MOUNTED SLEEVE BEARING V2.03.23
123	P0959123	EXTENSION SPRING 1.2 X 9 X 28

G0959 Jointer Table & Fence Parts List (Cont.)

REF	PART #	DESCRIPTION
124	P0959124	FLAT HD TORX SCR M5-.8 X 12
125	P0959125	CARBIDE INSERT 15 X 15 X 2.5MM
126	P0959126	HELICAL CUTTERHEAD 12"
127	P0959127	CAP SCREW M5-.8 X 16
128	P0959128	LOCK WASHER 5MM
129	P0959129	BALL BEARING 6001ZZ
130	P0959130	CUTTERHEAD BEARING HOUSING (REAR)
131	P0959131	CUTTERHEAD BEARING HOUSING (FRONT)
132	P0959132	BALL BEARING 6002ZZ
133	P0959133	LOCK WASHER 5MM
134	P0959134	CAP SCREW M5-.8 X 16
135	P0959135	CHIP DEFLECTOR
136	P0959136	EXTENSION SPRING 1.6 X 10.5 X 29
137	P0959137	REAR RAIL
138	P0959138	LIMITING PLATE, RIGHT
139	P0959139	CAP SCREW M5-.8 X 12
140	P0959140	LOCK WASHER 5MM
141	P0959141	FLAT WASHER 5MM
142	P0959142	LIMITING PLATE, LEFT
143	P0959143	CAP SCREW M6-1 X 43
144	P0959144	EXT TOOTH WASHER 6MM
145	P0959145	INFEED TABLE SUPORT
146	P0959146	FRONT RAIL
147	P0959147	SET SCREW M6-1 X 6
148	P0959148	LOCK COLLAR
149	P0959149	TABLE ADJUSTMENT SHAFT
150	P0959150	FLAT WASHER 10MM
151	P0959151	HOLLOW HANDLE 38 X 50, 13
152	P0959152	FLAT WASHER 8MM
153	P0959153	LOCK NUT M8-1.25
154	P0959154	INFEED TABLE
155	P0959155	INSERT (RUBBER)
156	P0959156	COVER
157	P0959157	POINTER
158	P0959158	FLAT WASHER 4MM
159	P0959159	CAP SCREW M4-.7 X 10
160	P0959160	CHAIN 38L X 12.7 TYPE 081
161	P0959161	SPROCKET 12T
162	P0959162	FLAT WASHER 6MM
163	P0959163	CAP SCREW M6-1 X 10
164	P0959164	SET SCREW M6-1 X 10
165	P0959165	SPINDLE PULLEY

REF	PART #	DESCRIPTION
166	P0959166	V-BELT PJ280
167	P0959167	V-BELT PJ220
168	P0959168	CAP SCREW M8-1.25 X 16
169	P0959169	LOCK WASHER 8MM
170	P0959170	FLAT WASHER 8MM
171	P0959171	PULLEY SPINDLE
172	P0959172	PULLEY SUPPORT BRACKET ASSEMBLY
173	P0959173	EXTENSION SPRING 1.6 X 11.5 X 53.5
174	P0959174	HEX NUT M5-.8
175	P0959175	CAP SCREW M5-.8 X 25
176	P0959176	GEAR 86T
177	P0959177	SQUARE BUSHING
178	P0959178	SPROCKET 7T
179	P0959179	FLAT WASHER 8MM
180	P0959180	EXT RETAINING RING 9MM
181	P0959181	FEED PULLEY
182	P0959182	BUSHING
183	P0959183	NEEDLE BEARING HK1010
184	P0959184	EXT RETAINING RING 9MM
185	P0959185	CAP SCREW M5-.8 X 10
186	P0959186	FLAT WASHER 5MM
187	P0959187	KNOB BOLT M5-.8 X 9, D17
188	P0959188	CAP SCREW M5-.8 X 16
189	P0959189	CUTTERHEAD GUARD SUPPORT BRACKET
190	P0959190	TORSION SPRING
191	P0959191	SQUARE BAR
192	P0959192	CUTTERHEAD GUARD SHAFT
193	P0959193	BLADE GUARD
194	P0959194	FLAT WASHER 6MM
195	P0959195	CAP SCREW M6-1 X 12
196	P0959196	BUMPER
197	P0959197	DUST PORT HOUSING
198	P0959198	DUST PORT BASE
199	P0959199	INTERLOCK SWITCH KEY
200	P0959200	TAP SCREW M2.9 X 16
201	P0959201	TAP SCREW M2.9 X 13
202	P0959202	TAP SCREW M2.9 X 13
203	P0959203	E-CLIP 6MM
204	P0959204	FLAT WASHER 6MM
205	P0959205	KNOB BOLT M6-1 X D21, ROUND KD
206	P0959206	FLAT WASHER 6MM

G0959 Labels & Cosmetics



REF	PART #	DESCRIPTION
301	P0959301	MACHINE ID LABEL
302	P0959302	MODEL NUMBER LABEL
303	P0959303	CUTTERHEAD WARNING LABEL
304	P0959304	COMBO WARNING LABEL
305	P0959305	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
306	P0959306	MACHINE CONVERSION LABEL
307	P0959307	CUTTERHEAD GUARD LABEL
308	P0959308	DUST PORT WARNING LABEL
309	P0959309	TOUCH-UP PAINT, GRIZZLY GREEN
310	P0959310	GRIZZLY.COM LABEL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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