



MODEL G0656X 8" JOINTER w/SPIRAL CUTTERHEAD MANUAL INSERT

The Model G0656X is the same machine as the Model G0656, except it has a spiral cutterhead. Besides the differences noted in this insert, all other content in the Model G0656 owner's manual applies to this machine. Before operating your new machine, you **MUST** read and understand this insert and the entire Model G0656 manual to reduce the risk of injury when using this machine.

If you have any further questions about this manual insert or the differences between the Model G0656X and the Model G0656, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.

Machine Inventory

Refer to the inventory photos in the G0656 Manual on **Page 11**. After all the parts have been removed from the crate, you should have the following items:

Wood Crate:	Qty
A. Jointer Assembly	1
B. Cutterhead Guard.....	1
C. Handwheels.....	2
D. Handles	2
E. Fence Tilt Lever	1
F. Push Blocks.....	2
G. Spiral Cutterhead Hardware (Not Shown)	
—Inserts 14 x 14 x 2.....	5
—Flat Head Torx Screws T20 M6-1 x 15 10	
—L-Wrench Torx T20.....	1
—Driver Bit Torx T20	1
H. Tool Hardware Bag	
—Hex Wrenches 2.5, 3, 4, 6mm	1 Ea
—Open-End Wrench 8/10, 12/14mm.....	1Ea

The Model G0656X Cardboard Box and Assembly Fastener Components are identical to the corresponding components listed on **Page 11** of the G0656 Manual.

Setting Outfeed Table Height

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

To set 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 carbide inserts is at top-dead-center (TDC), as shown in **Figure 1**.

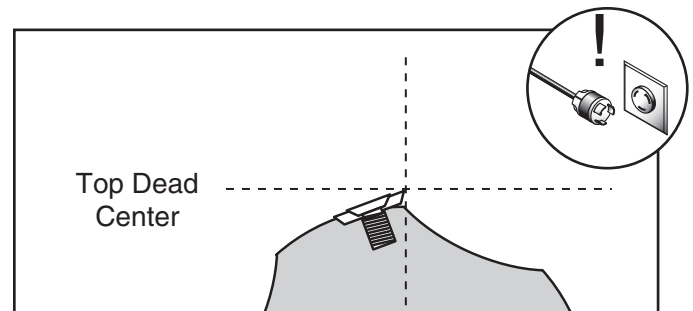


Figure 1. Cutterhead insert at top-dead-center.

- When correctly set, the carbide insert will just touch the straightedge when the insert is at its highest point of rotation (**Figure 2**).

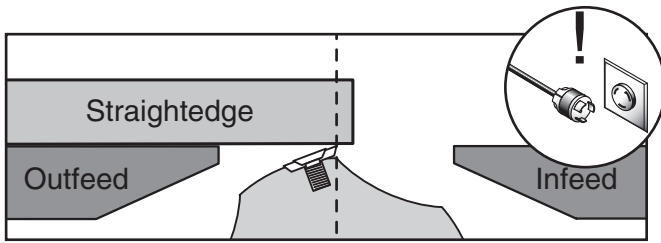


Figure 2. Using a straightedge to align the outfeed table height with insert at TDC.

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

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

Tip: Some advanced woodworkers have found that they can virtually eliminate snipe by setting the outfeed table in the following manner: Repeat **Steps 1-4** using a freshly exposed insert. Place two pencil marks on the straightedge $\frac{5}{32}$ " apart, and place the outward mark on the edge of the outfeed table, as shown in **Figure 3**.

Lower the outfeed table slightly so the insert lifts the straightedge off the table. Rotate the cutterhead clockwise—the straightedge should move $\frac{5}{32}$ " toward the infeed table and the inward mark should be directly over the edge of the outfeed table, as shown in **Figure 4**. Continue adjusting the outfeed table until the cutterhead moves the straightedge $\frac{5}{32}$ " toward the infeed table.

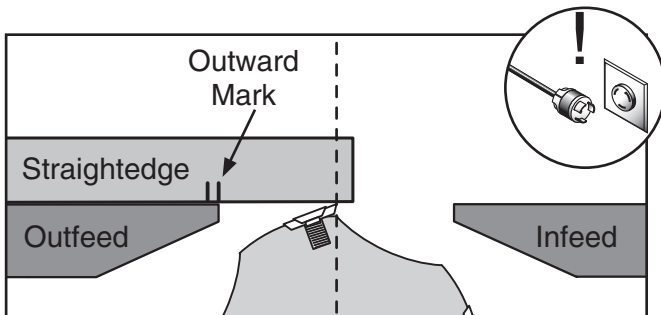


Figure 3. Straightedge outward mark at edge of outfeed table.

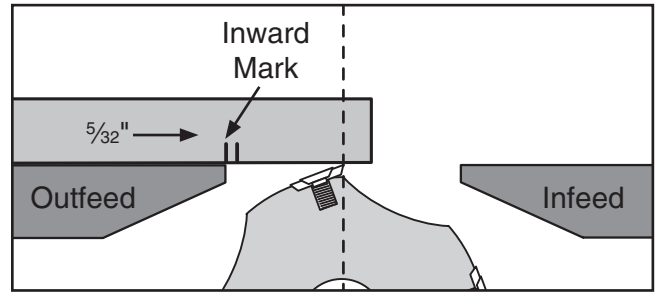


Figure 4. Straightedge inward mark at edge of outfeed table.

- Lock the outfeed table, reinstall the cutterhead guard, and close the rear access panel.

Replacing Carbide Inserts

Tools Needed:

Qty

L-Wrench Torx w/T20 Torx Driver..... 1

The cutterhead is equipped with 40 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge (**Figure 5**).

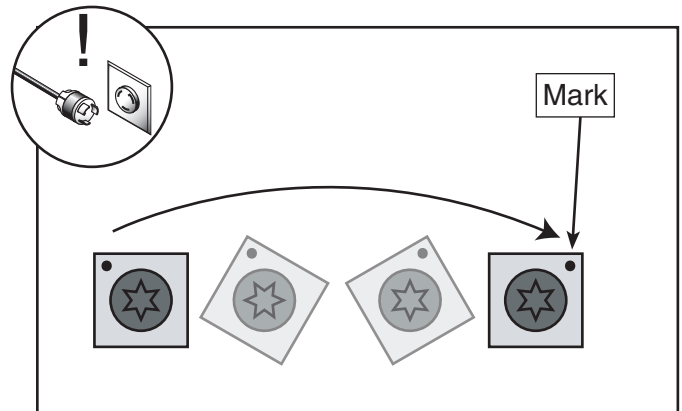


Figure 5. Insert rotating sequence.

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

Replacement carbide inserts should be included with the cutterhead. If you need additional inserts, call Grizzly Customer Service at (800) 523-4777 and order Part P0452Z002, Replacement Carbide Insert 14x14x2mm.



To rotate or change a carbide insert:

1. DISCONNECT JOINTER FROM POWER!
2. Move the cutterhead guard out of the way, or remove it.
3. Remove any sawdust from the head of the carbide insert Torx screw.
4. Remove the Torx screw and carbide insert.
5. Clean all dust and dirt off of the insert and the cutterhead pocket from which the insert was removed, and replace the insert so a fresh, sharp edge is facing outward. Make sure the insert is seated in the pocket on the cutterhead.

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

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

Note: *Excess oil may squeeze between the insert and cutterhead or at the bottom of the screw hole, causing hydrostatic lock and preventing the screw from fully tightening, thereby lifting the insert or screw slightly and affecting workpiece finishes. Make sure to carefully clean off any excess oil to prevent this from happening.*





MACHINE DATA SHEET

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

MODEL G0656X 8" JOINTER w/SPIRAL CUTTERHEAD & MOBILE BASE

Product Dimensions:

Weight 465 lbs.
Length/Width/Height 72½" x 26" x 47¼"
Foot Print (Length/Width)..... 26¾" x 16½"

Shipping Dimensions:

Box #1

Type..... Wood Crate
Content..... Machine
Weight 435 lbs.
Length/Width/Height 25" x 81" x 15"

Box #2

Type..... Cardboard
Content..... Stand
Weight 167 lbs.
Length/Width/Height 19" x 30" x 27"

Electrical:

Switch..... ON/OFF Push Button with Large OFF Paddle
Switch Voltage 220V
Cord Length 6 ft.
Cord Gauge 14 gauge
Minimum Circuit Size 20A
Included Plug No
Recommended Plug Type 6-20

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower 3 HP
Voltage 220V
Phase Single
Amps 15A
Speed 3450 RPM
Cycle..... 60 Hz
Number Of Speeds..... 1
Power Transfer..... V-Belt Drive
Bearings Shielded and Lubricated

Main Specifications:

Operation Information

Fence Length 34⅞"
Fence Width 1¼"
Fence Height..... 5"
Fence Stops 45, 90, and 135 deg.



Cutting Capacities

Bevel Jointing	Left & Right 45 deg.
Maximum Width of Cut.....	8"
Maximum Depth of Cut	1/8"
Maximum Rabbeting Depth.....	1/2"
Number of Cuts Per Minute.....	21,400

Cutterhead Information

Cutterhead Type.....	Spiral
Cutterhead Diameter	3"
Number of Cutter Spirals.....	4
Number of Indexable Cutters	40
Cutter Insert Type.....	Indexable Carbide
Cutter Insert Length.....	14mm
Cutter Insert Width	14mm
Cutter Insert Thickness	2mm
Cutterhead Speed	5350 RPM

Table Information

Table Length	72 1/2"
Table Width	9"
Floor to Table Height.....	33 1/2"
Table Adjustment Type	Handwheels

Construction

Body Assembly Construction	Cast Iron
Stand Construction.....	One-Piece Steel Cabinet
Fence Assembly Construction.....	Cast Iron
Guard Construction	Die Cast Metal
Dovetailed Ways on Bed.....	Adjustable
Parallelogram	No

Other Information

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

Other Specifications:

Country Of Origin.....	China
Warranty.....	1 Year
Serial Number Location	ID Label on Front of Stand
Assembly Time	1 Hour

Features:

- Built in Easy-to-Use Mobile Base
- Included Push Blocks
- Top Mount Switch Controls
- Super Long 72 1/2" Bed
- Handwheel Controlled Fence Adjustment
- Rabbeting Table



Table Parts Breakdown

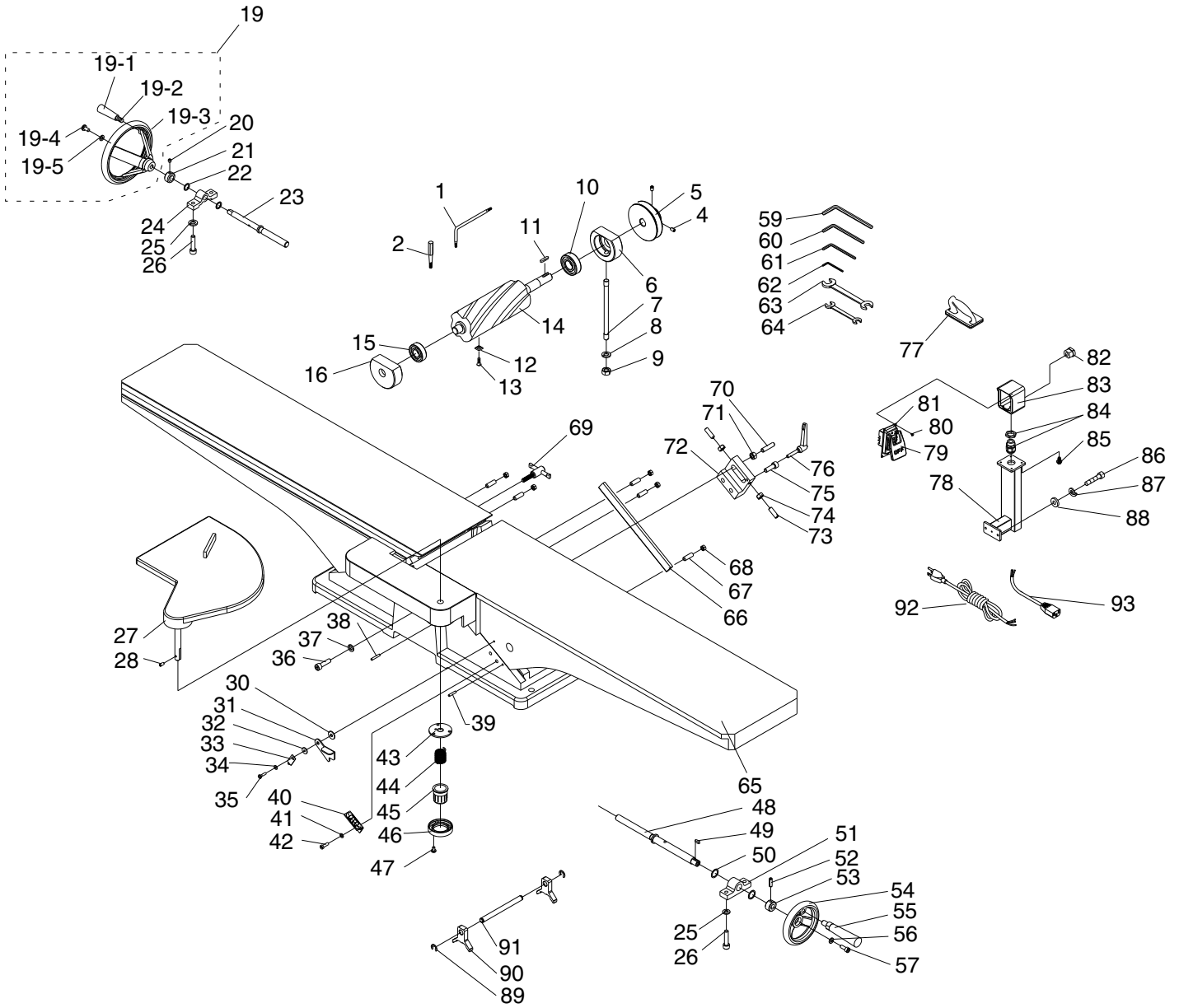


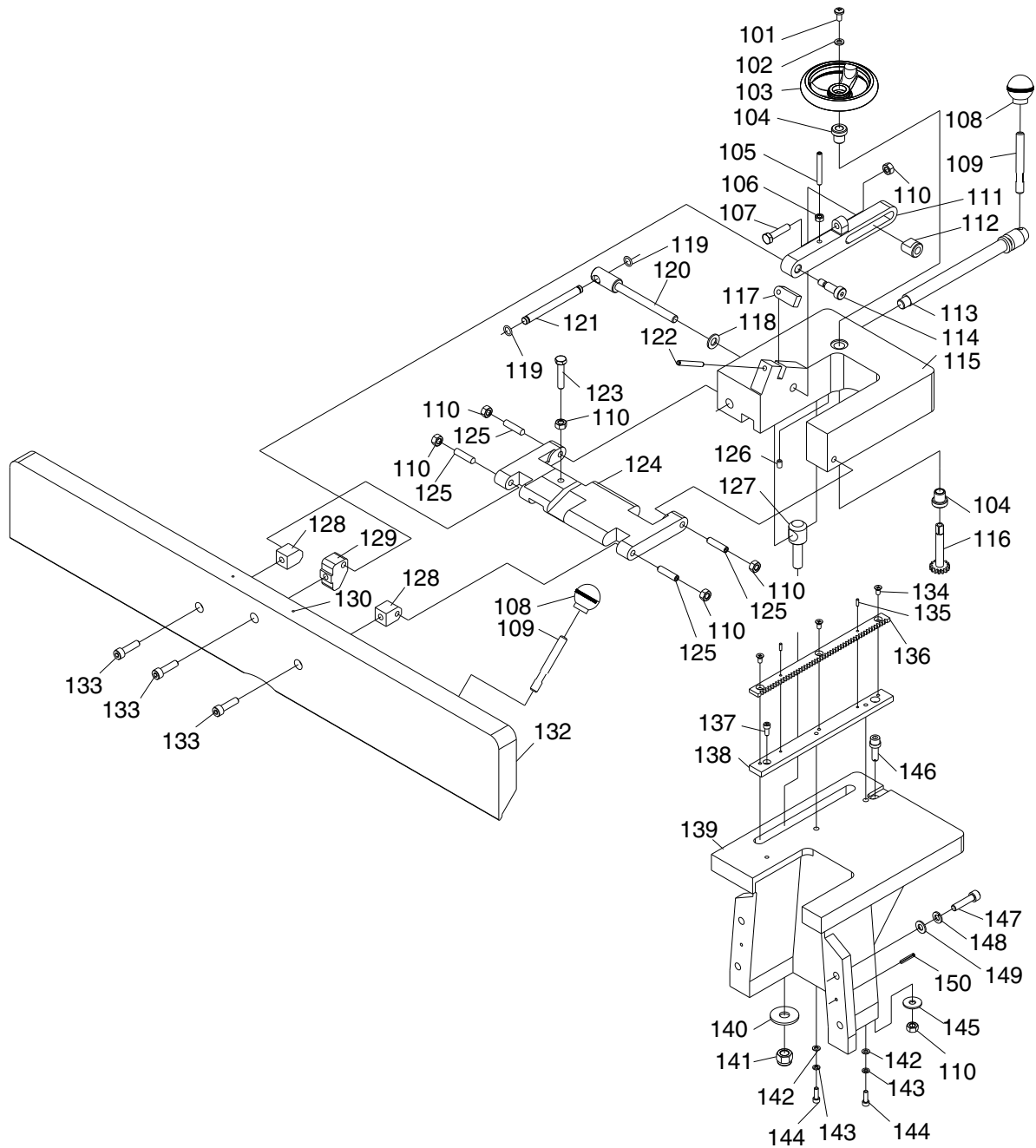
Table Parts List

REF	PART #	DESCRIPTION
1	P0452Z009	L-WRENCH TORX T20
2	P0452Z001	DRIVER BIT TORX T20
4	PSS01M	SET SCREW M6-1 X 10
5	P0656005	PULLEY
6	P0656006	RIGHT BEARING SUPPORT BLOCK
7	P0656007	STUD
8	PLW06M	LOCK WASHER 10MM
9	PN02M	HEX NUT M10-1.5
10	P6204	BALL BEARING 6204ZZ
11	PK74M	KEY 6 X 6 X 35
12	P0452Z002	INDEXABLE INSERT 14 x 14 x 2
13	PFH35M	FLAT HD TORX SCR T20 M6-1 X 15
14	P0656X014	SPIRAL CUTTERHEAD 8"
15	P6203	BALL BEARING 6203ZZ
16	P0656016	LEFT BEARING SUPPORT BLOCK
19	P0656019	HANDWHEEL ASSY
19-1	P0656019-1	HANDLE
19-2	P0656019-2	SHOULDER SCREW
19-3	P0656019-3	HANDWHEEL
19-4	PSB26M	CAP SCREW M6-1 X 12
19-5	PW03M	FLAT WASHER 6MM
20	PSS02M	SET SCREW M6-1 X 6
21	P0656021	COLLAR
22	P0656022	SPECIAL FLAT WASHER
23	P0656023	SCREW SHAFT
24	P0656024	BLOCK
25	PLW04M	LOCK WASHER 8MM
26	PSB40M	CAP SCREW M8-1.25 X 35
27	P0656027	CUTTERHEAD GUARD
28	PSS53M	SET SCREW M5-.8 X 12
30	P0656030	SPACER
31	P0656031	STOP LEVER
32	PW05M	FLAT WASHER 4MM
33	P0656033	POINTER
34	PW05M	FLAT WASHER 4MM
35	PS21M	PHLP HD SCR M4-.7 X 15
36	PSB40M	CAP SCREW M8-1.25 X 35
37	PLW04M	LOCK WASHER 8MM
38	PRP56M	ROLL PIN 4 X 25
39	P0656039	ALIGNMENT PIN 4 X 20
40	P0656040	DEPTH SCALE
41	PLW01M	LOCK WASHER 5MM
42	PSB24M	CAP SCREW M5-.8 X 16
43	P0656043	PLATE
44	P0656044	TORSION SPRING
45	P0656045	CUP
46	P0656046	RETAINER

REF	PART #	DESCRIPTION
47	PSB53M	CAP SCREW M5-.8 X 18
48	P0656048	SCREW SHAFT
49	PK69M	KEY 4 X 4 X 12
50	P0656050	SPACER
51	P0656051	BLOCK
52	PRP49M	ROLL PIN 5 X 25
53	P0656053	COLLAR
54	P0656054	HANDWHEEL
55	P0656055	HANDLE
56	P0656056	SPECIAL FLAT WASHER
57	PSB26M	CAP SCREW M6-1 X 12
59	PAW06M	HEX WRENCH 6MM
60	PAW04M	HEX WRENCH 4MM
61	PAW03M	HEX WRENCH 3MM
62	PAW02.5M	HEX WRENCH 2.5MM
63	PWR1214	WRENCH 12 X 14
64	PWR810	WRENCH 8 X 10
65	P0656065	TABLE ASSY
66	P0656066	GIB
67	PSS12M	SET SCREW M6-1 X 25
68	PN01M	HEX NUT M6-1
69	P0656069	OUTFEED TABLE LOCK M6-1 X 25
70	P0656070	SPECIAL SCREW
71	PN01M	HEX NUT M6-1
72	P0656072	STOP BLOCK
73	PSS21M	SET SCREW M8-1.25 X 25
74	PN03M	HEX NUT M8-1.25
75	PSB31M	CAP SCREW M8-1.25 X 25
76	P0656076	INFEED LOCK LEVER M6-1 X 30
77	P0656077	JOINTER PUSH BLOCK
78	P0656078	SWITCH PEDESTAL
79	P0656079	SWITCH PADDLE
80	PSB18M	CAP SCREW M4-.7 X 8
81	P0656081	SWITCH BRACKET
82	P0656082	STRAIN RELIEF
83	P0656083	SWITCH BOX
84	P0656084	STRAIN RELIEF
85	PFB17M	FLANGE BOLT M6-1 X 16
86	PSB31M	CAP SCREW M8-1.25 X 25
87	PLW04M	LOCK WASHER 8MM
88	PW01M	FLAT WASHER 8MM
89	PEC015M	E-CLIP 8MM
90	P0656090	KNIFE GAUGE BLOCK
91	P0656091	KNIFE GAUGE ROD
92	P0656092	POWER CORD 14AWG X 3C
93	P0656093	SWITCH CORD 14AWG X 3C



Fence Parts Breakdown



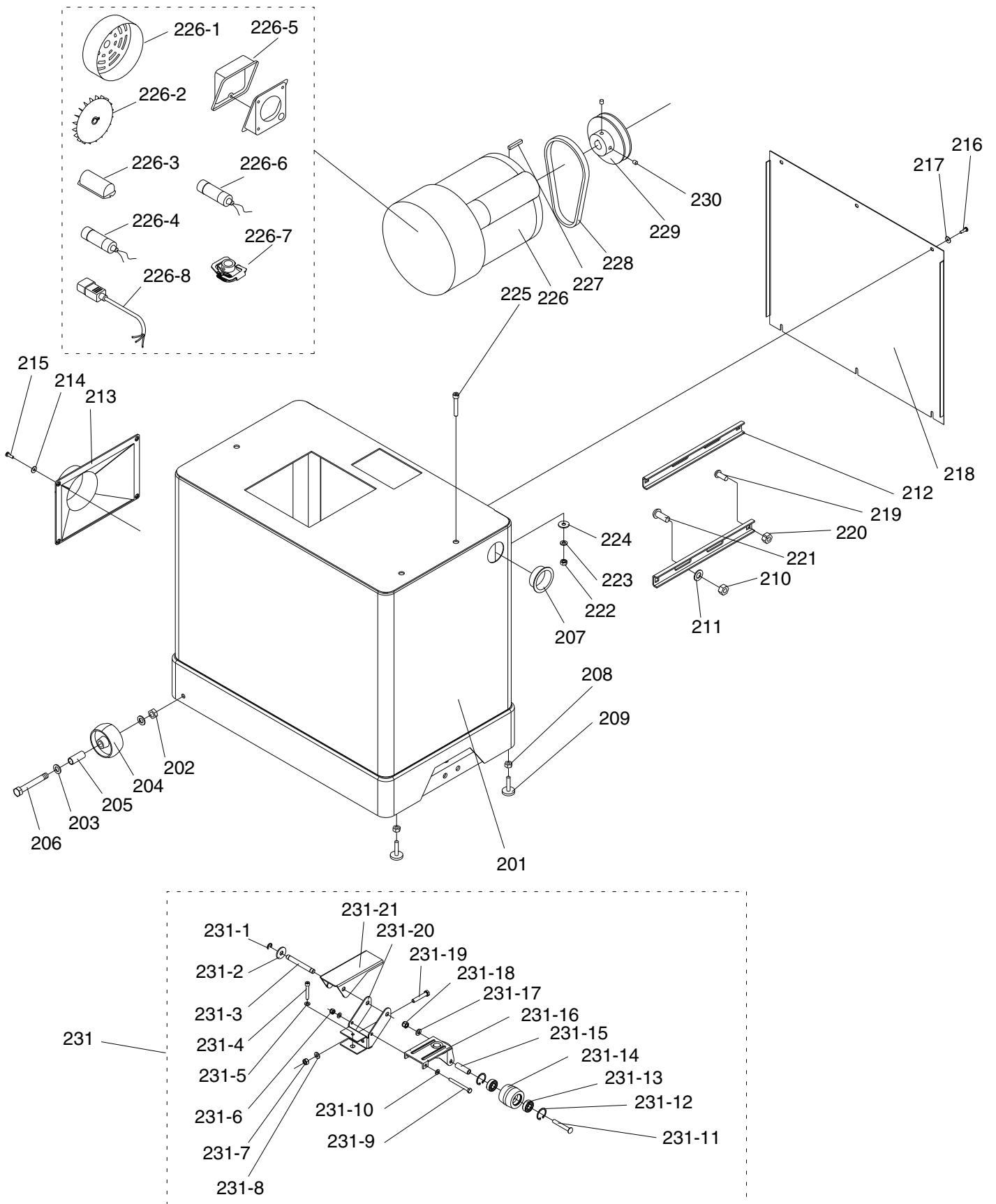
Fence Parts List

REF	PART #	DESCRIPTION
101	PS14M	PHLP HD SCR M6-1 X 12
102	PW03M	FLAT WASHER 6MM
103	P0656103	HANDWHEEL
104	P0656104	BUSHING
105	PSS85M	SET SCREW M6-1 X 45
106	PN01M	HEX NUT M6-1
107	PB20M	HEX BOLT M8-1.25 X 35
108	P0656108	KNOB M10-1.5
109	P0656109	STUD M10-1.5
110	PN03M	HEX NUT M8-1.25
111	P0656111	CLAMP ARM
112	P0656112	LOCK NUT
113	P0656113	ECCENTRIC LOCK LEVER
114	P0656114	SPECIAL SCREW M10-1.5 X 20
115	P0656115	FENCE CARRIAGE
116	P0656116	GEAR
117	P0656117	90 DEG STOP BLOCK
118	PW04M	FLAT WASHER 10MM
119	POR0010	O-RING 10 X 2
120	P0656120	TILT LOCK SHAFT
121	P0656121	TILT LOCK HANDLE
122	P0656122	ALIGNMENT PIN 6 X 50
123	PB15M	HEX BOLT M8-1.25 X 40
124	P0656124	BRACKET
125	PSS74M	SET SCREW M8-1.25 X 35

REF	PART #	DESCRIPTION
126	PSS01M	SET SCREW M6-1 X 10
127	P0656127	ADJUST LEVER
128	P0656128	SMALL BRACKET BLOCK
129	P0656129	BRACKET BLOCK
130	P0656130	RIVET 2 X 4
132	P0656132	FENCE
133	PSB13M	CAP SCREW M8-1.25 X 30
134	PFH07M	FLAT HD SCR M5-.8 X 10
135	PRP44M	ROLL PIN 3 X 10
136	P0656136	RACK
137	PSB20M	CAP SCREW M5-.8 X 14
138	P0656138	GIB
139	P0656139	FENCE SUPPORT
140	PW06M	FLAT WASHER 12MM
141	P0656141	SPECIAL HEX NUT M12-1.75
142	PW02M	FLAT WASHER 5MM
143	PLW01M	LOCK WASHER 5MM
144	PSB53M	CAP SCREW M5-.8 X 18
145	P0656145	SPECIAL FLAT WASHER
146	P0656146	ECCENTRIC STUD
147	PSB40M	CAP SCREW M8-1.25 X 35
148	PLW04M	LOCK WASHER 8MM
149	PW01M	FLAT WASHER 8MM
150	PRP49M	ROLL PIN 5 X 25



Stand Parts Breakdown



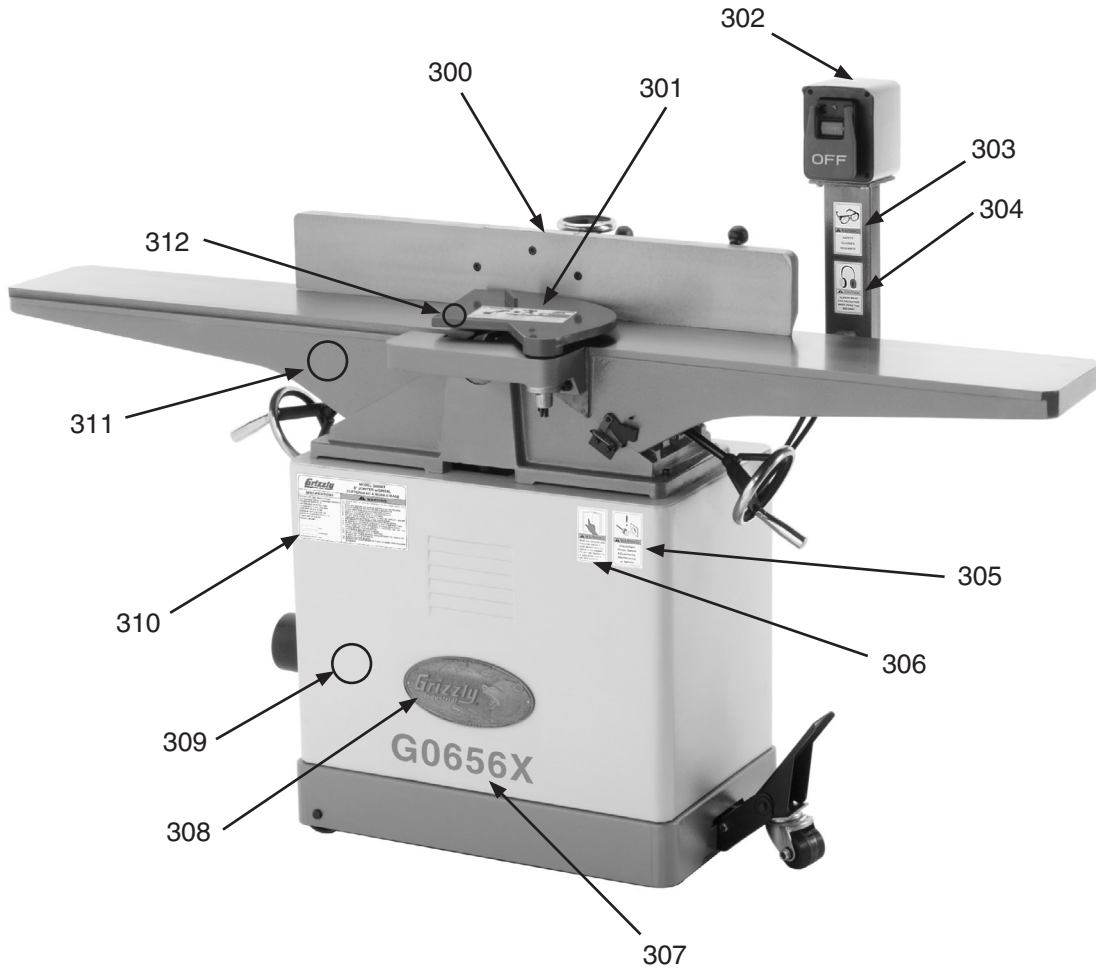
Stand Parts List

REF	PART #	DESCRIPTION
201	P0656201	CABINET
202	PLN04M	LOCK NUT M8-1.25
203	PW01M	FLAT WASHER 8MM
204	P0656204	WHEEL
205	P0656205	SLEEVE
206	PB86M	HEX BOLT M8-1.25 X 65
207	P0656207	PLASTIC GROMMET
208	PN08	HEX NUT 3/8-16
209	P0656209	ADJUSTING FOOT
210	PN02	HEX NUT 5/16-18
211	PW07	FLAT WASHER 5/16
212	P0656212	MOTOR BRACKET
213	P0656213	DUST PORT
214	PW02M	FLAT WASHER 5MM
215	PS40M	PHLP HD SCR M5-.8 X 16
216	PS40M	PHLP HD SCR M5-.8 X 16
217	PW02M	FLAT WASHER 5MM
218	P0656218	CABINET REAR COVER
219	PCB05	CARRIAGE BOLT 5/16-18 X 3/4
220	PN02	HEX NUT 5/16-18
221	PCB11	CARRIAGE BOLT 5/16-18 X 1
222	PN03M	HEX NUT M8-1.25
223	PLW04M	LOCK WASHER 8MM
224	PW01M	FLAT WASHER 8MM
225	PSB05M	CAP SCREW M8-1.25 X 50
226	P0656226	MOTOR 3PH 220V
226-1	P0656226-1	FAN COVER
226-2	P0656226-2	FAN
226-3	P0656226-3	R CAPACITOR COVER
226-4	P0656226-4	R CAP 30M 450V 2-3/4 X 1-1/2

REF	PART #	DESCRIPTION
226-5	P0656226-5	JUNCTION BOX
226-6	P0656226-6	S CAPACITOR 200M 250V 3-1/2 X 1-1/2
226-7	P0656226-7	CENTRIFUGAL SWITCH
226-8	P0656226-8	MOTOR CORD 14AWG X 3C
227	PK12M	KEY 5 X 5 X 30
228	PVA50	V-BELT A-50 4L500
229	P0656229	MOTOR PULLEY
230	PSS01M	SET SCREW M6-1 X 10
231	P0656231	PEDAL ASSEMBLY
231-1	PR16M	EXT RETAINING RING 9MM
231-2	P0656231-2	SPECIAL FLAT WASHER 9MM
231-3	P0656231-3	SHAFT
231-4	PB22M	HEX BOLT M8-1.25 X 50
231-5	PW01M	FLAT WASHER 8MM
231-6	P0656231-6	SPECIAL HEX NUT M8-1.25
231-7	PN02M	HEX NUT M10-1.5
231-8	PW04M	FLAT WASHER 10MM
231-9	PB45M	HEX BOLT M8-1.25 X 100
231-10	PW01M	FLAT WASHER 8MM
231-11	P0656231-11	SPECIAL BOLT
231-12	PR21M	INT RETAINING RING 35MM
231-13	P6202	BALL BEARING 6202ZZ
231-14	P0656231-14	TROLLEY WHEEL
231-15	P0656231-15	SLEEVE
231-16	P0656231-16	UNIVERSAL KIT TROLLEY
231-17	PW04M	FLAT WASHER 10MM
231-18	P0656231-18	SPECIAL HEX NUT M10
231-19	PB144M	HEX BOLT M10-1.5 X 55
231-20	P0656231-20	BRACKET
231-21	P0656231-21	PEDAL



Label Placement



REF	PART #	DESCRIPTION
300	P0656300	FENCE/CUTTERHEAD LABEL
301	P0656301	CUTTTERHEAD GUARD LABEL
302	PLABEL-14	ELECTRICITY LABEL
303	PLABEL-11	SAFETY GLASSES 2" X 3 5/16"
304	PLABEL-15	EAR PROTECTION 2" X 3-5/16"H
305	PLABEL-63	UNPLUG 220V POWER LABEL
306	PLABEL-12A	READ MANUAL-VERTICAL NS 7/05

REF	PART #	DESCRIPTION
307	P0656X307	MODEL NUMBER LABEL
308	G8588	SMALL GRIZZLY NAMEPLATE
309	PPAINT-11	PUTTY TOUCH-UP PAINT
310	P0656X310	MACHINE ID LABEL
311	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
312	PPAINT-16	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.

