



MODEL G0654

6" JOINTER w/ MOBILE BASE

OWNER'S MANUAL



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FOR MACHINES MANUFACTURED SINCE 9/07 #BL10265 PRINTED IN CHINA



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

Machine Description

We are proud to offer the Model G0654 6" Jointer with Mobile Base. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0654 when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

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

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


Manual Accuracy

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

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

If you find this to be the case, and the difference between the manual and machine leaves you confused about a procedure, 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, please write down the **Manufacture Date** and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.

		MODEL GXXXX	
		MACHINE NAME	
SPECIFICATIONS		⚠ WARNING!	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Ensure safety devices are properly adjusted/setup and	
Weight:		4. power is connected to grounded circuit before starting.	
		5. Make sure the motor has stopped and disconnect	
		power before adjustments, maintenance, or service.	
		6. DO NOT expose to rain or dampness.	
		7. DO NOT modify this machine in any way.	
		8. Do not use machine if intoxicated or under the	
		influence of drugs or alcohol.	
		9. Maintain machine carefully to prevent accidents.	
		10.	
Manufactured for Grizzly in Taiwan			

Manufacture Date

Serial Number



Identification

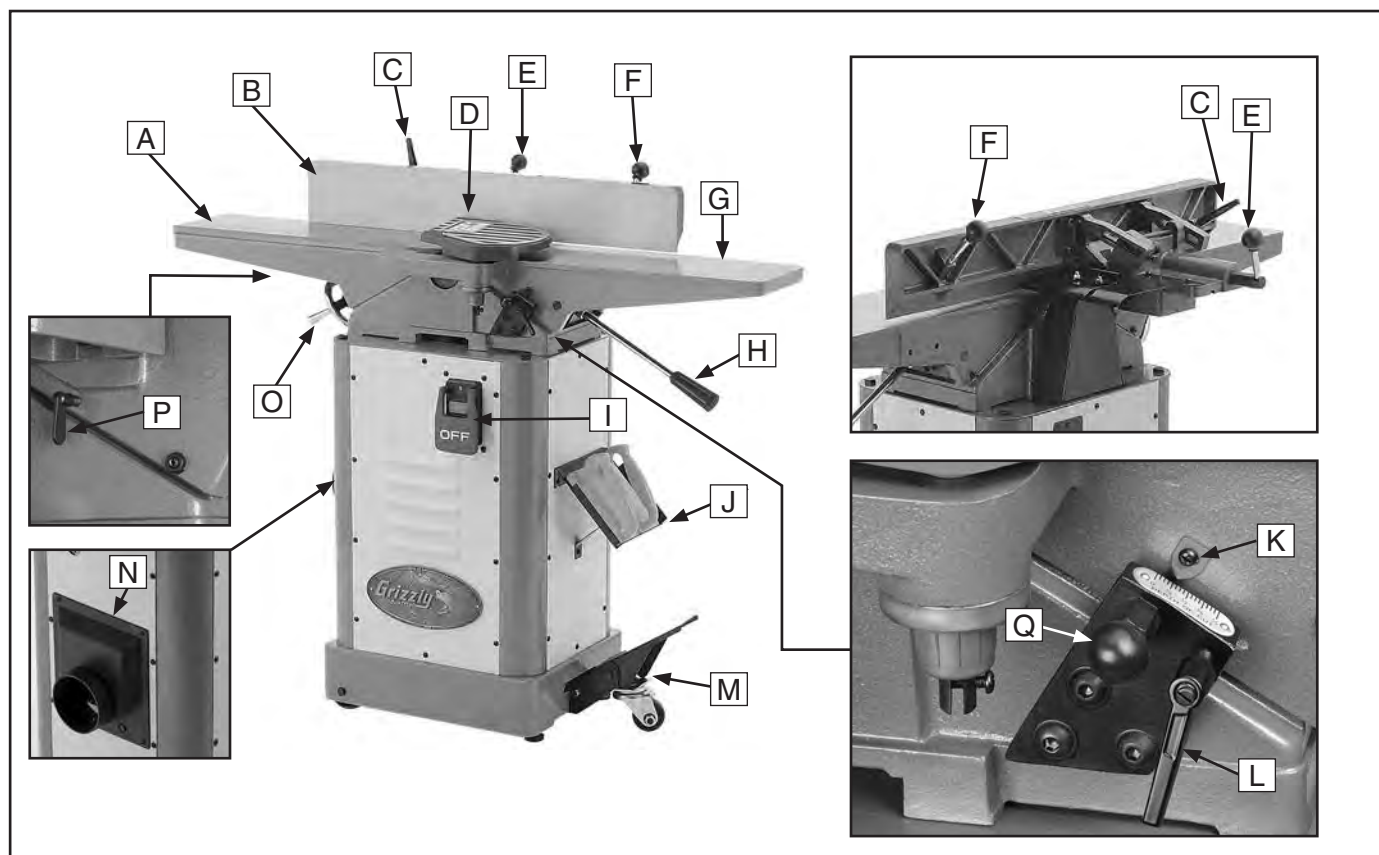


Figure 1. Model G0654 identification.

- A. Outfeed Table
- B. Fence
- C. Fence Tilt Lever
- D. Cutterhead Guard
- E. Fence Lock
- F. Fence Tilt Handle
- G. Infeed Table
- H. Infeed Table Adjustment Lever
- I. ON/OFF Switch
- J. Push Block Holder
- K. Depth Scale
- L. Infeed Table Lock
- M. Wheel Assembly
- N. Dust Port
- O. Outfeed Table Handwheel
- P. Outfeed Table Lock
- Q. Depth Stop Knob





MACHINE DATA SHEET

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

MODEL G0654 6" X 46" JOINTER

Product Dimensions:

Weight..... 231 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 46 x 21-1/4 x 37-3/4 in.
Footprint (Length x Width)..... 17-1/8 x 14-1/8 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 236 lbs.
Length x Width x Height..... 49 x 23 x 16 in.
Must Ship Upright..... No

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 14A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 8 ft.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... ON/OFF Push Button Switch w/Large Shut-Off Paddle

Motors:

Main

Type..... TEFC Capacitor-Start Induction
Horsepower..... 1 HP
Phase..... Single-Phase
Amps..... 14A
Speed..... 3450 RPM
Power Transfer..... V-Belt Drive
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Cutting Capacities

Bevel Jointing..... 0 – 45 deg. L/R
Maximum Width of Cut..... 6 in.
Maximum Depth of Cut..... 1/8 in.
Minimum Workpiece Length..... 8 in.
Minimum Workpiece Thickness..... 1/2 in.
Maximum Rabbeting Depth..... 1/2 in.
Number of Cuts Per Minute..... 14,400



Fence Information

Fence Length..... 29-3/8 in.
Fence Width..... 1-3/16 in.
Fence Height..... 4-1/2 in.
Fence Stops..... 45, 90, 135 deg.

Cutterhead Information

Cutterhead Type..... 3 Knife
Cutterhead Diameter..... 2-1/2 in.
Cutterhead Speed..... 4800 RPM

Knife Information

Number of Knives..... 3
Knife Type..... HSS, Single-Sided
Knife Length..... 6-1/8 in.
Knife Width..... 5/8 in.
Knife Thickness..... 1/8 in.
Knife Adjustment..... Jack Screws or Springs

Table Information

Table Length..... 46 in.
Table Width..... 7-1/2 in.
Floor to Table Height..... 33-3/8 in.
Table Adjustment Type..... Handwheel
Table Movement Type..... Dovetailed Ways

Construction

Base..... Cast Iron
Body Assembly..... Cast Iron
Cabinet..... Pre-formed Steel
Fence Assembly..... Cast Iron
Guard..... Die Cast Metal
Table..... Precision Ground Cast Iron
Paint..... Powder Coated

Other Information

Number of Dust Ports..... 1
Dust Port Size..... 4 in.
Mobile Base..... Built-In

Other Specifications:

Country Of Origin China
Warranty 1 Year
Approximate Assembly & Setup Time 2 Hours
Serial Number Location ID Label on Front of Cabinet
ISO 9001 Factory No
CSA Certified No



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.



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



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



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

NOTICE

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

Safety Instructions for Machinery



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 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 avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and 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.

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.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

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.



WARNING

Additional Safety for Jointers

JOINTER INJURY RISKS. Familiarize yourself with the main injury risks associated with jointers—always use common sense and good judgment to reduce your risk of injury. **Main injury risks from jointers:** amputation/lacerations from contact with the moving cutterhead, entanglement/crushing injuries from getting caught in moving parts, blindness or eye injury from flying wood chips, or impact injuries from workpiece kickback.

KICKBACK. Know how to reduce the risk of kickback and kickback-related injuries. “Kickback” occurs during the operation when the workpiece is ejected from the 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 the workpiece, resulting in impact injuries (i.e., blindness, broken bones, bruises, death); (2) operator’s hands are pulled into blade, resulting in amputation or severe lacerations.

GUARD REMOVAL. Except when rabbeting, never remove guards during operation or while connected to power. Always replace guard after rabbeting. You could be seriously injured if you accidentally touch the spinning cutterhead or get entangled in moving parts. Before removing sawdust, turn jointer **OFF** and disconnect power before clearing. Immediately replace guards.

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

OUTFEED TABLE ALIGNMENT. To reduce the risk of kickback and personal injuries, keep the outfeed table even with the knives/inserts at top dead center (the highest point during rotation). If the outfeed table is set too low, the workpiece may rock against the cutterhead. If the table is set too high, the workpiece may hit the outfeed table and get stuck over the cutterhead.

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

GRAIN DIRECTION. Jointing against the grain or end grain increases the required cutting force, which could produce chatter or excessive chip out, and lead to kickback.

CUTTING LIMITATIONS. To reduce the risk of accidental cutterhead contact or kickback, never perform jointing, planing, or rabbeting cuts on pieces smaller than 8" long, $\frac{3}{4}$ " wide, or $\frac{1}{4}$ " thick.

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

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

WORKPIECE SUPPORT. To reduce accidental cutterhead contact and kickback, support workpiece continuously during operation. Position and guide workpiece with fence; support long or wide stock with auxiliary stands.

FEED WORKPIECE PROPERLY. To reduce the risk of kickback, never start jointer with workpiece touching cutterhead. Allow cutterhead to reach full speed before feeding. Never back work toward the infeed table.

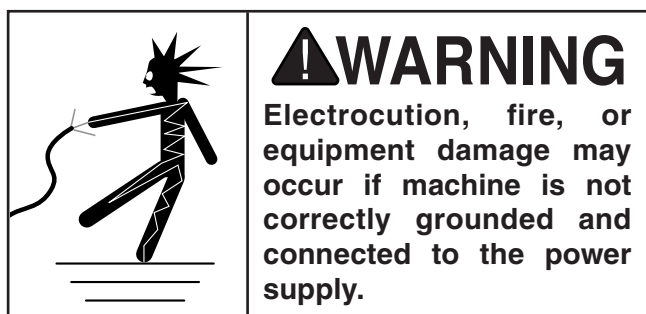
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than $\frac{1}{8}$ " (0.125") from cutterhead body.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 110V..... 14 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 requirements in the following section.

!WARNING

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

110V 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–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: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the 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 (similar to the figure below). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

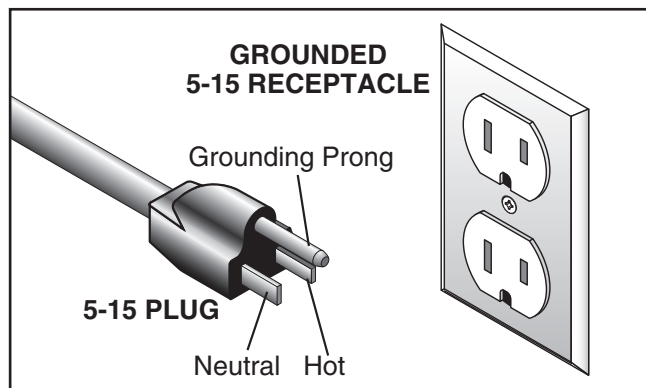
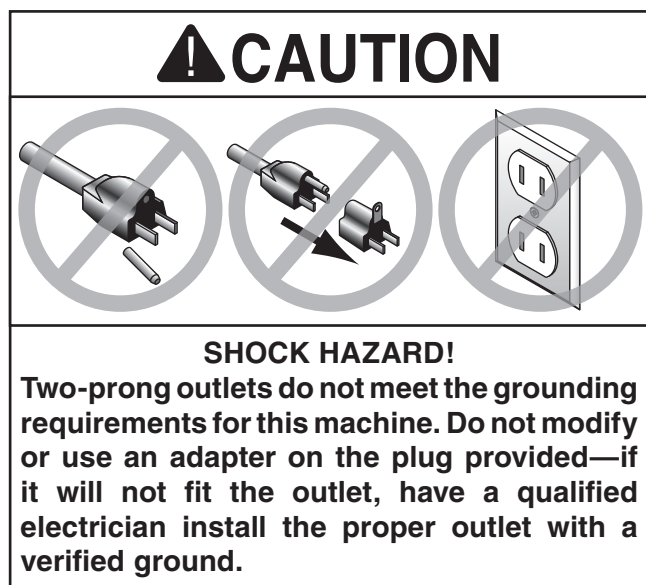


Figure 2. Typical 5-15 plug and receptacle.



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 may 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 contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size14 AWG
Maximum Length (Shorter is Better).....50 ft.

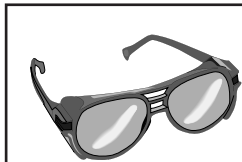


SECTION 3: SETUP

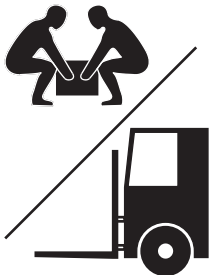
Items Needed for Setup

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

Description	Qty
• Safety Glasses (for each person)	1
• Dust Collection System	1
• 4" Dust Hose (length as needed)	1
• 4" Hose Clamp	1
• Phillips Head Screwdriver	1
• Extra Person for Lifting Help	1
• Straightedge	1
• 3/4" Socket Wrench.....	1



!WARNING
Wear safety glasses during the entire setup process!



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

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

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

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



!WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.



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: (Figures 3 & 4)	Qty
A. Right Panel.....	1
B. Left Panel	1
C. Back Panel	1
D. Front Panel.....	1
E. Top Plate Assembly	1
F. Bottom Plate.....	1
G. Belt Guard Assembly	1
H. Push Block Holder.....	1
I. Dust Chute	1
J. Mobile Base Chassis.....	1
K. Push Blocks.....	2
L. Cabinet Supports.....	4
M. Jointer Table Assembly	1
N. Fence Assembly	1
O. Cutterhead Guard.....	1
P. Locking Foot Pedal Assembly	1
Q. Rear Guard Top and Base	1
R. Dust Port	1
S. V-Belt.....	1
T. Motor Pulley	1
U. Motor-Switch Assembly.....	1
V. Infeed Table Lever	1
W. Knobs	2
X. Knife Setting Jig	1
Y. Outfeed Table Adjustment Handwheel	1

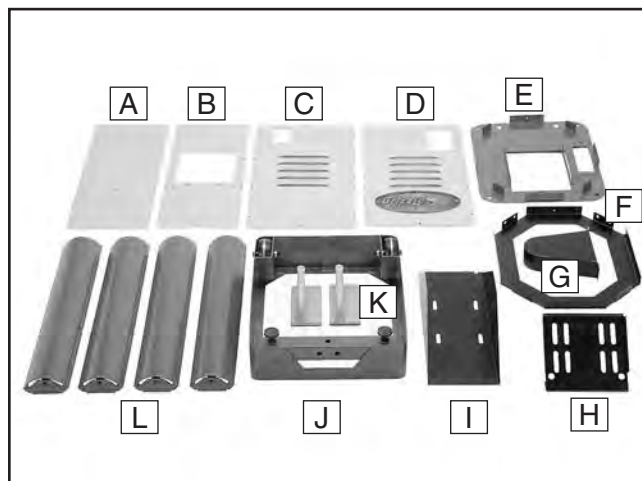


Figure 3. Box 1 inventory contents.

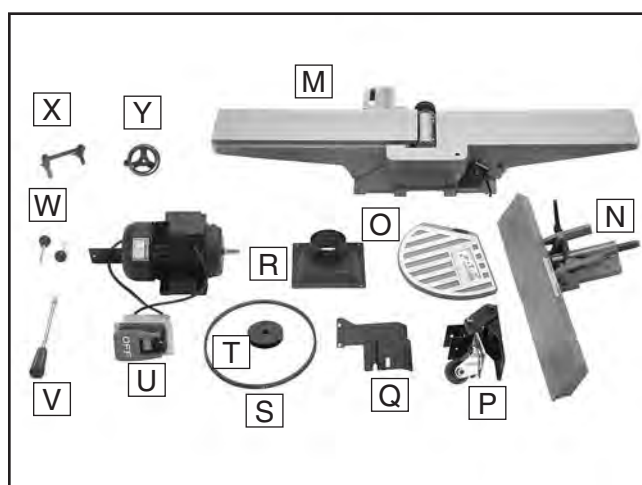


Figure 4. Box 1 inventory contents.



Fasteners (and where used)	Qty
Hex Bolts $\frac{3}{8}$ "-16 x 1" (Cabinet Support).....	4
Flange Bolts M6-1 x 12 (Bottom Plate).....	8
Flat Washers 6mm (Bottom Plate).....	8
Hex Nuts M6-1 (Bottom Plate).....	8
Hex Bolts $\frac{3}{8}$ "-16 x 1" (Top Plate).....	4
Flange Screws #10-24 x $\frac{3}{8}$ " (Left & Right Panels)	20
Flange Bolts M6-1 x 12 (Dust Chute)	6
Flat Washers 6mm (Dust Chute).....	6
Hex Nuts M6-1 (Dust Chute).....	6
Hex Bolt M8-1.25 x 50 (Wheel Assy.).....	1
Flat Washer 8mm (Wheel Assy.)	1
Hex Bolts M10-1.5 x 55 (Wheel Assy.)	2
Flat Washers 10mm (Wheel Assy.).....	2
Hex Nuts M10-1.5 (Wheel Assy.).....	2
Leveling Feet (Cabinet).....	2
Carriage Bolts $\frac{5}{16}$ "-18 x $1\frac{1}{8}$ " (Motor)	4
Flat Washers $\frac{5}{16}$ " (Motor).....	4
Hex Nuts $\frac{5}{16}$ "-18 (Motor)	4
Hex Nuts M10-1.5 (Jointer Assy.)	3
Lock Washers 10mm (Jointer Assy.)	3
Flange Screws #10-24 x $\frac{3}{8}$ " (Front Panel)	10
Flange Screws #10-24 x $\frac{3}{8}$ " (Switch).....	4
Flange Screws #10-24 x $\frac{3}{8}$ " (Dust Port).....	4
Flange Screws #10-24 x $\frac{3}{8}$ " (Push Block Holder)	3
Flange Bolt M6-1 x 12 (Belt Guard)	2
Flat Washers 6mm (Belt Guard)	2
Hex Nuts M6-1 (Belt Guard).....	2
Flange Screws #10-24 x $\frac{3}{8}$ " (Rear Panel).....	10
Flange Screws #10-24 x $\frac{3}{8}$ " (Mtr Cord Plate) ...	2
Phillips Head Screws M6-1 x 12 (Rear Guard). 2	
Phillips Head Screw M5-.8 x 12 (Cutterhead Guard)	1

Tools (not shown)	Qty
Hex Wrench 2.5mm.....	1
Hex Wrench 3mm.....	1
Hex Wrench 4mm.....	1
Hex Wrench 6mm.....	1
Wrenches 8/10, 12/14, 14/17	1 ea



Cleanup

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

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

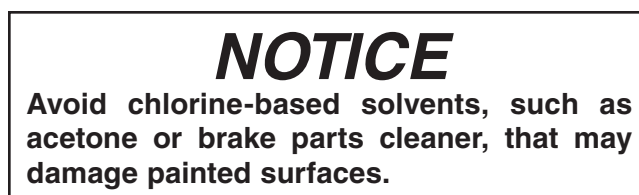
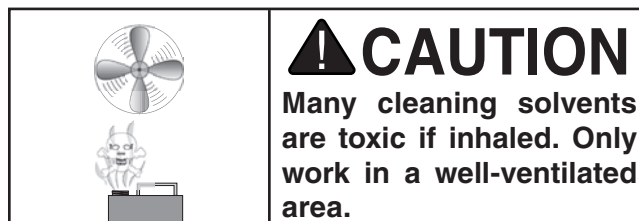
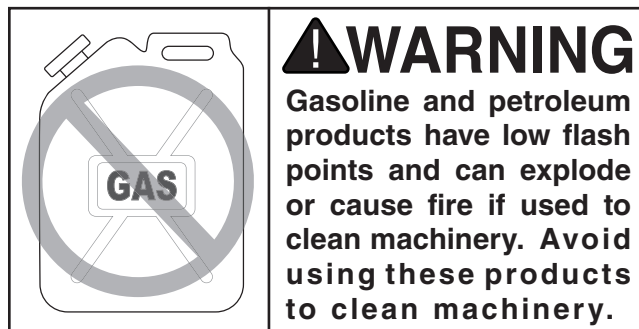
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

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

Basic steps for removing rust preventative:

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



T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.



Figure 5. T23692 Orange Power Degreaser.



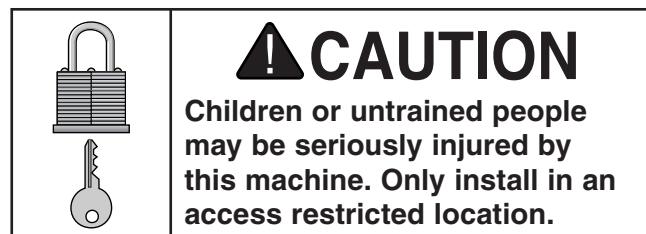
Site Considerations

Weight Load

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

Space Allocation

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



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 access to a means of disconnecting the power source or engaging 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.

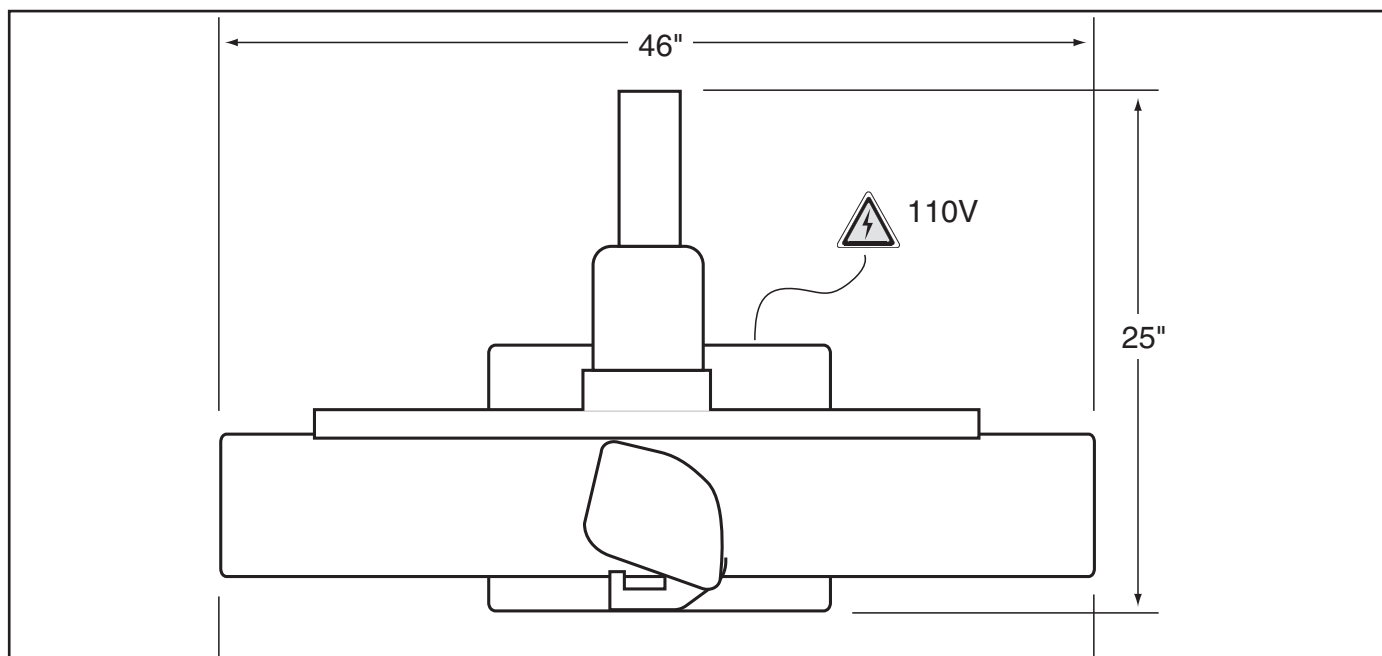


Figure 6. Minimum working clearances.



Assembly

To assemble the joiner:

1. Fasten each cabinet support to the mobile base chassis with a $\frac{3}{8}$ "-16 x 1" hex bolt, threading the bolts through the bottom of the chassis, as shown in **Figure 7**.

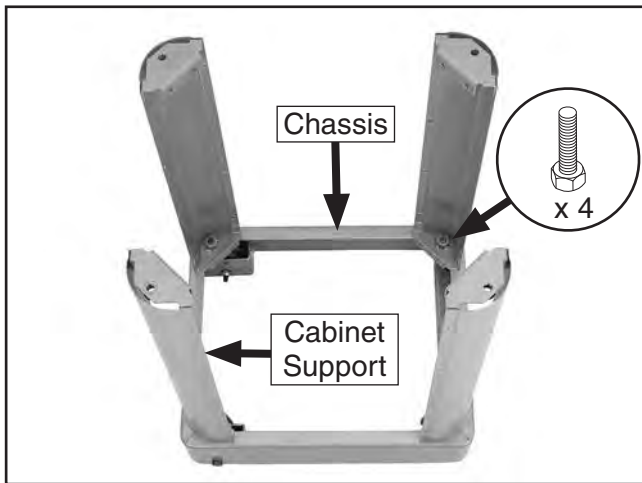


Figure 7. Cabinet supports fastened to chassis.

2. Fasten the bottom plate to the mobile base chassis with (8) M6-1 x 12 flange bolts, 6mm flat washers, and M6-1 hex nuts, as shown in **Figure 8**.

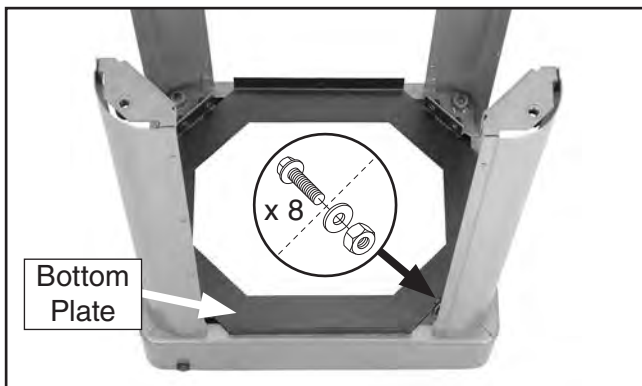


Figure 8. Bottom plate installed.

3. Fasten the top plate to the cabinet supports with the (4) $\frac{3}{8}$ "-16 x 1" hex bolts, as shown in **Figure 9**, so the flat side is up and the single elliptical slot is on the wheel side of the cabinet.

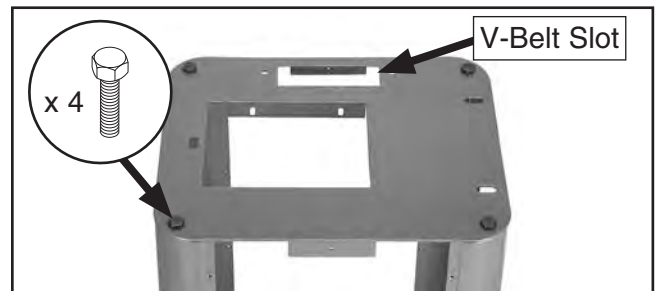


Figure 9. Top plate installed.

4. Secure the left and right panels to the cabinet supports with (20) #10-24 x $\frac{3}{8}$ " flange screws, as shown in **Figure 10**.

Note: The two holes on the left panel below the dust chute slot should face down. The right panel should be installed with the two block holder holes facing up.

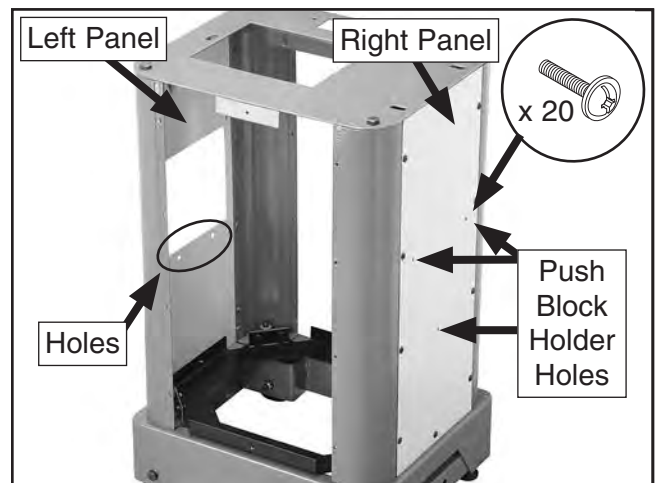


Figure 10. Left and right panels installed.



5. Carefully place the cabinet on its left side, and secure the dust chute to the top plate flanges and left panel with (6) M6-1 x 12 flange bolts, 6mm flat washers, and M6-1 hex nuts (**Figures 11 & 12**).

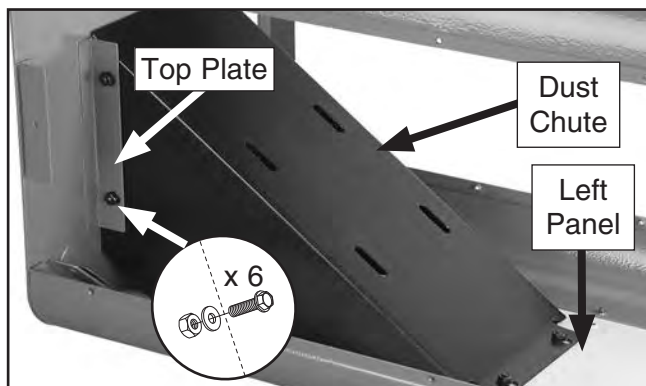


Figure 11. Dust chute installed.

Note: Thread the M6-1 x 12 flange bolts from the inside of the dust chute (see **Figure 12**).

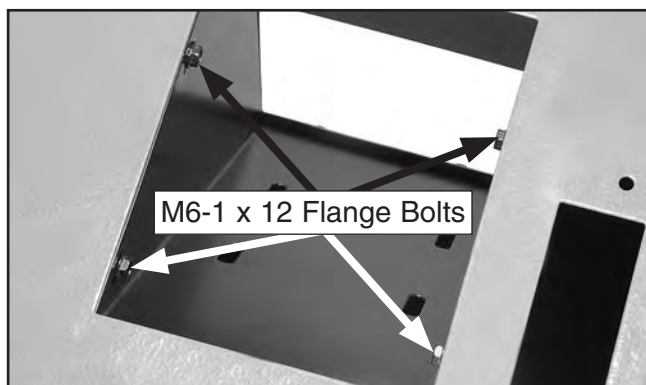


Figure 12. Dust chute installed (interior view).

6. With the cabinet still placed on its left side, bolt the wheel assembly to the stand with the provided hardware, as shown in **Figure 13**.

Note: Refer to the **Inventory List** on **Page 12** for a list of components needed for assembly.

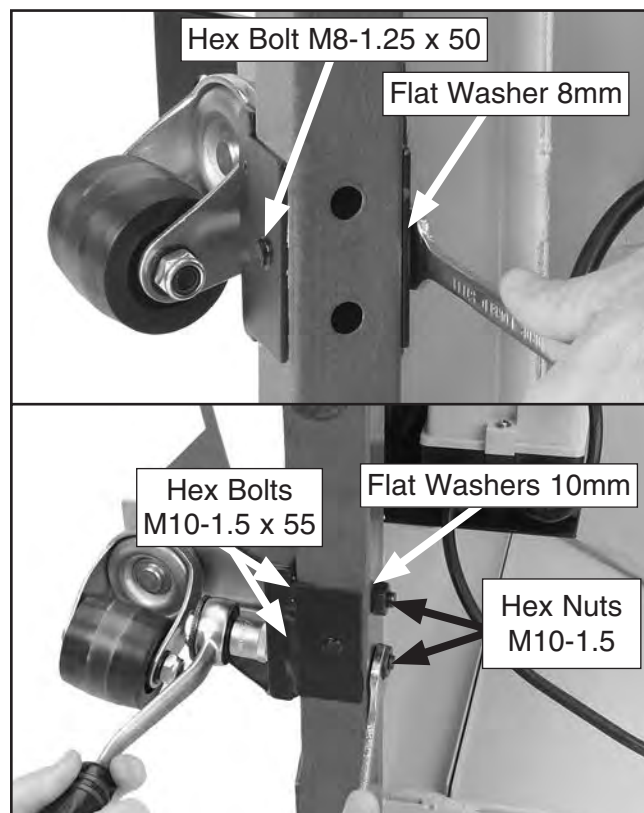


Figure 13. Example of bolting the wheel assembly to the stand.

7. Back off the set screws on the motor pulley and align the shaft key with the pulley keyway.
8. Slide the pulley onto the motor shaft so the pulley is flush with the shaft end, then tighten the set screws, as shown in **Figure 14**.

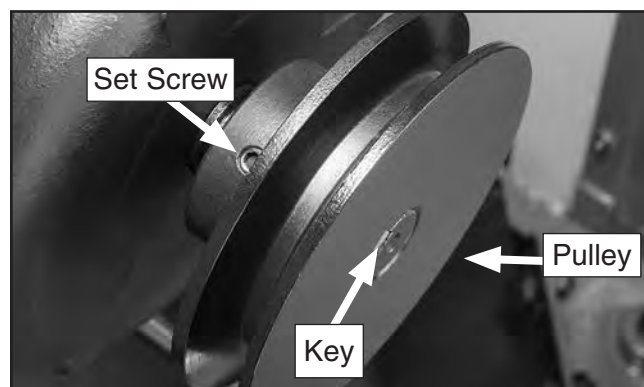


Figure 14. Motor pulley installed.

9. Place the motor on the dust chute and align the mounting holes, making sure the pulley faces the V-belt slot (**Figure 15**).

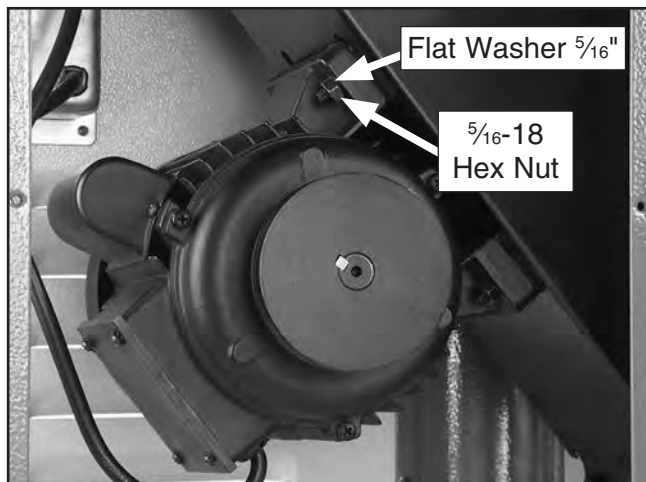


Figure 15. Motor mounted to dust chute.

10. Reach into the dust chute, thread (4) $\frac{5}{16}$ "-18 x $1\frac{1}{8}$ " carriage bolts through the chute and motor and secure with (4) $\frac{5}{16}$ "-18 hex nuts and $\frac{5}{16}$ " flat washers (see **Figure 16**). Do not fully tighten the fasteners.

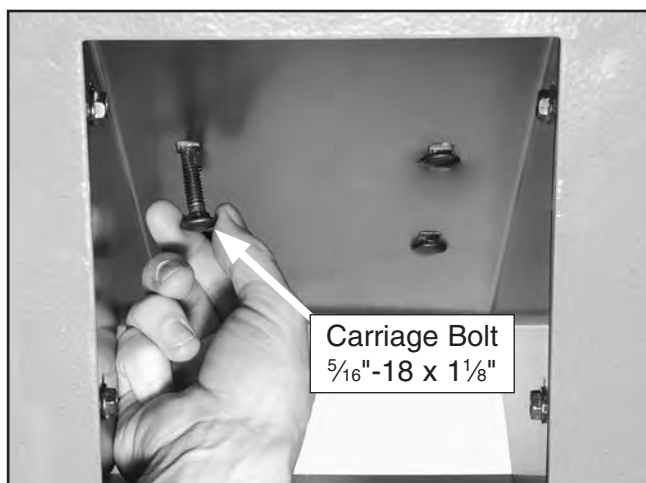


Figure 16. Securing motor to dust chute.

11. Place the stand in the upright position and adjust the leveling feet as needed with the hex nuts so the cabinet rests level and stable on the floor.
12. With the help of an assistant, place the jointer table assembly on top of the cabinet assembly, sliding the studs on the bottom of the jointer table through the cabinet mounting holes.

13. Fasten the jointer table assembly to the cabinet with the (3) M10-1.5 hex nuts and 10mm lock washers, as shown in **Figure 17**.

Note: Reach inside the dust chute to secure the stud on the right side.

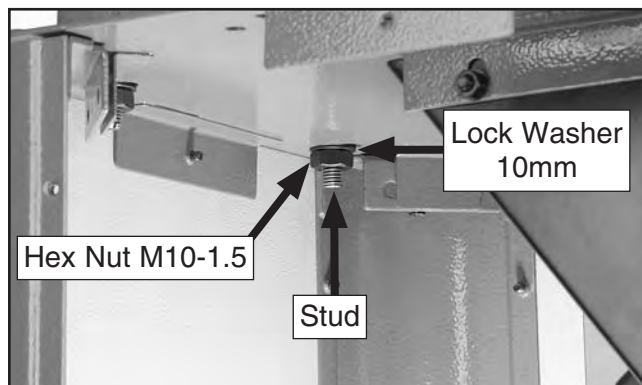


Figure 17. Jointer secured to cabinet.

14. Slide the motor up, place the V-belt around the cutterhead and motor pulleys, then slide the motor down to rest on the V-belt.
15. Check the alignment of the pulleys to make sure that they are aligned and that the V-belt is straight up and down, as shown in **Figure 18**.

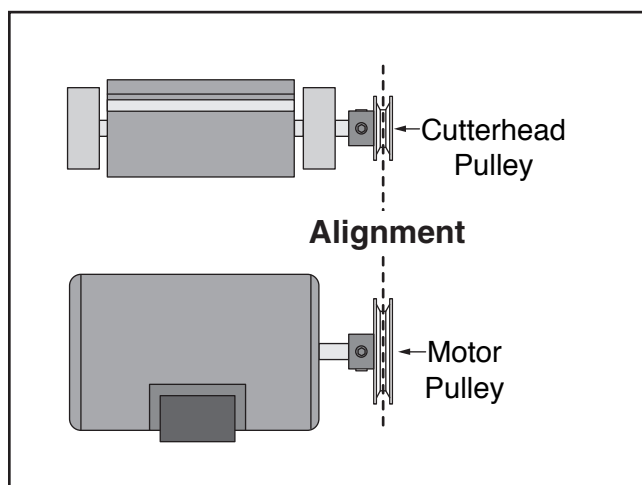


Figure 18. Pulleys aligned.

- If the pulleys are aligned, then tighten the motor fasteners and go to **Step 19**.
- If the pulleys are NOT aligned, then perform **Steps 16-18**.



16. Loosen the motor or cutterhead pulley set screws and move the pulleys in or out as needed to bring them into alignment.
17. Tighten the pulley set screws.
18. Lower the motor to increase belt tension, tighten the motor mount bolts and recheck pulley alignment.
19. Install the front panel (**Figure 19**) onto the cabinet with (10) #10-24 x $\frac{3}{8}$ " flange screws, making sure the panel is installed on the same side as the motor fan.



Figure 19. Front panel installed.

20. Install the switch assembly onto the front panel with (4) #10-24 x $\frac{3}{8}$ " flange screws, as shown in **Figure 20**.



Figure 20. Switch installed.

21. Attach the dust port to the left cabinet panel and dust chute with (4) #10-24 x $\frac{3}{8}$ " flange screws, as shown in **Figure 21**.



Figure 21. Dust port installed.

22. Thread (2) #10-24 x $\frac{3}{8}$ " flange screws half way into the cabinet right panel, slide the push block holder over the screws, secure the arm with a third #10-24 x $\frac{3}{8}$ " flange screw, then tighten all the screws (see **Figure 22**).

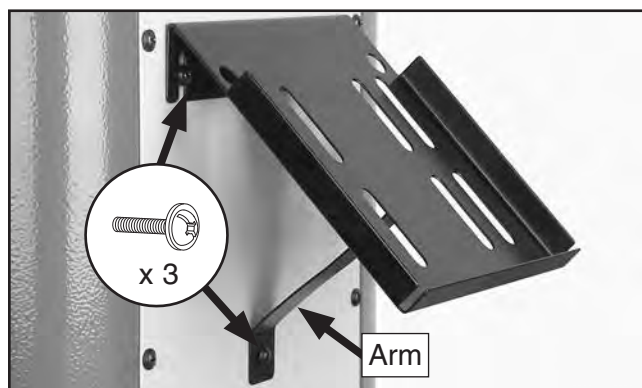


Figure 22. Push block holder installed.

23. Remove the lock nut and flat washer (**Figure 23**) from the fence lock handle bolt, place the fence on the jointer, and insert the bolt through the slot in the carriage, making sure the carriage fits over the key (see **Figure 24**).

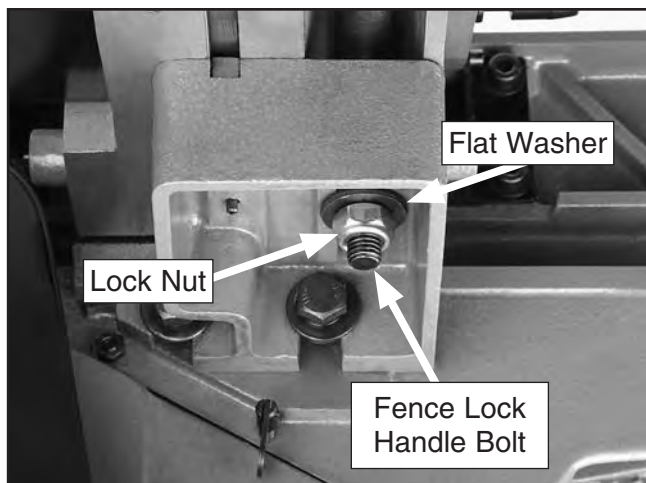


Figure 23. Fence lock nut and washer.

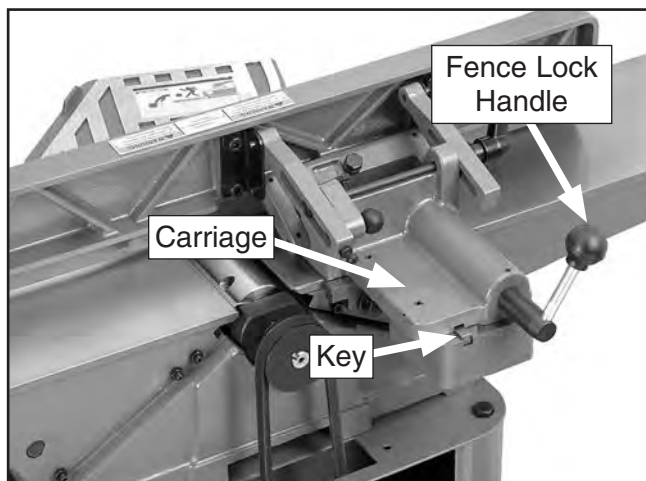


Figure 24. Fence mounted to jointer.

24. Slide the fence lock handle bolt as close to the machine as possible.
25. Secure the fence lock handle bolt with the lock nut and flat washer removed in **Step 23**.
26. Install the fence tilt lever (see **Figure 25**).

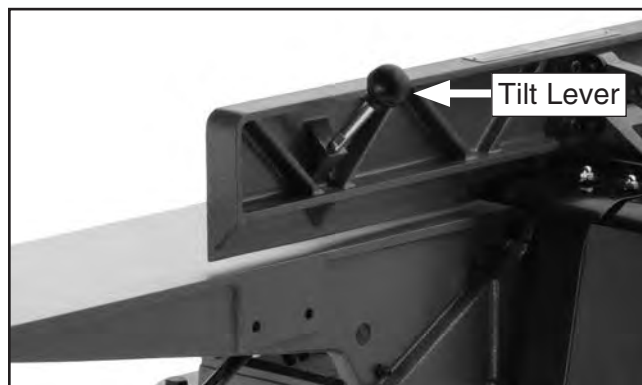


Figure 25. Fence tilt lever installed.

27. Install the belt guard on the cabinet with the (2) M6-1 x 12 flange bolts, 6mm flat washers, and M6-1 hex nuts, as shown in **Figure 26**.

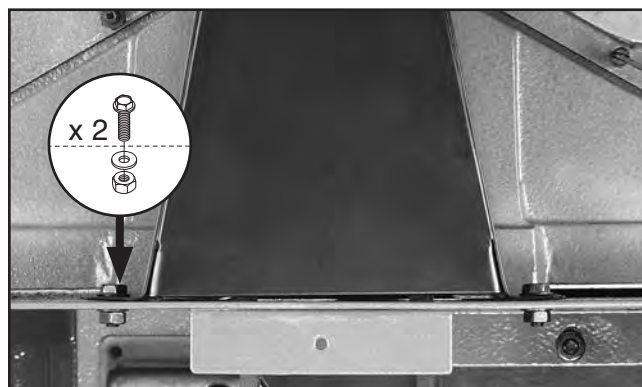


Figure 26. Belt guard installed.

28. Insert the motor cord and motor cord plate through the rectangular slot on the rear panel, and fasten the plate to the rear panel with (2) #10-24 x 3/8" flange screws. Secure the rear panel to the cabinet with (10) #10-24 x 3/8" flange screws (see **Figure 27**).

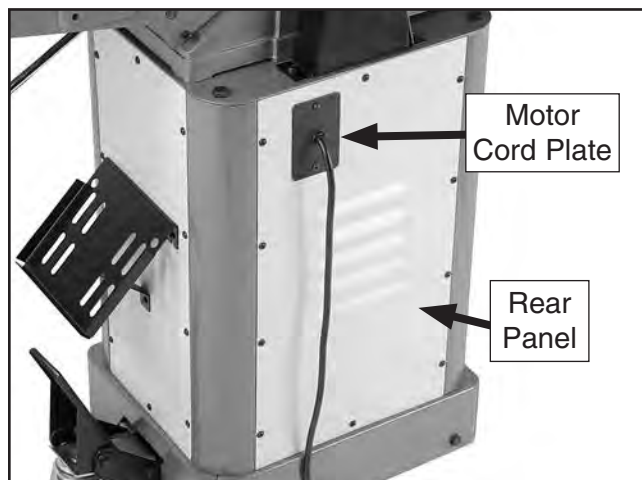


Figure 27. Rear panel and motor cord plate installed.



29. Install the rear guard onto the carriage with the two Phillips head screws and flat washers already on the fence support, as shown in **Figure 28**.

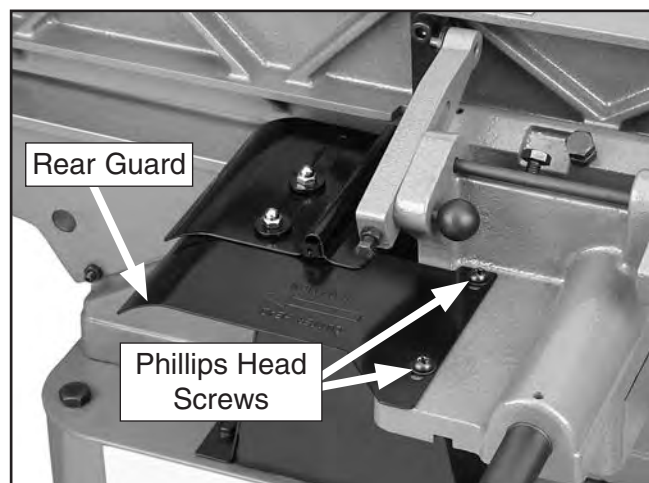


Figure 28. Rear guard installed on fence support.

30. Thread the infeed table lever into the hole shown in **Figure 29**, and tighten the M12-1.75 lock nut.

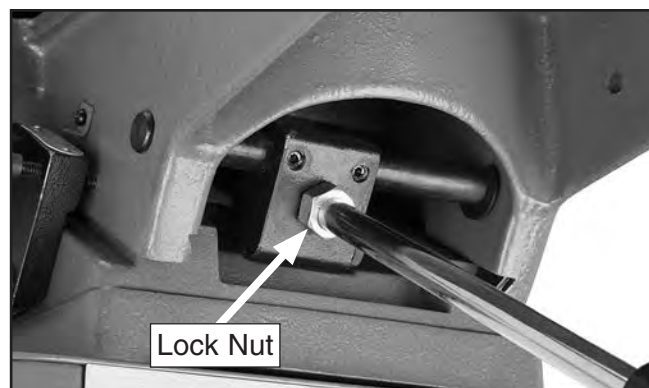


Figure 29. Infeed lever installed.

31. Move the fence back as far as possible.
32. Remove the Phillips head screw from the forked end of the cutterhead guard shaft, and slide the cutterhead guard shaft down through the mounting hole on the table.

Note: The guard may not fully seat in the hole initially; however, rotating the guard will allow the shaft to fully seat in the hole.

33. Thread the Phillips head screw through the forked end of the cutterhead guard shaft, as shown in **Figure 30**.

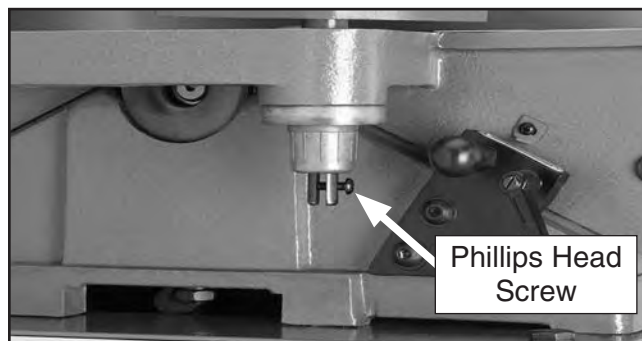


Figure 30. Phillips head screw installed on cutterhead guard.

34. Rotate the guard one revolution counter-clockwise as it appears from the top, then hold the guard in position.
35. Slide the fence forward and allow the guard to swing back against the fence.

NOTICE

The cutterhead guard must always return to the closed position over the cutterhead whenever it is moved.

36. Test the guard by pulling it back and letting it go.

—The guard should snap back over the cutterhead against the fence without dragging across the table.

—If the guard drags across the table, loosen the screw, raise the guard.

—If the guard does not snap back, remove it and repeat **Steps 32–35**.

37. Attach the outfeed table adjustment handle using the pre-installed Phillips head screw (see **Figure 31**).

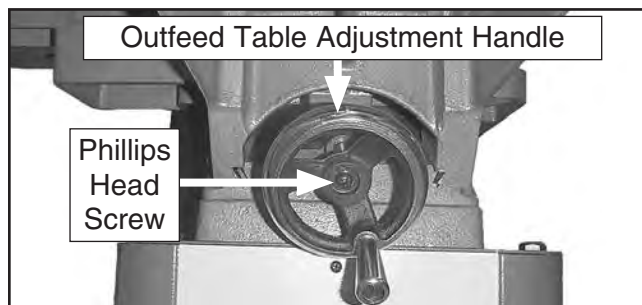


Figure 31. Outfeed adjustment wheel.



Dust Collection

⚠ CAUTION

This machine creates substantial amounts of 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.

Recommended CFM at Dust Port: 400 CFM

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

To connect the machine to a dust collector:

1. Fit a 4" dust hose that is connected to a dust collector over the dust port, as shown in **Figure 32**, and secure in place with a hose clamp.

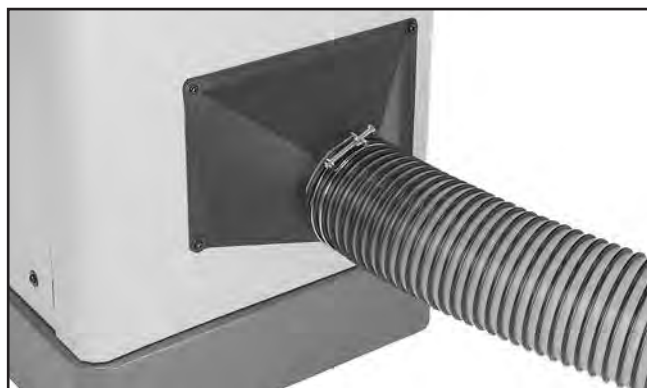


Figure 32. Dust hose attached to dust port.

2. Tug the hose to make sure it does not come off. **Note:** A tight fit is necessary for proper performance.

Setting Outfeed Table Height

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

To set the outfeed table height:

1. DISCONNECT JOINTER FROM POWER!
2. Move the cutterhead guard out of the way or remove it, and open the rear access panel.
3. Place a straightedge on the outfeed table so it extends over the cutterhead and rotate the cutterhead pulley until one of the knives is at top-dead-center (TDC) (see **Figure 33**).

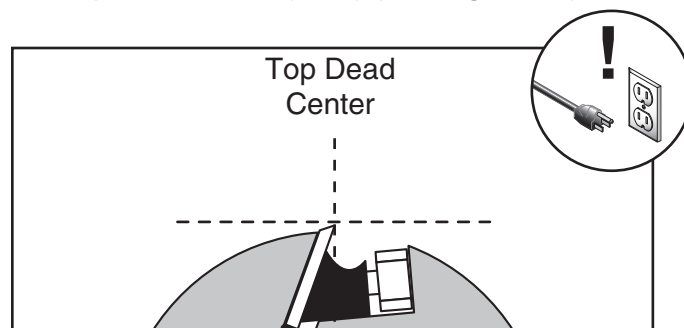


Figure 33. Cutterhead knife at top-dead-center.

4. When correctly set, the knife will just touch the straightedge when the knife is at its highest point of rotation (see **Figure 34**), and the straightedge should move $\frac{5}{32}$ " toward the infeed table when the cutterhead pulley is rotated.

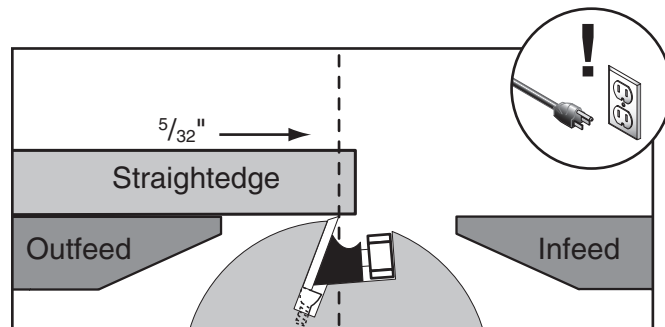


Figure 34. Using a straightedge to align outfeed table height with knife at TDC.



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

—If the knife lifts the straightedge off the table or the table is below the straightedge, loosen the outfeed table lock, and adjust the outfeed table height with the hand wheel until the straightedge just touches a knife at its highest point of rotation.

5. Lock the outfeed table, re-install the cutterhead guard, and close the rear access panel.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 36**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
2. Make sure all tools and objects used during set up are cleared away from the machine.
3. Connect the machine to the power source.
4. Turn the machine **ON**.
5. Listen for abnormal noises or actions and watch for vibration. The machine should run smoothly.

—Strange or unusual noises must be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

6. Turn the machine **OFF**.

Recommended Adjustments

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

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

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

Factory adjustments that should be verified:

1. Knife Settings (see **Page 38**).
2. Depth Scale Calibration (see **Page 40**).
3. Fence Stop Accuracy (see **Page 41**).

Tighten V-Belt

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

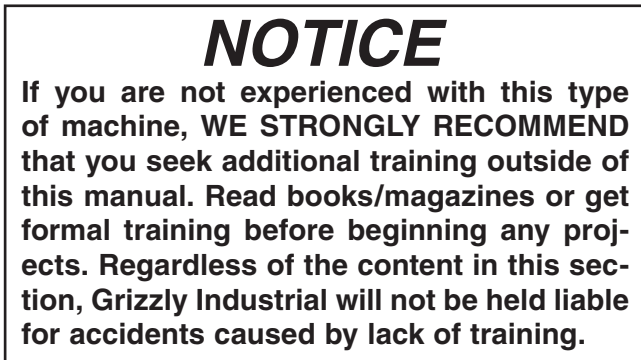
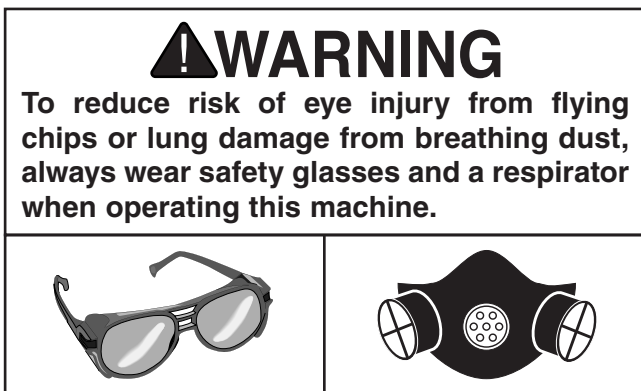
Note: *Pulleys and belts can get hot. This is a normal condition. Allow them to cool before making adjustments.*

A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate a problem with the machine or V-belt.



SECTION 4: OPERATIONS

Operation Safety



Basic Controls

This section covers the basic controls used during routine operations.

START Button: Starts motor.

STOP Paddle: Stops motor when pushed in.

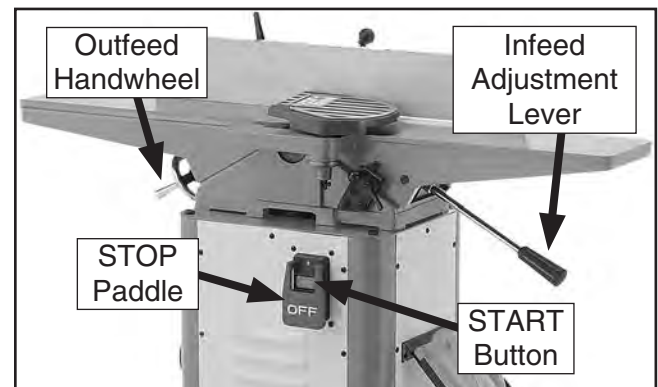


Figure 35. START/STOP controls.

Table Movement: To move the infeed or outfeed tables, loosen the table locks (see **Figure 36**), move the tables with the infeed adjustment lever or outfeed hand wheel (see **Figure 35**), then tighten the table locks. The depth stop knob locks the cutting depth at $\frac{1}{8}$ ". To disengage the stop knob, pull it out and move the infeed table up or down.

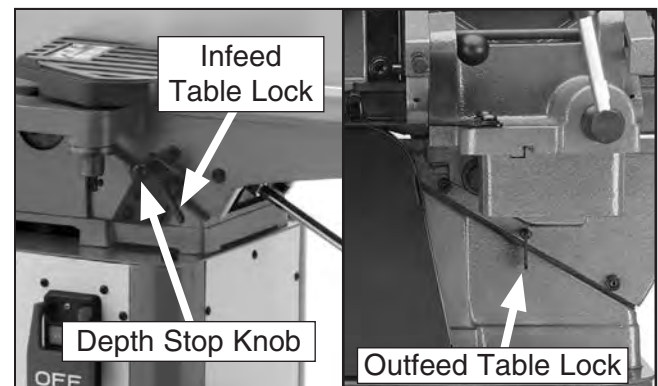


Figure 36. Table control locations.



Fence Movement: The fence has a lock that keeps it in position (see **Figure 37**). To move the fence, loosen the lock and slide the fence where needed, then retighten the lock.

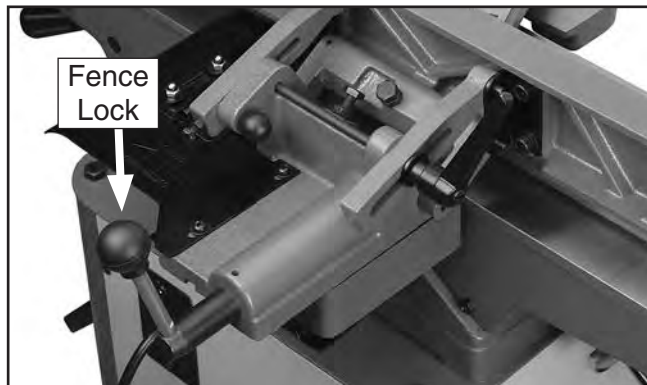


Figure 37. Fence lock location.

Fence Tilting: The tilt lock (see **Figure 38**) secures the fence at any position in the available range. The plunger locks the fence tilt for 90° cuts. Two positive stops stop the fence at 45° inward and 45° outward for common 45° bevel cuts. Even when the fence is resting against the positive stops, the tilt lock must be tightened before cutting. Also, the plunger must be disengaged for 45° outward bevel cuts.

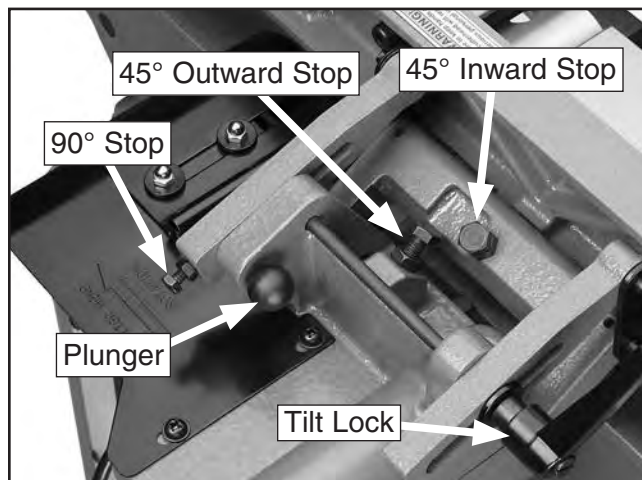


Figure 38. Tilt lock and swing stop locations.



Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

- **DO NOT joint or surface place 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.
- **Jointing and surface planing with the grain is safer for the operator and produces a better finish.** Cutting against the grain increases the likelihood of kickback and workpiece tear-out. DO NOT cut against the grain! Cutting with the grain is feeding the stock across the cutterhead so the grain points down and back, as viewed from the front edge of the stock (see **Figure 39**).

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

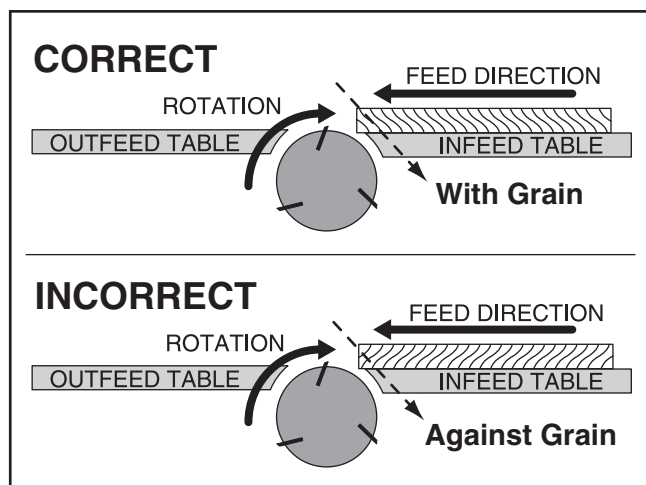


Figure 39. Proper grain alignment with the cutterhead.

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

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

Note: 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.
- **Make sure your workpiece exceeds the minimum dimension requirements, as shown in Figure 40, before processing it through the jointer, or the workpiece may break or kickback during the operation.**

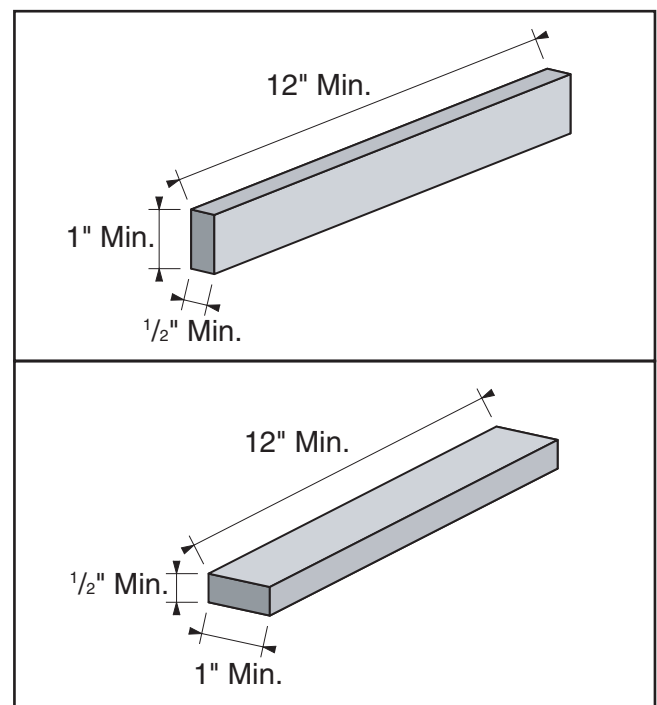


Figure 40. Minimum stock dimensions for the jointer.



!WARNING

Before turning the jointer **ON**, make sure the outfeed table height is properly set (refer to Setting Outfeed Table Height on Page 22 for detailed instructions) to avoid workpiece kickback and to ensure good results. Kickback of the workpiece could cause serious personal injury!

Squaring Stock

Squaring stock involves four steps performed in the following order:

1. **Surface Plane on the Jointer:** The concave face of the workpiece is surface planed flat with the jointer (see **Figure 41**).

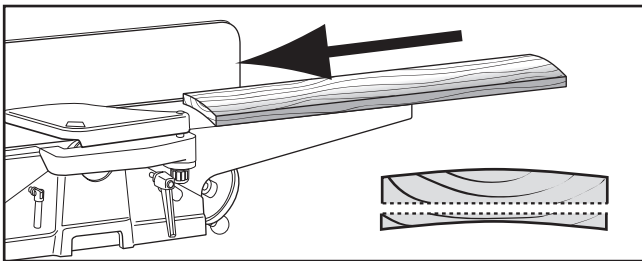


Figure 41. Surface planing on the jointer.

2. **Surface Plane on a Thickness Planer:** The opposite face of the workpiece is surface planed flat with a thickness planer (see **Figure 42**).

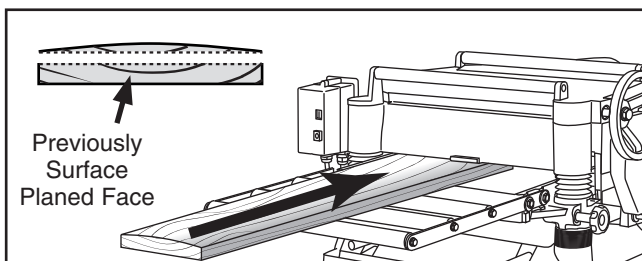


Figure 42. Surface planing on a thickness planer.

3. **Edge Joint on the Jointer:** The concave edge of the workpiece is jointed flat with the jointer (see **Figure 43**).

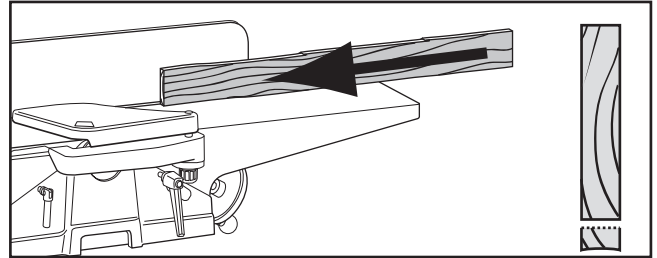


Figure 43. Edge jointing on the jointer.

4. **Rip Cut on a Table Saw:** The jointed edge of the workpiece is placed against the table saw fence and the opposite edge is cut off (see **Figure 44**).

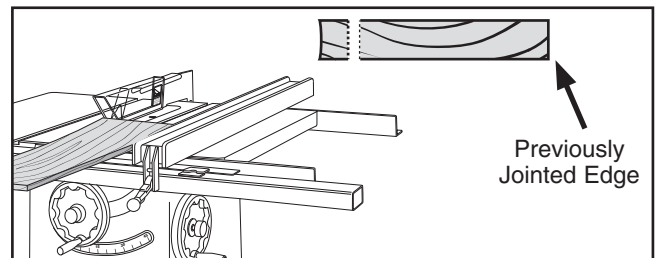


Figure 44. Rip cutting on a table saw.

!WARNING

Making adjustments to the jointer while the machine is **ON** greatly increases the risk to the operator from the rotating cutterhead. **ALWAYS** make sure the jointer is **OFF** and disconnected from power before performing adjustments, maintenance, or service on the machine!



Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see **Figures 45 & 46**). This is a necessary step when preparing a workpiece to be run through a planer when squaring stock.

NOTICE

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

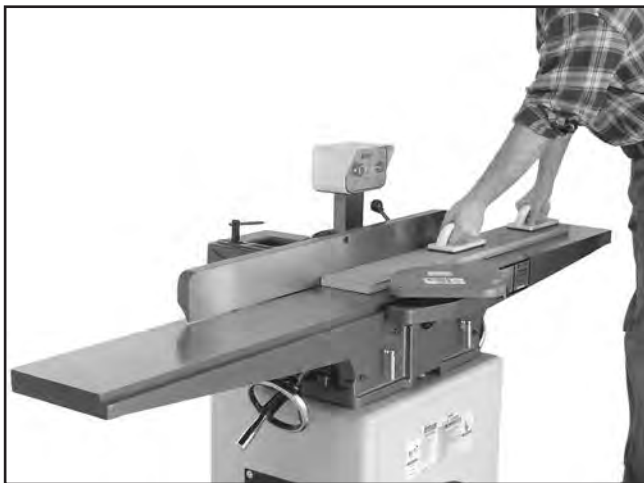


Figure 45. Typical surface planing operation.

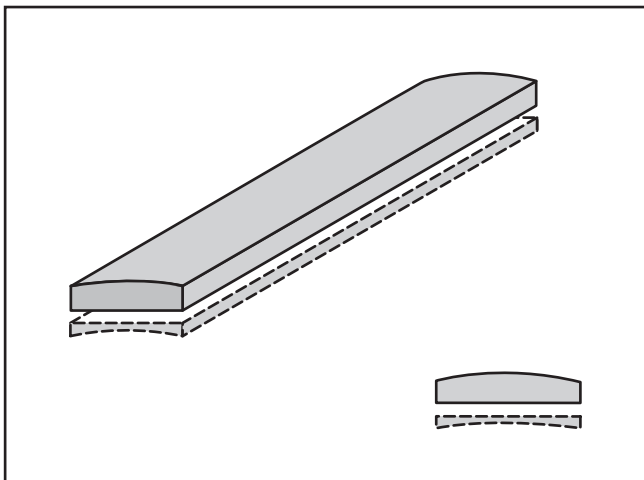


Figure 46. Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26**.
3. Set the cutting depth for your operation. (We suggest $\frac{1}{32}$ " for surface planing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure the fence is set to 90°.
5. If the workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.
6. Start the jointer.

! WARNING

Failure to use push blocks when surface planing may result in cutterhead contact, which will cause serious personal injury. Always use push blocks to protect your hands when surface planing on the jointer.

7. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

Note: If your leading hand (with push block) gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, **DO NOT** let them get closer than 4" from the cutterhead when it is moving!

8. Repeat **Step 7** until the entire surface is flat.



Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 47 & 48**) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

NOTICE

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



Figure 47. Typical edge jointing operation.

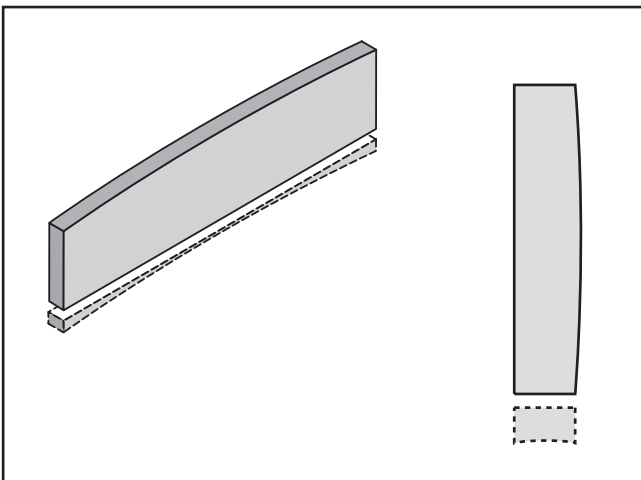


Figure 48. Illustration of edge jointing results.

To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26**.
3. Set the cutting depth for your operation. (We suggest between $\frac{1}{16}$ " and $\frac{1}{8}$ " for edge jointing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure the fence is set to 90° .
5. If your workpiece is cupped (warped), place it so the concave edge is face down on the surface of the infeed table.
6. Start the jointer.
7. With a push block in your leading hand, press the workpiece against the table and fence with firm pressure. Use your trailing hand to guide the workpiece through the cut, and feed the workpiece over the cutterhead.

Note: If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place it on the portion of the workpiece that is over the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, **DO NOT** let them get closer than 4" from the cutterhead when it is moving!

8. Repeat **Step 7** until the entire edge is flat.



Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece (see **Figures 49 & 50**).

The Model G0654 has preset fence stops at 45° inward, 90°, and 45° outward (135°). If your situation requires a different angle, the fence can be locked anywhere between these angles.

NOTICE

If you are not experienced with a jointer, set the depth of cut to zero, and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.



Figure 49. Typical bevel cutting operation, fence stop at 45° outward.

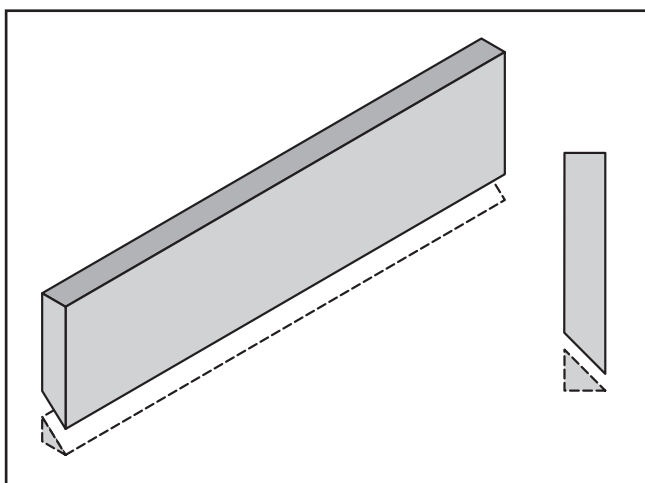


Figure 50. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26**.
3. Set the cutting depth for your operation. (We suggest between $\frac{1}{16}$ " and $\frac{1}{8}$ " for bevel cutting, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure your fence is set to the angle of your desired cut.
5. If your workpiece is cupped (warped), place it so the concave edge is face down on the surface of the infeed table.
6. Start the jointer.
7. With a push block in your leading hand (see **Figure 49**), press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*
8. Repeat **Step 7** until the angled cut is satisfactory to your needs.



Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge (see **Figures 51 & 52**). When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

NOTICE

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



Figure 51. Typical rabbet cutting operation.

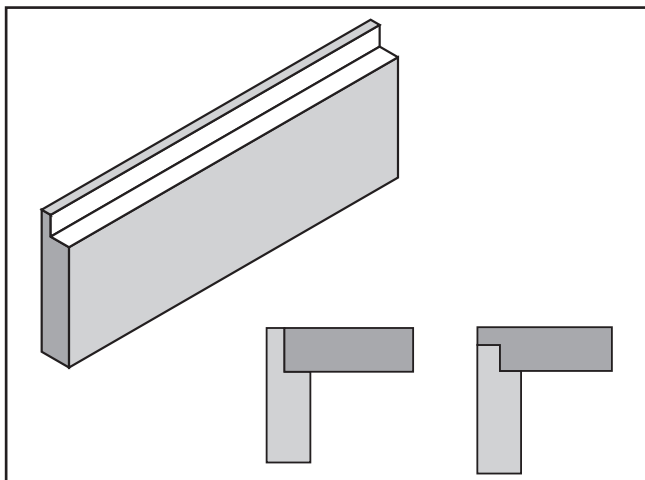


Figure 52. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26**.
3. Set the cutting depth for your operation. (We suggest between $\frac{1}{16}$ " and $\frac{1}{8}$ " for rabbet cutting.
4. Remove the cutterhead guard.
5. Make sure your fence is moved forward, so the amount of infeed/outfeed table exposed is the same as the size of your rabbet. Also, make sure your fence is set to 90°.
6. Start the jointer.
7. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

Note: If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, **DO NOT** let them get closer than 4" from the cutterhead when it is moving!

8. Repeat **Step 7** until the your rabbet is cut to depth.

⚠ WARNING

When the cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes the operator to the moving cutterhead. Always replace the cutterhead guard after rabbet cutting!



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.

H7764—6" Byrd® Shelix Cutterhead

Made in the USA by Byrd, this indexable carbide insert cutterhead is the best money can buy—period! The inserts are not only placed along a spiral pattern, they are also at an angle so that the shearing action leaves a glassy smooth cut on the toughest of woods. Each cutterhead comes with 5 extra replacement inserts.

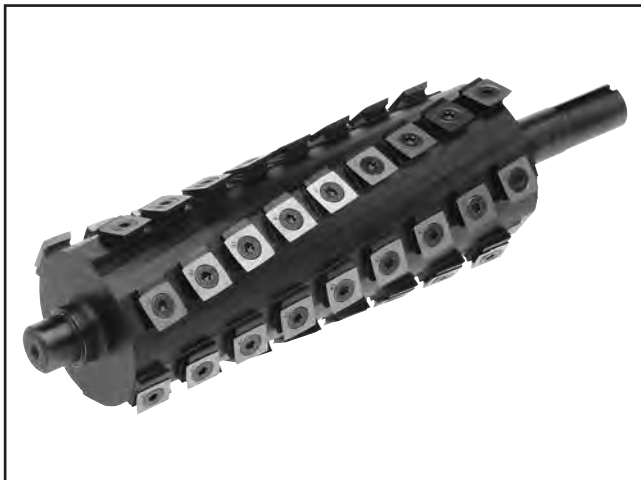


Figure 53. H7764 Byrd Shelix Cutterhead.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

H3788—G96® Gun Treatment 12 oz Spray

H3789—G96® Gun Treatment 4.5 oz Spray



Figure 54. Recommended products for protecting unpainted cast iron/steel part on machinery.

H8029—5 Piece Safety Kit

This kit has four essential jigs. Includes two push blocks, push stick, featherboard and combination saw and router gauge. Featherboard fits $\frac{3}{8}$ " x $\frac{3}{4}$ " miter slots. Made of high visibility yellow plastic.



Figure 55. H8029 5 Piece Safety Kit.

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



T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20452—"Kirova" Anti-Reflective S. Glasses
T20451—"Kirova" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5



Figure 56. Eye protection assortment.

G9256—6" Dial Caliper
G9257—8" Dial Caliper
G9258—12" Dial Caliper

Required for jointing, planing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!

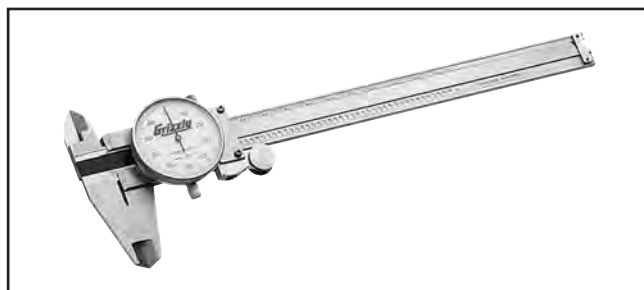


Figure 57. Grizzly® Dial Calipers.

G1163—1HP Dust Collector

Effective dust collection not only keeps your shop cleaner and more pleasant to work in, it can also keep you healthier. Our systems feature powerful motors and convenient collection bags - so they're ideal for just about any-sized woodworking operation.



Figure 58. G1163 1HP dust collector.

H1052—Clear Flexible Hose 4" x 10'
G1536—Black Flexible Hose 4" x 10'
G3179—Heavy-Duty Clear Flex Hose 4" x 10'
G8830—Hose Hanger 4½"
G1552—Y-Fitting 4" x 4" x 4"
G1545—90° Elbow 4"
G2482—Hose Coupler (Splice) 4"
G2974—Wire Hose Clamp 4"
G1843—Plastic Blast Gate 4"
G4679—Anti-Static Grounding Kit

We've hand picked a selection of commonly used dust collection components for machines with 4" dust ports.

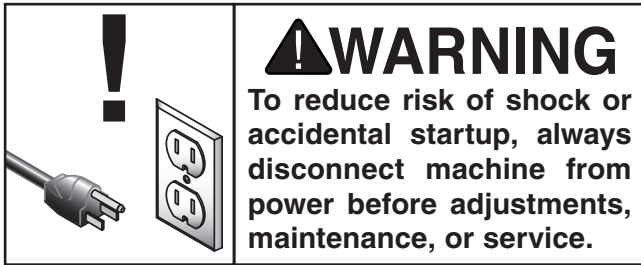


Figure 59. Dust collection accessories.

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



SECTION 6: MAINTENANCE



Schedule

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

Daily Check:

- Vacuum all dust on and around the machine.
- Wipe down tables and all other unpainted cast iron with a metal protectant.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check:

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth—this ensures moisture from wood dust does not remain on bare metal surfaces. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning. We recommend products like SLIPIT®, G96® Gun Treatment, or Boeshield® T-9 (see **Page 32** for more details).

Lubrication

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

The following components require periodic lubrication. Be careful not to over-lubricate them. Large amounts of lubricant will attract sawdust, causing the metal components to gum up and bind.

Leadscrew: Lubricate the outfeed table leadscrew with light machine oil as needed. See the location shown in **Figure 60** and Part 41 on **Page 46**. Wipe off excess oil and sawdust with a cloth.



Figure 60. Leadscrew lubrication location.



Gibs: Lower the infeed and outfeed table to access the gibs. Annually place a couple drops of oil at the top of each gib and move the tables up and down to distribute the oil. See the locations shown in **Figure 61** and Parts 73 and 74 on **Page 46**. Wipe off excess oil.

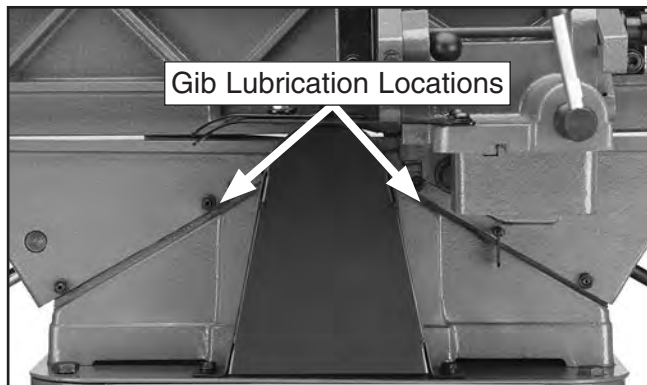


Figure 61. Location to lubricate gibs.

Fence: Place one or two drops of light machine oil on the fence pivot points (**Figure 62**) as needed.

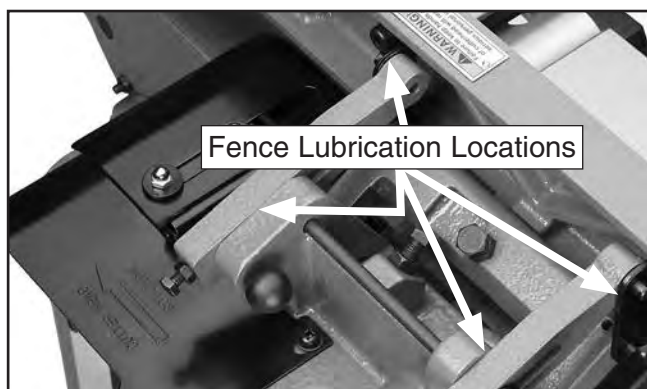


Figure 62. Fence lubrication locations.

V-Belt

V-belt removal and replacement involves removing the V-belt, rolling it off of the pulleys, replacing it with a new belt, then tensioning it.

Consider replacing the stock belt with a Power Twist V-belt (see **Page 32**) to reduce vibration and noise, and increase belt lifespan.

To adjust/replace the V-belt:

1. DISCONNECT JOINTER FROM POWER!

2. Remove the rear access panel and belt guard.
3. Using a 12mm wrench, loosen the motor mount bolts shown in **Figure 63**, raise the motor to remove the V-belt tension.

Note: *DO NOT* completely remove the motor mount hex nuts.

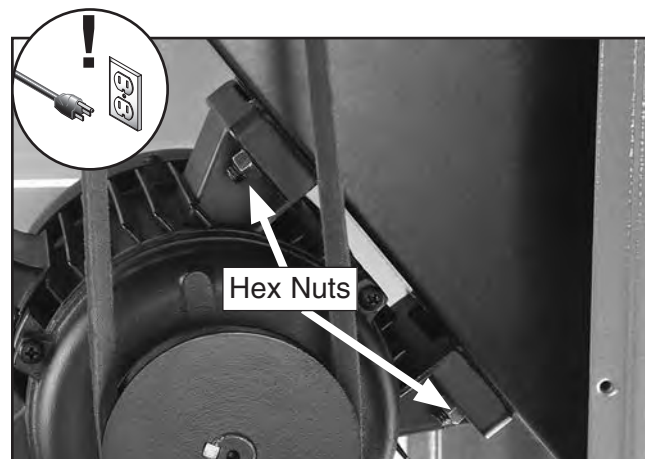


Figure 63. Motor mount hex nuts.

4. Remove the V-belt and replace it with a new one.
5. Lower the motor and adjust the V-belt tension as needed so there is approximately $\frac{1}{4}$ " deflection when the V-belt is pushed with moderate pressure, as shown in **Figure 64**.

Note: *After the first 16 hours of belt life, tension the belt, as it will stretch and seat during this time.*

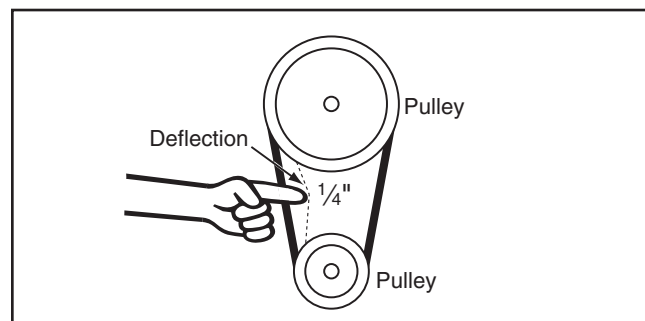


Figure 64. Checking V-belt tension.

6. Tighten the motor mount bolts, replace the rear access panel and belt guard.

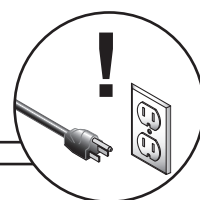


SECTION 7: SERVICE

Review the troubleshooting and 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 at (570) 546-9663.

Note: Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting

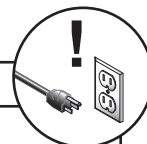


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Motor does not start or a breaker trips.	<ol style="list-style-type: none"> 1. STOP button not reset. 2. Power supply switched OFF or is at fault. 3. Plug/receptacle is at fault or wired incorrectly. 4. Start capacitor is at fault. 5. Motor connection wired incorrectly. 6. Wall fuse/circuit breaker is blown/tripped. 7. Wiring is open/has high resistance. 8. Motor START/STOP switch is at fault. 9. Motor is at fault. 	<ol style="list-style-type: none"> 1. Lift paddle and press STOP button down completely until it clicks. Press START button in completely. 2. Ensure power supply is switched ON; ensure power supply has the correct voltage. 3. Test for good contacts; correct the wiring. 4. Test/replace if faulty. 5. Correct motor wiring connections. 6. Ensure circuit size is suitable for this machine; replace weak breaker. 7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 8. Replace faulty START/STOP switch. 9. Test/repair/replace.
Motor stalls or is overloaded.	<ol style="list-style-type: none"> 1. Workpiece material is not suitable for this machine. 2. V-belt slipping. 3. Motor connection is wired incorrectly. 4. Plug/receptacle is at fault. 5. Pulley/sprocket slipping on shaft. 6. Motor bearings are at fault. 7. Machine is undersized for the task. 8. Motor has overheated. 9. Motor is at fault. 10. Centrifugal switch is at fault. 	<ol style="list-style-type: none"> 1. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece. 2. Replace bad V-belt, align pulleys, and re-tension. 3. Correct motor wiring connections. 4. Test for good contacts; correct the wiring. 5. Replace loose pulley/shaft. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Use sharp knives; reduce feed rate/depth of cut. 8. Clean off motor, let cool, and reduce workload. 9. Test/repair/replace. 10. Adjust/replace centrifugal switch if available.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. Knives/gibs are at fault. 3. V-belt worn or loose. 4. Pulley is loose. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Resharpen/replace knives as required; set knife alignment/protrusion correctly (Page 38). 3. Inspect/replace V-belt with a new one (refer to Page 35). 4. Realign/replace shaft, pulley, set screw, and key as required.



Motor & Electrical Continued



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	5. Motor mount loose/broken. 6. Machine is incorrectly mounted or sits unevenly. 7. Motor fan is rubbing on fan cover. 8. Motor bearings are at fault. 9. Cutterhead bearings at fault.	5. Tighten/replace. 6. Relocate machine or adjust feet to level jointer. 7. Replace dented fan cover; replace loose/damaged fan. 8. Test by rotating shaft; rotational grinding/loose shaft requires motor replacement. 9. Replace bearing(s)/realign cutterhead.

Table

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	1. Table locks are engaged or partially engaged. 2. Infeed table depth stop blocking movement.	1. Completely loosen the table locks. 2. Disengage infeed table depth stop.

Cutting

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	1. Outfeed table is set too low. 2. Operator pushing down on trailing end of the workpiece.	1. Align outfeed table with cutterhead knife at top dead center (Page 22). 2. Reduce/eliminate downward pressure on that end of workpiece.
Workpiece stops in the middle of the cut.	1. Outfeed table is set too high.	1. Align outfeed table with cutterhead knife at top dead center (Page 22).
Chipping.	1. Knots or conflicting grain direction in wood. 2. Nicked or chipped blades. 3. Feeding workpiece too fast. 4. Taking too deep of a cut.	1. Inspect workpiece for knots and grain (Page 26); only use clean stock. 2. Adjust one of the nicked knives sideways; replace knives (Page 38). 3. Slow down the feed rate. 4. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)
Fuzzy Grain.	1. Wood may have high moisture content or surface wetness. 2. Dull knives.	1. Check to make sure moisture content is less than 20% and allow to dry if moisture is too high. 2. Sharpen or replace knives (Page 38).
Long lines or ridges that run along the length of the board	1. Nicked or chipped knives.	1. Adjust one of the nicked knives sideways; replace knives (Page 38).
Uneven cutter marks, wavy surface, or chatter marks across the face of the board.	1. Feeding workpiece too fast. 2. Knives not adjusted at even heights in the cutterhead.	1. Slow down the feed rate. 2. Adjust the knives so they are set up evenly in the cutterhead (Page 38).
Board edge is concave or convex after jointing.	1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven.	1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass.



Inspecting Knives

The height of the knives can be easily and quickly inspected with the included knife setting gauge. This inspection will ensure that the knives are set to the correct height in the cutterhead. For best results, we recommend using a W1211A Jointer Pal magnetic knife setting jig.

Tools Needed	Qty
Knife Setting Gauge	1

To inspect the knives:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the cutterhead guard or block it out of the way.
3. Lower the infeed table to the $\frac{1}{2}$ " scale mark and lower the outfeed table as needed.
4. Remove the rear panel and rotate the V-belt so a knife is exposed.
5. Place the knife gauge on the cutterhead, directly over a knife, as shown in **Figure 65**.

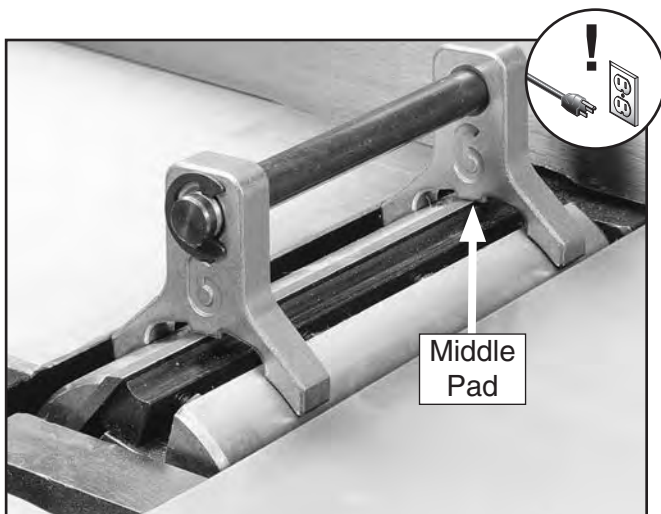


Figure 65. Gauge positioned over cutterhead knife.

6. Carefully inspect how the gauge touches the cutterhead and the knife.

—If both outside legs of the gauge sit firmly on the cutterhead and the middle pad just touches the knife, then that knife is set correctly. (Repeat this inspection with the other knives).

—If the gauge does not sit firmly on the cutterhead and touch the knife edge as described, then reset that knife. (Repeat this inspection with the other knives before resetting.)

Setting/Replacing Knives

Setting the knives correctly is crucial to the proper operation of the jointer and is very important in keeping the knives sharp. If one knife is higher than the others, it will do the majority of the work, and thus, dull much faster than the others.

The knife gauge included with the jointer is designed to set the knives at 0.063" ($\frac{1}{16}$ "), which is the correct distance all the knives should protrude above the cutterhead.

The Model G0654 comes with jack screws for cutterhead adjustments (see **Figure 66**).

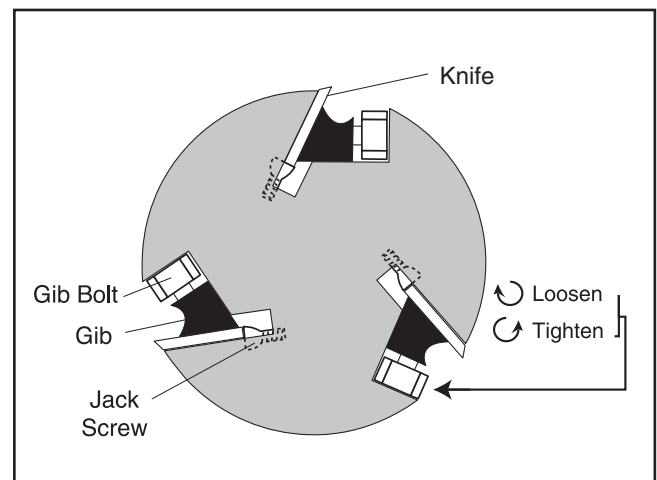


Figure 66. Cutterhead profile diagram.



Tools Needed	Qty
Knife Setting Gauge	1
Hex Wrench 2.5mm.....	1
Wrench 8mm	1

To set or replace the knives:

1. **DISCONNECT JOINTER FROM POWER!** 2. Remove the cutterhead guard from the table and lower the infeed and outfeed tables as far as they go. This will give you unrestricted access to the cutterhead.
2. Remove the rear access panel to expose the cutterhead pulley.
3. Rotate the cutterhead pulley to give you good access to one of the cutterhead knives.
4. Loosen the cutterhead gib bolts, starting in the middle and alternating back-and-forth until all of the gib bolts are loose but not falling out.

—If this is the first time you are setting the knives, or if you are replacing them, remove a gib and knife from the cutterhead. Clean the gib and clean inside the cutterhead slot to remove all pitch or sawdust. Coat the knife and gib with a metal protectant (**Page 32**).
5. Position the knife gauge over the knife as shown in **Figure 65** and loosen the gib bolts until the knife is completely loose.

6. Using a 2.5mm hex wrench, rotate the jack screws (see **Figure 67**) in the access holes to raise or lower the knife. When the knife is set correctly, it will barely touch the middle pad of the knife setting jig. Snug the gib bolts tight enough to just hold the knife in place. Repeat **Steps 5-7** with the rest of the knives.

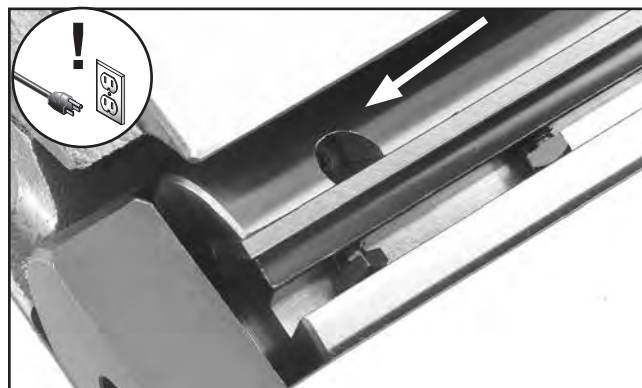


Figure 67. Jack screw access hole.

7. Rotate the cutterhead to the first knife you adjusted. Slightly tighten all the gib bolts, starting at the middle and working your way to the ends by alternating left and right (see **Figure 68**). Repeat this step on the rest of the knives.

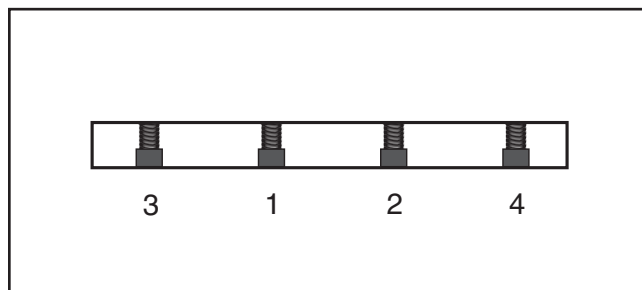


Figure 68. Gib bolt tightening sequence.

8. Repeat **Step 8**, but final tighten each gib bolt.
9. Adjust the outfeed table to match the new knife heights (refer to **Setting Outfeed Table Height** on **Page 22**).
10. Replace the cutterhead guard and the rear access panel.



Calibrating Infeed Table

The infeed table height is calibrated by adjusting the depth scale and depth stop knob.

Tools Needed	Qty
Straightedge	1
Phillips Head Screwdriver	1

Calibrating Depth Scale

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

To calibrate the depth scale:

1. Set the outfeed table height as described in **Setting Outfeed Table Height** on **Page 22**.
2. Move the cutterhead guard out of the way.
3. Place a straightedge across the infeed and outfeed tables.
4. Adjust the infeed table until it is level with the outfeed table, as illustrated in **Figure 69**.

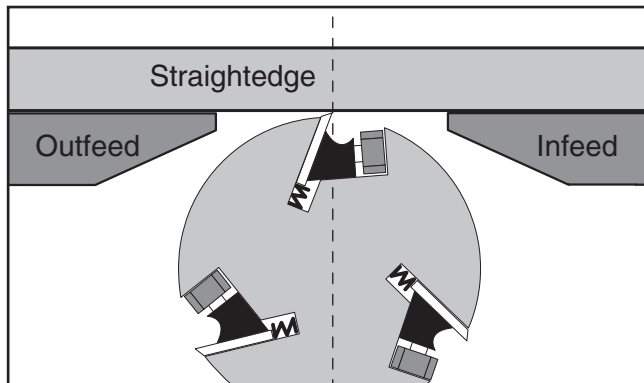


Figure 69. Infeed table adjusted even with outfeed table.

5. Using a screwdriver, adjust the scale pointer exactly to "0", as shown in **Figure 70**.

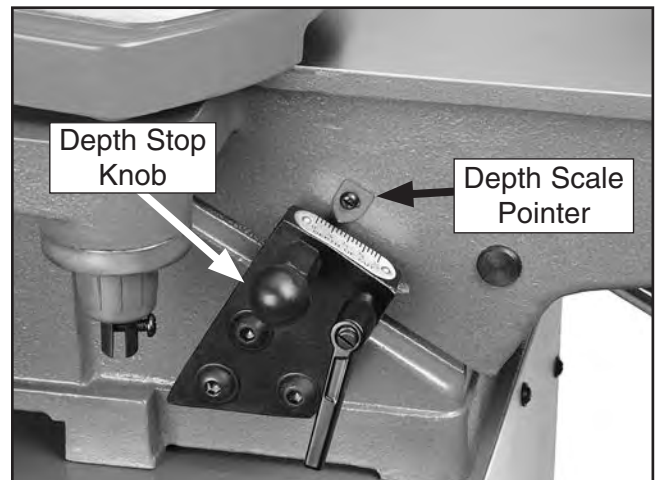


Figure 70. Depth scale and depth stop knob.

Depth Stop Knob

A depth stop knob (see **Figure 70**) on the depth scale assembly allows the operator to set the maximum depth of cut to $\frac{1}{8}$ ".

To engage the knob, adjust the table height to $\frac{1}{8}$ " until the knob clicks into place. To disengage the knob, pull it out and adjust the table to the desired height.



Setting Fence Stops

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

Tools Needed	Qty
45° Square	1
90° Square	1
Sliding Bevel.....	1
Wrench 14mm	1
Wrench 10mm	1

To set the 45° inward fence stop:

1. Using a 45° square, adjust the fence to the 45° inward position, as shown in **Figure 71**.



Figure 71. Example of adjusting fence 45° inward.

2. Loosen the jam nut shown in **Figure 72**.

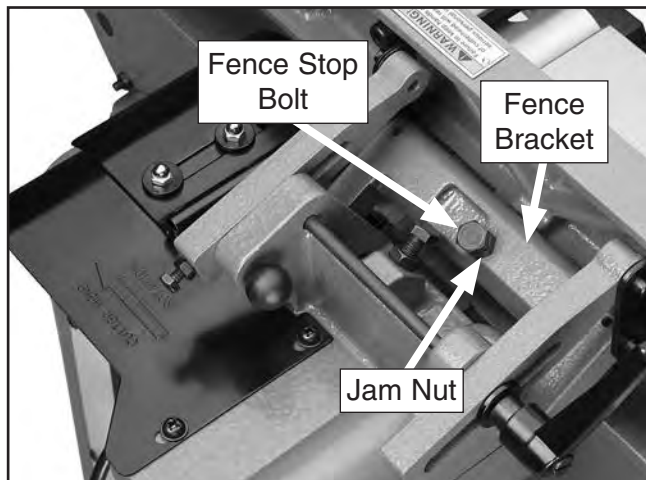


Figure 72. 45° inward fence stop bolt.

3. Adjust the 45° inward fence stop bolt until it makes contact with the back of the fence bracket.

4. Retighten the jam nut loosened in **Step 2**.

To set the 90° fence stop:

1. Using a 90° square, adjust the fence to the 90° position, as shown in **Figure 73**.



Figure 73. Example of adjusting fence to 90°.

2. Push the plunger in.

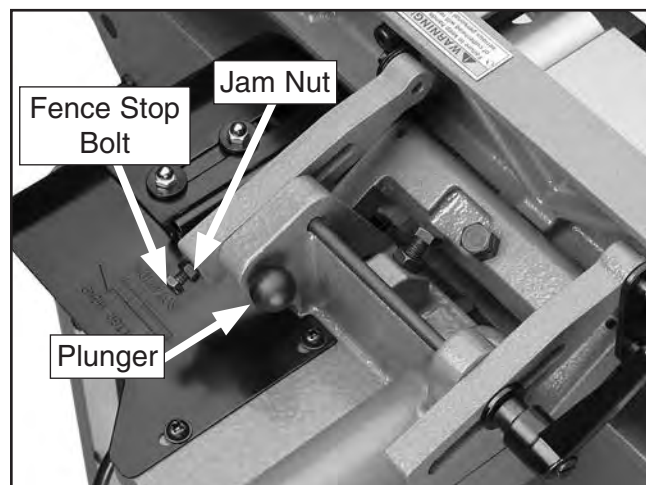


Figure 74. Plunger engaged.

3. Loosen the jam nut on the 90° fence stop bolt (see **Figure 74**).
4. Adjust the 90° fence stop bolt until it makes contact with the 90° plunger knob shaft.
5. Retighten the jam nut loosened in **Step 3**.



To set the 45° outward fence stop:

1. Pull the plunger out (see **Figure 74** on **Page 41**).
2. Using a sliding bevel adjusted to 135°, adjust the fence to the 135° (45° outward) position, as shown in **Figure 75**.



Figure 75. Example of adjusting fence 45° outward.

3. Loosen the jam nut on the 45° outward fence stop bolt (see **Figure 76**).

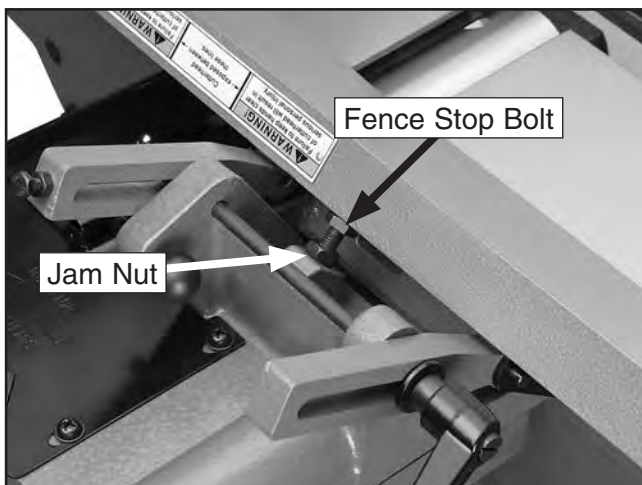


Figure 76. 45° outward fence stop bolt.

4. Adjust the 45° outward fence stop bolt until it makes contact with the back of the fence.
5. Retighten the jam nut loosened in **Step 3**.

Adjusting Gibs

The table gibs eliminate excessive play in the table movement, and control how easy the tables move up and down.

Tools Needed

Qty

Wrench 10mm	1
Hex Wrench 3mm.....	1

To adjust the table gibs:

1. Using a 10mm wrench, loosen the three infeed table gib nuts on the back of the jointer base (see **Figure 77**).

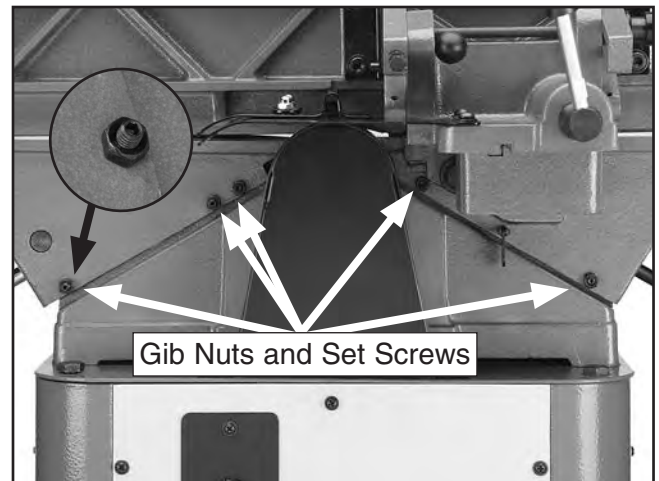


Figure 77. Table gib nuts and set screw locations.

2. Oil the gibs if needed (see **Page 34**).
3. Using a 3mm hex wrench, evenly tighten the gib set screws a small amount, then check the table by moving it up and down. Adjust the set screws as needed until the friction of the table movement is balanced between minimal play and ease of movement.

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

4. Repeat **Steps 1-3** with the outfeed table, and oil the outfeed table leadscrew, if needed.
5. Set the outfeed table height as described in **Setting Outfeed Table Height** on **Page 22**.



Wiring Diagram

Grizzly
Industrial, Inc.®

COLOR KEY

BLACK — (Bk) —
WHITE — (Wt) —
GREEN — (Gn) —

NOTICE

The motor wiring shown here is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

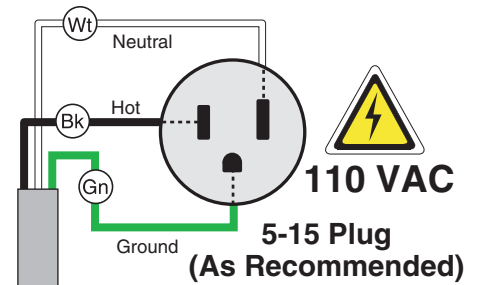


WARNING!

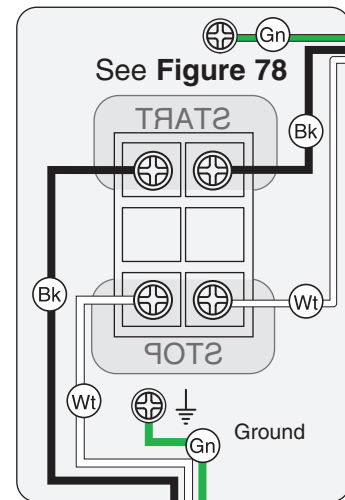
SHOCK HAZARD!
Disconnect power
before working on
wiring.



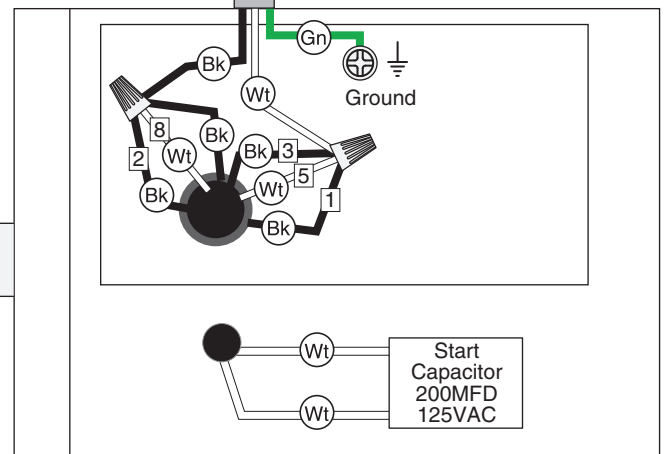
View this page in color at
www.grizzly.com.



PUSH BUTTON SWITCH
(viewed from behind)



MOTOR



See Figure 79



Figure 78. Switch wiring.

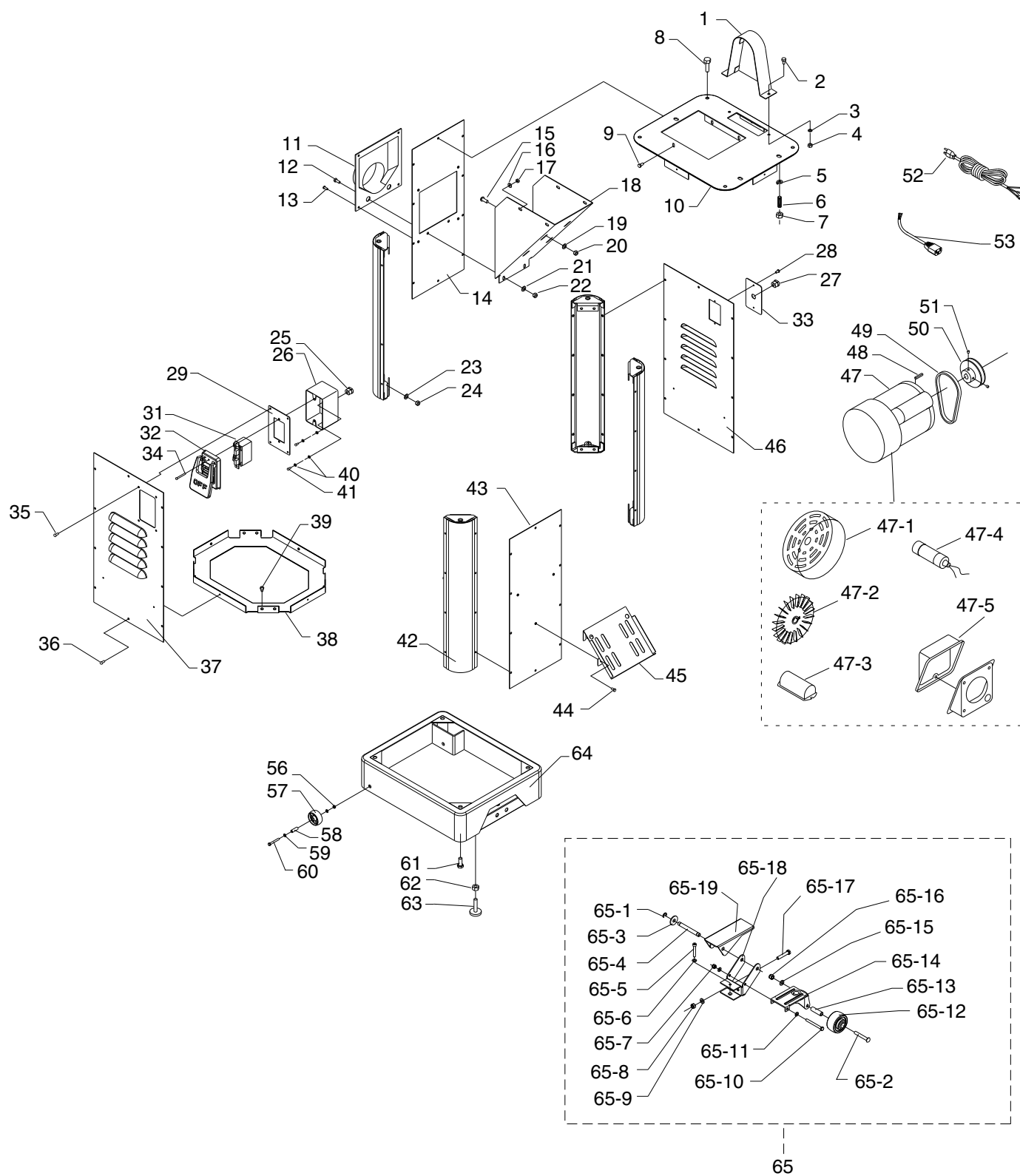


Figure 79. Motor junction box and capacitor wiring.

Model G0654 (Mfg. Since 9/07)



Stand Parts Breakdown



Stand Parts List

REF	PART #	DESCRIPTION
1	P0654001	BELT GUARD ASSEMBLY
2	PFB01M	FLANGE BOLT M6-1 X 12
3	PW03M	FLAT WASHER 6MM
4	PN01M	HEX NUT M6-1
5	PLW06M	LOCK WASHER 10MM
6	P0654006	SPECIAL STUD M10-1.5
7	PN02M	HEX NUT M10-1.5
8	PB18	HEX BOLT 3/8-16 X 1
9	PB02M	HEX BOLT M6-1 X 12
10	P0654010	TOP PLATE ASSEMBLY
11	P0654011	DUST PORT
12	PFB01M	FLANGE BOLT M6-1 X 12
13	PFS03	FLANGE SCREW 10-24 X 3/8
14	P0654014	LEFT PANEL
15	PCB06	CARRIAGE BOLT 5/16-18 X 1-1/4
16	PW03M	FLAT WASHER 6MM
17	PN01M	HEX NUT M6-1
18	P0654018	DUST CHUTE
19	PW07	FLAT WASHER 5/16
20	PN02	HEX NUT 5/16-18
21	PW03M	FLAT WASHER 6MM
22	PN01M	HEX NUT M6-1
23	PW03M	FLAT WASHER 6MM
24	PN01M	HEX NUT M6-1
25	P0654025	STRAIN RELIEF 6N-4
26	P0654026	SWITCH BOX
27	P0654027	STRAIN RELIEF 6N-4
28	PFS03	FLANGE SCREW 10-24 X 3/8
29	P0654029	SWITCH BOX BRACKET
31	P0654031	SWITCH
32	P0654032	SWITCH COVER
33	P0654033	CORD PLATE
34	P0654034	SPECIAL SCREW M4-.7 X 20
35	PFS03	FLANGE SCREW 10-24 X 3/8
36	PFS03	FLANGE SCREW 10-24 X 3/8
37	P0654037	FRONT PANEL
38	P0654038	BOTTOM PLATE
39	PFB01M	FLANGE BOLT M6-1 X 12
40	PTLW02M	EXT TOOTH WASHER 5MM
41	PS05M	PHLP HD SCR M5-.8 X 8
42	P0654042	CABINET SUPPORT
43	P0654043	RIGHT PANEL
44	PFS03	FLANGE SCREW 10-24 X 3/8

REF	PART #	DESCRIPTION
45	P0654045	PUSH BLOCK HOLDER
46	P0654046	BACK PANEL
47	P0654047	MOTOR 1HP 110V
47-1	P0654047-1	FAN COVER
47-2	P0654047-2	FAN
47-3	P0654047-3	S CAPACITOR COVER
47-4	PC200D	S CAP 200M 125V 1-1/4 X 2-3/4
47-5	P0654047-5	JUNCTION BOX
48	PK12M	KEY 5 X 5 X 30
49	PVA36	V-BELT A-36 4L360
50	P0654050	MOTOR PULLEY
51	PSS01M	SET SCREW M6-1 X 10
52	P0654052	POWER CORD 14AWG X 3C
53	P0654053	SWITCH CORD 16AWG X 3C
56	PLN04M	LOCK NUT M8-1.25
57	P0654057	WHEEL
58	P0654058	SLEEVE
59	PW01M	FLAT WASHER 8MM
60	PB86M	HEX BOLT M8-1.25 X 65
61	PB18	HEX BOLT 3/8-16 X 1
62	PN08	HEX NUT 3/8-16
63	P0654063	LEVELING FOOT
64	P0654064	MOBILE BASE CHASSIS
65	P0654065	PEDAL ASSEMBLY
65-1	PEC10M	E-CLIP 9MM
65-2	P0654065-2	SPECIAL BOLT
65-3	P0654065-3	SPECIAL FLAT WASHER
65-4	P0654065-4	SHAFT
65-5	PB22M	HEX BOLT M8-1.25 X 50
65-6	PW01M	FLAT WASHER 8MM
65-7	P0654065-7	SPECIAL HEX NUT M8
65-8	PN02M	HEX NUT M10-1.5
65-9	PW04M	FLAT WASHER 10MM
65-10	PB45M	HEX BOLT M8-1.25 X 100
65-11	PW01M	FLAT WASHER 8MM
65-12	P0654065-12	TROLLEY WHEEL
65-13	P0654065-13	SLEEVE
65-14	P0654065-14	TROLLEY BRACKET
65-15	PW04M	FLAT WASHER 10MM
65-16	P0654065-16	SPECIAL HEX NUT M10
65-17	PB144M	HEX BOLT M10-1.5 X 55
65-18	P0654065-18	PEDAL BRACKET
65-19	P0654065-19	PEDAL



Table Parts Breakdown

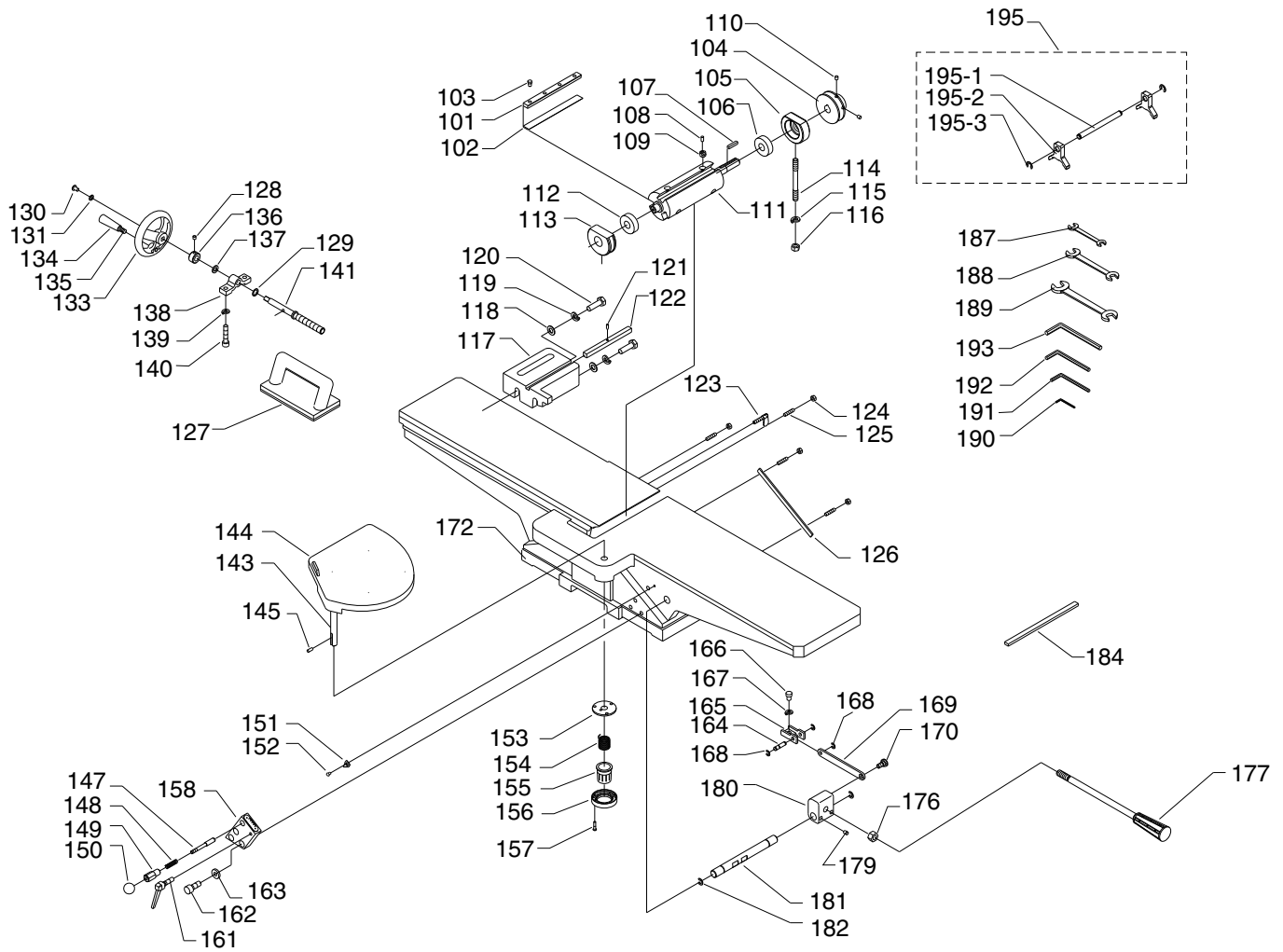


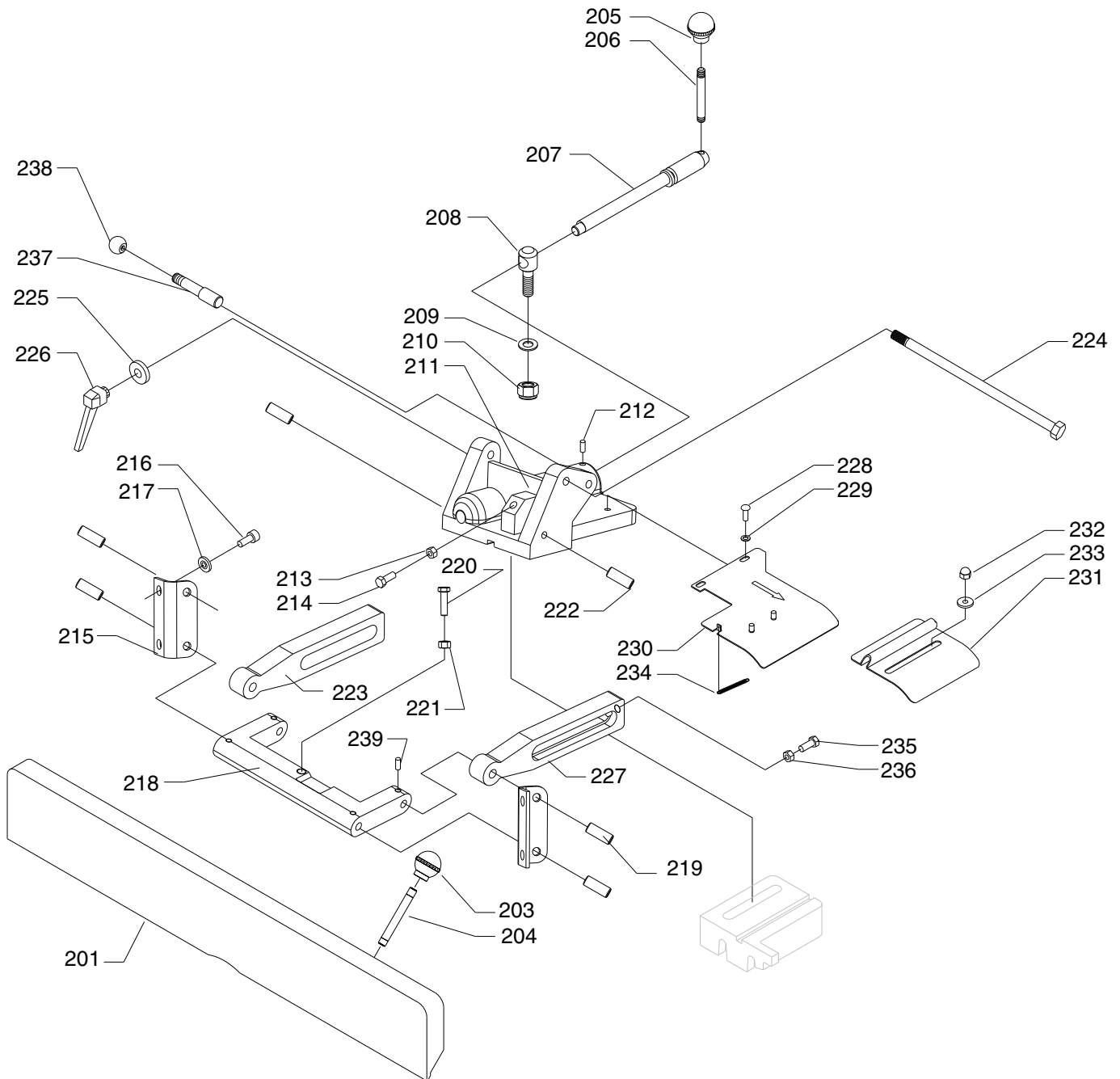
Table Parts List

REF	PART #	DESCRIPTION
101	P0654101	GIB
102	P0654102	KNIFE
103	P0654103	GIB BOLT M6-.9 X 7
104	P0654104	CUTTERHEAD PULLEY
105	P0654105	RIGHT HAND BEARING SUPPORT
106	P6203	BALL BEARING 6203ZZ
107	PK12M	KEY 5 X 5 X 30
108	PSS53M	SET SCREW M5-.8 X 12
109	P0654109	SPECIAL NUT
110	PSS01M	SET SCREW M6-1 X 10
111	P0654111	CUTTERHEAD
112	P6202	BALL BEARING 6202ZZ
113	P0654113	LEFT HAND BEARING SUPPORT
114	P0654114	SPECIAL STUD
115	PLW06M	LOCK WASHER 10MM
116	PN02M	HEX NUT M10-1.5
117	P0654117	FENCE CARRIAGE
118	PW04M	FLAT WASHER 10MM
119	PLW06M	LOCK WASHER 10MM
120	PB01M	HEX BOLT M10-1.5 X 30
121	PRP39M	ROLL PIN 4 X 20
122	P0654122	SPECIAL KEY 9.5 X 9.5 X 128
123	P0654123	LOCK SCREW ASSEMBLY
124	PN01M	HEX NUT M6-1
125	PSS12M	SET SCREW M6-1 X 25
126	P0654126	GIB
127	P0654127	PUSH BLOCK
128	PSS02M	SET SCREW M6-1 X 6
129	P0654129	SPECIAL WASHER
130	PS14M	PHLP HD SCR M6-1 X 12
131	PW03M	FLAT WASHER 6MM
133	P0654133	HANDWHEEL
134	P0654134	HANDLE
135	P0654135	SHOULDER SCREW
136	P0654136	COLLAR
137	P0654137	SPECIAL WASHER
138	P0654138	BLOCK
139	PLW04M	LOCK WASHER 8MM
140	PSB05M	CAP SCREW M8-1.25 X 50
141	P0654141	SCREW SHAFT
143	P0654143	GUARD SHAFT
144	P0654144	GUARD

REF	PART #	DESCRIPTION
145	PSS53M	SET SCREW M5-.8 X 12
147	P0654147	INDEX PIN M6-1 X 14
148	P0654148	COMPRESSION SPRING
149	P0654149	PLUNGER HOUSING
150	P0654150	BALL KNOB M6-1
151	P0654151	POINTER
152	PS17M	PHLP HD SCR M4-.7 X 6
153	P0654153	PLATE
154	P0654154	TORSION SPRING
155	P0654155	CUP
156	P0654156	RETAINER
157	PS01M	PHLP HD SCR M4-.7 X 18
158	P0654158	BLOCK ASSEMBLY
161	P0654161	LOCK LEVER M6-1 X 30
162	PSBS23M	BUTTON HD CAP SCR M8-1.25 X 25
163	PW01M	FLAT WASHER 8MM
164	P0654164	ALIGNMENT PIN
165	P0654165	BRACKET
166	PSB11M	CAP SCREW M8-1.25 X 16
167	PLW04M	LOCK WASHER 8MM
168	PEC07M	E-CLIP 7MM
169	P0654169	LINK
170	P0654170	SPECIAL BOLT
172	P0654172	JOINTER TABLE ASSEMBLY
176	PN09M	HEX NUT M12-1.75
177	P0654177	INFEED TABLE ADJUSTMENT LEVER
179	PSS20M	SET SCREW M8-1.25 X 8
180	P0654180	BLOCK
181	P0654181	SHAFT
182	PEC12M	E-CLIP 12MM
184	P0654184	SEAL
187	PWR810	WRENCH 8 X10
188	PRW1214	WRENCH 12 X 14
189	PWR1417	WRENCH 14 X 17
190	PAW02.5M	HEX WRENCH 2.5MM
191	PAW03M	HEX WRENCH 3MM
192	PAW04M	HEX WRENCH 4MM
193	PAW06M	HEX WRENCH 6MM
195	P0654195	KNIFE GAUGE ASSEMBLY
195-1	P0654195-1	KNIFE GAUGE ROD
195-2	P0654195-2	KNIFE GAUGE BLOCK
195-3	PEC015M	E-CLIP 8MM



Fence Parts Breakdown



Fence Parts List

REF PART # DESCRIPTION

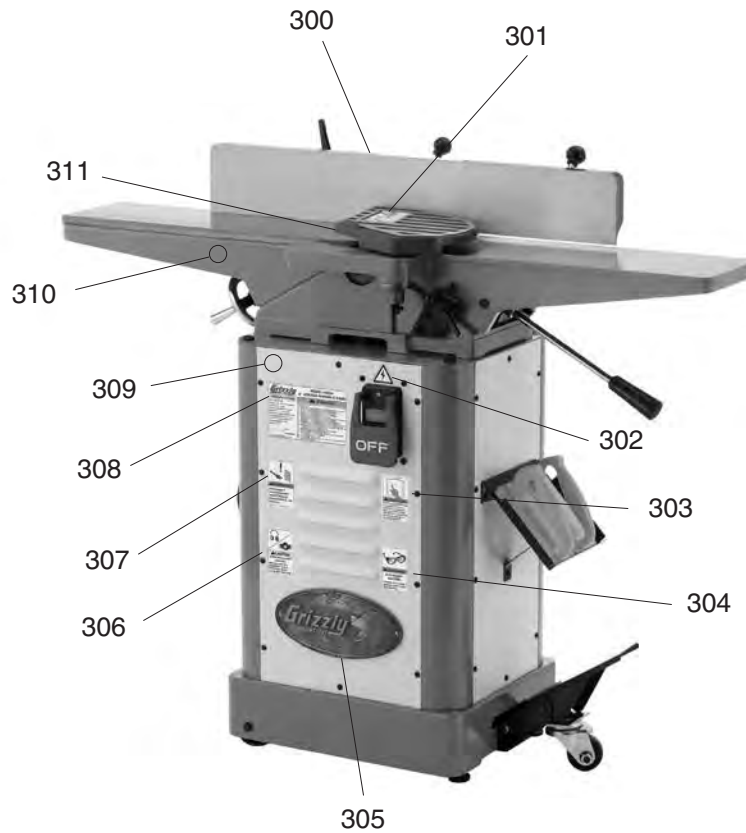
201	P0654201	FENCE
203	P0654203	BALL KNOB M10-1.5
204	P0654204	STUD M10-1.5
205	P0654203	BALL KNOB M10-1.5
206	P0654204	STUD M10-1.5
207	P0654207	FENCE LOCK HANDLE SHAFT
208	P0654208	FENCE LOCK HANDLE BOLT M12-1.75
209	PW06M	FLAT WASHER 12MM
210	P0654210	SPECIAL NUT M12
211	P0654211	FENCE SLIDE BRACKET
212	PSS04M	SET SCREW M6-1 X 12
213	PN03M	HEX NUT M8-1.25
214	PB26M	HEX BOLT M8-1.25 X 30
215	P0654215	BRACKET
216	PSB155M	CAP SCREW M8-1.25 X 14
217	PW01M	FLAT WASHER 8MM
218	P0654218	SUPPORT BRACKET
219	P0654219	ALIGNMENT PIN 7 X 24
220	PB26M	HEX BOLT M8-1.25 X 30

REF PART # DESCRIPTION

221	PN03M	HEX NUT M8-1.25
222	P0654222	ALIGNMENT PIN 7 X 24
223	P0654223	LEFT BRACKET
224	P0654224	SPECIAL SCREW M8-1.25
225	P0654225	SPECIAL FLAT WASHER
226	P0654226	LEVER ASSY M8-1.25
227	P0654227	RIGHT BRACKET
228	PS14M	PHLP HD SCR M6-1 X 12
229	PW03M	FLAT WASHER 6MM
230	P0654230	REAR GUARD BASE
231	P0654231	REAR GUARD TOP
232	PN35M	ACORN NUT M6-1
233	PW03M	FLAT WASHER 6MM
234	P0654234	EXTENSION SPRING
235	PB10M	HEX BOLT M6-1 X 25
236	PN01M	HEX NUT M6-1
237	P0654237	SHAFT LOCK M6-1
238	P0654238	BALL KNOB M6-1
239	PSS26M	SET SCREW M5-.8 X 6



Label Placement



REF	PART #	DESCRIPTION
300	P0654300	FENCE/CUTTERHEAD LABEL
301	PLABEL-29	CUTTERHEAD GUARD LABEL
302	PLABEL-14	ELECTRICITY LABEL
303	PLABEL-12A	READ MANUAL -VERTICAL NS 7/05
304	PLABEL-11	SAFETY GLASSES 2" X 3-5/16"
305	G8588	SMALL GRIZZLY NAMEPLATE

REF	PART #	DESCRIPTION
306	P0654306	EAR PROTECTION/RESPIRATOR
307	P0654307	UNPLUG 110V POWER
308	P0654308	MACHINE ID LABEL
309	PPAINT-11	PUTTY TOUCH-UP PAINT
310	P-PAINT1	GRIZZLY GREEN TOUCH-UP PAINT
311	P0654311	RED TOUCH-UP PAINT

WARNING

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





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

3. What is your annual household income?

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_____ \$50,000-\$59,000 _____ \$60,000-\$69,000 _____ \$70,000+

4. What is your age group?

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

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

_____ Yes _____ No

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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.

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