MODEL G0455/G0480
10" EXTREME SERIES JOINTER
OWNER'S MANUAL
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.

WARNING

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

Foreword

We are proud to offer the Model G0455/G0480 10" Extreme Series Jointer. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly’s commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0455/G0480. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0455/G0480 as supplied when the manual was prepared. However, owing to Grizzly’s policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
%/ Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
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Web Site: http://www.grizzly.com
**Grizzly Industrial, Inc.**

**MACHINE DATA SHEET**

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

**MODEL G0455 10" EXTREME SERIES JOINTER**

**Design Type:** Cabinet

**Overall Dimensions:**
- Table Size: 11" W x 84" L
- Height (from floor to table): 32 3/4"
- Overall Length: 84"
- Overall Width: 31"
- Overall Height: 44"
- Net Weight: 896 lbs.
- Shipping Weight: 1034 lbs.
- Shipping Box Size: 91"L x 31 1/2"W x 41"H
- Stand Footprint: 44" W x 21" D
- Cutterhead Diameter: 3 1/4"

**Capacities:**
- Maximum Rabbeting Capacity: 1/4"
- Maximum Depth of Cut (per pass): 1/4"
- Maximum Width of Cut: 10"
- Cutterhead Speed: 5000 RPM
- Cuts Per Minute: 20,000

**Construction:**
- Tables: Independently Adjustable, Precision Ground Cast Iron
- Ways: Dovetailed, Adjustable
- Fence Assembly: Cast Iron
- Body Assembly: Cast Iron
- Stand: Cast Iron
- Cutterhead: 4 Knife
- Cutterhead Size: 3 1/4"
- Knife Size: 10" L x 3/4" W x 1/4" T
- Knife Adjustment: Spring or Jack Screw
- Guard: Die Cast Metal
- Bearings: Shielded and Lubricated

**Motor:**
- Type: TEFC Capacitor Start Induction
- Horsepower: 3 HP
- Phase / Voltage: Single-Phase 220V
- Amps: 18A
- Cycle / RPM: 60 Hertz / 3450 RPM
- Switch: Magnetic w/Thermal Overload Protection
- Power Transfer: Triple V-Belt Drive
- Bearings: Shielded & Lubricated Ball Bearings

**Features:**
- Top Mount Switch Controls
- Super Long 84" Bed
- Wide-Angle Cabinet Design Provides Rock Solid Stability
- Included 4" Dust Port

*Specifications, while deemed accurate, are not guaranteed.*
**MODEL G0480  SPIRAL CUTTERHEAD 10" EXTREME SERIES JOINTER**

**Design Type:** Cabinet

**Overall Dimensions:**
- Table Size: 11" W x 84" L
- Height (from floor to table): 32½"
- Overall Length: 84"
- Overall Width: 31"
- Overall Height: 44"
- Net Weight: 896 lbs.
- Shipping Weight: 1034 lbs.
- Shipping Box Size: 91"L x 31½"W x 41"
- Stand Footprint: 44" W x 21" D
- Cutterhead Diameter: 3½"

**Capacities:**
- Maximum Rabbeting Capacity: ½" per pass
- Maximum Depth of Cut: 5¼" per pass
- Maximum Width of Cut: 10" per pass
- Cutterhead Speed: 5000 RPM
- Cuts Per Minute: 20,000 (Effective)

**Construction:**
- Cutterhead Size: 3½"
- Number of Carbide Inserts: 48
- Guard: Die Cast Metal
- Bearings: Shielded and Lubricated

**Motor:**
- Type: TEFC Capacitor Start Induction
- Horsepower: 3 HP
- Phase / Voltage: Single-Phase 220V
- Amps: 18A
- Cycle / RPM: 60 Hertz / 3450 RPM
- Switch: Magnetic w/Thermal Overload Protection
- Power Transfer: Triple V-Belt Drive
- Bearings: Shielded & Lubricated Ball Bearings

**Features:**
- Top Mount Switch Controls
- Super Long 84" Bed
- Wide-Angle Cabinet Design Provides Rock Solid Stability
- Included 4" Dust Port

*Specifications, while deemed accurate, are not guaranteed.*
Identification

A. Outfeed Table
B. Fence
C. Cutterhead Guard
D. Fence Tilt Handle
E. Fence Lock
F. Control Panel
G. Infeed Table
H. Infeed Table Handwheel
I. Depth Scale with Indexing Stop
J. Infeed Table Lock
K. Outfeed Table Lock
L. Outfeed Table Handwheel
SECTION 1: SAFETY

⚠️ WARNING

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 which are 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.

⚠️ DANGER

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

⚠️ WARNING

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

⚠️ CAUTION

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

NOTICE

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

⚠️ WARNING

Safety Instructions for Machinery

1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY. Machinery presents serious injury hazards to untrained users.

2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST. Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.

4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY. Machinery noise can cause permanent hearing damage.

5. WEAR PROPER APPAREL. DO NOT wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.

6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL. Be mentally alert at all times when running machinery.
⚠️ WARNING
Safety Instructions for Machinery

7. ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY. Make sure operation instructions are safe and clearly understood.

8. KEEP CHILDREN AND VISITORS AWAY. Keep all children and visitors a safe distance from the work area.

9. MAKE WORKSHOP CHILD PROOF. Use padlocks, master switches, and remove start switch keys.

10. NEVER LEAVE WHEN MACHINE IS RUNNING. Turn power OFF and allow all moving parts to come to a complete stop before leaving machine unattended.

11. DO NOT USE IN DANGEROUS ENVIRONMENTS. DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. KEEP WORK AREA CLEAN AND WELL LIT. Clutter and dark shadows may cause accidents.

13. USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE. Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.

14. ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY. Make sure switch is in OFF position before reconnecting.

15. MAINTAIN MACHINERY WITH CARE. Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.

17. REMOVE ADJUSTING KEYS AND WRENCHES. Make a habit of checking for keys and adjusting wrenches before turning machinery ON.

18. CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY. Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.

19. USE RECOMMENDED ACCESSORIES. Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.

20. DO NOT FORCE MACHINERY. Work at the speed for which the machine or accessory was designed.

21. SECURE WORKPIECE. Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. DO NOT OVERREACH. Keep proper footing and balance at all times.

23. MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR. Know and avoid conditions that cause the workpiece to "kickback."

24. ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.

25. BE AWARE THAT CERTAIN WOODS MAY CAUSE AN ALLERGIC REACTION in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to and always wear an approved respirator.
WARNING

Additional Safety for Jointers

1. JOINTER KICKBACK. "Kickback" is when the workpiece is thrown off the jointer table by the force of the cutterhead. Always use push blocks and safety glasses to reduce the likelihood of injury from "kickback." If you do not understand what kickback is, or how it occurs, DO NOT operate this machine.

2. CUTTERHEAD ALIGNMENT. Keep the top edge of the outfeed table aligned with the top edges of the knives at top dead center (TDC) to reduce chance of kickback and personal injuries.

3. PUSH BLOCKS. Always use push blocks whenever surface planing. Never pass your hands directly over the cutterhead without a push block.

4. WORKPIECE SUPPORT. Supporting the workpiece adequately at all times while cutting is crucial for making safe cuts and avoiding injury. Never attempt to make a cut with an unstable workpiece.

5. KICKBACK ZONE. The "kickback zone" is the path directly through the end of the infeed table. Never stand or allow others to stand in this area during operation.

6. MAXIMUM CUTTING DEPTH. The maximum cutting depth for one pass is 1/8" for the Model G0455 and 3/16" for the Model G0480. Never attempt any single cut deeper than this!

7. JOINTING WITH THE GRAIN. Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

8. KEEPING GUARDS IN PLACE. With the exception of rabbeting, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

9. PROPER CUTTING. When cutting, always keep the workpiece moving toward the outfeed table until the workpiece has passed completely over the cutterhead. Never back the work toward the infeed table.

10. USING GOOD STOCK. Jointing safety begins with your lumber. Inspect your stock carefully before you feed it over the cutterhead. Never joint a board that has loose knots, nails, or staples. If you have any doubts about the stability or structural integrity of your stock, DO NOT joint it!

WARNING

Like all machines there is danger associated with the Model G0455/G0480. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility 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.
SECTION 2: CIRCUIT REQUIREMENTS

220V Single-Phase

⚠️ WARNING
Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. DO NOT connect the machine to the power source until instructed to do so.

Amperage Draw
The motor on the Model G0455/G0480 will draw the following amps at maximum load:

Motor Load at 220V ....................... 18 Amps

Circuit Requirements
We recommend connecting this machine to a dedicated circuit with a verified ground, using the circuit breaker size given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire hazard—consult a qualified electrician to reduce this risk.

220V Circuit Breaker ....................... 20 Amps

Plug/Receptacle Type
Recommended Plug/Receptacle.... NEMA L6-20

Grounding
In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.

⚠️ WARNING
Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!

Extension Cords
We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you find it absolutely necessary to use an extension cord at 220V with your machine:

- Use at least a 10 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

Figure 1. NEMA 6-20 plug and receptacle.
SECTION 3: SET UP

Set Up Safety

⚠️ 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 set up process!

⚠️ WARNING
The Model G0455/G0480 is a very heavy machine that can cause serious injury if moved without mechanical or power lifting equipment, such as a forklift or hoist.

Items Needed for Set Up

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

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Straightedge (see Page 25)</td>
<td>1</td>
</tr>
<tr>
<td>Phillips Head Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Wrench ½” or 13mm</td>
<td>1</td>
</tr>
<tr>
<td>Wrench 19mm</td>
<td>1</td>
</tr>
<tr>
<td>Lifting Equipment (Forklift or Hoist)</td>
<td>1</td>
</tr>
<tr>
<td>An Assistant</td>
<td></td>
</tr>
</tbody>
</table>

Unpacking

The Model G0455/G0480 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

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

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

After all the parts have been removed from the crate, you should have the following items:

**Common Components (Figure 2)  Qty**
A. Jointer Assembly............................... 1
B. Fence Assembly.................................. 1
C. Cutterhead Guard Assembly................ 1
D. Push Blocks...................................... 2
E. Fence Lock Hardware Bag................. 1
   —Fence Lock Handle........................... 1
   —Flat Washer ½" ............................... 1
   —Fence Lock Nut .............................. 1
F. Tool Bag......................................... 1
   —Hex Wrench 5mm.............................. 1
   —Open End Wrench 12 x 14mm............... 1

**G0455 ONLY**
**Knife Setting Jig Hardware (Figure 3)**
• Knife Setting Jig Rod........................... 1
• Knife Setting Jig Foot.......................... 2
• E-Clip............................................ 4
• Open End Wrench 8 x 10mm................... 1

**G0480 ONLY**
**Spiral Cutterhead Hardware (Figure 4)**
• Torx Screw Driver T-Handle 6mm .......... 1
• Torx Bits T-20.................................. 1
• Carbide Inserts................................. 5
• Flat-Head Torx Screws......................... 5

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.
Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated. Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact.

![WARNING]

Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.

![CAUTION]

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.

Site Considerations

Floor Load

The Model G0455/G0480 is a very heavy machine. Refer to the Machine Data Sheet for the weight load and footprint size. Concrete floors are suitable for your machine; however, wood-built floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider the jointer dimensions and size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your jointer. See Figure 5 for the Model G0455/G0480 overhead dimensions.

![Diagram]

Figure 5. Model G0455/G0480 overhead dimensions.

![CAUTION]

Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!
Installing Fence Assembly

CAUTION
The fence is heavy. Seek assistance when lifting it onto the jointer.

Make sure the underside of the fence and top of the table have been thoroughly cleaned of all the export grease before installing the fence, or the fence will not slide easily and will get quickly gummed up when exposed to sawdust.

The fence has two keyway slots built into the underside of it that fit over the keys on the table. These keys keep the fence perpendicular to the cutterhead during adjustments.

Components and Hardware Needed: Qty
Fence Assembly ........................................ 1
Fence Lock Handle .................................... 1
Flat Washer ½" ........................................ 1
Fence Lock Nut ........................................ 1

To install the fence:

1. Have another person help you lift the fence onto the jointer table.

2. Position the fence keyway slots over the keys on the jointer, so the fence sits firmly against the table.

3. Lock the fence to the table with the lock handle, washer, and lock nut, as shown in Figure 6, making sure to keep the tabs on the lock nut facing up during installation.

Figure 6. Securing the fence to the jointer table.
Setting Outfeed Table Height

The outfeed table MUST be level with the knives or carbide inserts when they are at top-dead-center, or you cannot safely operate the jointer.

To set the outfeed table height:

1. Place a straightedge on the outfeed table so it extends over the cutterhead.

2. Rotate the cutterhead pulley until one of the knives (or carbide inserts) is at top-dead-center (TDC), as illustrated in Figure 7.

3. Raise or lower the outfeed table until the knife (or carbide insert) just touches the straight-edge (Figure 8).

4. Lock the outfeed table. (Refer to Identification on Page 6 to locate the lock handle.)

Cutterhead Guard

⚠️ CAUTION

The cutterhead guard is a critical safety feature on this machine. A torsion spring is mounted on the cutterhead guard shaft to help it return to its proper position over the cutterhead after a cutting operation. This torsion spring must have spring pressure during guard installation to work properly.

To install the cutterhead guard:

1. Slide the guard shaft into the casting and adjust the cutterhead guard about ½" above the table.

2. Using a 13mm or ½" wrench, as shown in Figure 9, wind the guard shaft back a half turn, and tighten the shaft lock.

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

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

   —If the guard drags across the table, raise it until it won't drag, then tighten the shaft lock.

   —If the guard does not snap back, remove it and repeat Steps 1 & 2, increasing the spring tension as needed.
**Pedestal Switch**

The pedestal switch is mounted sideways for shipping purposes.

**To correctly position the pedestal switch:**

1. Remove it from the jointer stand.

2. Install it upright and reattach it to the jointer stand with the same hardware you removed in Step 1. The pedestal switch should be positioned as shown in Figure 10.

![Figure 10. Switch positioned above the fence so it is accessible from the front.](image)

**Knife Setting Jig**

**Components and Hardware Needed:**

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Knife Setting Jig Rod</td>
<td>1</td>
</tr>
<tr>
<td>Knife Setting Jig Foot</td>
<td>2</td>
</tr>
<tr>
<td>E-Clip</td>
<td>4</td>
</tr>
</tbody>
</table>

Assemble the knife setting jig as shown in Figure 11.

![Figure 11. Knife setting jig assembly.](image)
Test Run

⚠️ WARNING
Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

⚠️ WARNING
Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

Starting the machine:

1. Read the entire instruction manual.

2. Make sure the cutterhead guard is installed and correctly adjusted (Page 15).

3. Make sure all tools and foreign objects have been removed from the machine.

4. Review SECTION 2: CIRCUIT REQUIREMENTS (Page 10) and connect your machine to the power source.

5. Press the START button to turn the machine ON.

   —The jointer should run smoothly with little or no vibration.

   —Immediately stop the jointer if you suspect any problems, and refer to Page 28 to troubleshoot/fix any problems before starting the jointer again.

Recommended Adjustments

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

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

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

Factory adjustments that should be verified:

1. Knife Settings (For G0455, Page 30).

2. Depth Scale Calibration (Page 33).

3. Fence Stop Accuracy (Page 34).
SECTION 4: OPERATIONS

Operation Safety

⚠️ WARNING
Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.

⚠️ WARNING
Loose hair and clothing could get caught in moving parts and cause serious personal injury. Keep loose clothing and long hair away from the machine.

NOTICE
If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Stock Inspection and Requirements

Here are some rules to follow when choosing and jointing stock:

- **DO NOT** joint or surface plane stock that contains knots. Injury to the operator or damage to the workpiece can occur if the knots become dislodged during the cutting operation.

- **DO NOT** joint or surface plane against the grain direction. Cutting against the grain increases the likelihood of stock kickback, as well as tear-out on the workpiece.

- Jointing and surface planing with the grain produces a better finish and is safer for the operator. Cutting with the grain is described as feeding the stock on the jointer so the grain points down and toward you as viewed from the edge (Figure 12).

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

![Diagram of correct and incorrect rotation](image_url)

**Figure 12.** Correct and incorrect grain alignment to cutterhead.
• Remove foreign objects from the stock. Make sure that any stock you process with the jointer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects that may damage the jointer blades.

• Only process natural wood fiber through your jointer. Never joint MDF, particle board, plywood, laminates or other synthetically made materials.

• Make sure all stock is sufficiently dried before jointing. Wood with a moisture content over 20% will cause unnecessary wear on the knives and poor cutting results.

• Make sure your workpiece exceeds the minimum dimension requirements (Figures 13 & 14) before edge jointing or surface planing, or it may break or kick back during the operation!

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### Squaring Stock

Squaring stock involves four steps performed in the order below:

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

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

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

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

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![Figure 13](image1.png)  
**Figure 13.** Minimum dimensions for edge jointing.

![Figure 14](image2.png)  
**Figure 14.** Minimum dimensions for surface planing.
Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see Figures 15 & 16) to prepare it for surface planing on a thickness planer.

**NOTICE**

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

**Figure 15.** Typical surface planing operation.

**Figure 16.** Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand SECTION 1: SAFETY, beginning on Page 7.
2. Make sure your stock has been inspected for dangerous conditions as described in the Stock Inspection & Requirements instructions, beginning on Page 18.
3. Set the cutting depth for your operation. (We suggest ½" for surface planing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure your fence is set to 90°.
5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.
6. Start the jointer.

**WARNING**

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

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

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

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

The purpose of edge jointing is to produce a finished, flat-edged surface (see Figures 17 & 18) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

---

**NOTICE**

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

---

**Figure 17.** Typical edge jointing operation.

---

**Figure 18.** Illustration of edge jointing results.

---

To edge joint on the jointer:


2. Make sure your stock has been inspected for dangerous conditions as described in the Stock Inspection & Requirements instructions, beginning on Page 18.

3. Set the cutting depth for your operation. (We suggest between ⅛" and ¼" for edge jointing, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure the fence is set to 90°.

5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.

6. Start the jointer.

7. Press the workpiece against the table and fence with firm pressure. Use your trailing hand to guide the workpiece through the cut, and feed the workpiece over the cutterhead.

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

8. Repeat Step 7 until the entire edge is flat.
Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece (see Figures 19 & 20).

The Model G0455/G0480 has preset fence stops at 45° inward, 90°, and 45° outward (135°). If your situation requires a different angle, the preset fence stops can be easily adjusted for your needs.

**NOTICE**

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

1. Read and understand SECTION 1: SAFETY, beginning on Page 7.

2. Make sure your stock has been inspected for dangerous conditions as described in the Stock Inspection & Requirements instructions, beginning on Page 18.

3. Set the cutting depth for your operation. (We suggest between ¼" and ½" for bevel cutting, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure your fence is set to the angle of your desired cut.

5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.

6. Start the jointer.

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

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

8. Repeat Step 7 until the angled cut is satisfactory to your needs.

To bevel cut on the jointer:

Figure 19. Typical bevel cutting operation.

Figure 20. Illustration of bevel cutting results.

G0455/G0480 10" Extreme Series Jointer
Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge (see Figures 21 & 22). When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

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

Figure 21. Typical rabbet cutting operation.

Figure 22. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. Read and understand SECTION 1: SAFETY, beginning on Page 7.

2. Make sure your stock has been inspected for dangerous conditions as described in the Stock Inspection & Requirements instructions, beginning on Page 18.

3. Set the cutting depth for your operation. (We suggest between ¼" and ⅛" for rabbet cutting, using a more shallow depth for hard wood species or for wide stock.)

4. Remove the cutterhead guard.

5. Make sure your fence is moved forward, so the amount of infeed/outfeed table exposed is the same as the size of your rabbet. Also, make sure your fence is set to 90°.

6. Start the jointer.

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

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

8. Repeat Step 6 until the rabbet is cut to depth.

WARNING
When the cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes the operator to the moving cutterhead. Always replace the cutterhead guard after rabbet cutting!
SECTION 5: ACCESSORIES

H7397—10" HSS Replacement Jointer Knives
(Set of 4)
H5307—10 Pack of Indexable Carbide Inserts
for Spiral Cutterhead

G1753—Joiner Pal® Magnetic Knife Jig
(For HSS & Cobalt Knives)
G1756—Joiner Pal® Magnetic Knife Jig
(For Carbide Knives)
This patented magnetic knife-setting system lets
you set jointer knives in perfect alignment every
time! It also allows you to shift nicked knives to get
a perfect cut to an accuracy of + or - 0.001".

Figure 23. Replacement knives and inserts.

G3639—Power Twist® V-Belt - ¾" x 48"
Smooth running with less vibration and noise
than solid belts. The Power Twist® V-belts can
be customized in minutes to any size—just add
or remove sections to fit your needs. Size: ¾" x
48"; replaces all "M" sized V-belts. Requires four
Power Twist® V-belts to replace the stock V-belts
on your Model G0455/G0480.

Figure 24. G3639 Power Twist® V-Belt.

G3631—Joiner/Planer Knife Hone
Add a razor hone to your planer and jointer knives
with this hand-held sharpening device. This handy
tool sharpens flat and beveled surfaces quickly
and easily. Great for touch-ups.

Figure 25. G1753 Joiner Pal® Knife Jig.

Figure 26. G3631 Joiner/Planer Knife Hone.

Call 1-800-523-4777 To Order
G9256—6" Dial Caliper
G9257—8" Dial Caliper
G9258—12" Dial Caliper
Required for jointing, planing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!

Figure 27. Grizzly® Dial Calipers.

H7431—Dispoz-A-Blade® System 10" (Includes 4 Holders & Knife Inserts)
H7432—Dispoz-A-Blade® Knife Inserts 10" HSS (Set of 4)
H7433—Dispoz-A-Blade® Knife Inserts 10" Cobalt (Set of 4)
Install a Dispoz-A-Blade® Knife system in your new jointer and save up to 70% on knife replacements for the life of your jointer. Each knife insert is double-edged, so you get two knives in one, and is indexed so that all knife inserts can be installed at the same height in just minutes. Yes, that means you can throw away the knife jig!

Figure 28. Dispoz-A-Blade® Holder and Knife.

H1411—PowerHands™ Safety Stick
This safety push stick features interchangeable traction treads; one for flat stock, and one for pressing against table and fence. It also has a spring loaded push-pin for full workpiece contact. Made in the USA.

Figure 29. H1411 PowerHands™ Safety Stick.

G9643—8" Precision Straightedge
G9644—12" Precision Straightedge
H2675—16" Precision Straightedge
Ideal for aligning your outfeed bed to the cutterhead and calibrating your depth scale. These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.

Figure 30. Straightedges.

Call 1-800-523-4777 To Order
G7984—Face Shield
H1298—Dust Sealed Safety Glasses
H1300—UV Blocking, Clear Safety Glasses
H2347—Uvex® Spitfire Safety Glasses
H0736—Shop Fox® Safety Glasses
Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

Figure 31. Our most popular safety glasses.

H6175—Power Respirator
H6892—3M Pre-Filter, 10-Pack
H6893—Filter Cartridge, 10-Pack, P100
Say goodbye to foggy safety glasses and labored breathing, this battery powered respirator supplies a constant breeze of fresh air all day long. Comes with its own plastic case for clean, sealed storage. Finally, a respirator you can look forward to wearing—at an affordable price!

Figure 32. H6175 Power Respirator.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Disposable Cartridge Filter Pair P100
Wood dust is a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 33. Half-mask respirator and disposable cartridge filters.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 34. Recommended products for protecting unpainted cast iron/steel parts on machinery.

Call 1-800-523-4777 To Order
SECTION 6: MAINTENANCE

Cleaning

Cleaning the Model G0455/G0480 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

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

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

Lubrication

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

Table ways and the fence assembly should not be lubricated. If the tables appear to be stuck, disassemble and clean any foreign materials from the ways. Re-assemble and reset the gibs.

Schedule

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

Daily:
- Vacuum all dust on and around the machine.
- Wipe down tables and other unpainted cast iron with a metal protectant (see Page 26).

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

V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition (free from cracks, fraying and wear) and properly aligned and tensioned (refer to the instructions on Page 32).
SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting Guide

Motor & Machine Operation

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor will not start.</td>
<td>1. Emergency stop button depressed.</td>
<td>1. Twist the emergency stop button to allow it to pop out.</td>
</tr>
<tr>
<td></td>
<td>2. Low voltage.</td>
<td>2. Check power line for proper voltage.</td>
</tr>
<tr>
<td></td>
<td>3. Open circuit in motor or loose connections.</td>
<td>3. Inspect all lead connections on motor for loose or open connections.</td>
</tr>
<tr>
<td>Fuses or circuit breakers blow.</td>
<td>1. Short circuit in line cord or plug.</td>
<td>1. Repair or replace cord or plug for damaged insulation and shorted wires.</td>
</tr>
<tr>
<td>Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).</td>
<td>1. Power supply circuit overloaded with lights, appliances, and other motors.</td>
<td>1. Reduce load on circuit.</td>
</tr>
<tr>
<td></td>
<td>2. Undersized wires or circuits too long.</td>
<td>2. Increase wire sizes or reduce length of the circuit.</td>
</tr>
<tr>
<td>Motor overheats.</td>
<td>1. Motor overloaded during operation.</td>
<td>1. Reduce load on motor; take lighter cuts.</td>
</tr>
<tr>
<td></td>
<td>2. Air circulation through the motor restricted.</td>
<td>2. Clean out motor to provide normal air circulation.</td>
</tr>
<tr>
<td>Motor stalls or shuts off during a cut.</td>
<td>1. Motor overloaded during operation.</td>
<td>1. Reduce load on motor; take lighter cuts.</td>
</tr>
<tr>
<td></td>
<td>2. Thermal overload protection tripped in magnetic switch.</td>
<td>2. Press the “Reset” button on the thermal overload relay, located inside the magnetic switch.</td>
</tr>
<tr>
<td></td>
<td>3. Short circuit in motor or loose connections.</td>
<td>3. Repair or replace connections on motor for loose or shorted terminals or worn insulation.</td>
</tr>
<tr>
<td></td>
<td>4. Circuit breaker tripped.</td>
<td>4. Install correct circuit breaker; reduce # of machines running on that circuit (circuit overload).</td>
</tr>
<tr>
<td>Blade slows when cutting or makes a squealing noise, especially on start-up.</td>
<td>1. V-belt loose.</td>
<td>1. Tighten V-belt (Page 32).</td>
</tr>
<tr>
<td></td>
<td>2. V-belt worn out.</td>
<td>2. Replace V-belt (Page 32).</td>
</tr>
<tr>
<td>Loud repetitive noise coming from machine.</td>
<td>1. Pulley setscrews or keys are missing or loose.</td>
<td>1. Inspect keys and setscrews. Replace or tighten if necessary.</td>
</tr>
<tr>
<td></td>
<td>2. Motor fan is hitting the cover.</td>
<td>2. Adjust fan cover mounting position, tighten fan, or shim fan cover.</td>
</tr>
<tr>
<td></td>
<td>3. V-belts are damaged.</td>
<td>3. Replace V-belts (Page 32).</td>
</tr>
<tr>
<td>Vibration when running or cutting.</td>
<td>1. Loose or damaged blade.</td>
<td>1. Tighten or replace blade.</td>
</tr>
<tr>
<td></td>
<td>2. Damaged V-belt.</td>
<td>2. Replace.</td>
</tr>
<tr>
<td></td>
<td>3. Worn cutterhead bearings.</td>
<td>3. Check/replace cutterhead bearings.</td>
</tr>
</tbody>
</table>
# Table

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tables are hard to adjust.</td>
<td>1. Table lock is engaged or partially engaged. 2. Table gibs are too tight.</td>
<td>1. Completely loosen the table lock. 2. Re-adjust the table gibs (Page 35).</td>
</tr>
<tr>
<td>Excessive play in table movement.</td>
<td>1. Table gibs are too loose.</td>
<td>1. Re-adjust the table gibs (Page 35).</td>
</tr>
</tbody>
</table>

## Cutting

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).</td>
<td>1. Outfeed table is set too low. 2. Operator pushing down on trailing end of workpiece.</td>
<td>1. Align outfeed table with cutterhead knife at top dead center (Page 15). 2. Reduce/eliminate downward pressure on trailing end of workpiece.</td>
</tr>
<tr>
<td>Workpiece stops in the middle of the cut.</td>
<td>1. Outfeed table is set too high.</td>
<td>1. Align outfeed table with cutterhead knife at top dead center (Page 15).</td>
</tr>
<tr>
<td>Chipping.</td>
<td>1. Knots or conflicting grain direction in wood. 2. Nicked or chipped blades. 3. Feeding workpiece too fast. 4. Taking too deep of a cut.</td>
<td>1. Inspect workpiece for knots and grain (Page 18); only use clean stock. 2. Adjust one of the nicked knives sideways; replace knives (Page 30). 3. Slow down the feed rate. 4. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)</td>
</tr>
<tr>
<td>Fuzzy Grain.</td>
<td>1. Wood may have high moisture content or surface wetness. 2. Dull knives.</td>
<td>1. Check moisture content and allow to dry if moisture is too high. 2. Replace knives (Page 30).</td>
</tr>
<tr>
<td>Long lines or ridges that run along the length of the board.</td>
<td>1. Nicked or chipped knives.</td>
<td>1. Adjust one of the nicked knives sideways; replace knives (Page 30).</td>
</tr>
<tr>
<td>Uneven cutter marks, wavy surface, or chatter marks across the face of the board.</td>
<td>1. Feeding workpiece too fast. 2. Knives not adjusted at even heights in the cutterhead.</td>
<td>1. Slow down the feed rate. 2. Adjust the knives so they are set up evenly in the cutterhead (Page 30).</td>
</tr>
<tr>
<td>Board edge is concave or convex after jointing.</td>
<td>1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.</td>
<td>1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on starting condition of board and depth of cut.</td>
</tr>
<tr>
<td>Uneven cut or breakout when rabbeting.</td>
<td>1. Uneven feed rate. 2. Depth of cut too deep. 3. Knives not adjusted evenly with each other in the cutterhead.</td>
<td>1. Feed the board evenly and smoothly during the cut. 2. Raise the infeed table to take a smaller depth of cut. Never exceed ⅛” per pass when rabbeting. 3. Adjust the knives so they are set up evenly in the cutterhead (Page 30).</td>
</tr>
</tbody>
</table>

G0455/G0480 10" Extreme Series Jointer -29-
Inspecting Knives (G0455 Only)

The height of the knives can be inspected with the knife setting jig. This inspection will ensure that the knives are set in the cutterhead as they should be. Usually this is done before calibrating the outfeed table or when troubleshooting.

To inspect the knives:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the cutterhead guard.
3. Lower the infeed table to the 1/2" scale mark.
4. Place the knife jig on the cutterhead, directly over a knife, as shown in Figure 35.

5. Carefully inspect how the jig touches the cutterhead and the knife.
   —If both outside legs of the jig sit firmly on the cutterhead and the middle pad just touches the knife, then that knife is set correctly. (Repeat this inspection with the other knives.)
   —If the jig does not sit firmly on the cutterhead and touch the knife edge as described, then reset that knife. (Repeat this inspection with the other knives before resetting.)

6. REPLACE CUTTERHEAD GUARD!

---

Setting Knives (G0455 Only)

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

The knife jig included with the jointer is designed to set the knives at the correct height.

The Model G0455 comes with both jack screws and springs to provide you with two options for cutterhead adjustments (see Figure 36). Note: Only one of these options is needed to set the knives—see Step 5* for clarification.

![Figure 36. Cutterhead profile diagram.]

To set the knives:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the cutterhead guard from the table and lower the infeed and outfeed tables as far as they go. This will give you unrestricted access to the cutterhead.
3. Remove the belt guard to expose the cutterhead pulley.
4. Rotate the cutterhead pulley to give you good access to one of the cutterhead knives.
5. Loosen the cutterhead gib bolts, starting in the middle and working toward the ends until the gib bolts are loose.

*If you decide to use the jack screws, remove the springs from the cutterhead. If you decide to use the springs, thread the jack screws completely into the cutterhead so they will not get lost.

6. Position the knife gauge over the knife as shown in Figure 35 and loosen the gib bolts until the knife is completely loose.

7. **Jack Screws:** Using a 3mm hex wrench, find the jack screws through the access holes in the cutterhead (Figure 37) and rotate them to raise/lower the knife. When the knife is set correctly, it will barely touch the middle pad of the knife setting jig. For now, only tighten the gib bolts enough to hold the knife in place. Repeat Steps 5–7 with the other knives.

![Figure 37. Jack screw access hole.](image)

**Springs:** Push the knife down with the jig so that the knife edge is touching the middle pad of the jig. Hold the jig down and only tighten the gib bolts enough to hold the knife in place. Repeat Steps 5–7 with the other knives.

8. Rotate the cutterhead to the first knife, and tighten the gib bolts by starting at the middle and working your way to the ends, alternating left and right. Repeat this step on the rest of the knives.

9. Repeat Step 8 to verify gib bolts are tight.

10. Adjust the outfeed table even with the new knife heights and REPLACE THE CUTTERHEAD GUARD!

---

### Replacing Inserts (G0480 Only)

The spiral cutterhead consists of 48 indexable carbide inserts. Each insert has four cutting edges, which can be easily rotated if the current cutting edge becomes dull or damaged.

A reference dot is on one corner of each insert to indicate when that insert has been rotated. After all four edges have been used, the dot will be back to its original position, indicating that the insert should be replaced. **Note:** To avoid confusion about which edges are sharp, always rotate inserts clockwise.

---

![Figure 38. Rotating carbide inserts.](image)

**To replace or rotate the inserts:**

1. **DISCONNECT JOINTER FROM POWER!**

2. Clean out the Torx screw head for the insert that you wish to replace or rotate.

   **NOTICE**

   Replacing an insert with wood dust or debris underneath will cause poor cutting results.

3. Remove the Torx screw, replace or rotate the insert, lubricate the threads of the Torx screw with a light machine oil, and torque the screw to 50 inch pounds.

   **NOTICE**

   Over-tightening Torx screws may strip the cutterhead threads!
Re replacing V-Belts

The V-belts should always be replaced together as a matching set.

**Tools Needed:**

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phillips Head Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Wrench 19mm</td>
<td>1</td>
</tr>
</tbody>
</table>

**To install the V-belt:**

1. Remove the back access panel and the V-belt guard from the jointer.

2. Using a 19mm wrench, loosen the motor mount adjustment nuts above the motor mount plate (Figure 39).

3. Turn the motor mount adjustment nuts underneath the motor mount plate to raise the motor enough to replace the V-belts on the pulleys.

4. Using the motor adjustment nuts, move the motor downward to tension the V-belts until there is approximately 3/4" deflection when the V-belts are pushed with moderate pressure.

5. Replace the access cover and V-belt guard on the jointer (Figure 40).

![Figure 39. Motor mount adjustment nuts.](image)

![Figure 40. V-belt guard replaced.](image)
Aligning V-Belts

Properly aligned V-belts last longer, run cooler, allow your machine to work more efficiently, and contribute to increased lifespan of the motor and cutterhead bearings.

To check and align the V-belts:

1. Move the fence forward and visually check the alignment of the two pulleys (Figure 41) to make sure that they are aligned.

![Diagram of V-belt alignment](image)

**Figure 41.** The pulleys should be aligned so the V-belts are straight up and down.

- If the pulleys are aligned, then no adjustments are necessary.

- If the pulleys are NOT aligned, perform Steps 2 & 3.

2. Remove the V-belts, loosen the set screws on the end of the cutterhead pulley, and align the cutterhead pulley with the motor pulley.

3. Tighten the set screws, replace the V-belts, and repeat Step 1.

Calibrating Depth Scale

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

To calibrate the depth scale:

1. Set the outfeed table height as described in the Outfeed Table Height sub-section on Page 15.

2. Place a straightedge across the infeed and outfeed tables.

3. Adjust the infeed table until it is level with the outfeed table, as illustrated in Figure 42.

![Diagram of outfeed table adjustment](image)

**Figure 42.** Infeed table adjusted even with outfeed table and knife at TDC.

4. Using a screwdriver, adjust the scale pointer exactly to “0” (Figure 43).

![Diagram of depth-of-cut pointer](image)

**Figure 43.** Depth-of-cut pointer adjusted to “0” position.
Setting Fence Stops

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

To set the 45° inward fence stop:

1. Using a 45° square, adjust the fence to the 45° inward position, as shown in Figure 44.

![Figure 44. Typical 45° inward fence adjustment.](image)

2. Loosen the jam nut shown in Figure 45.

![Figure 45. 45° inward fence stop components.](image)

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

4. Retighten the jam nut loosened in Step 2.

To set the 90° fence stop:

1. Using a 90° square, adjust the fence to the 90° position, as shown in Figure 46.

![Figure 46. Typical 90° fence adjustment.](image)

2. Flip the 90° swing stop into the position shown in Figure 47.

![Figure 47. 90° swing stop engaged.](image)

3. Loosen the jam nut on the 90° fence stop bolt (Figure 47).

4. Adjust the 90° fence stop bolt until it makes contact with the 90° swing stop.

5. Retighten the jam nut loosened in Step 3.
To set the 45° outward fence stop:

1. Using a sliding bevel adjusted to 135°, adjust the fence to the 135° (45° outward) position, as shown in Figure 48.

2. Loosen the jam nut on the 45° outward fence stop bolt (Figure 49).

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

4. Retighten the jam nut loosened in Step 2.

---

Adjusting Gibs

The function of the table gib is to eliminate excessive play in the table movement. The gib also control how easy it will be to move the tables up and down.

To adjust the table gib:

1. Using a 12mm wrench, loosen the outfeed table gib nuts on the side of the jointer base (Figure 50).

2. Using a 4mm hex wrench, evenly tighten the gib setscrews a small amount, then check the table by moving it up and down. Adjust the setscrews as needed until the friction of the table movement is balanced between minimal play and ease of movement.

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

3. Repeat Steps 1-2 with the other table.

4. Set the outfeed table height as described in Setting Outfeed Table Height on Page 15.
Wiring Diagram

MODEL G0455/G0480

CONTROL PANEL
(from behind)

SWITCH BOX

SINGLE-PHASE 220V POWER SOURCE

3 HP MOTOR

ON Switch
Power Light
STOP/Reset Switch

MAGNETIC SWITCH
SDE-Type
MA-18 (MP-18)
16 220V 3HP

Grounding Block

Overload Relay

1/2 3/4 5/6

Contactor

Junction Box

DIAGRAM

G0455/G0480 10" Extreme Series Jointer
G0455/G0480 Electrical Components

Motor Junction Box

Control Panel

Power Light

STOP/Reset Switch

ON Switch

Magnetic Switch

Contactor

Grounding Block

Overload Relay

G0455/G0480 10" Extreme Series Jointer
Jointer Parts Breakdown

G0455/G0480 10" Extreme Series Jointer
# Jointer Parts List

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Safety Label Locations

⚠️ WARNING

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

---

**REF** | **PART #** | **DESCRIPTION**
---|---|---
201 | P0455201 | G0455 MACHINE ID LABEL
201 | P0480201 | G0480 MACHINE ID LABEL
202 | P0455202 | CUTTERHEAD GUARD LABEL
203 | P0455203 | DISCONNECT POWER LABEL
204 | PLABEL-12 | READ MANUAL LABEL
205 | PLABEL-11 | SAFETY GLASSES LABEL
206 | G8588 | GRIZZLY NAMEPLATE
207 | P0455207 | G0455 MODEL NUMBER LABEL
207 | P0480207 | G0480 MODEL NUMBER LABEL
208 | PLABEL-15 | EAR PROTECTION LABEL
209 | P0455209 | EXTREME SERIES PLATE
210 | P0455210 | CUTTING DEPTH SCALE
211 | PLABEL-14 | ELECTRICITY LABEL
212 | P0455212 | TOUCH UP PAINT "PUTTY"
213 | P0455213 | TOUCH UP PAINT "HT GREEN"
WARRANTY AND RETURNS

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

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

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

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

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

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

Name ____________________________________________
Street ____________________________________________
City __________________ State ___________ Zip __________
Phone # __________________ Email __________________ Invoice # ______
Model # __________________ Order # __________ Serial # __________

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

1. How did you learn about us?
   ___ Advertisement ___ Friend ___ Catalog
   ___ Card Deck ___ Website ___ Other:

2. Which of the following magazines do you subscribe to?
   ___ Cabinet Maker ___ Popular Mechanics ___ Today's Homeowner
   ___ Family Handyman ___ Popular Science ___ Wood
   ___ Hand Loader ___ Popular Woodworking ___ Wooden Boat
   ___ Handy ___ Practical Homeowner ___ Woodshop News
   ___ Home Shop Machinist ___ Precision Shooter ___ Woodsmith
   ___ Journal of Light Cont. ___ Projects in Metal ___ Woodwork
   ___ Live Steam ___ RC Modeler ___ Woodworker West
   ___ Model Airplane News ___ Rifle ___ Woodworker's Journal
   ___ Modeltec ___ Shop Notes ___ Other:
   ___ Old House Journal ___ Shotgun News

3. What is your annual household income?
   ___ $20,000-$29,000 ___ $30,000-$39,000 ___ $40,000-$49,000
   ___ $50,000-$59,000 ___ $60,000-$69,000 ___ $70,000+

4. What is your age group?
   ___ 20-29 ___ 30-39 ___ 40-49
   ___ 50-59 ___ 60-69 ___ 70+

5. How long have you been a woodworker/metalworker?
   ___ 0-2 Years ___ 2-8 Years ___ 8-20 Years ___ 20+ Years

6. How many of your machines or tools are Grizzly?
   ___ 0-2 ___ 3-5 ___ 6-9 ___ 10+

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

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

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
   Note: We never use names more than 3 times. ___ Yes ___ No

10. Comments: ____________________________________________
    ____________________________________________________________________
    ____________________________________________________________________
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