



**MODEL G0429**  
**12½" BENCHTOP PLANER**  
**with DUST COLLECTION**  
**OWNER'S MANUAL**  
*(For models manufactured since 04/26)*



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#JP23949 PRINTED IN TAIWAN

V1.04.26

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



## **WARNING!**

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

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

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

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



## **WARNING!**

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

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

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

# Table of Contents

|                                         |           |                                              |           |
|-----------------------------------------|-----------|----------------------------------------------|-----------|
| <b>INTRODUCTION.....</b>                | <b>2</b>  | <b>SECTION 5: MAINTENANCE.....</b>           | <b>25</b> |
| Contact Info .....                      | 2         | Schedule .....                               | 25        |
| Manual Accuracy .....                   | 2         | Cleaning & Protecting .....                  | 25        |
| Identification .....                    | 3         | Lubrication .....                            | 25        |
| Controls & Components.....              | 4         | Cleaning Feed Rollers & Blocks .....         | 27        |
| Machine Data Sheet .....                | 5         | <b>SECTION 6: SERVICE .....</b>              | <b>28</b> |
| <b>SECTION 1: SAFETY .....</b>          | <b>7</b>  | Troubleshooting .....                        | 28        |
| Safety Instructions for Machinery ..... | 7         | Replacing Cutterhead Knives .....            | 30        |
| Additional Safety for Planers .....     | 9         | Replacing Motor Brushes .....                | 31        |
| <b>SECTION 2: POWER SUPPLY .....</b>    | <b>10</b> | Tensioning/Replacing V-Belt .....            | 32        |
| <b>SECTION 3: SETUP .....</b>           | <b>12</b> | Calibrating Scale.....                       | 33        |
| Needed for Setup.....                   | 12        | Adjusting Cutterhead/Table Parallelism ..... | 34        |
| Unpacking .....                         | 12        | <b>SECTION 7: WIRING.....</b>                | <b>35</b> |
| Inventory .....                         | 12        | Wiring Safety Instructions .....             | 35        |
| Site Considerations.....                | 13        | Wiring Diagram & Electrical Components ...   | 36        |
| Measuring Hardware .....                | 14        | <b>SECTION 8: PARTS .....</b>                | <b>37</b> |
| Bench Mounting .....                    | 15        | Main .....                                   | 37        |
| Assembly .....                          | 15        | Labels & Cosmetics .....                     | 40        |
| Dust Collection.....                    | 16        | <b>WARRANTY &amp; RETURNS.....</b>           | <b>41</b> |
| Test Run.....                           | 17        |                                              |           |
| <b>SECTION 4: OPERATIONS.....</b>       | <b>19</b> |                                              |           |
| Operation Overview .....                | 19        |                                              |           |
| Disabling Switch .....                  | 20        |                                              |           |
| Workpiece Inspection.....               | 20        |                                              |           |
| Wood Types .....                        | 21        |                                              |           |
| Planing Tips .....                      | 21        |                                              |           |
| Cutting Problems .....                  | 22        |                                              |           |
| Adjusting Depth of Cut.....             | 23        |                                              |           |
| Feeding Workpiece .....                 | 24        |                                              |           |

# INTRODUCTION

## Contact Info

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

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

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

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

### WARNING

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

### CAUTION

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

## Manual Accuracy

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

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

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

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

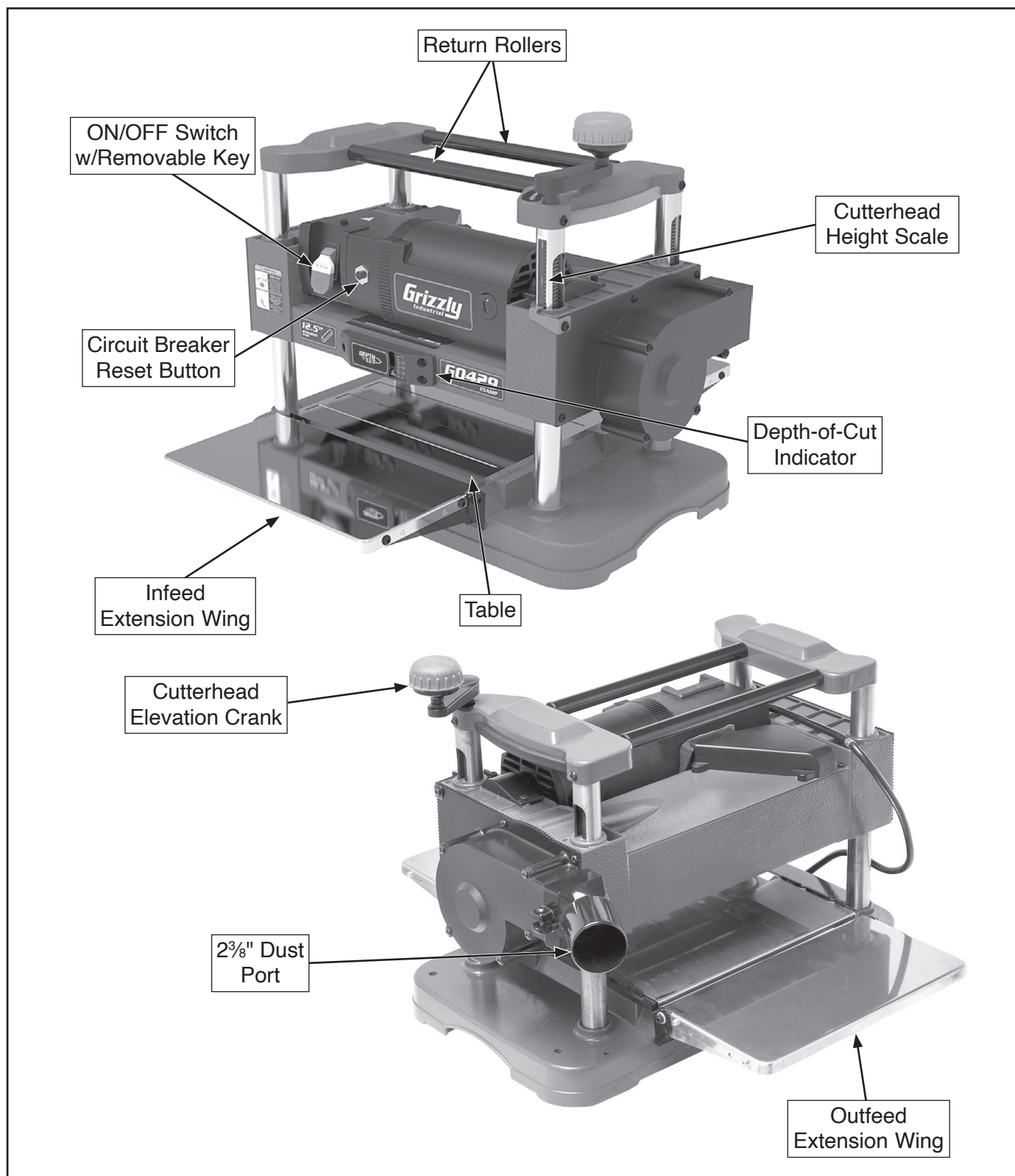
|                                                                                      |                                                           |                                                                                                |  |
|--------------------------------------------------------------------------------------|-----------------------------------------------------------|------------------------------------------------------------------------------------------------|--|
|  |                                                           | MODEL GXXXX<br>MACHINE NAME                                                                    |  |
| SPECIFICATIONS                                                                       |                                                           |  WARNING! |  |
| Motor:                                                                               | To reduce risk of serious injury when using this machine: |                                                                                                |  |
| Specification:                                                                       | Manual before operation.                                  |                                                                                                |  |
| Specification:                                                                       | Safety glasses and respirator.                            |                                                                                                |  |
| Specification:                                                                       | Correctly adjusted/setup and                              |                                                                                                |  |
| Weight:                                                                              | power is connected to grounded circuit before starting.   |                                                                                                |  |
|                                                                                      | 4. Make sure the motor has stopped and disconnect         |                                                                                                |  |
|                                                                                      | power before adjustments, maintenance, or service.        |                                                                                                |  |
|                                                                                      | 5. DO NOT expose to rain or dampness.                     |                                                                                                |  |
|                                                                                      | 6. DO NOT modify this machine in any way.                 |                                                                                                |  |
|                                                                                      | 7.                                                        |                                                                                                |  |
|                                                                                      | 8.                                                        |                                                                                                |  |
|                                                                                      | 9. ended.                                                 |                                                                                                |  |
|                                                                                      | 10. Use of drugs or alcohol.                              |                                                                                                |  |
|                                                                                      | 10. Maintain machine carefully to prevent accidents.      |                                                                                                |  |

Manufactured for Grizzly in Taiwan

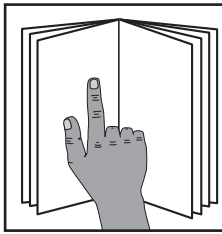


# Identification

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



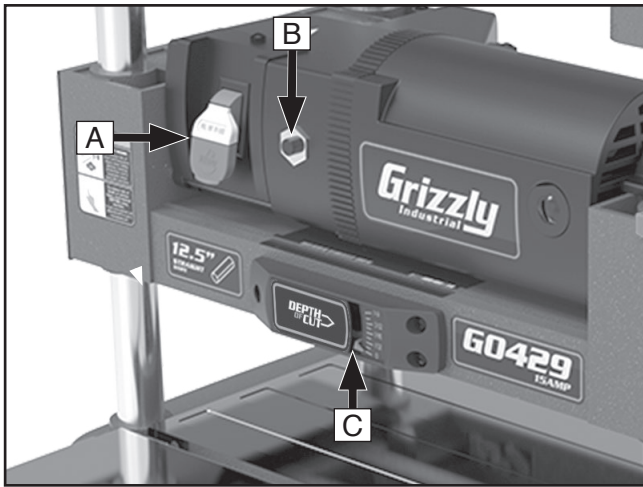
# Controls & Components



## **!WARNING**

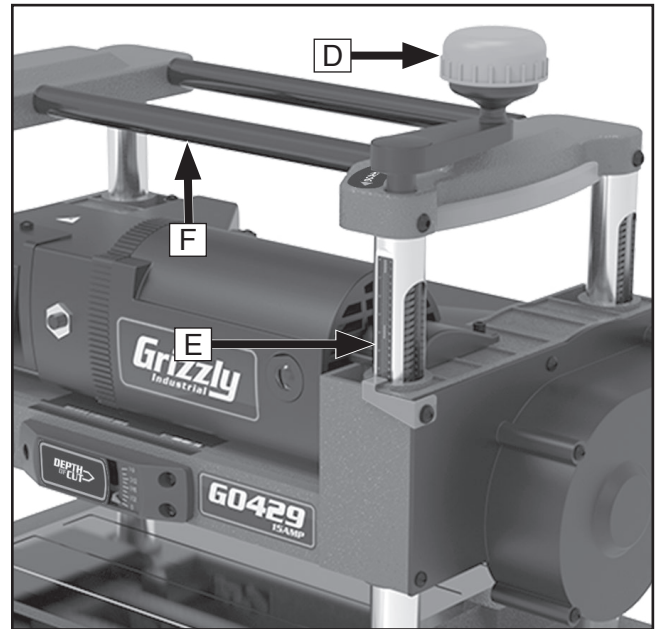
To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

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



**Figure 1.** ON/OFF switch and reset button.

- A. ON/OFF Switch:** Turns motor **ON** and **OFF**. Remove yellow key to disable switch.
- B. Circuit Breaker Reset Button:** Allows machine to be restarted after thermal overload protection has tripped motor. To reset button, place ON/OFF switch in OFF position, wait a few minutes for motor to cool, then press reset button. If button does not stay depressed, allow motor to cool longer, then try again.
- C. Depth-of-Cut Indicator:** Shows depth of cut as workpiece enters machine.



**Figure 2.** Elevation controls and return rollers.

- D. Cutterhead Elevation Crank:** Raises and lowers cutterhead. Turning clockwise raises cutterhead; turning counterclockwise lowers it.
- E. Cutterhead Elevation Scale:** Shows elevation of cutterhead above table. Measurement indicated by red arrow is effective thickness of board *after* planing.
- F. Return Roller (1 of 2):** For assistant to slide workpiece back to operator following planing operation.





# MACHINE DATA SHEET

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

## MODEL G0429 12-1/2" BENCHTOP PLANER WITH DUST COLLECTION

### Product Dimensions:

Weight..... 65 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 22 x 27 x 18-1/2 in.  
Footprint (Length x Width)..... 22 x 13 in.

### Shipping Dimensions:

Type..... Cardboard Box  
Content..... Machine  
Weight..... 72 lbs.  
Length x Width x Height..... 26 x 17 x 19 in.  
Must Ship Upright..... Yes

### Electrical:

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

### Motors:

#### Main

Horsepower..... 2 HP  
Voltage..... 120V  
Phase..... Single-Phase  
Amps..... 15A  
Speed..... 18,000 RPM  
Type..... Universal  
Power Transfer ..... Belt  
Bearings..... Shielded & Permanently Lubricated

### Main Specifications:

#### Main Specifications

Planer Size..... 12-1/2 in.  
Max. Cut Width..... 12-1/2 in.  
Min. Stock Thickness..... 5/16 in.  
Max. Stock Thickness..... 4-1/2 in.  
Number of Cuts Per Inch..... 60  
Number of Cuts Per Minute..... 18,000  
Cutterhead Speed..... 9,000 RPM  
Planing Feed Rate..... 26 FPM  
Max. Cut Depth Planing Full Width..... 1/32 in.  
Max. Cut Depth Planing 6-Inch Wide Board..... 1/16 in.



**Cutterhead Info**

|                           |                 |
|---------------------------|-----------------|
| Cutterhead Type.....      | 2 Knife         |
| Cutterhead Diameter ..... | 2 in.           |
| Number of Knives.....     | 2               |
| Knife Type.....           | SK5, Reversible |
| Knife Size Length.....    | 12-1/2 in.      |
| Knife Size Width.....     | 1/2 in.         |
| Knife Size Thickness..... | 1/16 in.        |

**Table Info**

|                               |            |
|-------------------------------|------------|
| Table Bed Size Length.....    | 12-3/4 in. |
| Table Bed Size Width.....     | 12-1/2 in. |
| Table Bed Size Thickness..... | 0.06 in.   |
| Table Wings Size Length.....  | 13 in.     |
| Table Wings Size Width.....   | 6-7/8 in.  |

**Construction**

|                          |                 |
|--------------------------|-----------------|
| Table.....               | Stainless Steel |
| Body.....                | Aluminum        |
| Cutterhead Assembly..... | Steel           |
| Infeed Roller.....       | Rubber & Steel  |
| Outfeed Roller.....      | Rubber & Steel  |
| Paint Type/Finish.....   | Powder Coated   |

**Other**

|                           |               |
|---------------------------|---------------|
| Measurement Scale.....    | Inch & Metric |
| Number of Dust Ports..... | 1             |
| Dust Port Size.....       | 2-3/8 in.     |

**Other Specifications:**

|                                                                      |                  |
|----------------------------------------------------------------------|------------------|
| Country of Origin .....                                              | Taiwan           |
| Warranty .....                                                       | 1 Year           |
| Approximate Assembly & Setup Time .....                              | 30 Minutes       |
| Serial Number Location .....                                         | Machine ID Label |
| Sound Rating .....                                                   | 95 dB            |
| Certified by a Nationally Recognized Testing Laboratory (NRTL) ..... | Yes              |

**Features:**

4-1/2" Maximum Cutting Height  
Magnetic Handles for Changing Knives  
Built-In Cord Wrap  
Front & Rear Extension Tables



# 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**

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

## 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 your workshop kid proof!

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

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

### **ELECTRICAL EQUIPMENT INJURY RISKS.**

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

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

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



## **WARNING**

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Planers

## WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

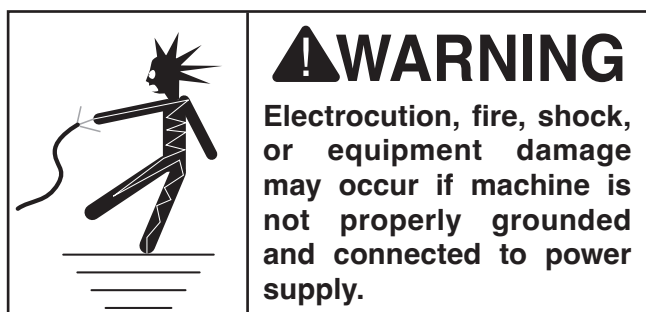
**SECURE KNIVES/INSERTS.** Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation.



# SECTION 2: POWER SUPPLY

## Availability

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



## Full-Load Current Rating

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

### Full-Load Current Rating at 120V ..... 15 Amps

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

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

## **!WARNING**

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

## 120V Circuit Requirements

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

**Nominal Voltage ..... 110V, 115V, 120V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 20 Amps**  
**Plug/Receptacle ..... NEMA 5-15**

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

## **!CAUTION**

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

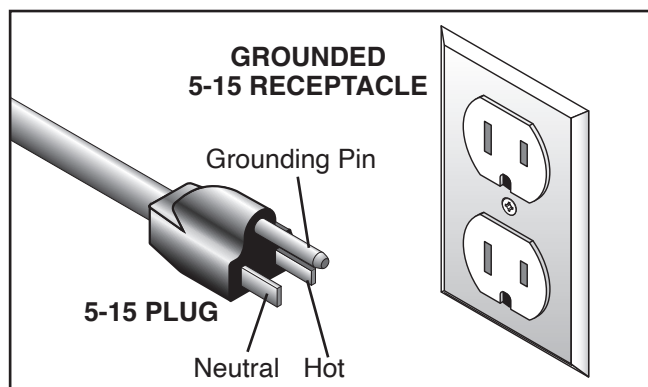
**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel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



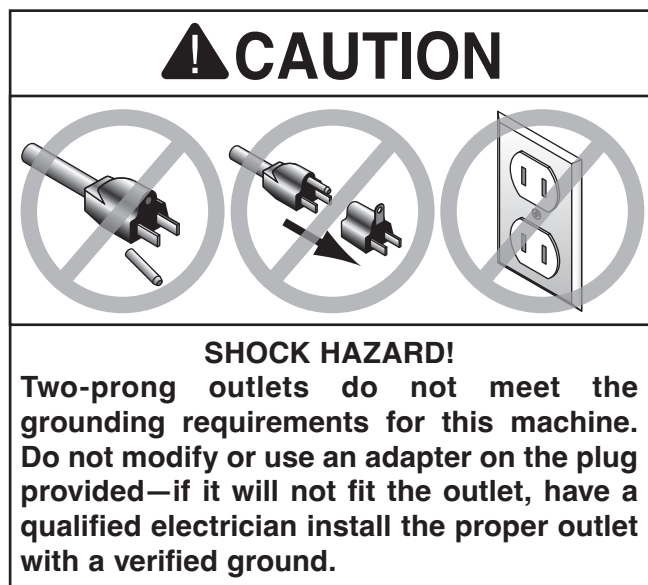
## Grounding & Plug Requirements

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

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



**Figure 3.** 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 machine is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

## Extension Cords

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

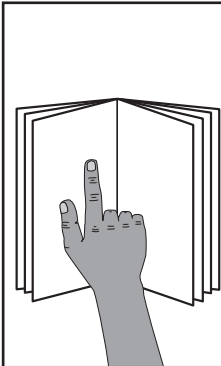
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

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

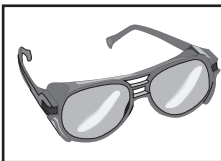


# SECTION 3: SETUP



## **WARNING**

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



## **WARNING**

Wear safety glasses during the entire setup process!

## Needed for Setup

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

| Description                                          | Qty |
|------------------------------------------------------|-----|
| • Safety Glasses .....                               | 1   |
| • Phillips Head Screwdriver #2 .....                 | 1   |
| • Mounting Hardware ( <b>Page 15</b> ) ... As Needed |     |
| Optional                                             |     |
| • Dust Collection System .....                       | 1   |
| • Dust Hose 2½" .....                                | 1   |
| • Hose Clamps 2½" .....                              | 2   |

## Unpacking

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

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

## Inventory

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

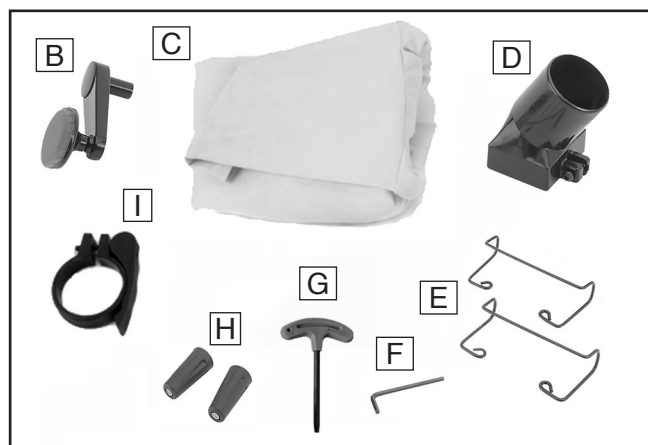
If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

## ***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.**

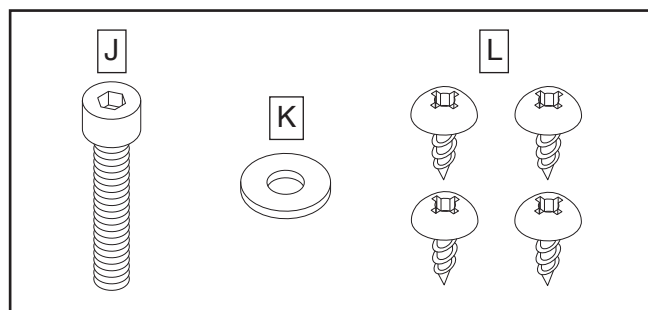


| <b>Box 1 (Figure 4)</b> |                                                 | <b>Qty</b> |
|-------------------------|-------------------------------------------------|------------|
| <b>A.</b>               | Planer (Not Shown) .....                        | 1          |
| <b>B.</b>               | Elevation Crank Handle.....                     | 1          |
| <b>C.</b>               | Dust Bag.....                                   | 1          |
| <b>D.</b>               | Dust Port 2 <sup>3</sup> / <sub>8</sub> " ..... | 1          |
| <b>E.</b>               | Cord Wraps .....                                | 2          |
| <b>F.</b>               | Hex Wrench 4mm.....                             | 1          |
| <b>G.</b>               | T-Handle Torx Wrench T-30 .....                 | 1          |
| <b>H.</b>               | Knife-Changing Magnets.....                     | 2          |
| <b>I.</b>               | Dust Bag Clamp .....                            | 1          |



**Figure 4.** Inventory.

| <b>Fasteners (Figure 5)</b> |                                      | <b>Qty</b> |
|-----------------------------|--------------------------------------|------------|
| <b>J.</b>                   | Cap Screw M5-.8 x 25 (P0429006)..... | 1          |
| <b>K.</b>                   | Flat Washer 5mm (P0429156).....      | 1          |
| <b>L.</b>                   | Tap Screws M4 x 10 (P0429028) .....  | 4          |



**Figure 5.** Fastener inventory.

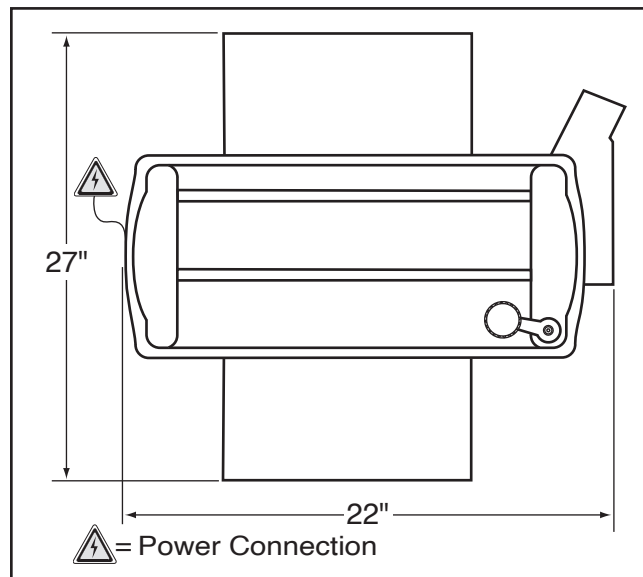
## Site Considerations

### Workbench Load

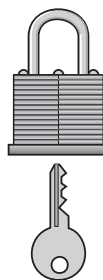
Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

### Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.



**Figure 6.** Minimum working clearances.



### **CAUTION**

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.

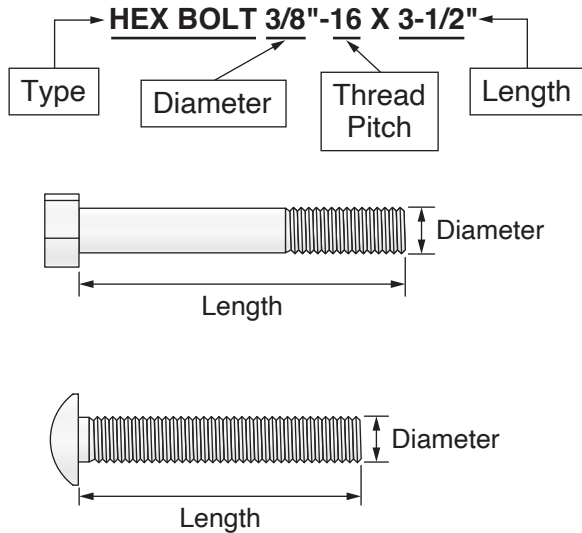


# Measuring Hardware

Use this page to understand how hardware is measured in this manual.

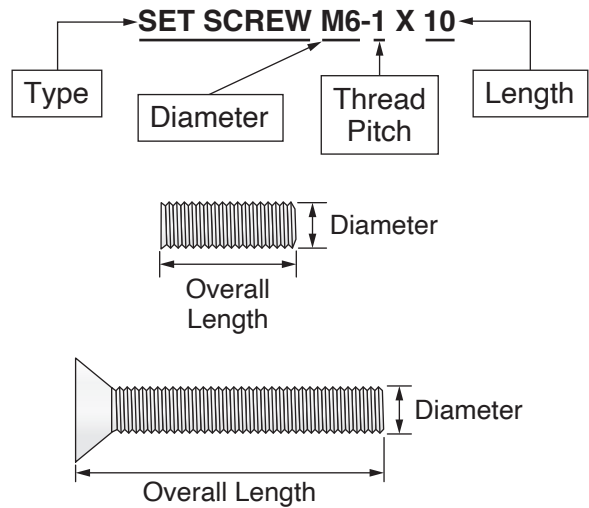
## Bolts & Screws

Most bolts and screws are measured by the outside diameter of the threads, thread pitch, and the length from under the head to the opposite end:

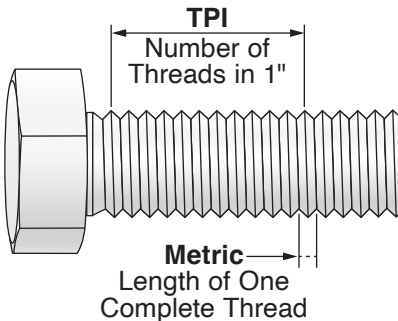


## Flat Head & Set Screws

Flat head and set screws are measured by the outside diameter of the threads, thread pitch, and overall length of the fastener. These fasteners are often meant to sit flush with the adjoining surface:



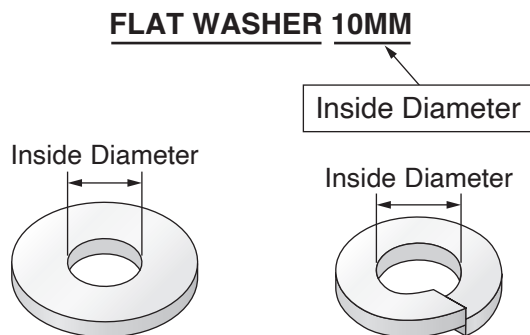
Thread pitch is the distance from the tip of one thread to the tip of the next thread. For US Standard threads, pitch is measured in threads per inch (TPI). Metric thread pitch is the length of one complete thread.



**Note:** Grizzly Industrial does not typically list a thread pitch for thread-forming screws and bolts, such as tap screws, wood screws, and lag bolts.

## Washers

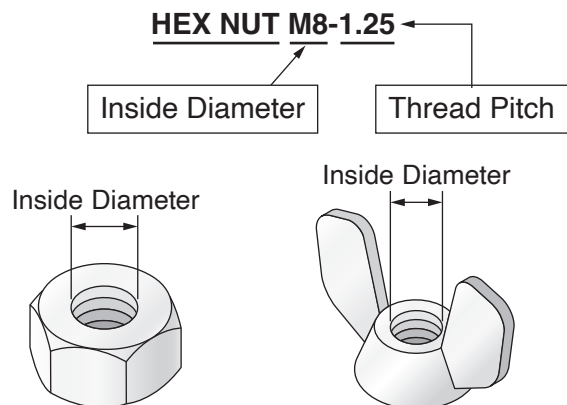
Common washers are measured by their inside diameter.



**Note:** Specialized washers may list the inside diameter, outside diameter, and the thickness.

## Nuts

Nuts are measured by the inside diameter of the threads and the thread pitch.

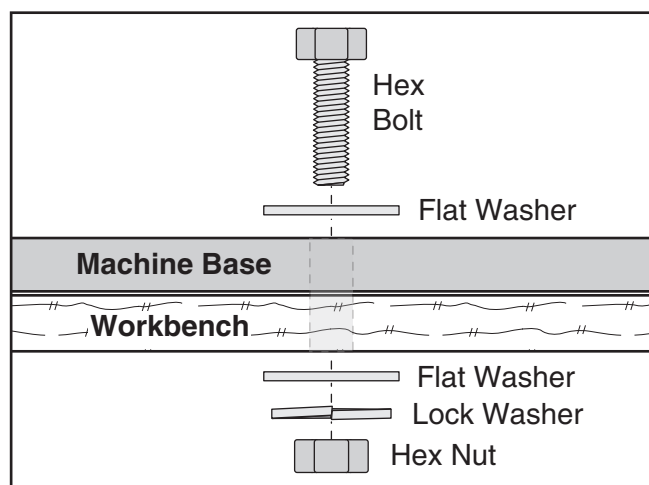


# Bench Mounting

**Number of Mounting Holes..... 4**  
**Diameter of Mounting Hardware Needed...  $\frac{5}{16}$ "**

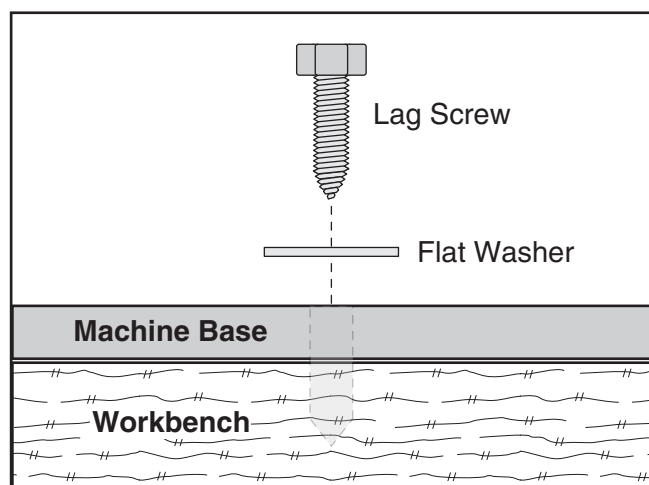
The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.



**Figure 7.** "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.



**Figure 8.** "Direct Mount" setup.

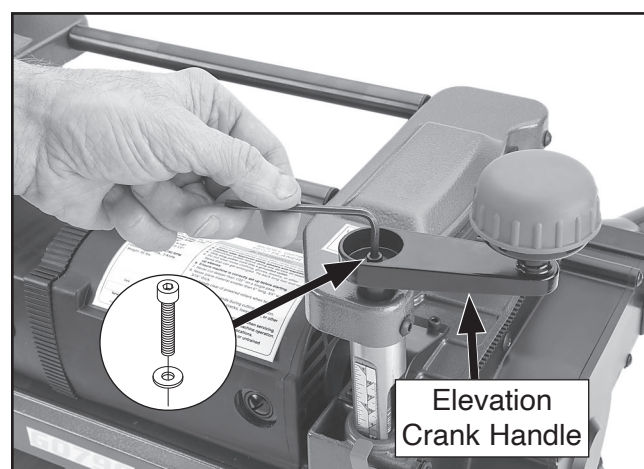


# Assembly

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

## To assemble machine:

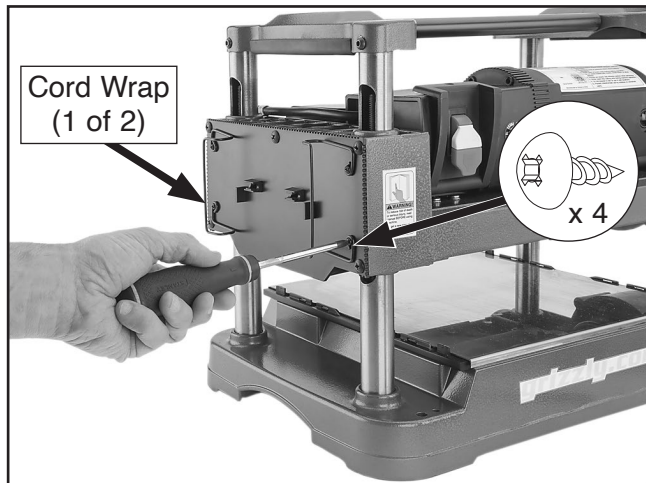
1. Remove cap from crank handle.
2. Align flat portion inside crank handle bore with flat portion on elevation shaft, then place crank handle on elevation shaft.
3. Secure elevation crank handle with M5-.8 x 25 cap screw and 5mm flatwasher (see **Figure 9**). Do not over-tighten.



**Figure 9.** Example of installing elevation crank handle.

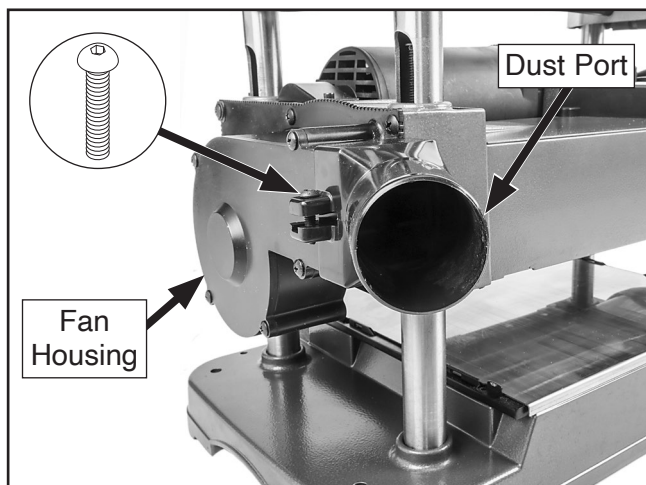
4. Install crank handle cap.

5. Position (2) cord wraps over pre-drilled holes in cabinet (see **Figure 10**), and secure with (4) M4 x 10 tap screws.



**Figure 10.** Example of installing cord wraps.

6. Slide dust port onto fan housing (see **Figure 11**) and secure with pre-installed button head cap screw.



**Figure 11.** Dust port installed on fan housing.

## Dust Collection

The G0429 is designed to help manage wood chips and dust generated during operation. It includes a dust collection bag that installs directly over the dust port for simple, portable dust collection when a centralized system is not available. For improved dust and chip removal, the planer may also be connected to a suitable dust collection system using an appropriate hose and fittings.

### **⚠ CAUTION**

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

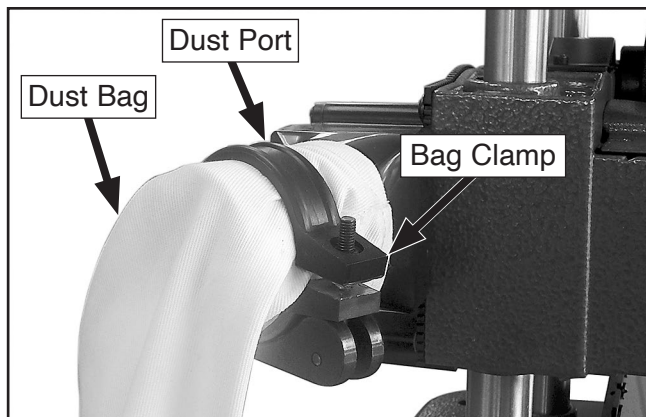
#### **Recommended CFM at Dust Port: 150 CFM**

*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.*



## Installing Dust Bag

To install the dust bag, slide the dust bag clamp over the dust bag, then slide the bag and clamp over the dust port (see **Figure 12**), and secure with the quick-release handle.

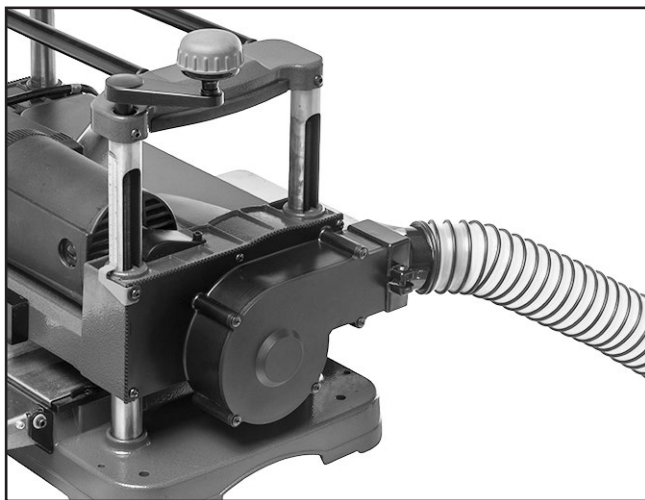


**Figure 12.** Dust bag installed on port and secured by clamp.

## Connecting Dust Hose

To install a dust hose, fit a 2½" dust hose over the dust port (see **Figure 13**), and secure with a hose clamp. Tug the hose to make sure it does not come off.

**Note:** *A tight fit is necessary for proper performance.*



**Figure 13.** Dust hose installed.

## Test Run

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

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

The Test Run consists of verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the switch disabling key disables the switch properly.

### **WARNING**

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

### **WARNING**

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

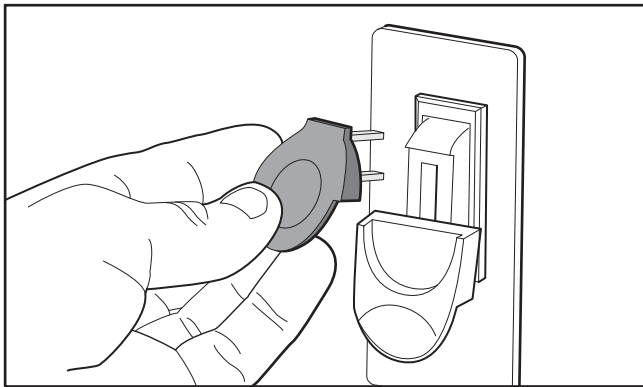


**To test run machine:**

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine **ON**, verify motor operation, then turn machine **OFF**.

Motor should run smoothly and without unusual problems or noises.

4. Remove switch disabling key, as shown in **Figure 14**.



**Figure 14.** Removing switch disabling key from ON/OFF switch.

5. Try to start machine with ON/OFF switch. Machine should not start.
  - If machine *does not* start, switch disabling feature is working correctly.
  - If machine *does start*, immediately stop machine. Switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

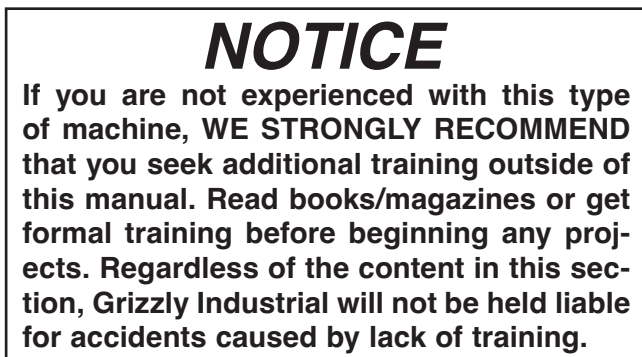
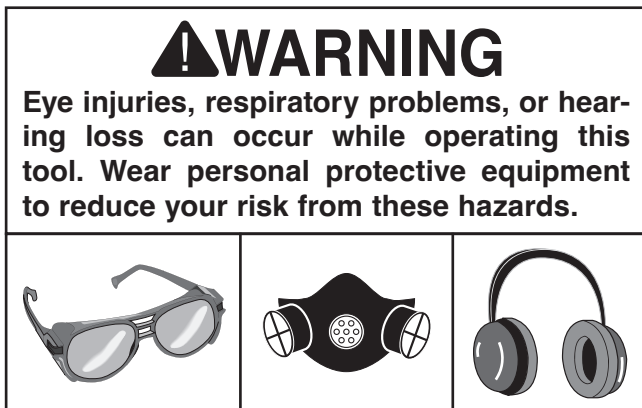


# SECTION 4: OPERATIONS

## Operation Overview

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

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



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

1. Examines workpiece to make sure it is suitable for planing.
2. Puts on safety glasses or face shield, a respirator, and ear protection.
3. Places workpiece on table with flat side down and correctly adjusts cutterhead elevation for workpiece thickness and depth of cut.
  - If workpiece is not flat, operator flattens one side with jointer or hand plane.



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

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

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

6. Once workpiece is clear of outfeed roller and stops moving, operator removes workpiece from outfeed table and measures workpiece thickness. If further planing is required, operator typically lowers cutterhead approximately  $\frac{1}{4}$  to  $\frac{1}{2}$  turn of the cutterhead elevation crank, then feeds workpiece into front of planer again.
7. Operator continues process until desired thickness is achieved, then turns machine and dust collector **OFF**.



# Disabling Switch

The switch can be disabled by removing the key, as shown below. Disabling the switch in this manner can prevent unauthorized operation of the machine, which is important if it is not kept inside an access-restricted building or in a location where children may be present.

**IMPORTANT:** Disabling the switch only restricts its function. It is not a substitute for disconnecting machine from power when adjusting or servicing.

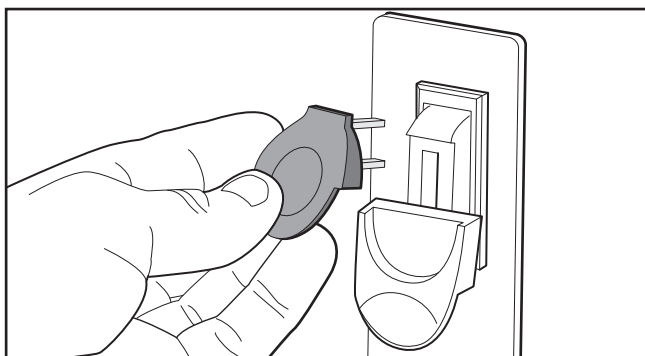


Figure 15. Disabling switch by removing key.

## WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, always disable switch before leaving machine unattended. Make sure to place key in a well-hidden or secure location!

# Workpiece Inspection

Some workpieces are not safe to use or may require modification before they are. **Before planing, inspect all workpieces for the following:**

- **Material Type:** This machine is only intended for workpieces of natural wood fiber. Attempting to use workpieces of any other material that may break apart during operation could lead to serious personal injury and property damage.
- **Foreign Objects:** Inspect lumber for defects and foreign objects (nails, staples, embedded gravel, etc.). If you have any question about the quality of your lumber, DO NOT use it. Remember, wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.
- **Large/Loose Knots:** Loose knots can become dislodged during operation. Large knots can cause kickback and machine damage. Always use workpieces that do not have large/loose knots.
- **Wet or "Green" Stock:** Avoid using wood with a high water content. Wood with more than 20% moisture content or wood exposed to excessive moisture (such as rain or snow), will cut poorly and cause excessive wear to the machine. Excess moisture can also hasten rust and corrosion of the machine and/or individual components.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to plane because they are unstable and often unpredictable when being planed. DO NOT use workpieces with these characteristics!
- **Minor Cupping:** Always true a cupped workpiece with a jointer prior to planing. Workpieces with slight cupping can be safely supported if the cupped side is facing the table. On the contrary, a workpiece supported on the bowed side will rock during operation and could cause severe injury from kickback.



# Wood Types

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

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

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

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

**Figure 16.** Janka Hardness Rating for some common wood species.

# Planing Tips

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



# Cutting Problems

---

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

## Chipped Grain

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

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

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

## Fuzzy Grain

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

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

## Snipe

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

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

## Pitch & Glue Build-up

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

**Solution:** Clean the rollers and cutterhead.

## Chip Marks or Indentations

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

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

**Solution:**

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



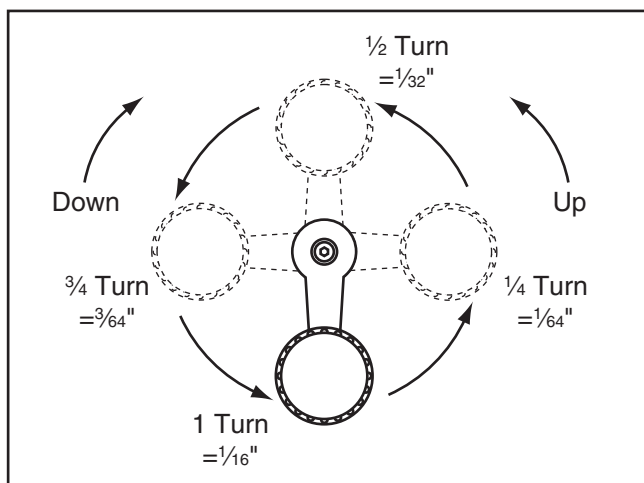
# Adjusting Depth of Cut

## Table Movement per Handwheel Revolution

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

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

The depth of cut is set by adjusting the distance of the cutterhead above the table. Rotating the elevation crank counterclockwise raises the cutterhead, while rotating the crank clockwise lowers it (see **Figure 17**). This distance is the thickness of the workpiece minus the depth of cut. The range of material thickness that can be planed is  $\frac{5}{16}"$ – $4\frac{1}{2}"$ .



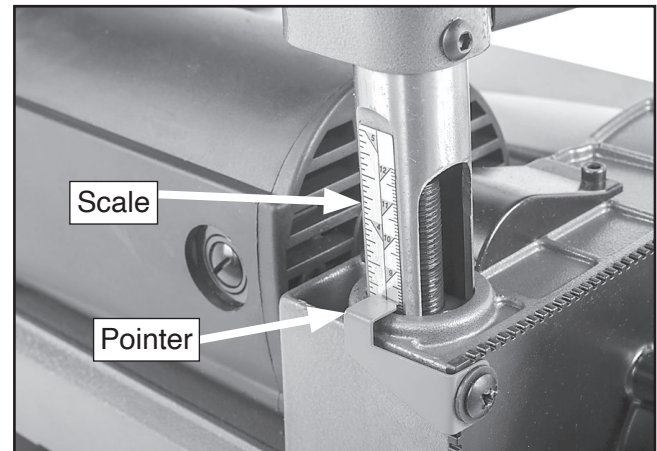
**Figure 17.** Handwheel elevation increments.

A small amount of backlash may be present with the cutterhead elevation crank after switching directions. Switching elevation direction may cause slightly less than  $\frac{1}{16}"$  backlash during the first rotation of the crank. As the elevation crank is turned more rotations in the same direction, backlash will not be a factor.

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend the maximum depth of cut (per pass) be no more than  $\frac{1}{32}"$ . A series of light cuts will give better end results and put less stress on the planer than trying to take off too much material in a single pass.

## Cutterhead Elevation Scale

The cutterhead elevation scale (see **Figure 18**) on the front of the machine shows workpiece thickness after it leaves the planer. The thickness measurement is indicated by the top edge of the pointer.



**Figure 18.** Cutterhead elevation scale.

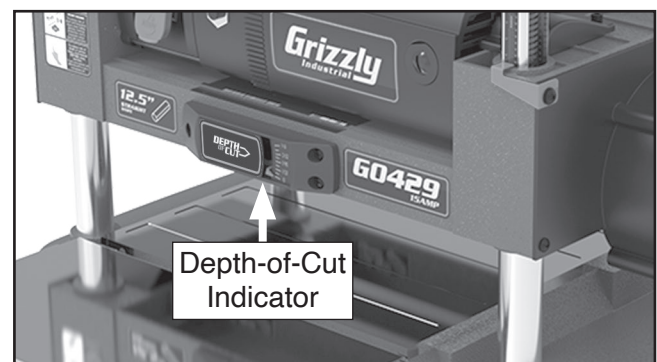
**Note:** The cutterhead elevation scale does not provide a precise measurement and should only be used for approximate measurements. If precise workpiece thicknesses are needed, use calipers to ensure your workpieces meet your standards.

## Depth-of-Cut Indicator

The depth-of-cut indicator (see **Figure 19**) on the front of the machine shows the depth of cut as stock enters the machine.

Maximum Cut Depth (Full Width).....  $\frac{1}{32}"$   
Maximum Cut Depth at (6" Width).....  $\frac{1}{16}"$

**Note:** Any cut depths above  $\frac{1}{16}"$  for full width stock will bog down the motor and affect cut quality.



**Figure 19.** Depth-of-cut indicator.



# Feeding Workpiece

Infeed and outfeed rollers move the workpiece through the planer at a rate of 26 feet per minute while keeping it flat and providing a consistent rate of movement.

## WARNING

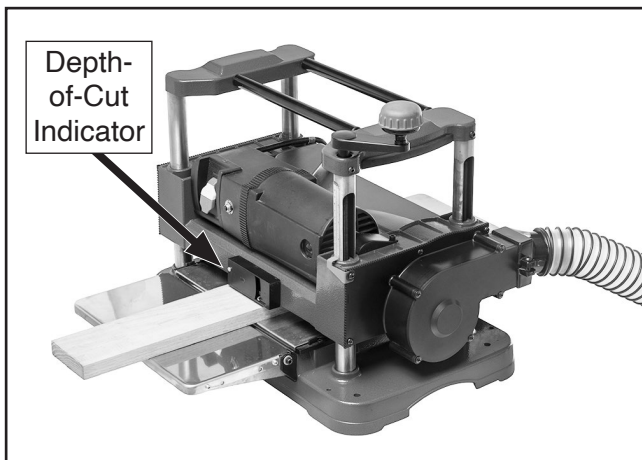
**Bowed, twisted, or cupped workpieces can cause kickback, leading to serious injury.**

### To feed workpiece:

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

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

2. Lower cutterhead until depth of cut indicator button (see **Figure 20**) just touches workpiece.



**Figure 20.** Example of basic planing operation setup.

**Note:** Whenever elevation direction is changed, there will be a small amount of backlash—so first rotation of crank after switching directions will be slightly less than  $\frac{1}{16}$ ". However, as long as you move crank in same direction during operation, backlash will not be a factor.

3. Turn cutterhead elevation crank  $\frac{1}{4}$  turn clockwise to raise cutterhead approximately  $\frac{1}{64}$ ". This will set depth of cut to  $\frac{1}{32}$ ". Remove workpiece from planer.

4. Turn machine **ON**.

5. Feed workpiece into front of planer, making sure not to stand directly in front or behind workpiece to reduce the risk of a kickback injury.

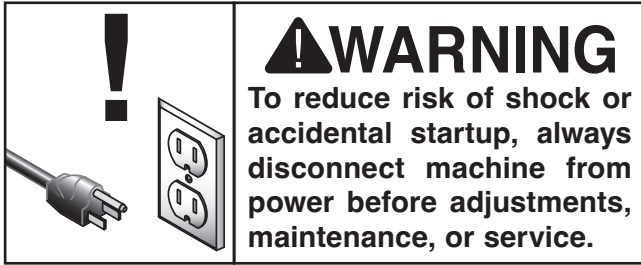
— If cut is too deep and bogs down planer, turn planer **OFF** immediately, allow it to come to a complete stop, then raise cutterhead and remove workpiece. Repeat **Steps 4–5** at a reduced depth of cut.

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

6. Once workpiece is clear of outfeed roller, measure workpiece thickness. If further planing is needed, lower cutterhead by turning elevation crank handle  $\frac{1}{2}$  turn ( $\frac{1}{32}$ "), and repeat **Step 5**.



# SECTION 5: MAINTENANCE



## Schedule

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

### Ongoing

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

- Loose mounting bolts.
- Build-up of dust and debris.
- Worn or damaged knives.
- Worn or damaged wires.
- Any other unsafe condition.

### Monthly

- Clean and lubricate chains and sprockets.
- Clean and lubricate elevation leadscrews (**Page 25**).
- Clean feed rollers and blocks (**Page 27**).
- Check V-belt for tension, damage, or wear (**Page 32**).
- Remove cutterhead guard and fan cover and thoroughly clean built-up sawdust and chips.

## Cleaning & Protecting

Cleaning the Model G0429 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.



## Lubrication

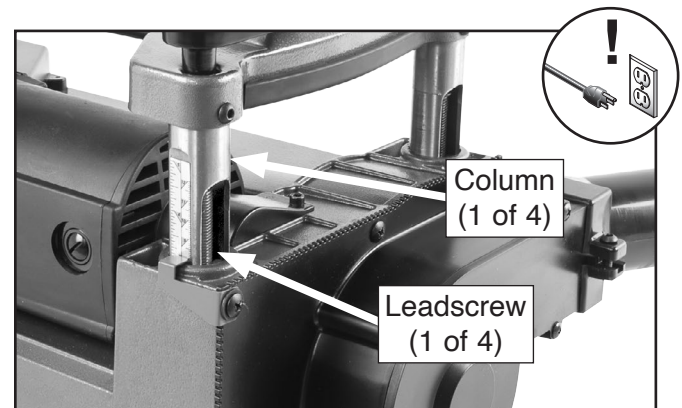
There are three primary systems that require periodic lubrication: the cutterhead elevation leadscrews and chain and the feed roller drive chain and sprockets. Clean the components with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

### Cutterhead Elevation Leadscrews

Lubrication Type ..... Dry Coating Lubricant  
Frequency ..... Monthly

#### To lubricate cutterhead elevation leadscrews:

1. DISCONNECT MACHINE FROM POWER!
2. Vacuum chips and dust from leadscrews through open face of all four columns (see **Figure 21**).



**Figure 21.** Location of elevation leadscrews.

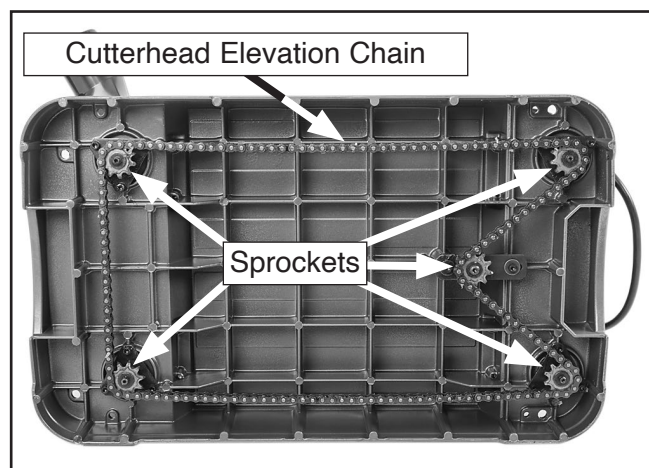
3. Use mineral spirits, stiff brush, and shop rags to remove old lubricant.
4. Spray lubricant onto each leadscrew. Move cutterhead up and down to evenly distribute.

## Cutterhead Elevation Chain

Lubrication Type ...T23964 NLGI#2 or Equivalent  
Lubrication Frequency .....Monthly

### To lubricate cutterhead elevation chain:

1. DISCONNECT MACHINE FROM POWER!
2. Gently tilt machine onto its side (see **Figure 22**) to expose chain.



**Figure 22.** Cutterhead elevation chain and sprockets exposed for lubricating.

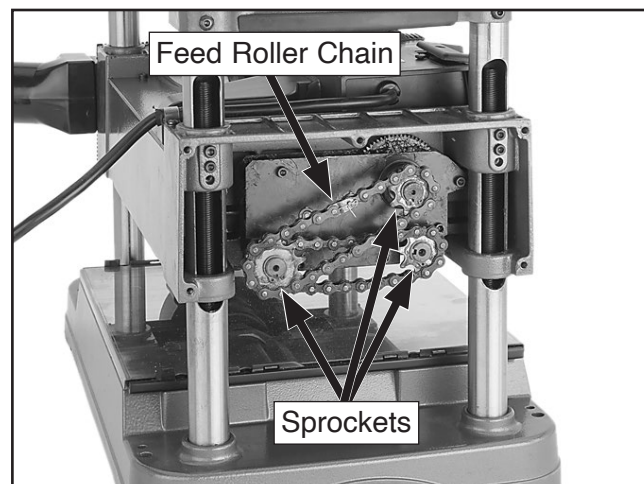
3. Use mineral spirits, stiff brush, and shop rags to clean old grease from chain.
4. Apply light coating of grease to chain linkage and sprockets.
5. Tilt machine back onto its base.
6. Adjust cutterhead up and down to distribute grease.

## Feed Roller Chain Drive & Sprockets

Lubrication Type ...T23964 NLGI#2 or Equivalent  
Lubrication Frequency .....Monthly

### To lubricate feed roller chain drive:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (4) button head cap screws to remove side cover to expose chain (see **Figure 23**).



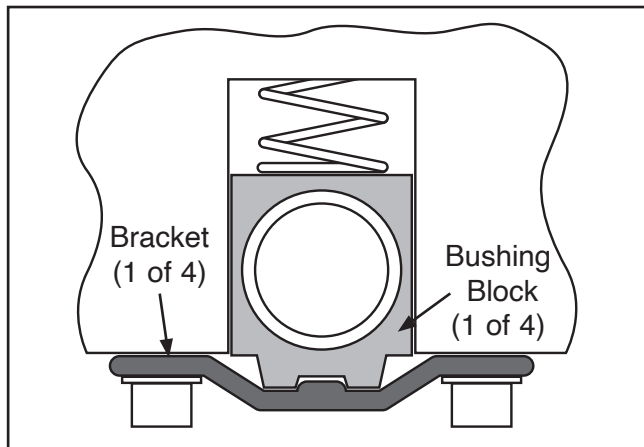
**Figure 23.** Feed roller drive chain and sprockets exposed for lubricating.

3. Use mineral spirits, stiff brush, and shop rags to clean old grease from chain.
4. Apply light coating of grease to chain links and sprockets.
5. Install side cover.
6. Turn machine **ON** to distribute grease.



# Cleaning Feed Rollers & Blocks

The feed rollers rotate in bushing blocks that are spring loaded. The feed rollers ride up on the board so that the roller pressure is maintained. If chips or sawdust build up between the bracket and bushing block (see **Figure 24**), the amount of roller vertical travel will be reduced, potentially causing improper feeding of workpiece through the machine.



**Figure 24.** Bushing block and bracket.

Periodically check and clean chips and sawdust from between the bushing blocks and brackets.

## Items Needed

## Qty

4" Tall Block of Wood ..... 1

## To clean feed rollers:

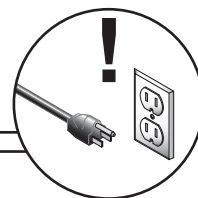
1. DISCONNECT MACHINE FROM POWER!
2. Place a 4" tall block of wood between one feed roller and planer table. Ensure block of wood is not under cutterhead.
3. Lower cutterhead assembly just enough so roller is pushed up against spring and pressure is off of two brackets.
4. Remove any trapped material from between roller assembly and bracket.



# SECTION 6: SERVICE

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

## Troubleshooting



### Motor & Electrical

| Symptom                                                                          | Possible Cause                                                                                                                                                                                                                                                                                                                                                                                     | Possible Solution                                                                                                                                                                                                                                                                                                                                                                                                                         |
|----------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Machine does not start, or power supply breaker immediately trips after startup. | <ol style="list-style-type: none"> <li>1. Switch disabling key removed.</li> <li>2. Machine circuit breaker tripped.</li> <li>3. Incorrect power supply voltage or circuit size.</li> <li>4. Power supply circuit breaker tripped or fuse blown.</li> <li>5. Wiring broken, disconnected, or corroded.</li> <li>6. Motor brushes worn out.</li> <li>7. Motor or motor bearing at fault.</li> </ol> | <ol style="list-style-type: none"> <li>1. Install switch disabling key.</li> <li>2. Reset circuit breaker on switch.</li> <li>3. Ensure correct power supply voltage and circuit size.</li> <li>4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.</li> <li>5. Fix broken wires or disconnected/corroded connections.</li> <li>6. Remove/replace brushes (<b>Page 31</b>).</li> <li>7. Replace motor.</li> </ol> |
| Machine stalls or is underpowered.                                               | <ol style="list-style-type: none"> <li>1. Motor brushes worn out.</li> <li>2. Motor overheated, tripping machine circuit breaker.</li> <li>3. Extension cord too long.</li> <li>4. Motor or motor bearings at fault.</li> </ol>                                                                                                                                                                    | <ol style="list-style-type: none"> <li>1. Replace motor brushes.</li> <li>2. Clean motor, let cool, and reduce workload. Reset breaker.</li> <li>3. Move machine closer to power supply; use shorter extension cord.</li> <li>4. Replace motor.</li> </ol>                                                                                                                                                                                |
| Machine has vibration or noisy operation.                                        | <ol style="list-style-type: none"> <li>1. Motor or component loose.</li> <li>2. Motor bearings at fault.</li> </ol>                                                                                                                                                                                                                                                                                | <ol style="list-style-type: none"> <li>1. Replace damaged or missing bolts/nuts or tighten if loose.</li> <li>2. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> </ol>                                                                                                                                                                                                                         |

### Operations

| Symptom                                     | Possible Cause                                                                                                                                                                                                                                               | Possible Solution                                                                                                                                                                                                                                                                                                                                                                                 |
|---------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Motor overheats or operates at limited RPM. | <ol style="list-style-type: none"> <li>1. Motor overloaded during operation.</li> <li>2. Motor brushes worn or at fault.</li> </ol>                                                                                                                          | <ol style="list-style-type: none"> <li>1. Reduce depth of cut (<b>Page 23</b>); reduce cutting depth when planing hard woods.</li> <li>2. Replace motor brushes (<b>Page 31</b>).</li> </ol>                                                                                                                                                                                                      |
| Machine stalls or is underpowered.          | <ol style="list-style-type: none"> <li>1. Workpiece material unsuitable for machine.</li> <li>2. Gearbox at fault.</li> <li>3. V-Belt slipping/pulleys misaligned.</li> <li>4. Pulley slipping on shaft.</li> <li>5. Machine undersized for task.</li> </ol> | <ol style="list-style-type: none"> <li>1. Only cut wood/ensure moisture is below 20%.</li> <li>2. Replace broken gearbox component.</li> <li>3. Clean/tension/replace V-belt (<b>Page 32</b>); ensure pulleys are aligned.</li> <li>4. Tighten/replace loose pulley.</li> <li>5. Use sharp knives; reduce depth of cut (<b>Page 23</b>), reduce cutting depth when planing hard woods.</li> </ol> |



## Operations (Cont.)

| Symptom                                                                                                                                                                                    | Possible Cause                                                                                                                                                                                                                                             | Possible Solution                                                                                                                                                                                                                                                                                           |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Machine has vibration or noisy operation.                                                                                                                                                  | <ol style="list-style-type: none"> <li>1. Cutterhead knives dull or damaged.</li> <li>2. V-belt worn, loose, pulleys misaligned or belt slapping cover.</li> <li>3. Incorrectly mounted on workbench.</li> <li>4. Cutterhead bearings at fault.</li> </ol> | <ol style="list-style-type: none"> <li>1. Replace cutterhead knives (<b>Page 30</b>).</li> <li>2. Inspect/replace belts with a new matched set. Realign pulleys if necessary.</li> <li>3. Adjust feet, shim, or tighten mounting hardware.</li> <li>4. Replace cutterhead bearings.</li> </ol>              |
| Excessive snipe (gouge in end of board that is uneven with rest of cut).<br><b>Note:</b> <i>A small amount of snipe is inevitable with all types of planers—the key is to minimize it.</i> | <ol style="list-style-type: none"> <li>1. Rear extension wing (or aftermarket support table) not aligned with main table.</li> <li>2. Workpiece not supported as it leaves planer.</li> <li>3. Some snipe is inevitable.</li> </ol>                        | <ol style="list-style-type: none"> <li>1. Adjust rear extension wing to align with main table.</li> <li>2. Support workpiece as it leaves outfeed end of planer.</li> <li>3. Plane lumber longer than your intended workpiece length, then cut off excess after planing complete.</li> </ol>                |
| Workpiece stops/slows in middle of cut.                                                                                                                                                    | <ol style="list-style-type: none"> <li>1. Feed roller brackets built up with sawdust.</li> <li>2. Pitch and glue buildup on planer components.</li> </ol>                                                                                                  | <ol style="list-style-type: none"> <li>1. Clean feed roller brackets (<b>Page 27</b>).</li> <li>2. Clean internal cutterhead components with pitch/resin dissolving solvent.</li> </ol>                                                                                                                     |
| Chipping (consistent pattern).                                                                                                                                                             | <ol style="list-style-type: none"> <li>1. Knots or conflicting grain direction in wood.</li> <li>2. Excessive depth of cut.</li> <li>3. Nicked, chipped, or dull knife/insert.</li> </ol>                                                                  | <ol style="list-style-type: none"> <li>1. Inspect workpiece for knots and grain direction; only use clean stock, and cut WITH the grain.</li> <li>2. Reduce depth of cut (<b>Page 23</b>); reduce cutting depth when planing hard woods.</li> <li>3. Replace cutterhead knives (<b>Page 30</b>).</li> </ol> |
| Chipping/indentation in workpiece surface (inconsistent pattern).                                                                                                                          | <ol style="list-style-type: none"> <li>1. Chips are not being properly expelled from cutterhead.</li> </ol>                                                                                                                                                | <ol style="list-style-type: none"> <li>1. Use proper dust collection system (<b>Page 16</b>).</li> </ol>                                                                                                                                                                                                    |
| Fuzzy grain.                                                                                                                                                                               | <ol style="list-style-type: none"> <li>1. Wood may have high moisture content or surface wetness.</li> <li>2. Knives dull.</li> </ol>                                                                                                                      | <ol style="list-style-type: none"> <li>1. Check moisture content is below 20% and allow to dry if moisture is too high.</li> <li>2. Replace cutterhead knives (<b>Page 30</b>).</li> </ol>                                                                                                                  |
| Long lines or ridges that run along length of board.                                                                                                                                       | <ol style="list-style-type: none"> <li>1. Nicked or chipped knife(s).</li> </ol>                                                                                                                                                                           | <ol style="list-style-type: none"> <li>1. Replace cutterhead knives (<b>Page 30</b>).</li> </ol>                                                                                                                                                                                                            |
| Uneven cutting marks, wavy surface, or chatter marks across face of board.                                                                                                                 | <ol style="list-style-type: none"> <li>1. Knives not properly installed.</li> <li>2. Cutterhead bearings worn.</li> </ol>                                                                                                                                  | <ol style="list-style-type: none"> <li>1. Properly clean mounting surfaces and re-install cutterhead knives (<b>Page 30</b>).</li> <li>2. Replace cutterhead bearings.</li> </ol>                                                                                                                           |
| Glossy surface.                                                                                                                                                                            | <ol style="list-style-type: none"> <li>1. Knives dull.</li> <li>2. Cutting depth too shallow.</li> </ol>                                                                                                                                                   | <ol style="list-style-type: none"> <li>1. Replace cutterhead knives (<b>Page 30</b>).</li> <li>2. Increase depth of cut (<b>Page 23</b>).</li> </ol>                                                                                                                                                        |



# Replacing Cutterhead Knives

The cutterhead on the G0429 is equipped with reversible knives, with a usable cutting edge on each side. When one edge becomes dull or worn, the knives may be removed and reversed to expose a fresh cutting edge. Knives only need to be replaced when both cutting edges have been worn or damaged.

Replacement Knives (T34715) ..... 1 Set

## **!WARNING**

The cutterhead knives on Model G0429 are extremely sharp. Accidental contact with knives can result in severe cuts. Take great caution whenever working with or around cutterhead knives. Wear work gloves to reduce risk of severe cuts.

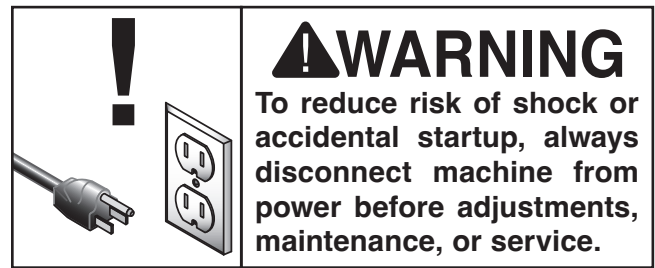
## **NOTICE**

To maintain accurate and consistent planing results, we do not recommend sharpening knives yourself. Instead, just replace dull knives or have them professionally sharpened.

The condition of the knives on the Model G0429 will affect the precision of the cut. During operation, watch for the following signs of dulled knives:

- Raised grain occurs as a result of dull knives hammering at the surface of the wood.
- A "fuzzy" appearance on the surface of the wood occurs as a result of dull knives tearing, rather than cutting the wood fibers.
- Ridges occur as a result of nicks along the knife edge.
- Difficulty feeding the workpiece into the planer.

If any of these signs become apparent during use, the knives should be reversed or replaced.



### Items Needed

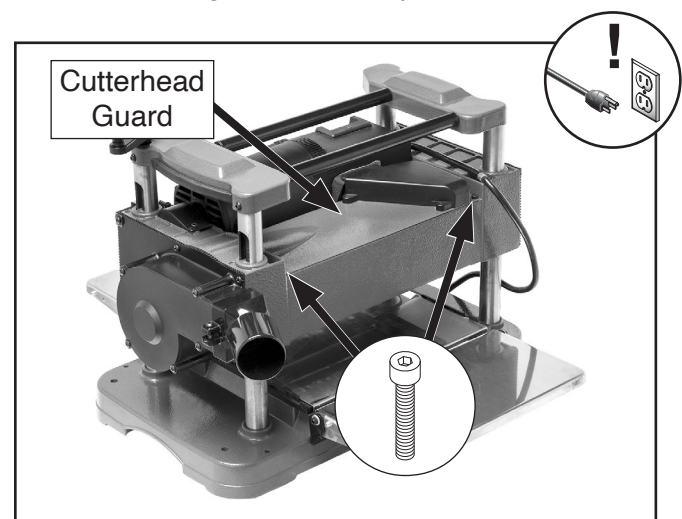
### Qty

|                             |        |
|-----------------------------|--------|
| Work Gloves .....           | 1 Pair |
| Hex Wrench 4mm .....        | 1      |
| Torx Head Wrench T-30 ..... | 1      |

## Removing Knives

1. DISCONNECT MACHINE FROM POWER!
2. Remove (2) cap screws from cutterhead guard, then remove guard (see **Figure 25**).

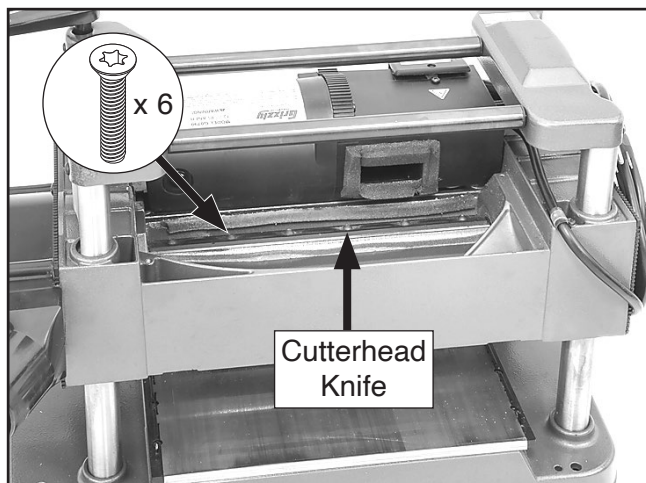
**Note:** Cutterhead guard locks in place. After removing cap screws, slide guard away from fan housing approximately 1/8" to release.



**Figure 25.** Location of cutterhead guard fasteners.

3. Wearing work gloves, carefully turn cutterhead until knives are visible (see **Figure 26**).
4. Remove (6) torx head screws from gib (see **Figure 26**).





**Figure 26.** Location of cutterhead knives and torx screws.

5. Use included magnets to remove gib, then knife.

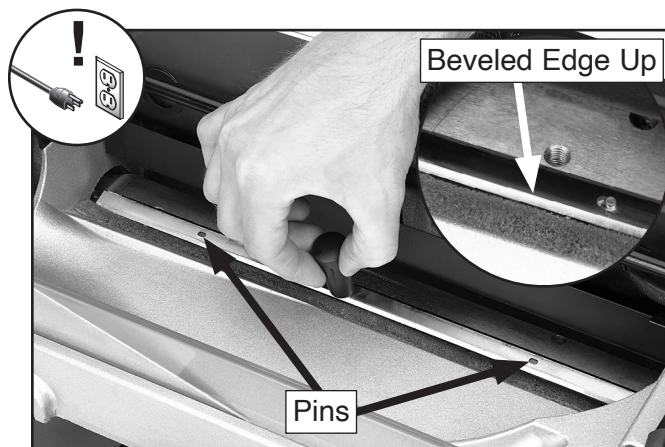
### Inspecting Cutterhead, Gib, and Knives

Carefully clean and inspect the cutterhead with a rag and with a flashlight, inspect the following:

- Make sure the threaded screw holes do not contain wood material or sawdust.
- Make sure that the torx socket and the threads of all torx screws are in good condition. Replace if questionable.
- Make sure any resin or glue buildup on the cutterhead, gib, and knives is removed so the knife and gib will sit flat on the cutterhead.
- Make sure the knives are free of cracks. If any cracks exist, replace both knives.

### Installing Knives

1. DISCONNECT MACHINE FROM POWER!
2. Using magnets, position knife over two pins on cutterhead (see **Figure 27**). Be sure knife is oriented with beveled edge up.



**Figure 27.** Example of knife installation.

3. Using magnets, place gib over knife. Secure gib with (6) torx head screws removed in **Step 4 of Removing Knives**.

**IMPORTANT:** Tighten screws beginning in the middle and work outward.

4. Carefully rotate cutterhead until second knife slot is exposed.
5. Repeat **Steps 2–3** for second knife, then replace knife guard.

## Replacing Motor Brushes

This motor is equipped with two long-life carbon brushes. However, brush life expectancy is affected by motor loading. Regularly planing very wide, dense boards or cutting too deeply will reduce brush life.

Check brushes if motor loses power or becomes noisy. Replace the carbon brushes when the motor no longer reaches full power or if brushes measure less than 1/4" long (new brushes are 5/8" long).

### Tools Needed

|                                  | Qty   |
|----------------------------------|-------|
| Flat Head Screwdriver 1/4".....  | 1     |
| Motor Brushes (P0429155-2) ..... | 1 Set |



## To replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Unscrew brush cap and carefully remove brush from motor (see **Figure 28**).



**Figure 28.** Example of removing motor brush.

3. Install new brush and re-install brush cap.
4. Repeat **Steps 2–3** to replace motor brush on opposite side of motor housing.

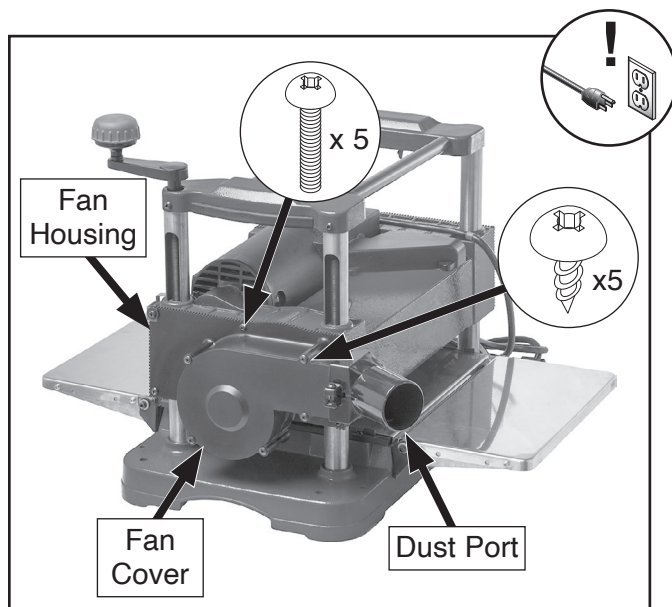
## Tensioning/Replacing V-Belt

The cutterhead is driven by a durable V-belt located on the right-hand side of the motor and cutterhead assembly (when facing the front of the machine); however, with extended use the belt may stretch and begin to slip, indicating that tightening or replacement is required. Inspect the V-belt monthly for proper tension and for signs of wear or cracking.

| Tools Needed                       | Qty       |
|------------------------------------|-----------|
| Hex Wrench 4mm.....                | 1         |
| Hex Wrench 5mm.....                | 1         |
| Phillips Head Screwdriver #2 ..... | 1         |
| V-Belt Replacement (P0429065)..... | As Needed |

### To tension/replace V-belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove dust port from fan housing.
3. Remove (5) tap screws securing fan housing cover (see **Figure 29**).

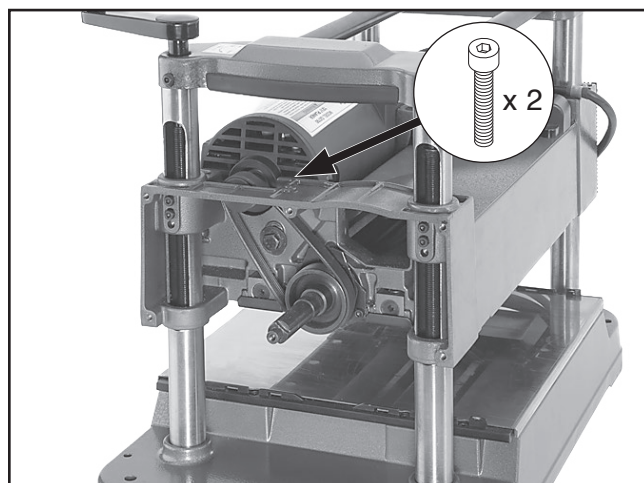


**Figure 29.** Location of fan housing.

4. Remove button head cap screw securing fan to shaft then slide fan off shaft.

**Note:** *This screw has left-hand threads; rotate right to loosen or left to tighten.*

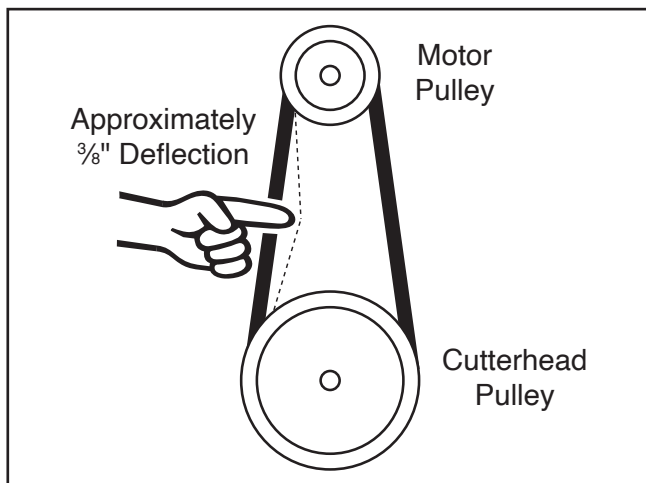
5. Remove (5) Phillips head screws (see **Figure 29**) to remove fan housing and expose V-belt.
6. Remove (2) cap screws that secure belt guard (see **Figure 30**).



**Figure 30.** Fan housing removed and V-belt exposed.

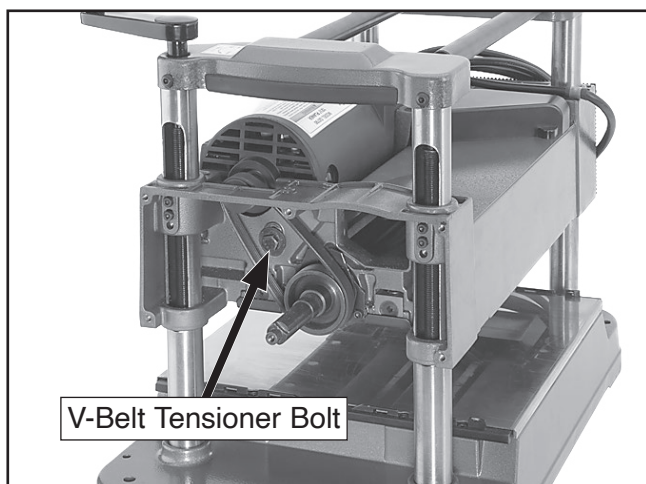
7. Inspect V-belt for signs of wear and proper tension. V-belt is correctly tensioned when there is approximately 3/8" deflection when moderate pressure is applied midway between pulleys, as illustrated in **Figure 31**.





**Figure 31.** Correct amount of belt deflection.

- If V-belt is in good condition with approximately  $\frac{3}{8}$ " deflection, no adjustments are necessary. Proceed to **Step 9**.
  - If V-belt tension is frayed, cracked, glazed, or does not have approximately  $\frac{3}{8}$ " deflection, proceed to **Step 8**.
- 8.** Loosen V-belt tensioner bolt (see **Figure 32**) and position motor as needed to properly adjust V-belt tension, then tighten bolt.
- Replacing V-belt is simply a matter of rotating motor toward rear of machine enough to roll old belt off and installing a new one.



**Figure 32.** Location of V-belt tensioner bolt.

- 9.** Install belt guard, fan housing, fan, and fan housing cover in reverse order that they were removed.

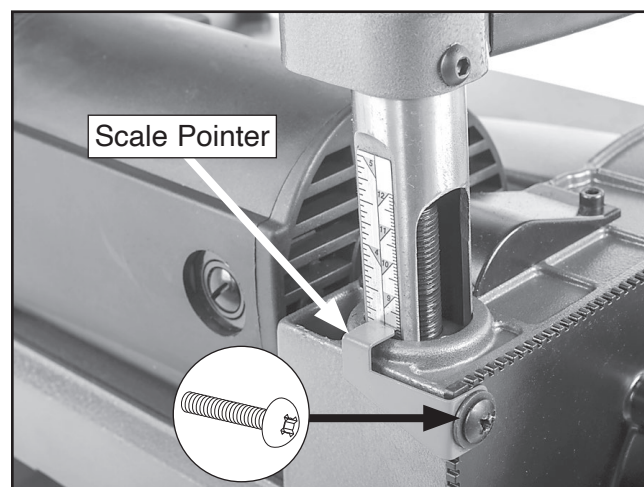
## Calibrating Scale

The scale pointer is set at the factory however, it can be adjusted for accuracy if necessary.

| Items Needed                       | Qty |
|------------------------------------|-----|
| Phillips Head Screwdriver #2 ..... | 1   |
| Scrap Piece of Stock.....          | 1   |
| Calipers .....                     | 1   |

### To calibrate scale:

- 1.** Plane scrap piece of stock until it is flat on both sides and has even thickness along its length.
- Note:** Turn scrap board over between each pass to make surfaces parallel.
- 2.** Use calipers to measure board thickness.
  - 3.** If there is a discrepancy between board thickness and reading on elevation scale, loosen Phillips head screw securing scale pointer (see **Figure 33**), adjust position of pointer to indicate correct thickness, then tighten screw.



**Figure 33.** Elevation scale components.



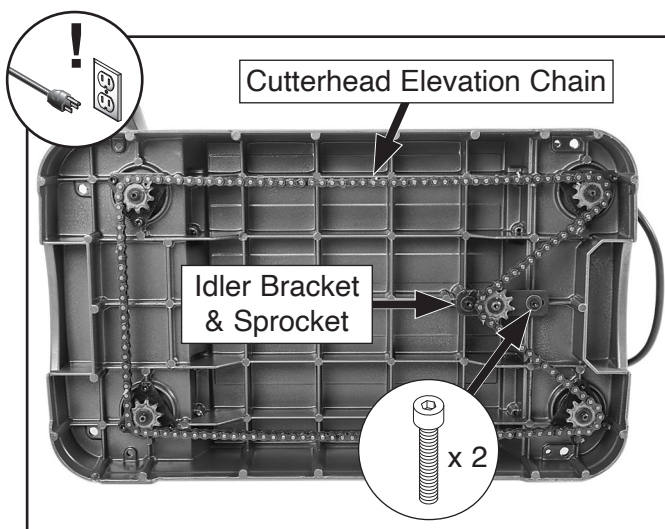
# Adjusting Cutterhead/Table Parallelism

The table and cutterhead are checked for parallelism at the factory. However, over long periods of use, parallelism may be affected. To restore parallelism between the table and the cutterhead, perform the following steps.

| Items Needed          | Qty       |
|-----------------------|-----------|
| Hex Wrench 4mm.....   | 1         |
| Scrap Wood Piece..... | As Needed |

## To adjust cutterhead/table parallelism:

1. Plane a test piece of wood. Measure amount of taper side to side and determine which corner(s), if any, needs to be adjusted.
2. DISCONNECT MACHINE FROM POWER!
3. Gently tilt machine onto its side (see **Figure 34**) to expose cutterhead elevation chain and sprockets.
4. Loosen (2) cap screws on idler bracket (see **Figure 34**) to loosen chain, then tighten cap screws to keep idler bracket from slipping. Do not remove chain.

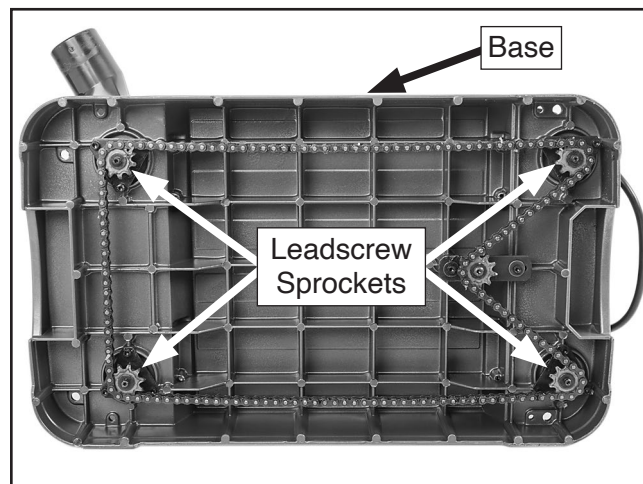


**Figure 34.** Idler bracket, sprocket, and chain (viewed from bottom).

## NOTICE

During next step, DO NOT let chain fall off sprockets. It can be very difficult to return chain to proper location on sprockets without changing table adjustments.

**Note:** The goal in the next step is to adjust the elevation of the cutterhead by rotating the leadscrew sprockets at the corners of the base (see **Figure 35**).



**Figure 35.** Location of leadscrew sprockets (viewed from bottom).

5. Gently lift chain clear of one leadscrew sprocket at a time. Rotating sprocket by one tooth will move that corner of table by approximately 0.006".
6. When satisfied with adjustments, tension chain by loosening cap screws and moving idler bracket toward center of machine base, then tighten cap screws. Set machine back on its base.
7. Perform a test cut to verify parallelism. If cutterhead and table are not parallel, perform **Steps 2–6** again.



# SECTION 7: WIRING

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

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

## WARNING

### Wiring Safety Instructions

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

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

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

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

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

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

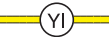
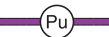
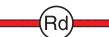
**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

#### NOTICE

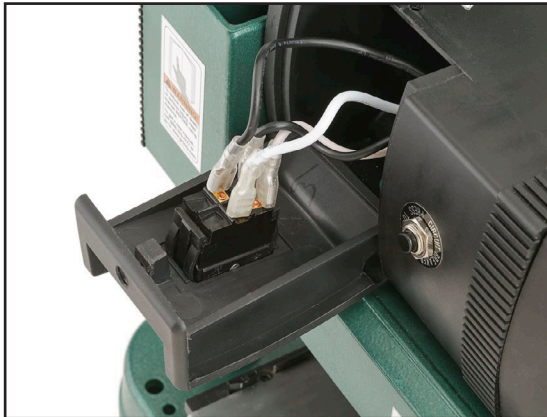
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

#### COLOR KEY

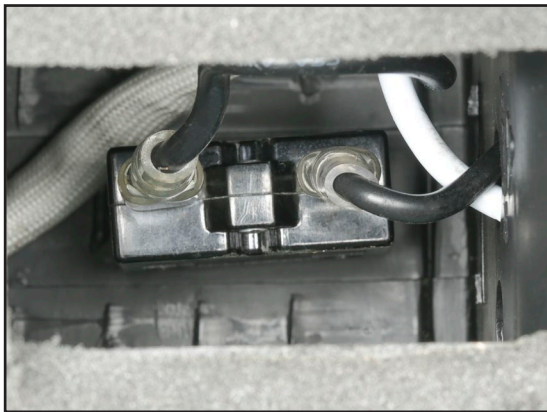
|       |                                                                                     |        |                                                                                     |              |                                                                                       |       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



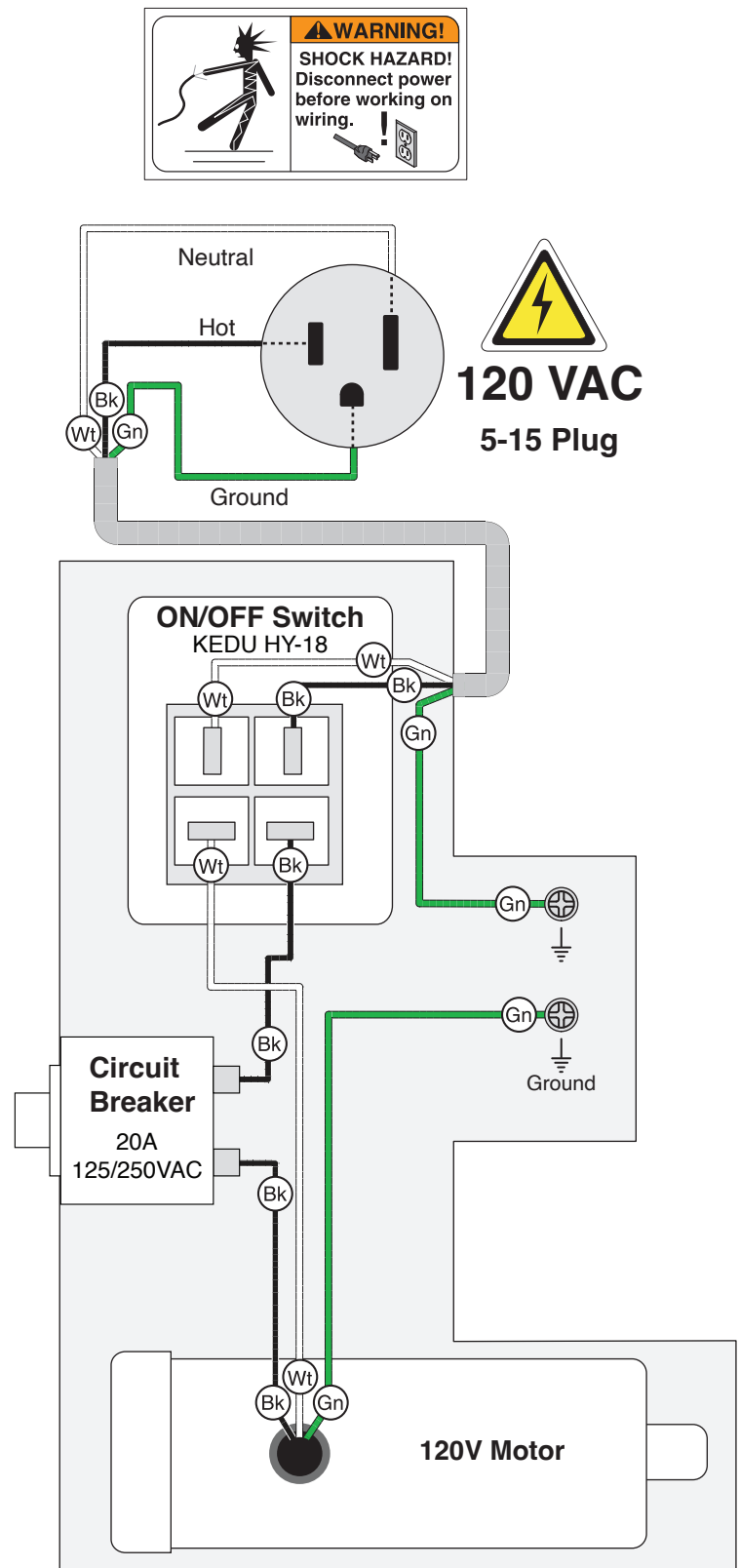
# Wiring Diagram & Electrical Components



**Figure 36.** ON/OFF switch wiring.



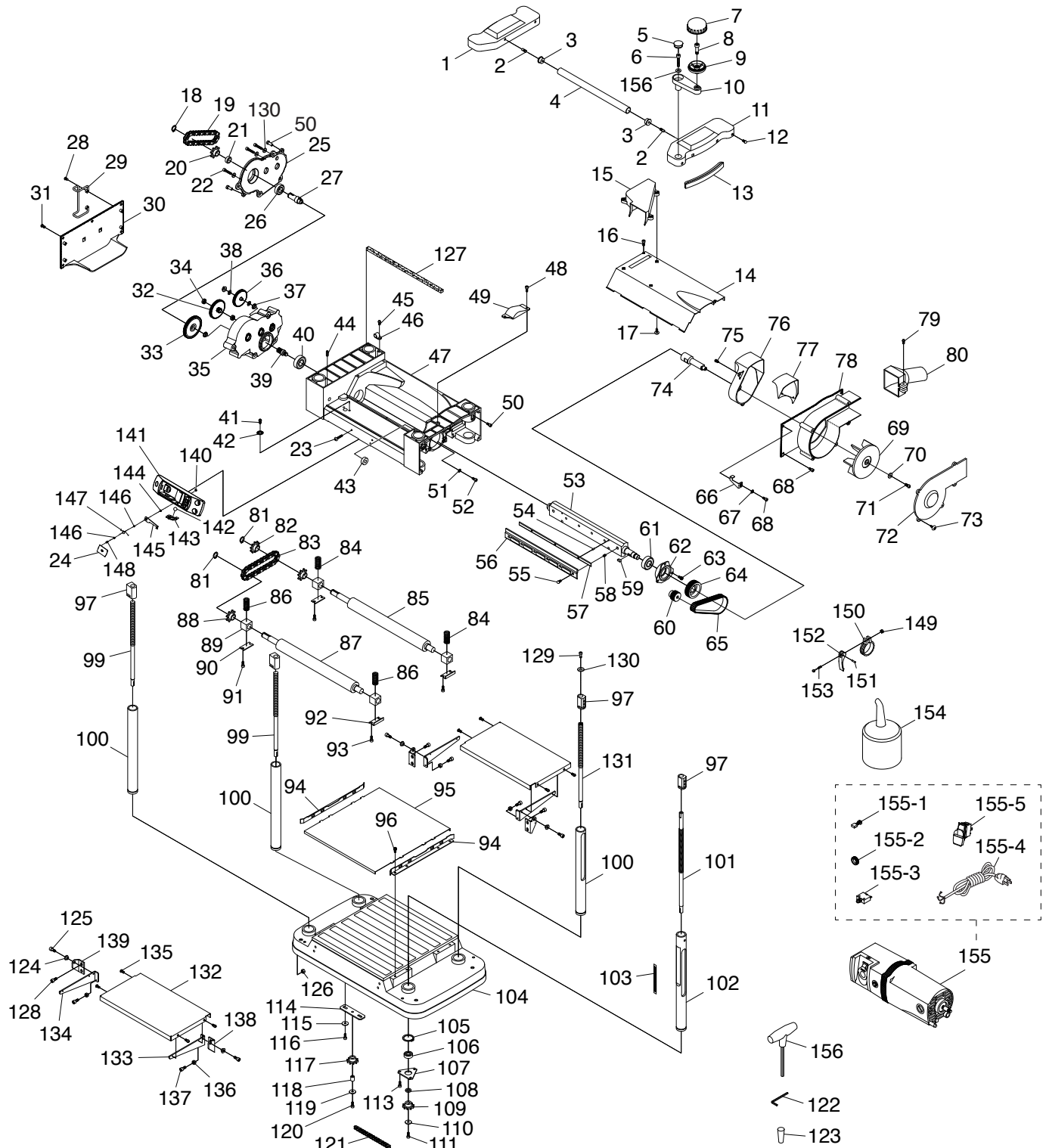
**Figure 37.** Circuit breaker wiring.



# SECTION 8: PARTS

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

## Main



# Main Parts List

| REF | PART #   | DESCRIPTION                     |
|-----|----------|---------------------------------|
| 1   | P0429001 | TOP CAP, LEFT                   |
| 2   | P0429002 | ROLLER PIN                      |
| 3   | P0429003 | ROLLER BUSHING                  |
| 4   | P0429004 | RETURN ROLLER                   |
| 5   | P0429005 | HANDLE CAP                      |
| 6   | P0429006 | CAP SCREW M5-.8 X 25            |
| 7   | P0429007 | KNOB CAP                        |
| 8   | P0429008 | SHOULDER SCREW M8-1.25 X 7, 29L |
| 9   | P0429009 | KNOB BASE                       |
| 10  | P0429010 | CRANK HANDLE                    |
| 11  | P0429011 | TOP CAP, RIGHT                  |
| 12  | P0429012 | BUTTON HD CAP SCR M6-1 X 6      |
| 13  | P0429013 | CARRYING GRIP                   |
| 14  | P0429014 | BLADE GUARD                     |
| 15  | P0429015 | AIR DUCT                        |
| 16  | P0429016 | CAP SCREW M5-.8 X 10            |
| 17  | P0429017 | TAP SCREW M4 X 10               |
| 18  | P0429018 | EXT RETAINING RING 15MM         |
| 19  | P0429019 | ROLLER CHAIN #410-27            |
| 20  | P0429020 | SPROCKET 8T                     |
| 21  | P0429021 | SPACER 15 X 20 X 7              |
| 22  | P0429022 | CAP SCREW M5-.8 X 30            |
| 23  | P0429023 | CAP SCREW M4-.7 X 10            |
| 24  | P0429024 | INDICATOR COVER                 |
| 25  | P0429025 | GEARBOX COVER                   |
| 26  | P0429026 | BALL BEARING 6002ZZ             |
| 27  | P0429027 | GEAR SHAFT                      |
| 28  | P0429028 | TAP SCREW M4 X 10               |
| 29  | P0429029 | CORD WRAP                       |
| 30  | P0429030 | SIDE COVER                      |
| 31  | P0429031 | BUTTON HD CAP SCR M6-1 X 12     |
| 32  | P0429032 | DOUBLE GEAR 58T/12T             |
| 33  | P0429033 | GEAR 70T                        |
| 34  | P0429034 | SPACER 5 X 20MM                 |
| 35  | P0429035 | GEARBOX                         |
| 36  | P0429036 | DOUBLE GEAR 52T/12T             |
| 37  | P0429037 | BUSHING                         |
| 38  | P0429038 | SHIM WASHER 8 X 14MM            |
| 39  | P0429039 | SPLINE SHAFT 12T                |
| 40  | P0429040 | BALL BEARING 6203ZZ             |
| 41  | P0429041 | PHLP HD SCR M5-.8 X 8           |
| 42  | P0429042 | EXT TOOTH WASHER 5MM            |
| 43  | P0429043 | SPACER                          |
| 44  | P0429044 | SET SCREW M5-.8 X 8             |
| 45  | P0429045 | PHLP HD SCR M5-.8 X 10          |
| 46  | P0429046 | CABLE CLAMP                     |
| 47  | P0429047 | HEADSTOCK CASTING               |
| 48  | P0429048 | CAP SCREW M5-.8 X 10            |
| 49  | P0429049 | BELT GUARD                      |
| 50  | P0429050 | CAP SCREW M5-.8 X 12            |
| 51  | P0429051 | FLAT WASHER 8MM                 |
| 52  | P0429052 | CAP SCREW M8-1.25 X 20          |

| REF | PART #   | DESCRIPTION                             |
|-----|----------|-----------------------------------------|
| 53  | P0429053 | CUTTERHEAD                              |
| 54  | P0429054 | BLADE LOCATING PIN                      |
| 55  | P0429055 | TORX SCREW M6-1 X 16                    |
| 56  | P0429056 | GIB                                     |
| 57  | P0429057 | KNIFE 12-1/2" X 1/2" X 1/16" (SET OF 2) |
| 58  | P0429058 | COMPRESSION SPRING                      |
| 59  | P0429059 | KEY 5 X 5 X 10                          |
| 60  | P0429060 | MOTOR PULLEY                            |
| 61  | P0429061 | BALL BEARING 6203ZZ                     |
| 62  | P0429062 | BEARING RETAINER                        |
| 63  | P0429063 | CAP SCREW M5-.8 X 12                    |
| 64  | P0429064 | CUTTERHEAD PULLEY                       |
| 65  | P0429065 | V-BELT 135J6                            |
| 66  | P0429066 | SCALE INDICATOR                         |
| 67  | P0429067 | FENDER WASHER 6MM                       |
| 68  | P0429068 | PHLP HD SCR M6-1 X 12                   |
| 69  | P0429069 | BLOWER FAN                              |
| 70  | P0429070 | FENDER WASHER 6MM                       |
| 71  | P0429071 | BUTTON HD CAP SCR M6-1 X 12 LH          |
| 72  | P0429072 | FAN COVER                               |
| 73  | P0429073 | TAP SCREW M5 X 16                       |
| 74  | P0429074 | FAN SHAFT                               |
| 75  | P0429075 | TAP SCREW M5 X 10                       |
| 76  | P0429076 | DUST CHUTE                              |
| 77  | P0429077 | DUST DEFLECTOR                          |
| 78  | P0429078 | FAN HOUSING                             |
| 79  | P0429079 | BUTTON HD CAP SCR M6-1 X 25             |
| 80  | P0429080 | DUST PORT 2-3/8"                        |
| 81  | P0429081 | EXT RETAINING RING 15MM                 |
| 82  | P0429082 | SPROCKET 10T                            |
| 83  | P0429083 | ROLLER CHAIN #410-26                    |
| 84  | P0429084 | COMPRESSION SPRING 2.4 X 17 X 35        |
| 85  | P0429085 | OUTFEED ROLLER                          |
| 86  | P0429086 | COMPRESSION SPRING 2.4 X 17 X 30        |
| 87  | P0429087 | INFEED ROLLER                           |
| 88  | P0429088 | SPROCKET 8T                             |
| 89  | P0429089 | FEED ROLLER RETAINING BLOCK             |
| 90  | P0429090 | FEED ROLLER BRACKET (LEFT)              |
| 91  | P0429091 | CAP SCREW M5-.8 X 10                    |
| 92  | P0429092 | FEED ROLLER BRACKET (RIGHT)             |
| 93  | P0429093 | CAP SCREW M5-.8 X 10                    |
| 94  | P0429094 | TABLE GUIDE                             |
| 95  | P0429095 | TABLE                                   |
| 96  | P0429096 | CAP SCREW M5-.8 X 10                    |
| 97  | P0429097 | LEADSCREW NUT                           |
| 99  | P0429099 | LEADSCREW (LEFT)                        |
| 100 | P0429100 | COLUMN                                  |
| 101 | P0429101 | LEADSCREW (MASTER)                      |
| 102 | P0429102 | COLUMN (MASTER)                         |
| 103 | P0429103 | ELEVATION SCALE                         |
| 104 | P0429104 | BASE                                    |
| 105 | P0429105 | EXT RETAINING RING 30MM                 |



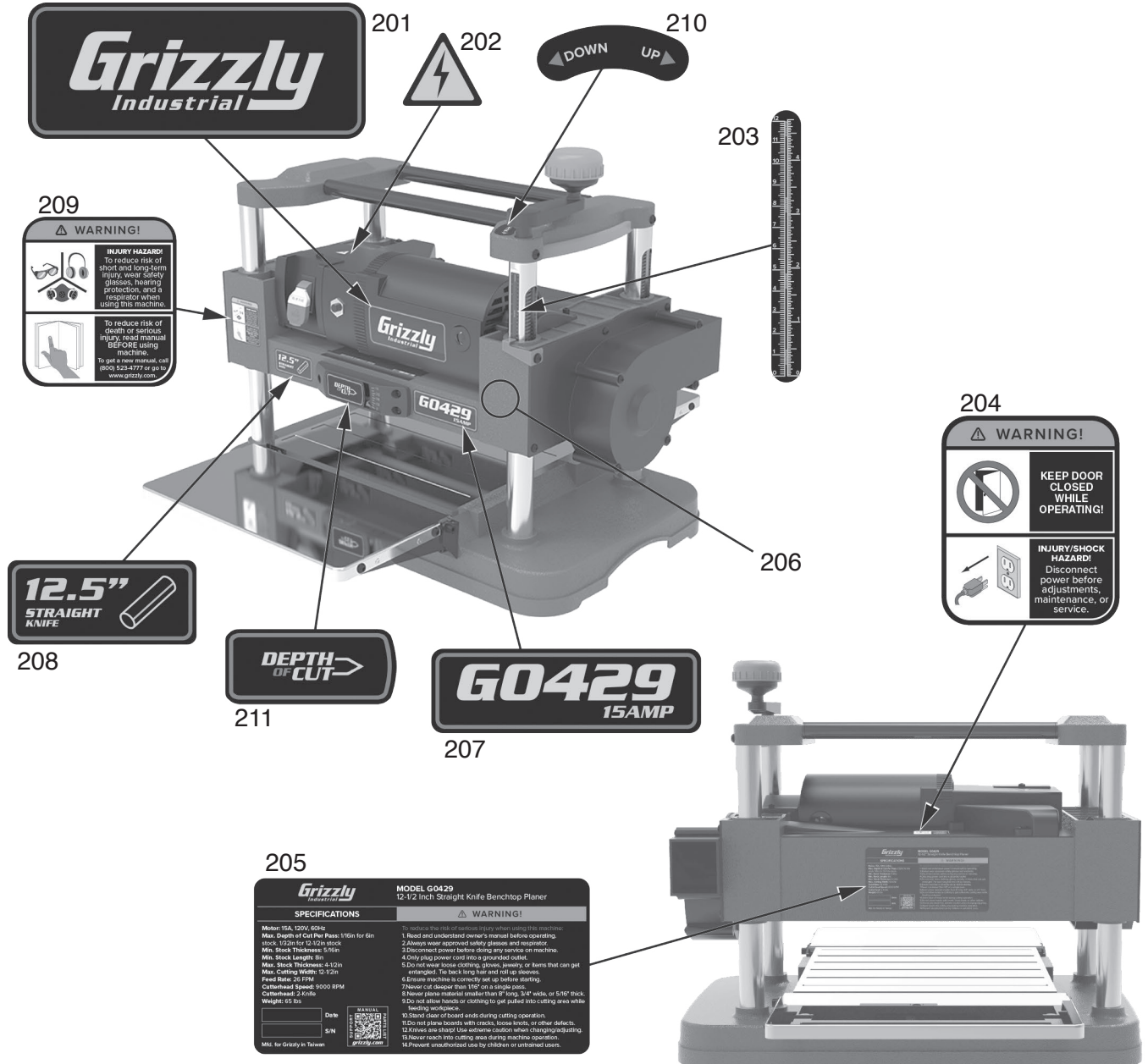
# Main Parts List (Cont.)

| REF | PART #   | DESCRIPTION                     |
|-----|----------|---------------------------------|
| 106 | P0429106 | BALL BEARING 6000ZZ             |
| 107 | P0429107 | BEARING RETAINER                |
| 108 | P0429108 | SPACER 17 X 10.25 X 3           |
| 109 | P0429109 | SPROCKET 10T                    |
| 110 | P0429110 | FENDER WASHER 4MM               |
| 111 | P0429111 | CAP SCREW M4-.7 X 12            |
| 113 | P0429113 | CAP SCREW M5-.8 X 10            |
| 114 | P0429114 | IDLER BRACKET                   |
| 115 | P0429115 | FENDER WASHER 5MM               |
| 116 | P0429116 | CAP SCREW M5-.8 X 10            |
| 117 | P0429117 | SPROCKET 10T                    |
| 118 | P0429118 | SPACER 6 X 11 X 14              |
| 119 | P0429119 | FENDER WASHER 6MM               |
| 120 | P0429120 | BUTTON HD CAP SCR M6-1 X 20     |
| 121 | P0429121 | ROLLER CHAIN #35-156            |
| 122 | P0429122 | HEX WRENCH 4MM                  |
| 123 | P0429123 | KNIFE CHANGING MAGNET           |
| 124 | P0429124 | FLANGE BUSHING                  |
| 125 | P0429125 | CAP SCREW M6-1 X 12             |
| 126 | P0429126 | HEX NUT M6-1                    |
| 127 | P0429127 | COVER GASKET                    |
| 128 | P0429128 | PHLP HD SCR M6-1 X 16           |
| 129 | P0429129 | CAP SCREW M5-.8 X 10            |
| 130 | P0429130 | FLAT WASHER 5MM                 |
| 131 | P0429131 | LEADSCREW (RT REAR)             |
| 132 | P0429132 | EXTENSION TABLE                 |
| 133 | P0429133 | EXTENSION TABLE BRACKET (RIGHT) |
| 134 | P0429134 | EXTENSION TABLE BRACKET (LEFT)  |

| REF   | PART #     | DESCRIPTION                    |
|-------|------------|--------------------------------|
| 135   | P0429135   | PHLP HD SCR M4-.7 X 6          |
| 136   | P0429136   | HEX NUT M5-.8                  |
| 137   | P0429137   | CAP SCREW M5-.8 X 20           |
| 138   | P0429138   | SUPPORT BRACKET (RIGHT)        |
| 139   | P0429139   | SUPPORT BRACKET (LEFT)         |
| 140   | P0429140   | HEX NUT M4-.7                  |
| 141   | P0429141   | INDICATOR HOUSING              |
| 142   | P0429142   | STEEL BALL 12MM                |
| 143   | P0429143   | STEEL BALL COVER               |
| 144   | P0429144   | BUSHING                        |
| 145   | P0429145   | POINTER                        |
| 146   | P0429146   | FLAT WASHER 4MM                |
| 147   | P0429147   | TORSION SPRING                 |
| 148   | P0429148   | CAP SCREW M4-.7 X 14           |
| 149   | P0429149   | HEX NUT M6-1                   |
| 150   | P0429150   | DUST BAG CLAMP                 |
| 151   | P0429151   | DOWEL PIN, STEEL 4.9 X 20      |
| 152   | P0429152   | QUICK RELEASE HANDLE           |
| 153   | P0429153   | HINGED BOLT M6-1 X 50          |
| 154   | P0429154   | DUST BAG                       |
| 155   | P0429155   | MOTOR 2HP 120V 1-PH            |
| 155-1 | P0429155-1 | MOTOR BRUSHES (2-PC SET)       |
| 155-2 | P0429155-2 | MOTOR BRUSH CAP                |
| 155-3 | P0429155-3 | CIRCUIT BREAKER 20A 125/250VAC |
| 155-4 | P0429155-4 | POWER CORD 14G 3W 72" 5-15P    |
| 155-5 | P0429155-5 | PADDLE SWITCH KEDU-HY18        |
| 156   | P0429156   | T-HANDLE TORX WRENCH T-30      |



# Labels & Cosmetics



| REF | PART #   | DESCRIPTION                   |
|-----|----------|-------------------------------|
| 201 | P0429201 | GRIZZLY INDUSTRIAL LABEL      |
| 202 | P0429202 | ELECTRICITY LABEL             |
| 203 | P0429203 | ELEVATION SCALE LABEL         |
| 204 | P0429204 | COMBO WARNING LABEL           |
| 205 | P0429205 | MACHINE ID LABEL              |
| 206 | P0429206 | TOUCH-UP PAINT, GRIZZLY GREEN |

| REF | PART #   | DESCRIPTION           |
|-----|----------|-----------------------|
| 207 | P0429207 | MODEL NUMBER LABEL    |
| 208 | P0429208 | KNIFE LABEL           |
| 209 | P0429209 | COMBO WARNING LABEL   |
| 210 | P0429210 | CRANK DIRECTION LABEL |
| 211 | P0429211 | DEPTH OF CUT LABEL    |

## ⚠ WARNING

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



# WARRANTY & RETURNS

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

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

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

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

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

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

For further information about the warranty, visit <https://www.grizzly.com/forms/warranty> or scan the QR code below to be automatically directed to our warranty page.





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