

Grizzly **Industrial, Inc.**®

MODEL G0495X 8" X 83" JOINTER w/DIGITAL HEIGHT READOUT OWNER'S MANUAL *(For models manufactured since 06/22)*




C US
175370

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

WARNING!

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

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

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

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

WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

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

Manufacture Date

Serial Number



Identification

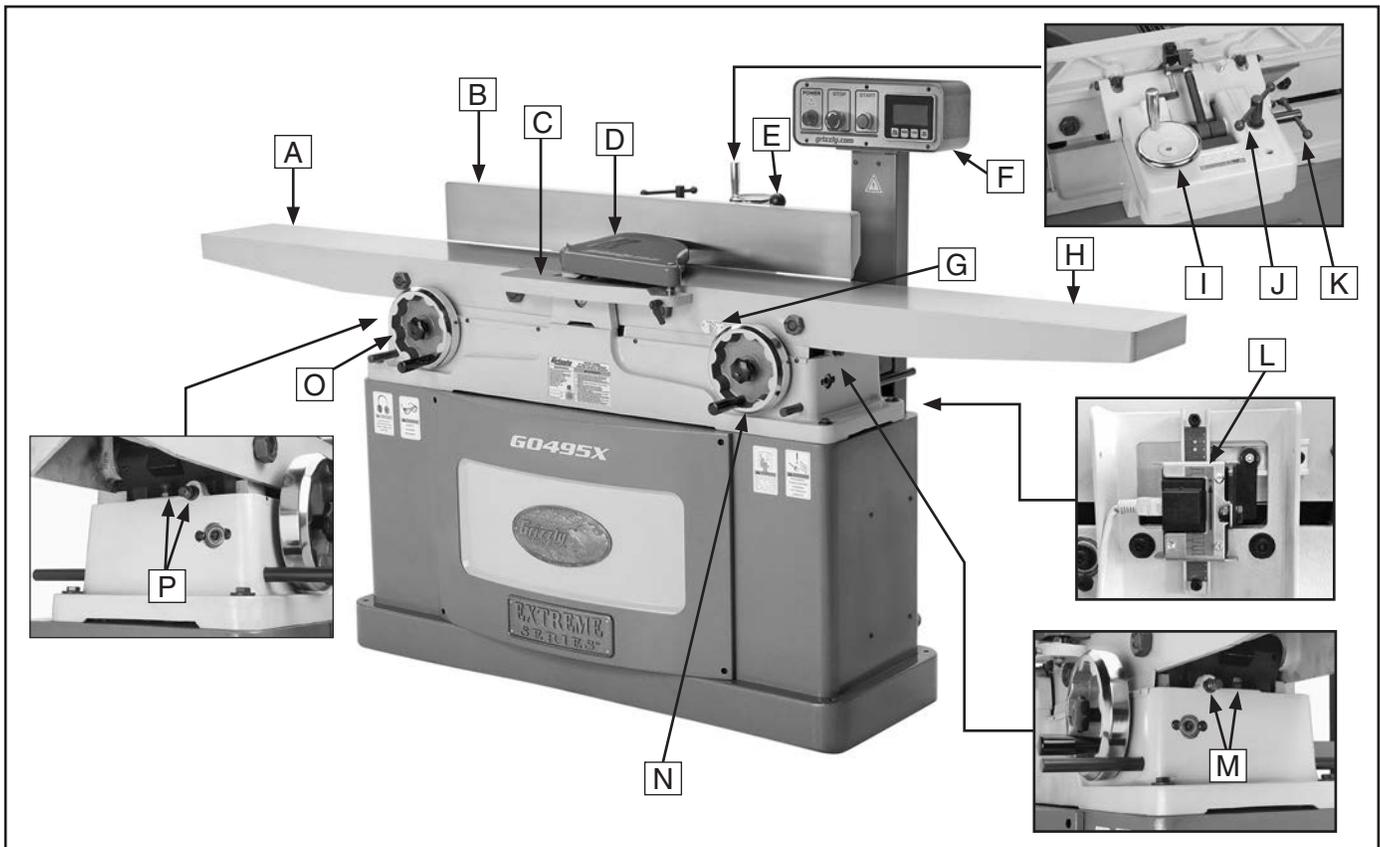


Figure 1. G0495X identification.

- | | |
|---------------------------------------|---------------------------|
| A. Outfeed Table | I. Fence Adjustment Wheel |
| B. Fence | J. Fence Lock |
| C. Rabbeting Extension | K. Tilt Lock |
| D. Cutterhead Guard | L. Digital Sensor |
| E. Fence Tilt Handle | M. Infeed Depth Stops |
| F. Control Panel with Digital Readout | N. Infeed Handwheel |
| G. Depth Scale | O. Outfeed Handwheel |
| H. Infeed Table | P. Outfeed Depth Stops |

WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

- Wear eye protection.
- Always keep cutterhead and drive guards in place and in proper operating condition. If removed, ALWAYS replace cutterhead guard immediately after rabbeting operations.
- Never make cuts deeper than $\frac{1}{8}$ " per pass.
- Always use hold-down or push blocks when jointing material narrower than 3" or planing material thinner than 3".
- Never perform jointing, planing, or rabbeting cuts on pieces shorter than 10" in length.



Controls & Components

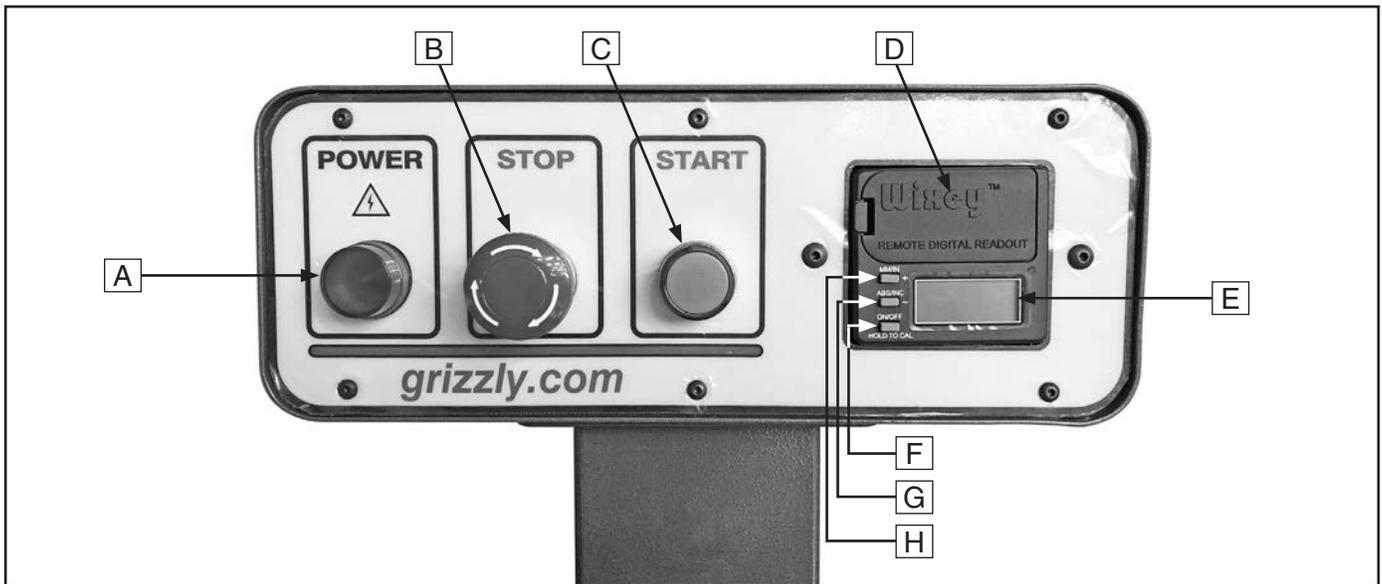


Figure 2. Control panel and digital readout features.

- A. POWER Light
- B. STOP Button
- C. START Button
- D. Battery Compartment
- E. Digital Display
- F. ON/OFF HOLD TO CAL BUTTON Button
- G. ABS/INC
- H. MM/IN





MACHINE DATA SHEET

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

MODEL G0495X 8" X 83" JOINTER W/DIGITAL HEIGHT READOUT

Product Dimensions:

Weight..... 596 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 83 x 24-1/2 x 44 in.
Footprint (Length x Width)..... 45-3/4 x 15 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 672 lbs.
Length x Width x Height..... 87 x 28 x 43 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 230V, Single-Phase, 60 Hz
Full-Load Current Rating..... 12A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6 ft.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 6-20
Switch Type..... Control Panel w/Magnetic Switch Protection

Motors:

Main

Horsepower..... 3 HP
Phase..... Single-Phase
Amps..... 12A
Speed..... 3450 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer V-Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Main Specifications

Jointer Size..... 8 in.
Bevel Jointing..... 0 – 45 deg. L/R
Maximum Width of Cut..... 8 in.
Maximum Depth of Cut..... 1/8 in.
Minimum Workpiece Length..... 10 in.
Minimum Workpiece Thickness..... 1/2 in.
Maximum Rabbeting Depth..... 1/2 in.
Number of Cuts Per Minute..... 28,000



Fence Information

Fence Length..... 38 in.
Fence Width..... 1-1/2 in.
Fence Height..... 4-3/4 in.
Fence Stops..... 45, 90, 135 deg.

Cutterhead Information

Cutterhead Type..... Helical
Cutterhead Diameter..... 3-1/16 in.
Number of Cutter Rows..... 4
Number of Indexable Cutters..... 36
Cutterhead Speed..... 7000 RPM

Cutter Insert Information

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

Table Information

Table Length..... 83 in.
Table Width..... 8 in.
Table Thickness..... 3-5/16 in.
Floor to Table Height..... 31 in.
Table Adjustment Type..... Handwheel
Table Movement Type..... Parallelogram

Construction

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

Other Information

Number of Dust Ports..... 1
Dust Port Size..... 4 in.

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 45 Minutes
Serial Number Location Machine ID Label
ISO 9001 Factory Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) Yes



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

WARNING

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

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

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

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

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety Instructions for Jointers

WARNING

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

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

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

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

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

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

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

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

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

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

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

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

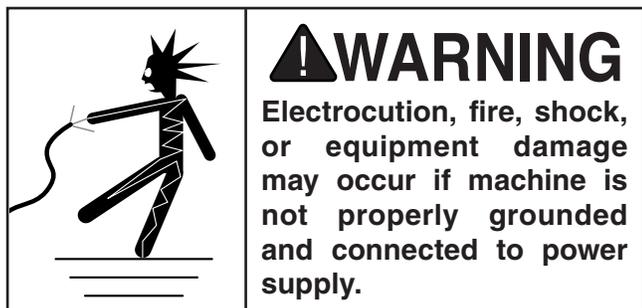
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can be thrown from cutterhead with dangerous force. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than $\frac{1}{8}$ " (0.125") from cutterhead body.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating 12 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.

Circuit Information

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.*

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 220V
- Cycle 60 Hz
- Phase Single-Phase
- Power Supply Circuit 20 Amps
- Plug/Receptacle NEMA 6-20



Grounding 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!

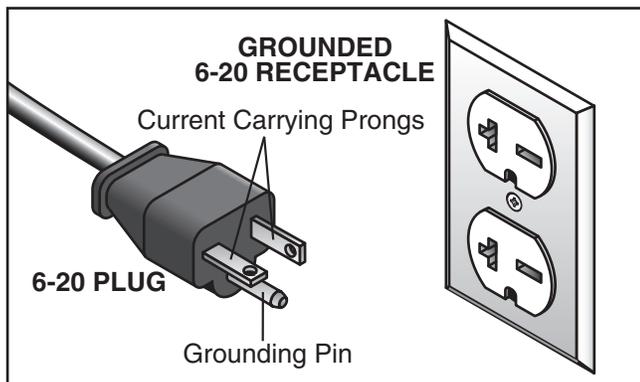
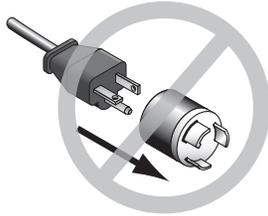


Figure 3. Typical 6-20 plug and receptacle.

CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

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.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

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

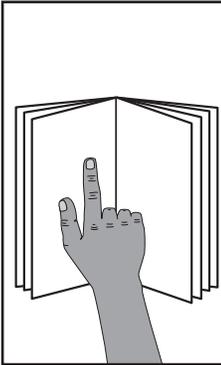
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

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



SECTION 3: SETUP



!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!



!WARNING

HEAVY LIFT!

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

Needed for Setup

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

| Description | Qty |
|---|-----|
| • Safety Glasses (for each person)..... | 1 |
| • Straightedge 4' (or longer)..... | 1 |
| • Dust Collection System | 1 |
| • 4" Dust Hose (length as needed) | 1 |
| • 4" Hose Clamp | 1 |
| • Forklift, Hoist, or Boom Crane..... | 1 |
| • Lifting Straps (1000 lb. Capacity Min.) | 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.

| Box 1 (Figures 4–5) | Qty |
|---------------------------------------|-----|
| A. Jointer Assembly (not shown) | 1 |
| B. Hex Wrench 3mm..... | 1 |
| C. Hex Wrench 4mm..... | 1 |
| D. Hex Wrench 5mm..... | 1 |
| E. Hex Wrench 6mm..... | 1 |
| F. Hex Wrench 8mm..... | 1 |
| G. Open End Wrench 12/14mm | 1 |
| H. Open End Wrench 14/17mm | 1 |
| I. Phillips Head Screwdriver..... | 1 |
| J. Push Blocks..... | 2 |
| K. T-Handle T-25 Torx Driver | 2 |
| L. Inserts 15 x 15 x 2.5..... | 5 |
| M. Flat Head Torx Screws #10-32..... | 10 |
| N. AAA Batteries (not shown) | 2 |

| Box 2 (Figure 6) | Qty |
|------------------------------------|-----|
| O. Cutterhead Guard Assembly | 1 |

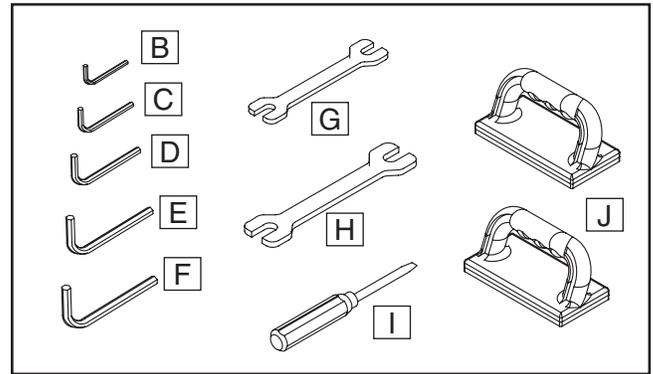


Figure 4. Tools inventory.

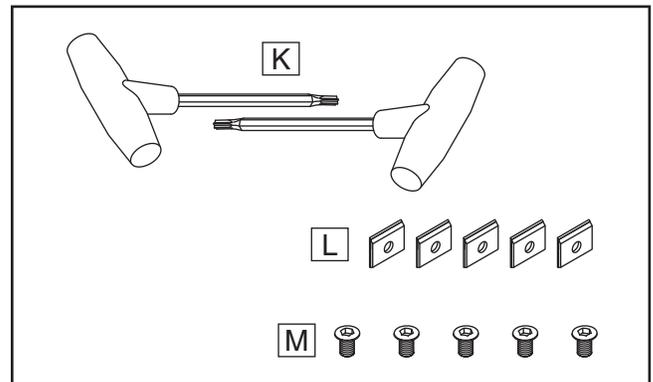


Figure 5. Helical cutterhead hardware.

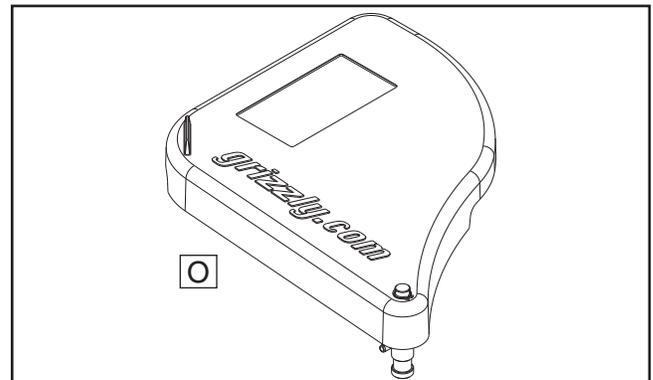


Figure 6. Cutterhead guard assembly.



Cleanup

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

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

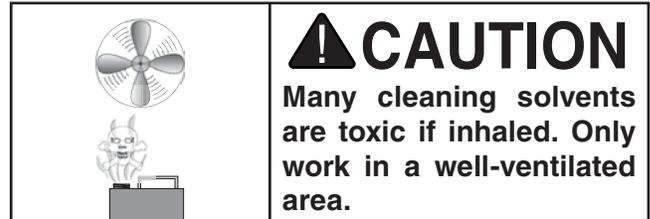
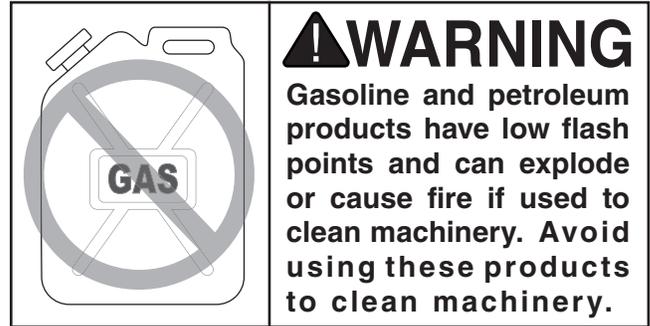
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

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

Basic steps for removing rust preventative:

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



T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from the **non-painted** parts of the machine during clean up.



Site Considerations

Weight Load

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

Space Allocation

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



Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

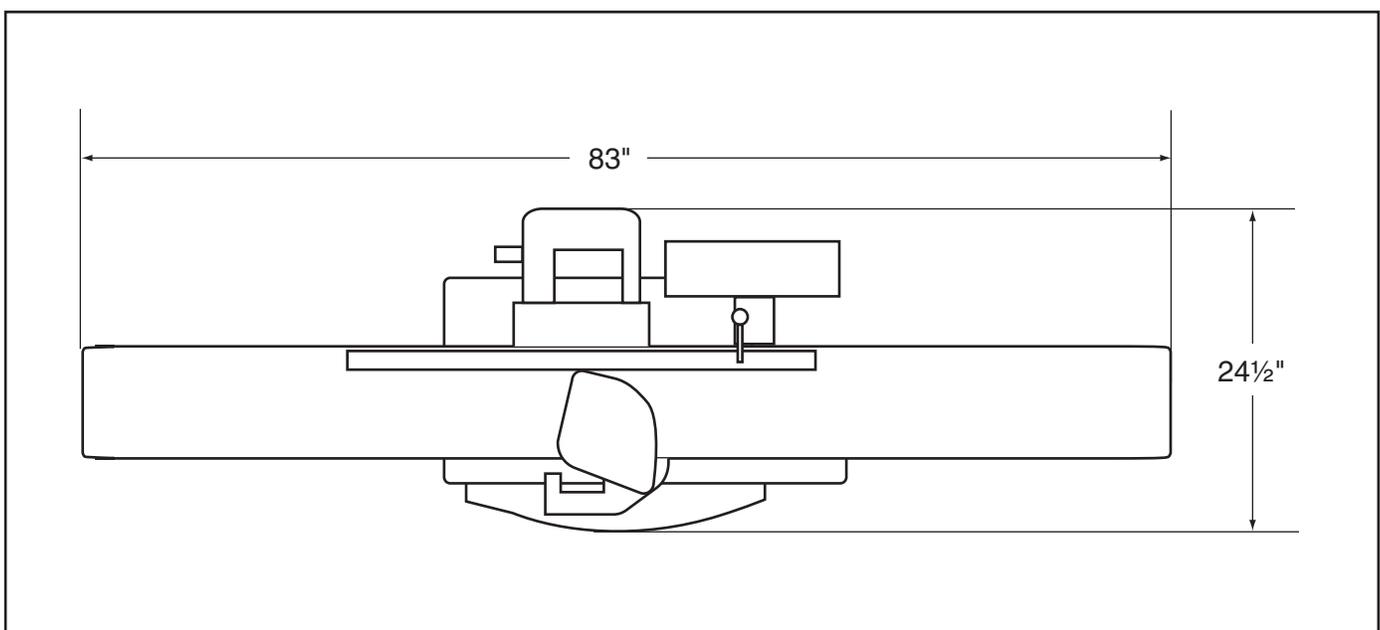


Figure 7. Minimum working clearances.



Assembly

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



The Model G0495X requires the use of lifting equipment such as a forklift, engine hoist, or boom crane. Each piece of lifting equipment must be rated for **at least 850 lbs.** to support dynamic loads that may be applied while lifting. **DO NOT** try to lift the machine by hand. **DO NOT** attempt to lift or move jointer without necessary assistance from other people.

Review the **Power Supply** section (see **Page 10**), then prepare a permanent location for the jointer.

NOTE: Do not destroy cardboard box or wood shipping crate and packaging until after Test Run.

To assemble jointer:

1. Unbolt jointer from pallet.
2. Wrap lifting straps around lifting rods, as shown in **Figure 8**.

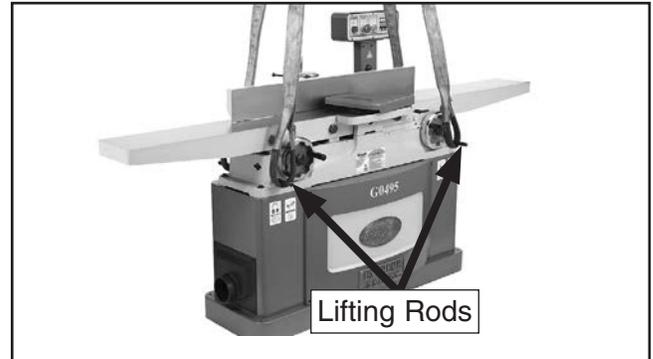


Figure 8. Model G0495X supported evenly by two lifting straps.

3. With lifting straps positioned evenly, lift jointer off of pallet and place it in desired location.
4. Verify outfeed table height is set correctly with inserts at top dead center (TDC) (refer to **Setting Outfeed Table Height** on **Page 40**) and all inserts are securely tightened in cutterhead.
5. Set fence to 90° and move it all the way back.
6. Remove pre-installed button head cap screw and flat washer from bottom of cutterhead guard shaft (see **Figure 9**); then loosen shaft lock and insert shaft into mounting hole, positioned so guard rests against fence.

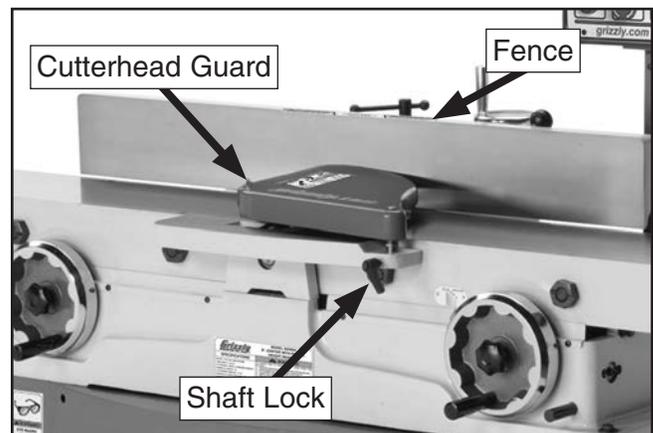


Figure 9. Cutterhead guard installed.



7. Position guard height as low as possible without dragging on infeed table/rabbeting ledge (approximately $\frac{1}{16}$ " above infeed table), tighten shaft lock to secure setting, then install button head cap screw and flat washer.

⚠ WARNING

The cutterhead guard is a critical safety feature of this jointer. You MUST verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

8. Verify proper operation of cutterhead guard by setting fence to 90° , moving fence to rear of table, then pulling cutterhead guard back and letting it go. It should spring back over cutterhead and contact fence without dragging across outfeed table.
 - If cutterhead guard does *not* spring back over cutterhead and contact fence, or if it drags across outfeed table, then it must be adjusted (refer to **Checking/Adjusting Cutterhead Guard** on **Page 41** for instructions).

Anchoring to Floor

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you **MUST** follow the anchoring methodology specified by the code.

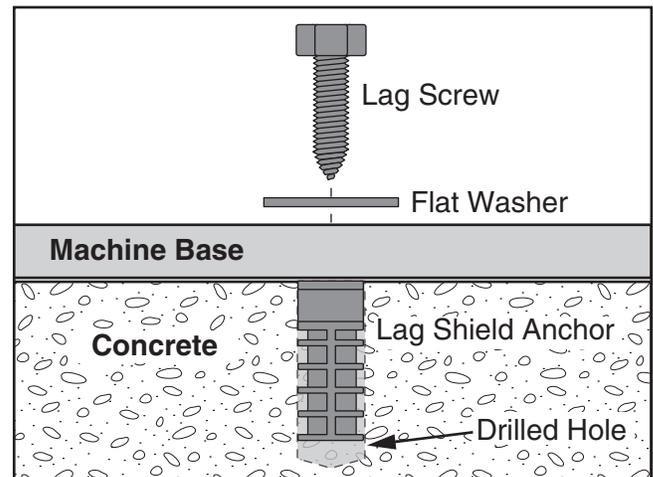


Figure 10. Popular method for anchoring machinery to a concrete floor.



Dust Collection

⚠ CAUTION

DO NOT operate the Model G0495X without an adequate dust collection system. This jointer creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 400 CFM

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

To connect the machine to a dust collector:

1. Fit a 4" dust hose that is connected to a dust collector over the dust port, as shown in **Figure 11**, and secure in place with a hose clamp.



Figure 11. Dust hose attached to dust port.

2. Tug the hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.

Digital Readout Batteries

You must install two AAA batteries in the battery compartment for the digital readout to function.

To install AAA batteries in the control panel:

1. Remove the access panel on the battery holder cover (see **Figure 12**).

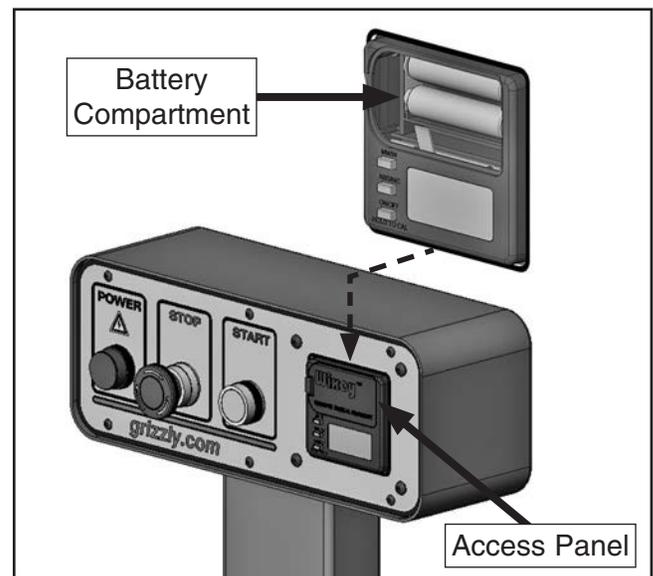


Figure 12. Location of digital readout battery compartment.

2. Install the included AAA batteries, then re-install the cover.



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.

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 the machine:

1. Clear all setup tools away from machine.
2. Connect the machine to the power source. The power light will illuminate.
—If the light does not illuminate, check the power connection.
3. Push the STOP button in, then twist it clockwise so it pops out. When the STOP button pops out, the switch is reset and ready for operation (see **Figure 13**).

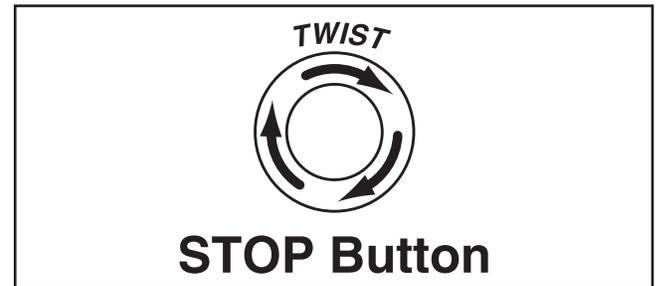


Figure 13. Resetting the STOP button.



4. Verify that the machine is operating correctly by pushing the START button.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

5. Press the STOP button to stop the machine.

6. WITHOUT resetting the switch, press the START button. The machine should not start.

—If the machine does not start, the STOP button safety feature is working correctly. The test run is complete.

—If the machine does start (with the STOP button pushed in), immediately disconnect power to the machine. The STOP button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Recommended Adjustments

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

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

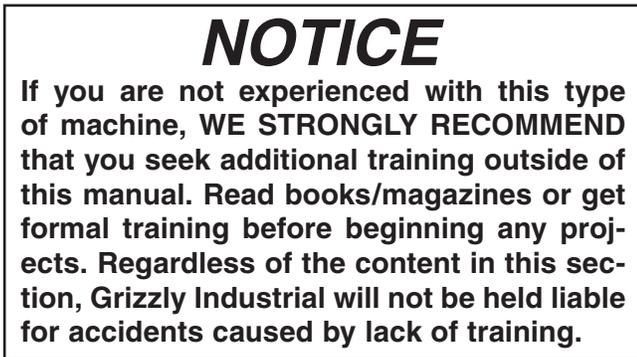
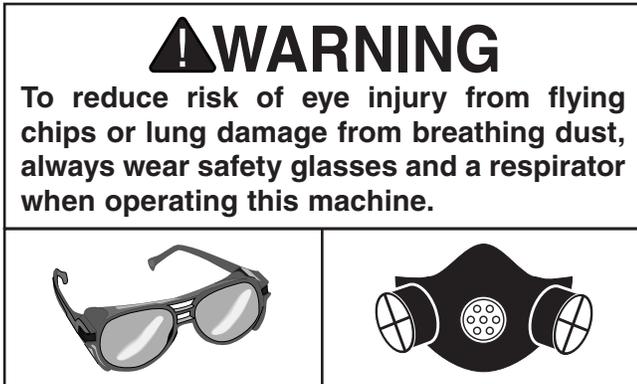
Step-by-step instructions for these adjustments can be found in **SECTION 7: SERVICE**.

Factory adjustments that should be verified:

1. Table Parallelism (**Page 35**).
2. Infeed Table Calibration (**Page 39**).
3. Outfeed Table Adjustment (**Page 40**).
4. Fence Stop Settings (**Page 42**).
5. Verify V-Belt Tension Adjustment (**Page 44**).



SECTION 4: OPERATIONS



Basic Joinder Controls

This section covers the basic controls used during routine operations.

START Button: Starts motor only if the STOP button is popped out.

STOP Button: Disables the START button. Enable the START button by twisting the STOP button until it pops out.

POWER Light: Indicates machine is correctly plugged into the power source.

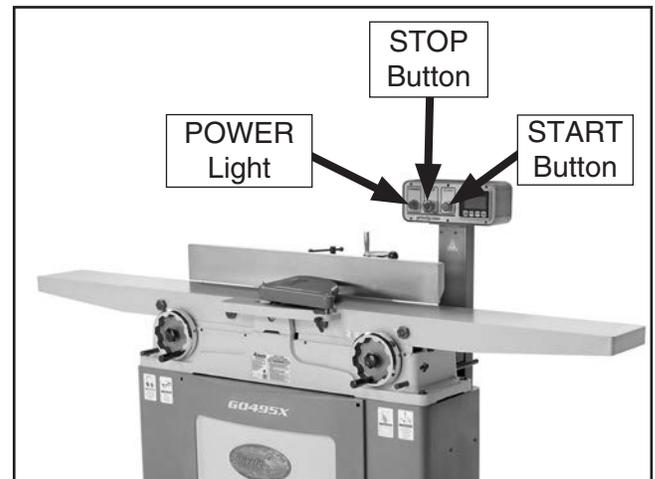


Figure 14. START/STOP button locations.



Table Movement: To move the infeed or outfeed tables, loosen the table locks (see **Figure 15**), move the tables with the infeed or outfeed handwheels (see **Figure 14**), then tighten the table locks.

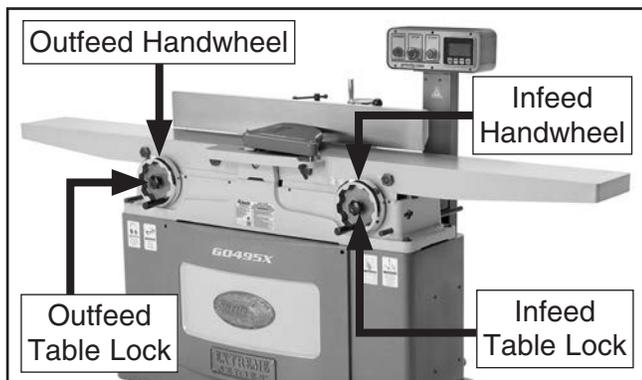


Figure 15. Table control locations.

Fence Movement: The fence has a lock that keeps it in position (see **Figure 16**). To move the fence, loosen the lock and turn the fence adjustment wheel to slide the fence where needed, then retighten the lock.

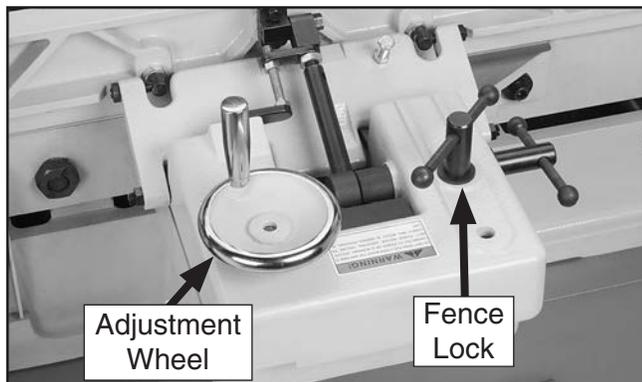


Figure 16. Fence lock location.

Fence Tilting: The tilt lock (see **Figure 17**) secures the fence at any position in the available range. The stop block locks the fence for 90° cuts. Two positive stops stop the fence at 45° inward and 45° outward for common bevel cuts. Even when the fence is resting against the positive stops, the tilt lock must be tightened before cutting. Also, the stop block must be disengaged for 45° outward bevel cuts.

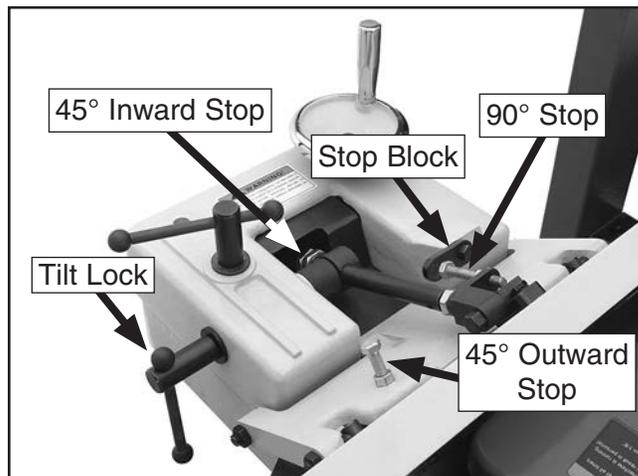


Figure 17. Tilt lock and stop block locations.

Digital Readout

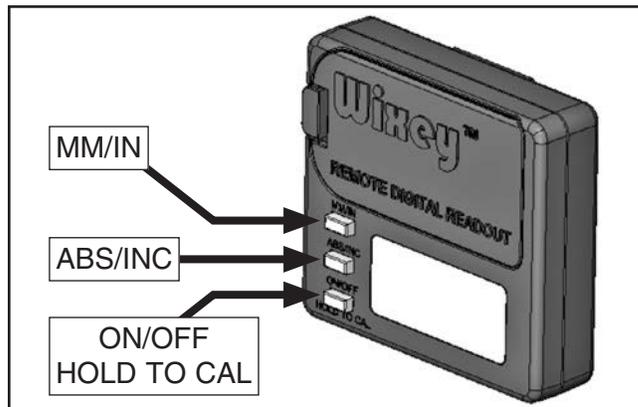


Figure 18. Digital readout.

MM/IN: Toggles between inch and metric measurements.



Stock Inspection & Requirements

ABS/INC: Toggles between absolute and incremental modes. Absolute mode shows the total depth of cut in relation to an absolute zero point. Incremental mode shows how much the table has moved up or down in relation to an arbitrarily chosen zero point. To select incremental mode, press the ABS/INC button until INC is displayed. To return to absolute mode, press the ABS/INC button again.

For example, to use absolute and incremental modes:

1. Press ABS/INC button to display ABS.
2. Press HOLD TO CAL button. This sets an absolute zero point.
3. To move infeed table down, press + and - buttons until display reads 0.125".
4. Press ABS/INC button to toggle to incremental mode, press HOLD TO CAL button to set arbitrary zero point, then move infeed table up -0.010".
5. Press ABS/INC button to toggle back to absolute mode. The screen displays 0.115", the total depth of cut relative to absolute zero point set in **Step 2**.

ON/OFF and HOLD TO CAL: Push to turn digital readout **ON** and **OFF**. Push and hold 3–5 seconds to enter calibration mode. Push to reset display to 0.000 in incremental mode. Follow **Step 2** in the previous example to reset display to 0.000 in absolute mode.

To use calibration modes:

1. Press ABS/INC button to enter absolute mode.
2. Raise or lower infeed table to desired cutting depth.
3. Press ABS/INC button to enter incremental mode.
4. Press HOLD TO CAL button to reset digital readout to 0.000.

Follow these rules when choosing and jointing stock:

- **DO NOT joint or surface plane stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.
- **DO NOT joint or surface plane against the grain direction.** Cutting against the grain increases the likelihood of kickback, as well as tear-out on the workpiece.
- **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 on the edge of the stock (see **Figure** below).

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

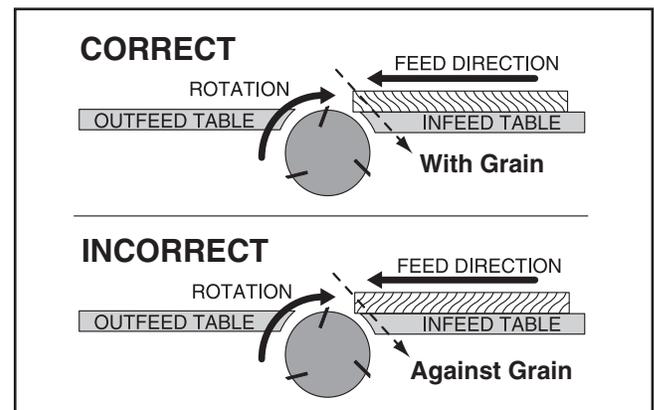


Figure 19. Proper grain alignment with the cutterhead.

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



- **Scrape all glue off the workpiece before jointing.** Glue deposits on the workpiece, hard or soft, will gum up the cutterhead and produce poor results.
 - **Remove foreign objects from the workpiece.** Make sure that any stock you process with the jointer is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects that could damage the cutterhead. These particles could also cause a spark as they strike the cutterhead and create a fire hazard.
- IMPORTANT:** Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.
- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.

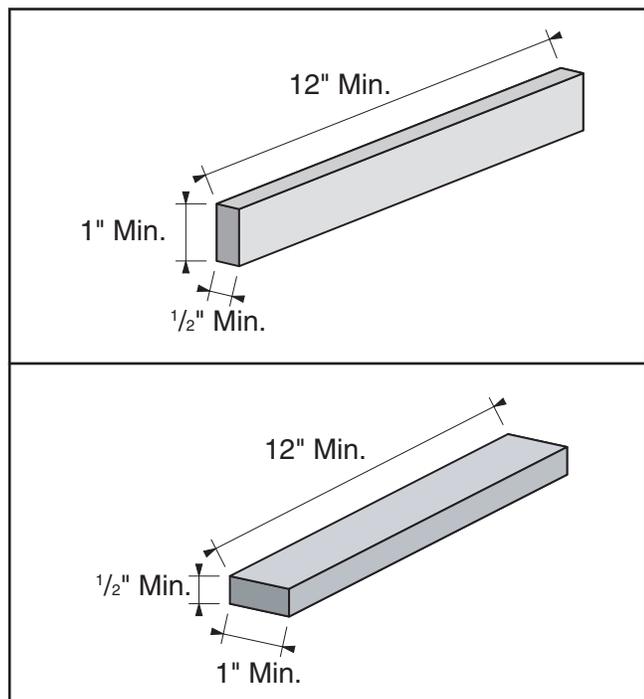


Figure 20. Minimum stock dimensions for jointer.

Squaring Stock

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

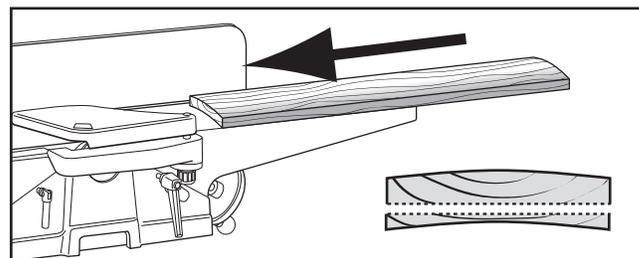
The purpose of squaring stock is to prepare it for accurate cuts and construction later on.

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

| Items Needed | Qty |
|----------------|-----|
| Jointer..... | 1 |
| Planer..... | 1 |
| Table Saw..... | 1 |

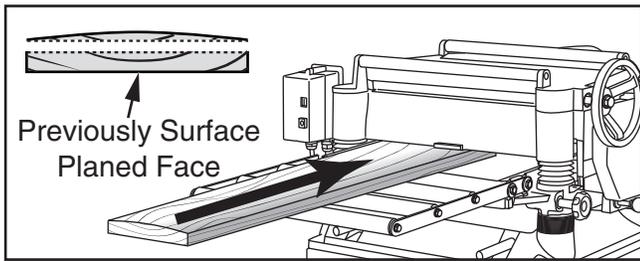
Squaring stock involves four steps performed in the order below:

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

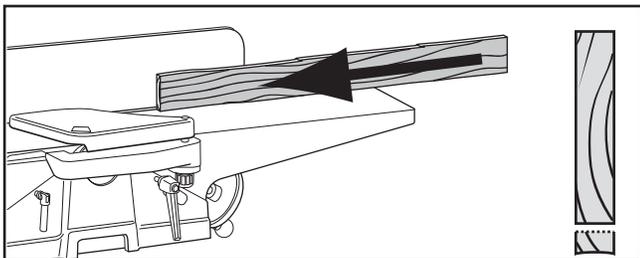


Surface Planing

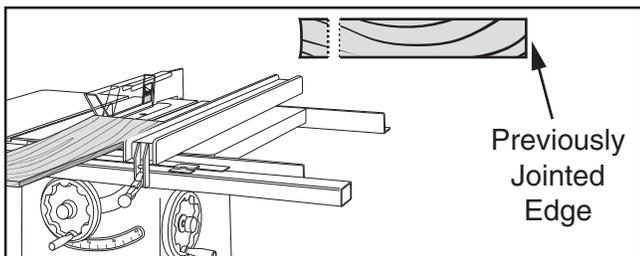
2. **Surface Plane on a Thickness Planer**—Opposite face of workpiece is surface planed flat with a thickness planer.



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



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



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

!WARNING

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

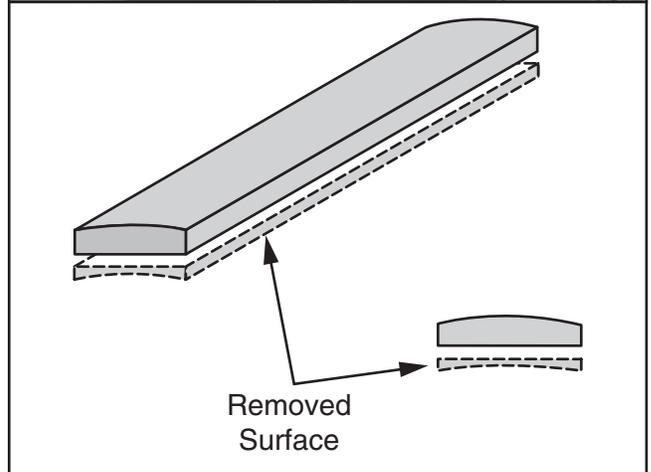


Figure 21. Example photo of a surface planing operation.



NOTICE

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

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Set infeed table height to desired cutting depth for each pass.

IMPORTANT: To minimize risk of kickback, do not exceed a cutting depth of $\frac{1}{8}$ " per pass when surface planing.

3. Set fence to 90° .
4. Start jointer.
5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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

Edge Jointing

Edge jointing (see example **Figures** below) produces a flat and true surface along the side of a workpiece by removing uneven areas. It is an essential step for squaring up warped or rough stock and when preparing a workpiece for joinery or finishing.

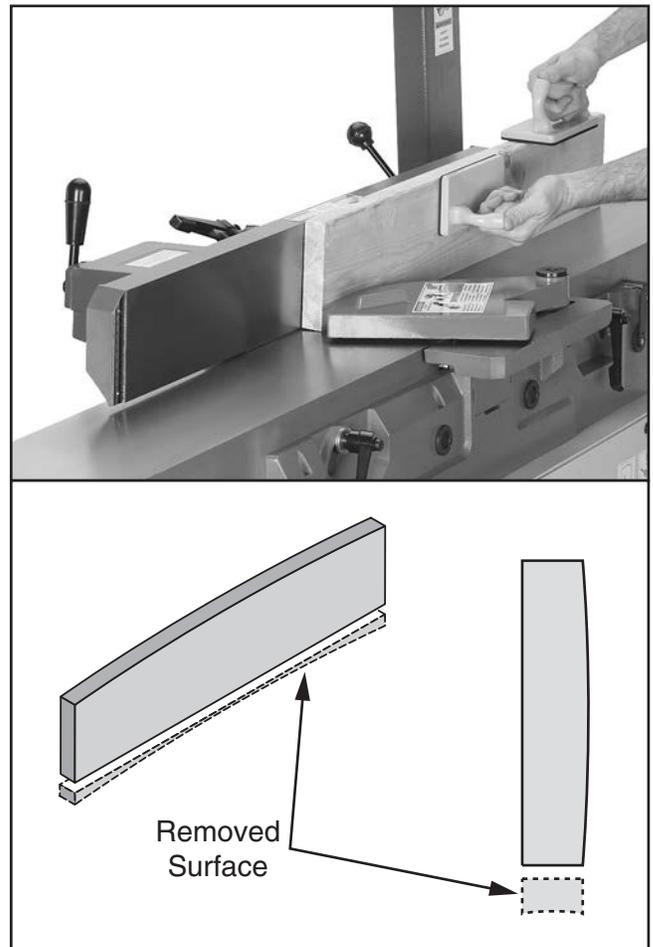


Figure 22. Example photo of an edge jointing operation.



NOTICE

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

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Surface plane workpiece (see **Surface Planing** section).
3. Set infeed table height to desired cutting depth for each pass.

▲ CAUTION: To minimize risk of kickback, do not exceed a cutting depth of 1/8" per pass.

4. Set fence to 90°.
5. Start jointer.
6. Place workpiece firmly against fence and infeed table with concave side facing down.

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

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

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

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

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

Bevel Cutting

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

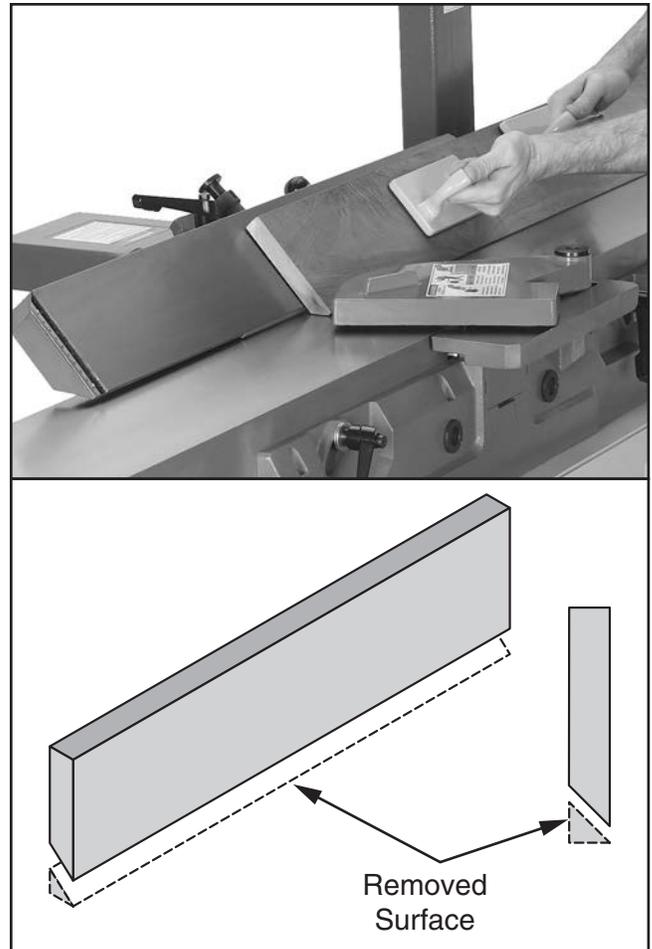


Figure 23. Example photo of fence set up for a bevel cut of 45°.



NOTICE

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

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Surface plane workpiece (see **Surface Planing** section).
3. Edge joint workpiece (see **Edge Jointing** section).
4. Set infeed table height to cutting depth desired for each pass.

⚠ CAUTION: Cutting depth for bevel cuts is typically between $\frac{1}{16}$ " and $\frac{1}{8}$ ", depending on hardness and width of stock.

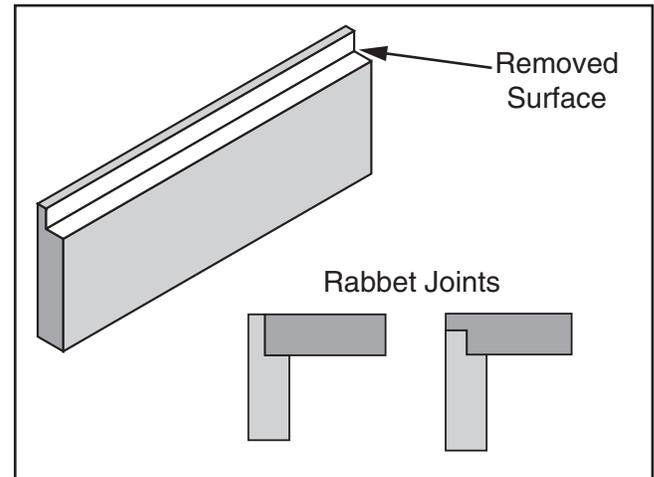
5. Set fence tilt to desired angle of cut.
6. Place workpiece against fence and infeed table with concave side face down.
7. Start jointer.
8. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

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

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

Rabbet Cutting

A rabbet cut removes a portion of a workpiece edge, so it fits together with an opposing, equally sized rabbet cut on another workpiece (see example **Figure** below). This is a classic method of joining two workpieces that is simple, yet strong.



This jointer can be used to make high-quality rabbet cuts, but there are some situations—whether it is due to an excessively large/small workpiece size or rabbet cutting width/depth—when it will not be safe or appropriate for making the rabbet cut on this jointer. In these cases, you need to use another tool or method for rabbet cutting that will be a safer alternative.

A rabbet cut can alternatively be made using a table saw, router, or even a hand saw. As with any type of cutting operation, always consider your safety first and use good judgement!

Typically, rabbet cutting with a jointer requires the cutterhead guard to be removed first, so the workpiece can slide along the rabbeting ledge during the cut. However, it is possible to make rabbet cuts with workpieces up to 1" thick without removing the cutterhead guard. This is done by performing the rabbet cut with the workpiece on end (similar to when you are edge jointing).



To rabbet cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Surface plane workpiece (see **Surface Planing** section).
3. Edge joint workpiece (see **Edge Jointing** section).
4. Set infeed table height to desired cutting depth for each pass.

▲ CAUTION: For safety reasons, cutting depth should never exceed $\frac{1}{8}$ " per pass.

5. Remove cutterhead guard if necessary to perform operation (see **Figures** below.)

6. Set fence to 90° and near front of jointer, so amount of exposed cutterhead in front of fence matches size of desired rabbet.
7. Start jointer.
8. Place workpiece firmly against fence and infeed table with concave side facing down.

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

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

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

10. Repeat **Step 7** until rabbet is cut to depth.

11. Re-install cutterhead guard if removed in **Step 3**.

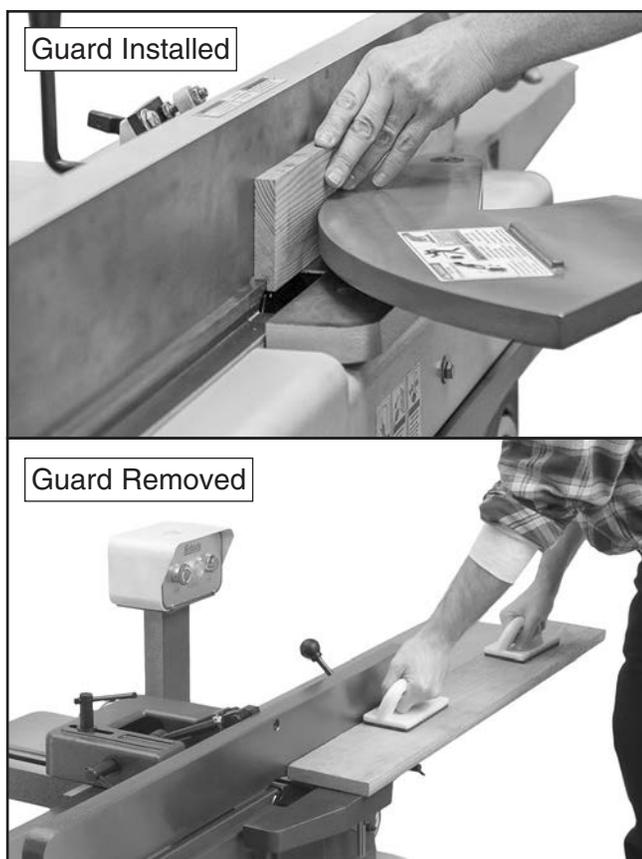


Figure 24. Examples of typical rabbet cutting operations.

▲WARNING

When cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes operator to moving cutterhead. To minimize risk of injury and unnecessary exposure to cutterhead, always keep cutterhead guard installed when possible, and **ALWAYS** immediately replace it after performing rabbet cuts.



SECTION 5: ACCESSORIES

! WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

Basic Eye Protection

- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20451—"Kirova" Clear Safety Glasses
- T20456—DAKURA Safety Glasses, Black/Clear
- T28175—R3 SAFETY Stealth Safety Glasses



Figure 25. Assortment of basic eye protection.

- D4206—Clear Flexible Hose 4" x 10'
 - D4256—45° Elbow 4"
 - D4216—Black Flexible Hose 4" x 10'
 - W1034—Heavy-Duty Clear Flex Hose 4" x 10'
 - D2107—Hose Hanger 4¼"
 - W1015—Y-Fitting 4" x 4" x 4"
 - W1017—90° Elbow 4"
 - W1019—Hose Coupler (Splice) 4"
 - W1317—Wire Hose Clamp 4"
 - W1007—Plastic Blast Gate 4"
 - W1053—Anti-Static Grounding Kit
- We've hand picked a selection of commonly used dust collection components for machines with 4" dust ports.



Figure 26. Dust collection accessories.

- H9893—10 pk. Carbide Inserts 15 x 15 x 2.5mm

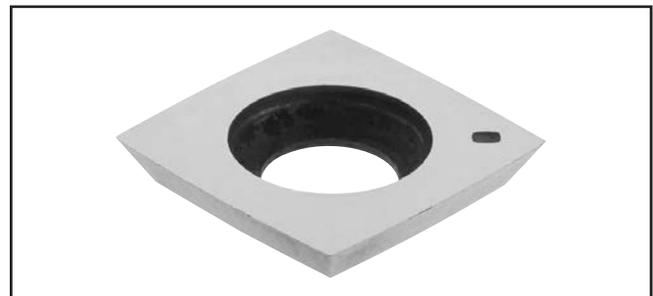


Figure 27. H9893 Replacement Carbide Inserts.

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



- H2499—Small Half-Mask Respirator**
- H3631—Medium Half-Mask Respirator**
- H3632—Large Half-Mask Respirator**
- H3635—Cartridge Filter Pair P100**

Wood dust 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 28. Half-mask respirator with disposable cartridge filters.

Recommended Metal Protectants

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



Figure 29. Recommended products for protecting unpainted cast iron/steel part on machinery.

G0862—3 HP Portable Cyclone Dust Collector

The capstone of our new line of affordable, high-quality cyclones, the G0862 features a 3 HP motor, a whopping 1941 CFM of airflow capacity, and a 45-gallon collection capacity. It's packed with features like a quick-release collection drum, latching system, high-efficiency, two-stage separation driven by a 16" aluminum impeller, durable powder coated finish, and a heavy-duty steel frame and housing.



Figure 30. Model G0862 3 HP Portable Cyclone Dust Collector.

T23246—The Missing Shop Manual: Jointer

Dedicated to providing integral information about woodworking tools and techniques that other manuals overlook, the books in this series contain safety facts, explanations about basic project set-up, and tips for maximizing tool performance.

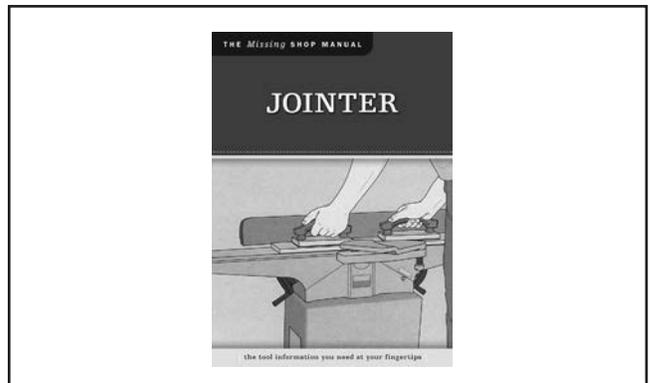


Figure 31. Instructional reference book.

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



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

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

- Loose mounting bolts.
- Dust or debris on and around machine.
- Dull or damaged cutterhead inserts.
- Unprotected cast-iron surfaces.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check

- Clean and lubricate fence pivot points.
- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside stand and off of motor.
- Replace batteries in control panel and digital sensor as needed.

Cleaning

Cleaning the Model G0495X 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. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

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 on the G0495X are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

Below is a list of components that require periodic lubrication. Be careful not to over-lubricate these components. Large amounts of lubricant will attract sawdust, causing the metal components to gum up and bind.

Fence: Place one or two drops of light machine oil on the fence pivot points (see **Figure 32**) as needed.

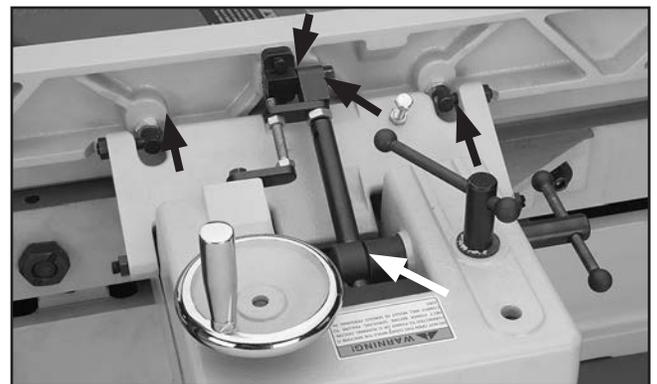


Figure 32. Fence lubrication locations.

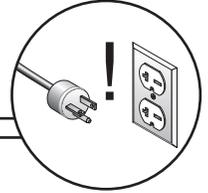
Gears: Use a small brush to apply multi-purpose grease to the worm gear shafts and gears.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

| Symptom | Possible Cause | Possible Solution |
|--|--|---|
| Machine does not start or a breaker trips. | <ol style="list-style-type: none"> Emergency stop push-button is engaged/faulty. Wiring is open/has high resistance. Motor START button or STOP switch is at fault. Fuse has blown. Power supply switched OFF or is at fault. Start capacitor is at fault. Thermal overload relay has tripped. Wall fuse/circuit breaker is blown/tripped. Contactors not getting energized/has burnt contacts. Motor is at fault. | <ol style="list-style-type: none"> Rotate clockwise slightly until it pops out/replace it. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. Replace faulty START OR STOP switch. Correct short/replace fuse on control panel. Ensure power supply is switched on; ensure power supply has the correct voltage. Test/replace if faulty. Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times. Reduce workload on machine or test and replace motor. If motor is OK, replace relay. Ensure circuit size is suitable for this machine; correct for short. Reset/replace fuse or breaker. Test for power on all legs and contactor operation. Replace unit if faulty. Test/repair/replace. |
| Machine stalls or is underpowered. | <ol style="list-style-type: none"> Feed rate/cutting speed too fast for task. Workpiece material is not suitable for this machine. Belt slipping. Motor connection is wired incorrectly. Motor bearings are at fault. Contactors not getting energized or has poor contacts. Motor has overheated. Motor is at fault. | <ol style="list-style-type: none"> Decrease feed rate/cutting speed. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece. Replace bad belt, align pulleys, and re-tension. Correct motor wiring connections. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. Test for power on all legs and contactor operation. Replace if faulty. Clean off motor, let cool, and reduce workload. Test/repair/replace. |
| Machine has vibration or noisy operation. | <ol style="list-style-type: none"> Motor or component is loose. Inserts are at fault. V-belt worn or loose. Pulley is loose. Motor mount loose/broken. | <ol style="list-style-type: none"> Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. Rotate or replace inserts causing problem. Inspect/replace belt with a new one (refer to Page 44). Realign/replace shaft, pulley, setscrew, and key as required. Tighten/replace. |



Motor & Electrical Cont.

| Symptom | Possible Cause | Possible Solution |
|---|---|---|
| Machine has vibration or noisy operation. | <ol style="list-style-type: none"> 6. Machine is incorrectly mounted or sits unevenly. 7. Motor fan is rubbing on fan cover. 8. Motor bearings are at fault. 9. Cutterhead bearings at fault. | <ol style="list-style-type: none"> 6. Tighten/replace anchor studs in floor; relocate/shim machine. 7. Replace dented fan cover; replace loose/damaged fan. 8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 9. Replace bearing(s)/re-align cutterhead. |

Machine Operation

| | | |
|--|--|---|
| Tables are hard to adjust. | <ol style="list-style-type: none"> 1. Table lock is engaged or partially engaged. 2. Table stops blocking movement. | <ol style="list-style-type: none"> 1. Completely loosen the table lock. 2. Loosen/reset table positive stops. |
| Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut). | <ol style="list-style-type: none"> 1. Outfeed table is set too low. 2. Operator pushing down on end of workpiece. | <ol style="list-style-type: none"> 1. Align outfeed table with cutterhead insert at top dead center (Page 40). 2. Reduce/eliminate downward pressure on that end of workpiece. |
| Workpiece stops in the middle of the cut. | <ol style="list-style-type: none"> 1. Outfeed table is set too high. | <ol style="list-style-type: none"> 1. Align outfeed table with cutterhead insert at top dead center (Page 40). |
| Chipping. | <ol style="list-style-type: none"> 1. Knots or conflicting grain direction in wood. 2. Nicked or chipped insert. 3. Feeding workpiece too fast. 4. Taking too deep of a cut. | <ol style="list-style-type: none"> 1. Inspect workpiece for knots and grain (Page 26); only use clean stock. 2. Rotate insert to expose sharp edge; replace insert (Page 38). 3. Slow down the feed rate. 4. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.) |
| Fuzzy Grain. | <ol style="list-style-type: none"> 1. Wood may have high moisture content or surface wetness. 2. Dull inserts. | <ol style="list-style-type: none"> 1. Check moisture content and allow to dry if moisture is too high. 2. Replace inserts (Page 38). |
| Long lines or ridges that run along the length of the board | <ol style="list-style-type: none"> 1. Nicked or chipped insert. | <ol style="list-style-type: none"> 1. Rotate insert to expose sharp edge; replace insert (Page 38). |
| Uneven insert marks, wavy surface, chatter marks across board face. | <ol style="list-style-type: none"> 1. Feeding workpiece too fast. | <ol style="list-style-type: none"> 1. Slow down the feed rate. |
| Board edge is concave or convex after jointing. | <ol style="list-style-type: none"> 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. | <ol style="list-style-type: none"> 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 the starting condition of the board and the depth of cut. |



Checking/Adjusting Table Parallelism

If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback can occur.

| Tools Needed | Qty |
|-------------------------------|-----|
| Straightedge | 1 |
| Wrench or Socket 12mm | 1 |
| Wrench or Socket 32mm..... | 1 |
| Adjustable Wrench 10" | 1 |
| Hex Wrench 4mm..... | 1 |
| Duct Tape | 1 |
| Electrical Parts Cleaner..... | 1 |

Checking Outfeed Table

1. DISCONNECT JOINTER FROM POWER!
2. Put on leather gloves.
3. Remove the cutterhead guard and the fence.
4. Loosen the outfeed table lock located at the front of the machine, then loosen the jam nuts and positive stop bolts located under the outfeed table (see **Figure 33**).

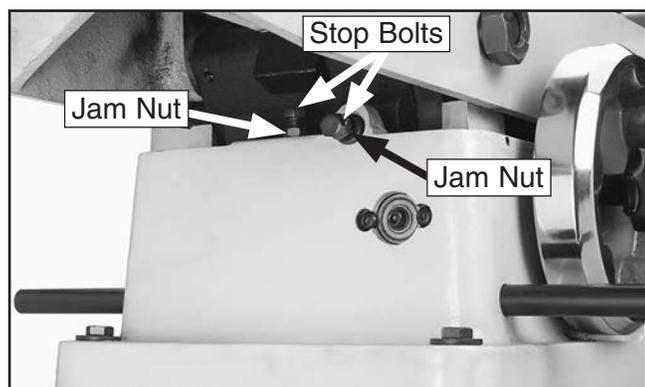


Figure 33. Outfeed table positive stop bolts.

5. Place the straightedge on the outfeed table so it hangs over the cutterhead, then lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 34** (rotate the cutterhead if necessary).

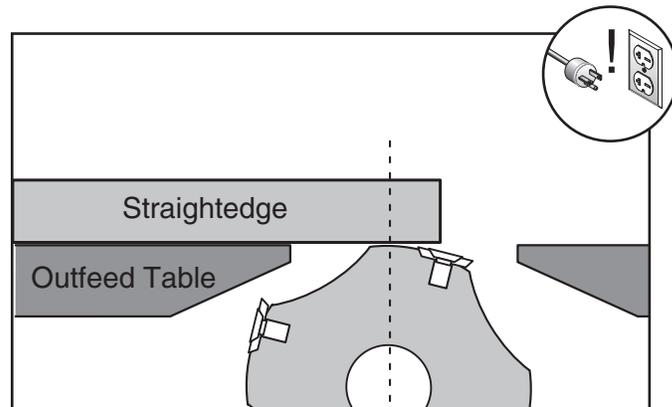


Figure 34. Adjusting outfeed table even with cutterhead body.

6. Place the straightedge in the positions shown in **Figure 35**. In each position, the straightedge should touch the cutterhead body and sit flat on the outfeed table.

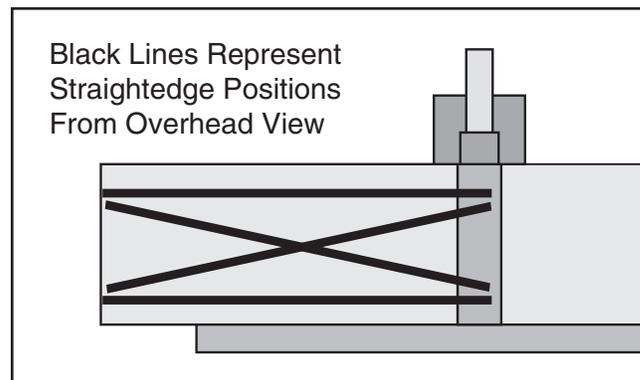


Figure 35. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

—If the straightedge touches the cutterhead and sits flat across the outfeed table in each position, then the outfeed table is already parallel with the cutterhead. Check the infeed table to make sure that it is parallel with the outfeed table.

—If the straightedge does not touch the cutterhead and sit flat on the outfeed table in any of the positions, then the outfeed table is not parallel with the cutterhead. Correct the outfeed table parallelism, then correct the infeed table parallelism.



Checking Infeed Table

1. Follow all the steps for checking the outfeed table parallelism to first make sure that the outfeed table is parallel with the cutterhead.
2. Raise the outfeed table higher than the cutterhead.
3. Loosen the infeed table jam nuts and positive stop bolts shown in **Figure 36**.

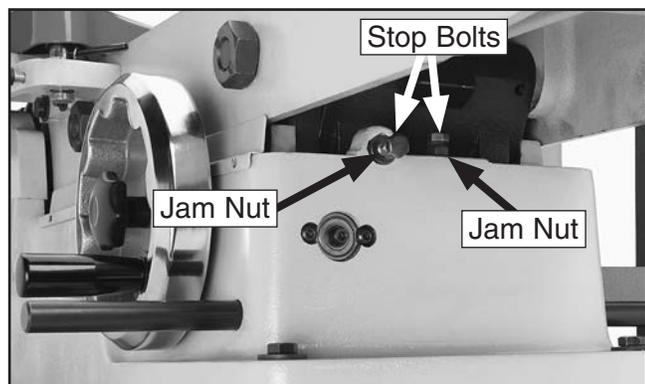


Figure 36. Infeed table positive stop bolts.

4. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 37**.

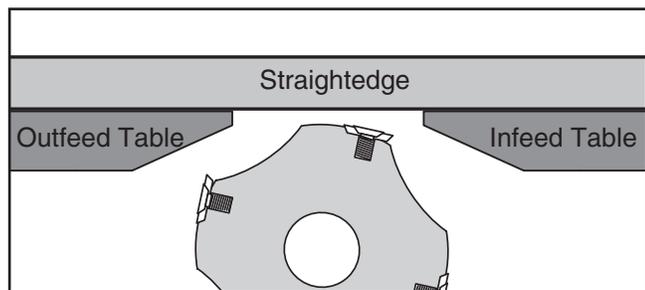


Figure 37. Infeed and outfeed tables set evenly.

5. Place the straightedge in the positions shown in **Figure 38**. In each position, the straightedge should sit flat against both the outfeed table and the infeed table.

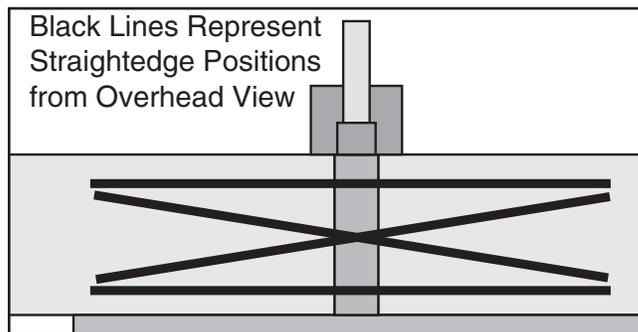


Figure 38. Straightedge positions for checking infeed/outfeed table parallelism.

—If the straightedge sits flat against both the infeed and outfeed table in each of the positions, then the tables are parallel. Set both table heights (**Pages 39 & 40**) and replace the cutterhead guard.

—If the straightedge does not sit flat against both the infeed and outfeed table in any of the positions, then follow the **Adjusting Table Parallelism** instructions.

Adjusting Table Parallelism

For safe and proper cutting results, the tables must be parallel to the cutterhead. Adjusting them to be parallel is a task of precision and patience, and may take up to one hour to complete. Luckily, this is considered a permanent adjustment and should not need to be repeated for the life of the machine.

Due to the complex nature of this task, we recommend that you double check the current table positions to make sure that they really need to be adjusted before starting.

The tables have four eccentric bushings under each corner that allow the tables to be adjusted parallel. These eccentric bushings are locked in place by set screws and adjust when rotated.

The correct order for adjusting the table parallelism is to first adjust the outfeed table parallel with the cutterhead to within 0.010"-0.012", then adjust the infeed table parallel with the outfeed table.

When setting the outfeed table, all measurements must be made from the cutterhead body—not the inserts.



IMPORTANT: The steps below are intended to be performed in succession with the steps involved in checking the outfeed table. Do not continue until you have followed those steps.

To adjust the table parallelism:

1. Place the straightedge on the outfeed table so it hangs over the cutterhead, then lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 34** (rotate the cutterhead if necessary).
2. Remove the screw cover (see **Figure 39**) covering each set screw on the outfeed table.

Note: It may help to clean the screw covers with electrical parts cleaner. Push duct tape firmly against the cover, then pull straight up.

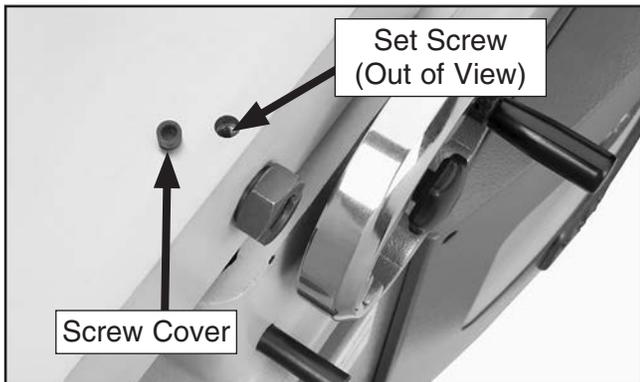


Figure 39. Screw cover and set screw location.

3. Loosen each set screw (see **Figure 39**) two turns.
4. Place the straightedge in one of the positions shown in **Figure 35**, and adjust the table by turning the eccentric bushings (**Figures 40 & 41**) as needed with an adjustable wrench so that the straightedge touches the cutterhead while lying flat across the outfeed table. Repeat this step with each of the remaining straightedge positions as many times as necessary until the outfeed table is parallel with the cutterhead to within 0.010"-0.012".

Note: Setting the outfeed table parallel to the cutterhead within 0.010"-0.012" will produce high quality results. Going lower than this number will produce minimal gain.

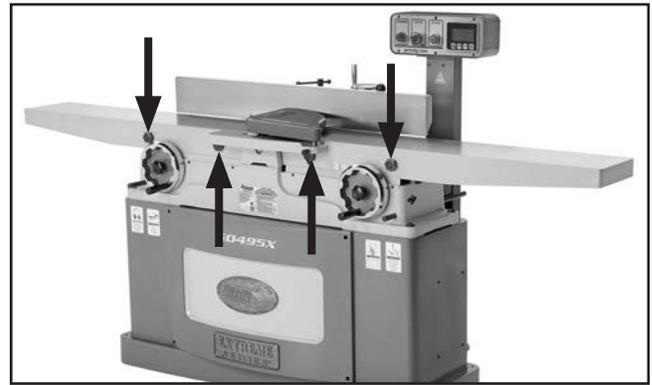


Figure 40. Front eccentric bushings.

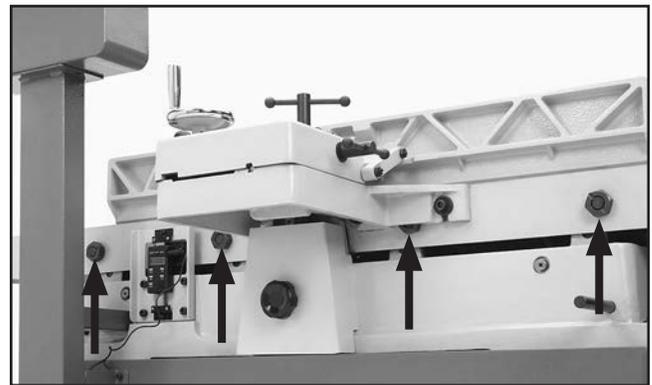


Figure 41. Rear eccentric bushings.

5. Tighten the set screws and replace the screw covers on the outfeed table.
6. Remove each of the four screw covers on the infeed table, and loosen the set screws underneath.
7. Place the straightedge halfway across the infeed table and halfway over the outfeed table, then adjust the infeed table even with the outfeed table, as shown in **Figure 37**.

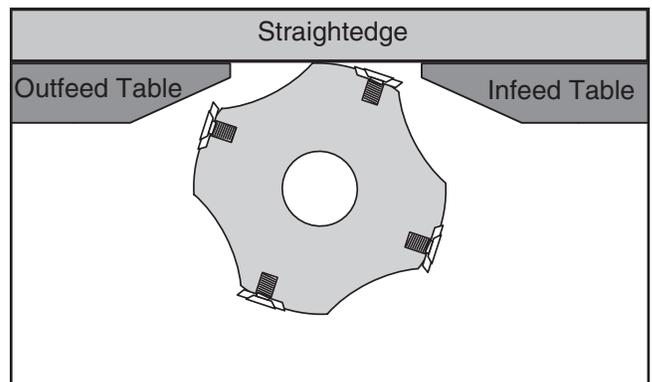


Figure 42. Infeed and outfeed tables adjusted even.



8. Place the straightedge in one of the positions shown in **Figure 38**, and adjust the eccentric bushings under the infeed table so the straightedge lies flat against both tables. Repeat this step with each of the remaining straightedge positions as many times as necessary until the infeed table is parallel with the outfeed table.
9. Tighten the set screws and replace the covers on the infeed table.
10. Set the outfeed table height (refer to **Setting Outfeed Table** on **Page 40**).
11. Re-install the cutterhead guard and fence.

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

To rotate or change a carbide insert:

1. DISCONNECT JOINTER FROM POWER!
2. Remove any sawdust from the head of the carbide insert Torx screw.
3. Remove the Torx screw and carbide insert.
4. Clean all dust and dirt off the insert and the cutterhead pocket from which the insert was removed, and replace the insert so a fresh, sharp edge is facing outward.

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

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

Note: *Excess oil may squeeze between the insert and cutterhead or in the screw hole, thereby lifting the insert or screw slightly and affecting workpiece finishes.*

Replacing Carbide Inserts

| | |
|---------------------------------------|------------|
| Tools Needed: | Qty |
| T-Handle Wrench w/T-25 Torx Bit | 1 |

The cutterhead is equipped with 36 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge (see **Figure 43**).

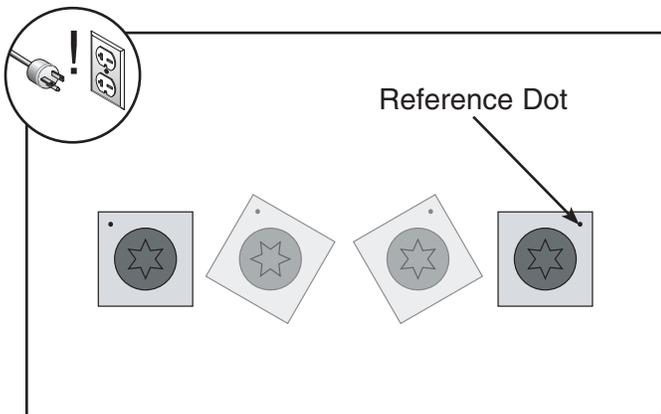


Figure 43. Insert rotating sequence.



Setting Infeed Table

The infeed table on the Model G0495X has positive stop bolts that, when properly set up, allow the operator to quickly adjust the infeed table between finish/final cuts and shaping/heavy cuts.

We recommend setting the minimum depth of cut to $\frac{1}{32}$ " and the maximum depth of cut to $\frac{1}{8}$ " for most operations. **DO NOT exceed $\frac{1}{8}$ " cut per pass on this machine or the risk of kickback and serious injury will be greatly increased!**

Each positive stop bolt (**Figure 44**) controls the top or bottom range of the table movement. The jam nuts lock the positive stop bolts in position so they won't move during operation.

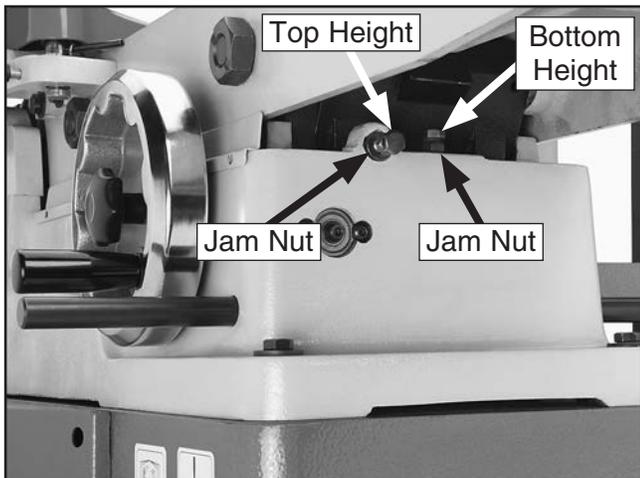


Figure 44. Infeed table positive stop bolts.

Calibrating Infeed Table

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

| Tools Needed | Qty |
|--------------------|-----|
| Straightedge | 1 |
| Wrench 12mm | 1 |

To calibrate the depth scale:

1. Set the outfeed table height as described in **Setting Outfeed Table Height** on **Page 40**.
2. Move the cutterhead guard out of the way.
3. Place a straightedge across the infeed and outfeed tables.
4. Adjust the infeed table until it is level with the outfeed table, as illustrated in **Figure 45**.

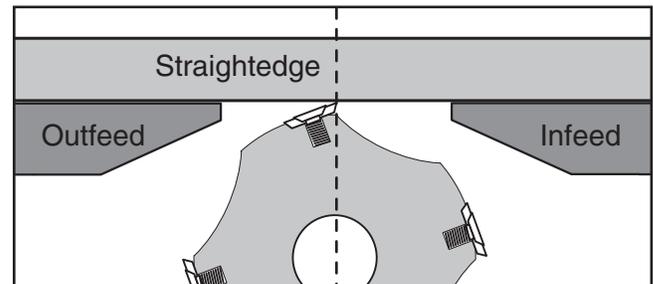


Figure 45. Infeed table adjusted even with outfeed table.



Setting Outfeed Table Height

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

To set the outfeed table height:

1. DISCONNECT JOINTER FROM POWER!
2. Move the cutterhead guard out of the way or remove it, and remove the V-belt guard.
3. Place a straightedge on the outfeed table so it extends over the cutterhead and rotate the cutterhead pulley until one of the carbide inserts is at top-dead-center (TDC), as shown in **Figure 46**.

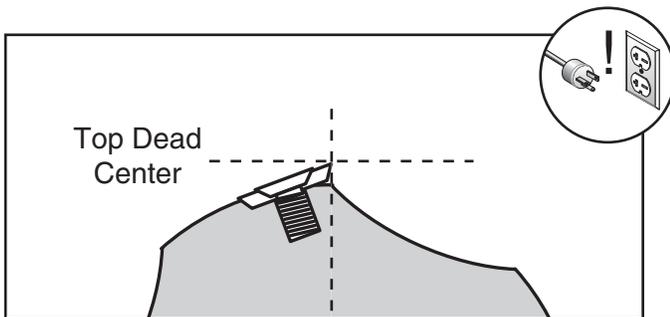


Figure 46. Cutterhead insert at top-dead-center.

4. When correctly set, the carbide insert will just touch the straightedge when the insert is at its highest point of rotation (see **Figure 47**).

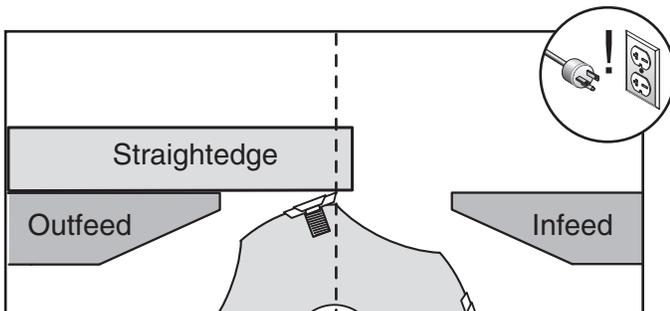


Figure 47. Using a straightedge to align outfeed table height with insert at TDC.

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

—If the insert lifts the straightedge off the table or the table is below the straightedge, loosen the outfeed table lock and outfeed table positive stop bolts and jam nuts (see **Figure 1, Page 3**) and adjust the outfeed table height with the handwheel until the straightedge just touches a insert at its highest point of rotation.

Tip: Some advanced woodworkers have found that they can virtually eliminate snipe by setting the outfeed table in the following manner: Repeat **Steps 1-4** using a freshly exposed insert. Then lower the outfeed table slightly so the insert lifts the straightedge off the table. Place a ruler next to the straightedge and rotate the cutterhead, watching how far the carbide insert pulls the straightedge. Adjust the outfeed table and recheck until the straightedge only moves $\frac{5}{32}$ ".

5. Lock the outfeed table, lock the outfeed table positive stop bolts, and re-install the cutterhead guard and V-belt guards.
6. Verify proper operation of cutterhead guard (refer to **Checking/Adjusting Cutterhead Guard** on **Page 41** for instructions).

!WARNING

The cutterhead guard is a critical safety feature of this jointer. You **MUST** verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.



Checking/Adjusting Cutterhead Guard

WARNING

The cutterhead guard is a critical safety feature of this jointer. You **MUST** install and verify its operation before using the jointer! Failure to properly install this guard will greatly increase the risk of serious personal injury.

The cutterhead guard is designed to reduce the risk of accidental contact with hands or fingers with the spinning cutterhead. When properly installed and functioning correctly, the guard automatically rotates clear of the cutterhead during the cutting operation and then springs back over the cutterhead as soon as the operation is complete.

In order to function as intended, the guard must be installed as low as possible over the infeed table without actually touching it (approximately $\frac{1}{16}$ " above infeed table), and it must have enough spring tension at the mounting shaft to quickly reposition itself against the fence after it is rotated away from the cutterhead and released. Before performing rabbeting operations, adjust guard height to just clear outfeed table.

To check/adjust cutterhead guard for proper operation:

1. DISCONNECT MACHINE FROM POWER!
2. Set fence to 90° and move it all the way back, then pull cutterhead guard (see **Figure 48**) and let it go.
 - If cutterhead guard *springs* back over cutterhead, *contacts* fence, and *does not drag* across infeed table, then it is properly adjusted.
 - If cutterhead guard *does not spring* back over cutterhead, *does not contact* fence, or *drags* across infeed table, then proceed to **Step 3**.
3. Loosen shaft lock (see **Figure 48**). Move guard so it is resting against fence, and $\frac{1}{16}$ " above infeed table.

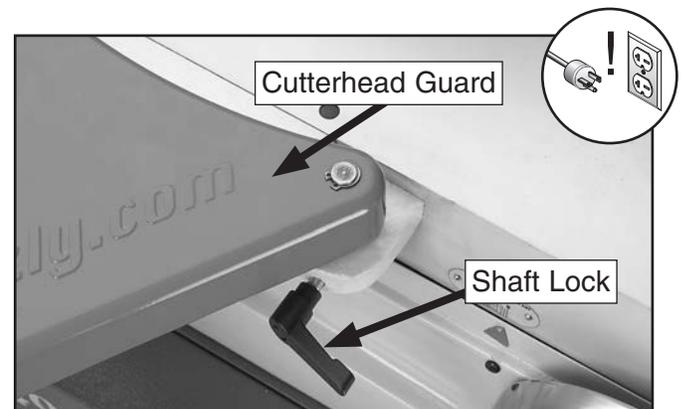


Figure 48. Cutterhead guard components.

4. Holding guard height in place, tighten shaft lock to secure setting.
5. Repeat **Step 2** and, if necessary, repeat **Steps 3–4** until cutterhead guard is properly adjusted.



Setting Fence Stops

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

| Tools Needed | Qty |
|----------------------------|-----|
| 45° Square | 1 |
| 90° Square | 1 |
| Sliding Bevel..... | 1 |
| Wrench 12mm | 1 |
| Wrench 24mm | 1 |
| Phillips Screwdriver | 1 |

To set the 45° inward fence stop:

1. Remove the fence assembly from the jointer, remove the Phillips head screws from the plate shown in **Figure 49** under the fence carriage. The plate must be removed to access the adjustment nuts.

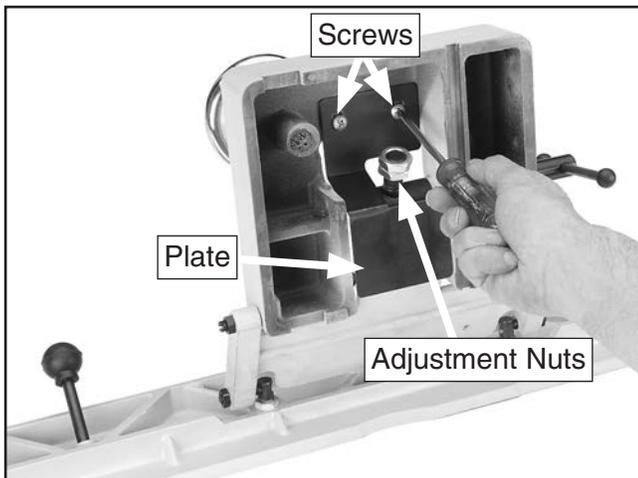


Figure 49. Removing plate to access inward fence stop.

2. Re-install the fence assembly on the jointer.

3. Using a 45° square, adjust the fence to the 45° inward position, as shown in **Figure 50**.

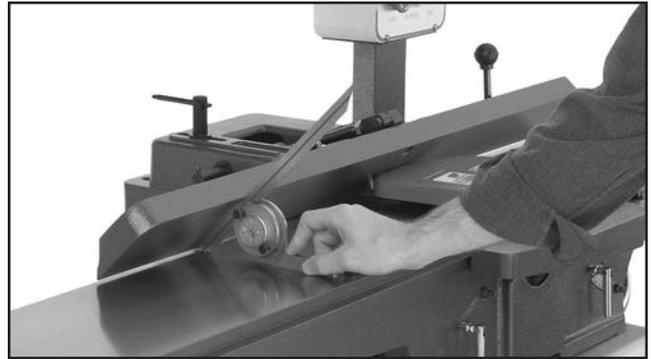


Figure 50. Example of adjusting fence 45° inward.

4. Loosen the jam nut shown in **Figure 51**.

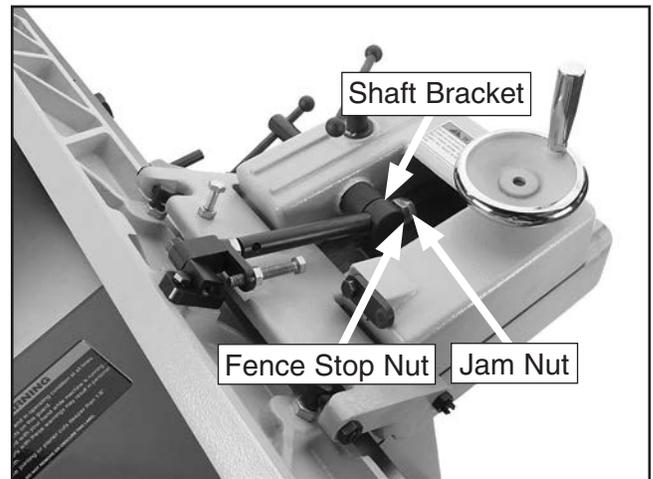


Figure 51. 45° inward fence stop jam nut.

5. Adjust the 45° inward fence stop nut until it makes contact with the back of the shaft bracket.
6. Retighten the jam nut loosened in **Step 4**.
7. Remove the fence assembly, re-install the plate with the screws removed in **Step 1**, then re-install the fence assembly.



To set the 90° fence stop:

1. Using a 90° square, adjust the fence to the 90° position, as shown in **Figure 52**.



Figure 52. Adjusting fence to 90°.

2. Flip the 90° stop block into the position shown in **Figure 53**.

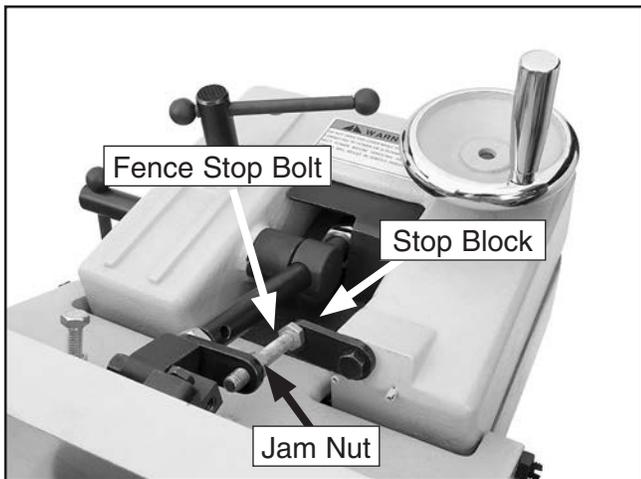


Figure 53. 90° stop block engaged.

3. Loosen the jam nut on the 90° fence stop bolt (see **Figure 53**).
4. Adjust the 90° fence stop bolt until it makes contact with the 90° stop block.
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 54**.



Figure 54. Adjusting fence 45° outward.

2. Loosen the jam nut on the 45° outward fence stop bolt (see **Figure 55**).

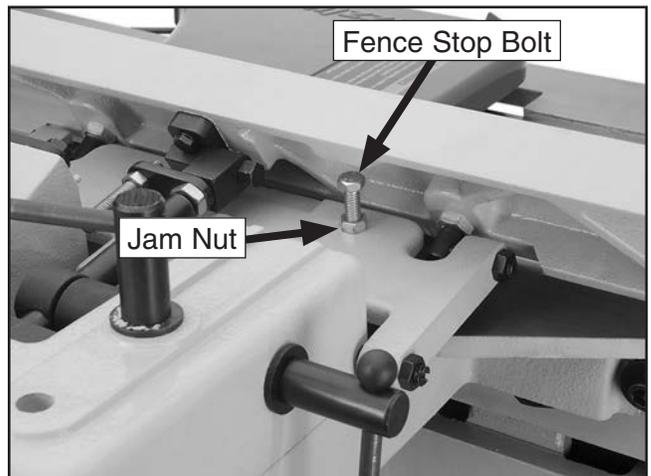


Figure 55. 45° outward fence stop jam nut.

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/Replacing V-Belt

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

To adjust/replace the V-belt:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the rear access panel and V-belt guard.
3. Using a 17mm wrench, loosen the fasteners on the tension rod shown in **Figure 56**.

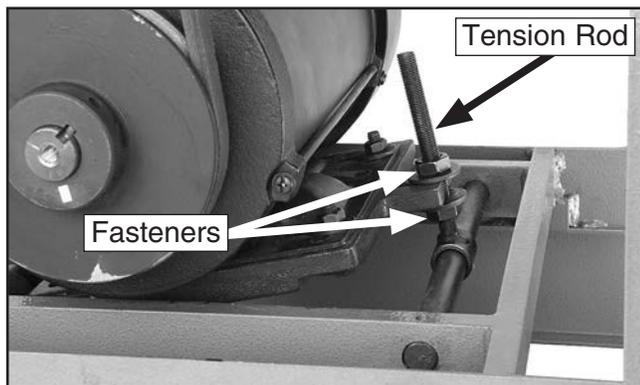


Figure 56. Fasteners needed to be loosened for V-belt replacement.

4. Lift the motor up, slide the V-belt off of the motor and cutterhead pulleys, and replace it with a new one.
5. Lower the motor and adjust the V-belt tension with the tension rod fasteners so there is approximately $\frac{1}{2}$ " deflection when the belt is pushed with moderate pressure, as shown in **Figure 57**.

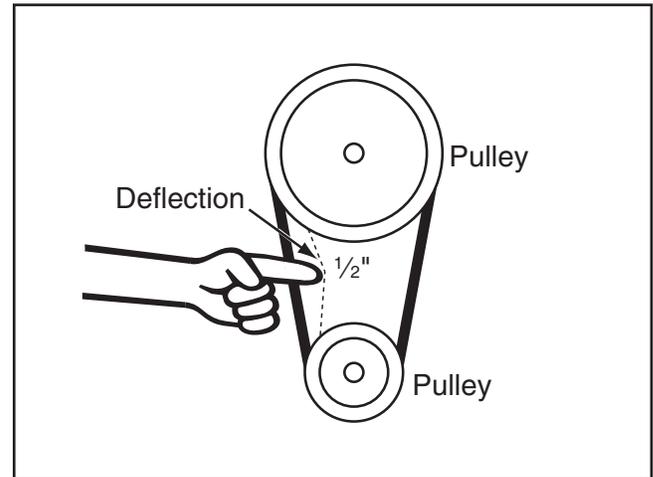


Figure 57. Checking V-belt tension.

6. Replace the rear access panel and the V-belt guard.



Pulley Alignment

Pulley alignment is another important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplaner) for optimum performance.

Each pulley can be adjusted by loosening the motor mount fasteners, sliding the motor in or out, and retightening the fasteners to lock the motor pulley in place.

Tools Needed: Qty
Wrench or Socket 17mm 1

To align the pulleys:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the rear access cover, V-belt guard and the fence assembly.
3. Place a straightedge against both pulleys (see **Figure 58**) and check to make sure that they are aligned and that the V-belt is straight up and down (see **Figure 59**).

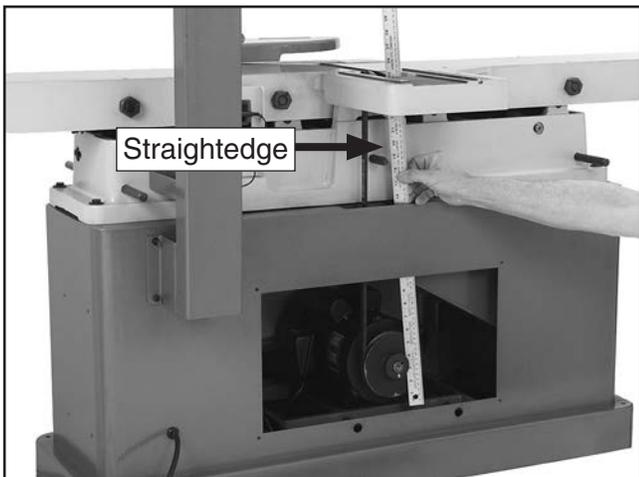


Figure 58. Checking belt alignment.

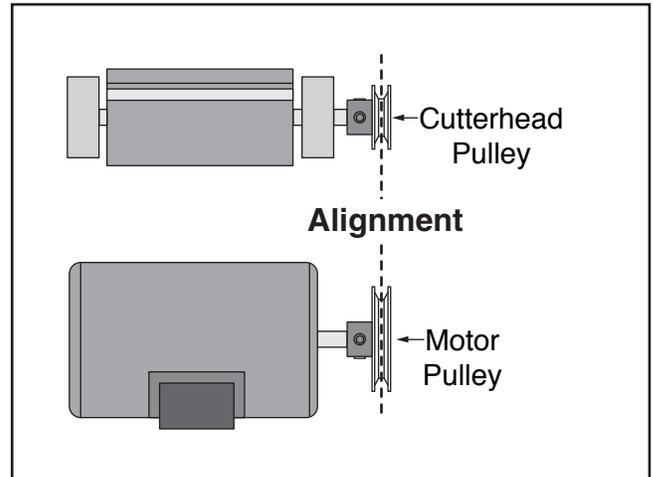


Figure 59. Pulleys aligned.

- If the pulleys are aligned, go to **Step 8**.
- If the pulleys are NOT aligned, perform **Steps 4–8**.

4. Loosen the motor mount fasteners shown in **Figure 60**.

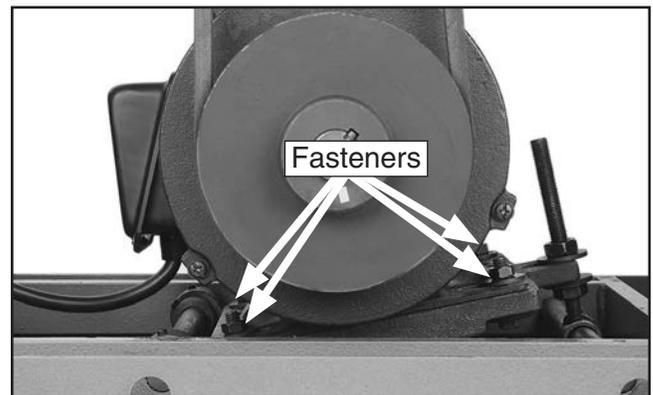


Figure 60. Motor mount fasteners.

5. Shift the motor horizontally as needed to align the motor pulley with the cutterhead pulley.
6. Tighten the motor mount fasteners. The V-belt should be parallel and aligned as shown in **Figure 59**.
7. Re-install the fence assembly, rear access panel, and V-belt guard.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

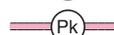
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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.

COLOR KEY

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



Electrical Components



Figure 61. Magnetic switch wiring.



Figure 62. Capacitor wiring.

Wiring Diagram

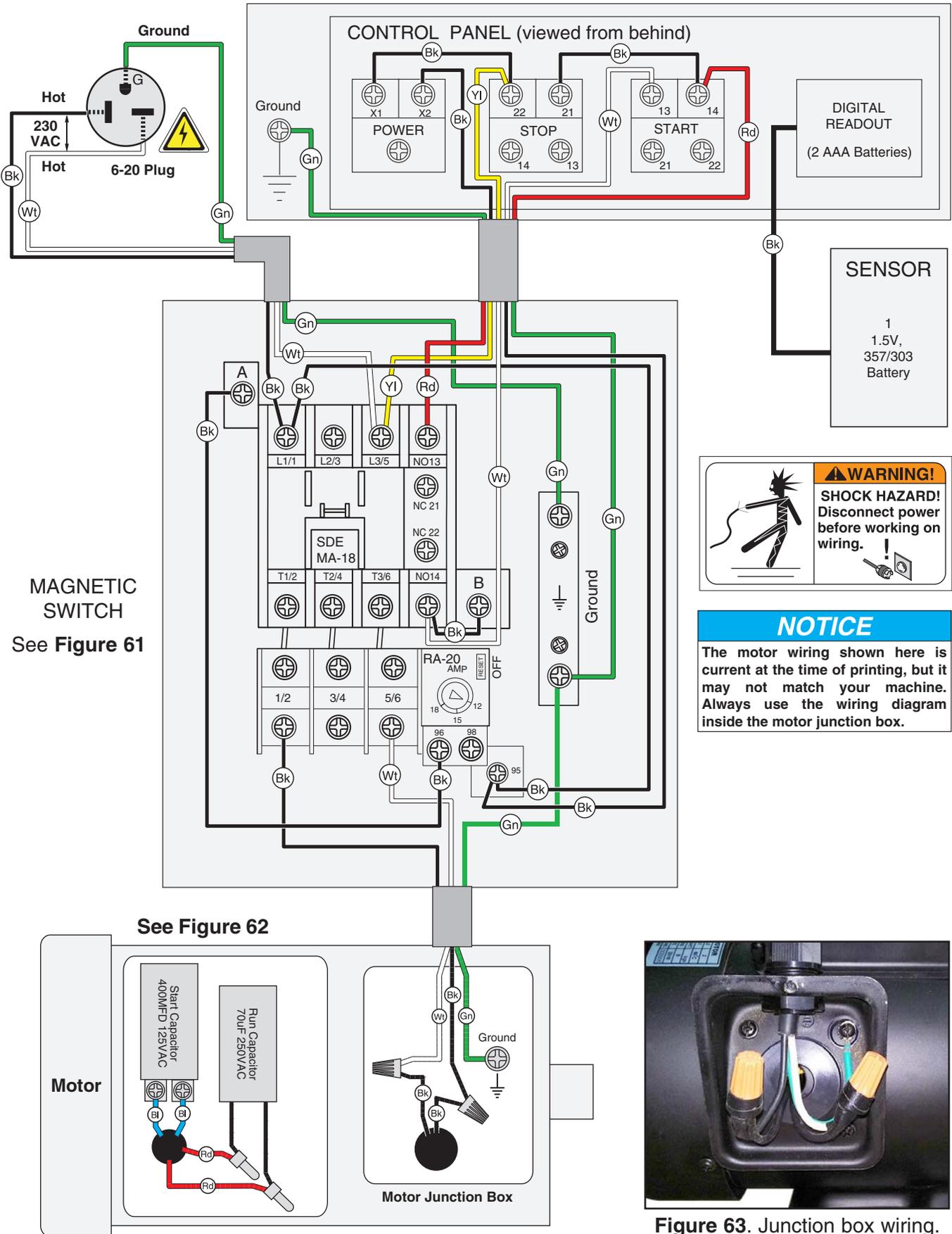


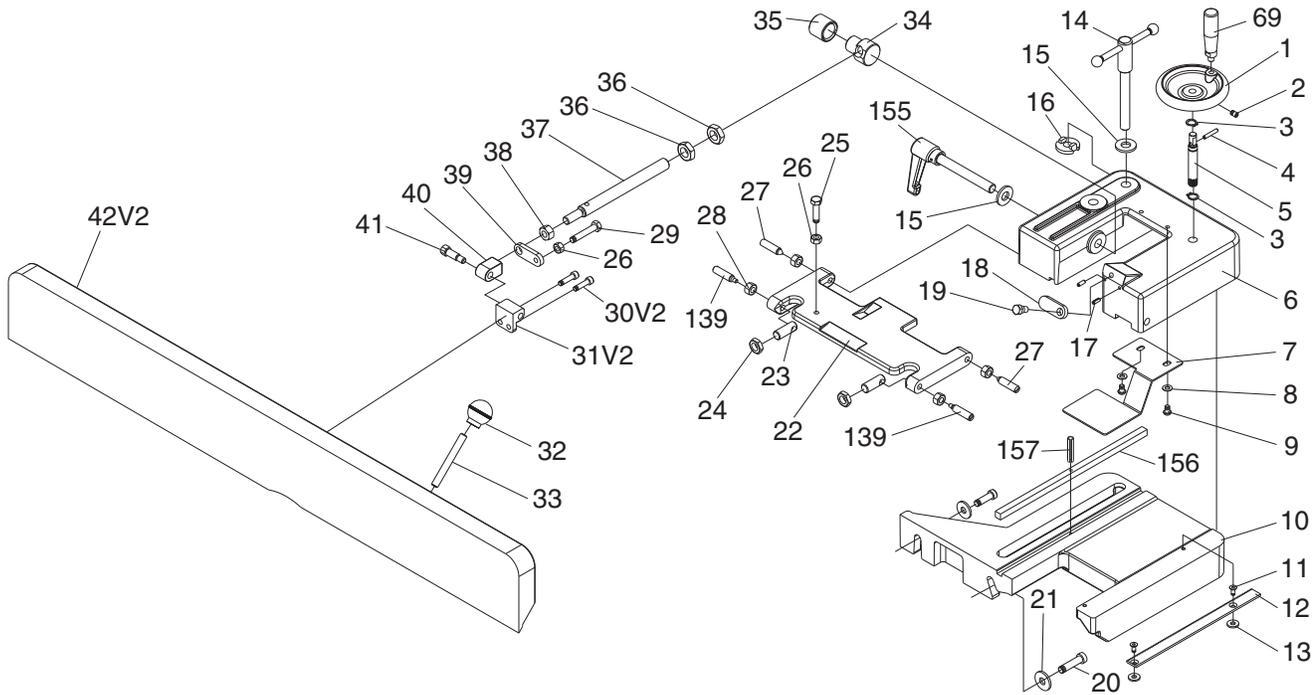
Figure 63. Junction box wiring.



SECTION 9: 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.

Fence



| REF | PART # | DESCRIPTION |
|-----|-----------|----------------------------|
| 1 | P0495X001 | HANDWHEEL |
| 2 | P0495X002 | SET SCREW 1/4-20 X 3/8 |
| 3 | P0495X003 | EXT RETAINING RING 15MM |
| 4 | P0495X004 | ROLL PIN 4 X 25 |
| 5 | P0495X005 | GEAR SHAFT |
| 6 | P0495X006 | FENCE BRACKET |
| 7 | P0495X007 | PLATE |
| 8 | P0495X008 | FLAT WASHER 6MM |
| 9 | P0495X009 | CAP SCREW 1/4-20 X 3/8 |
| 10 | P0495X010 | TABLE BRACKET |
| 11 | P0495X011 | FLAT HD SCR M5-.8 X 12 |
| 12 | P0495X012 | BAR |
| 13 | P0495X013 | FLAT WASHER 6MM |
| 14 | P0495X014 | LOCKING HANDLE ASSEMBLY |
| 15 | P0495X015 | FENDER WASHER 13MM |
| 16 | P0495X016 | FENCE LOCK NUT |
| 17 | P0495X017 | ROLL PIN 4 X 12 |
| 18 | P0495X018 | STOP BLOCK |
| 19 | P0495X019 | SPECIAL BOLT 5/16-18 X 3/8 |
| 20 | P0495X020 | CAP SCREW 3/8-16 X 1-1/4 |
| 21 | P0495X021 | FLAT WASHER 10MM |
| 22 | P0495X022 | FENCE HINGE |
| 23 | P0495X023 | SPECIAL BOLT |
| 24 | P0495X024 | HEX NUT 1/2-20 |

| REF | PART # | DESCRIPTION |
|------|-------------|---------------------------------|
| 25 | P0495X025 | HEX BOLT 5/16-18 X 1-1/4 |
| 26 | P0495X026 | HEX NUT 5/16-18 |
| 27 | P0495X027 | SPECIAL BOLT |
| 28 | P0495X028 | HEX NUT 3/8-16 |
| 29 | P0495X029 | HEX BOLT 5/16-18 X 1-3/4 |
| 30V2 | P0495X030V2 | CAP SCREW 1/4-20 X 3/4 V2.06.22 |
| 31V2 | P0495X031V2 | BRACKET V2.06.22 |
| 32 | P0495X032 | HANDLE |
| 33 | P0495X033 | SHAFT |
| 34 | P0495X034 | PIVOT NUT |
| 35 | P0495X035 | COLLAR |
| 36 | P0495X036 | HEX NUT 5/16-18 |
| 37 | P0495X037 | ROD |
| 38 | P0495X038 | HEX NUT 7/16-14 |
| 39 | P0495X039 | STOP TAB |
| 40 | P0495X040 | ADAPTER |
| 41 | P0495X041 | ADAPTER SCREW |
| 42V2 | P0495X042V2 | FENCE V2.06.22 |
| 69 | P0495X069 | FENCE ADJUSTMENT WHEEL HANDLE |
| 139 | P0495X139 | BOLT |
| 155 | P0495X155 | TILT LOCK |
| 156 | P0495X156 | KEY 9.5 X 9.5 X 268 |
| 157 | P0495X157 | ROLL PIN 4 x 14 |



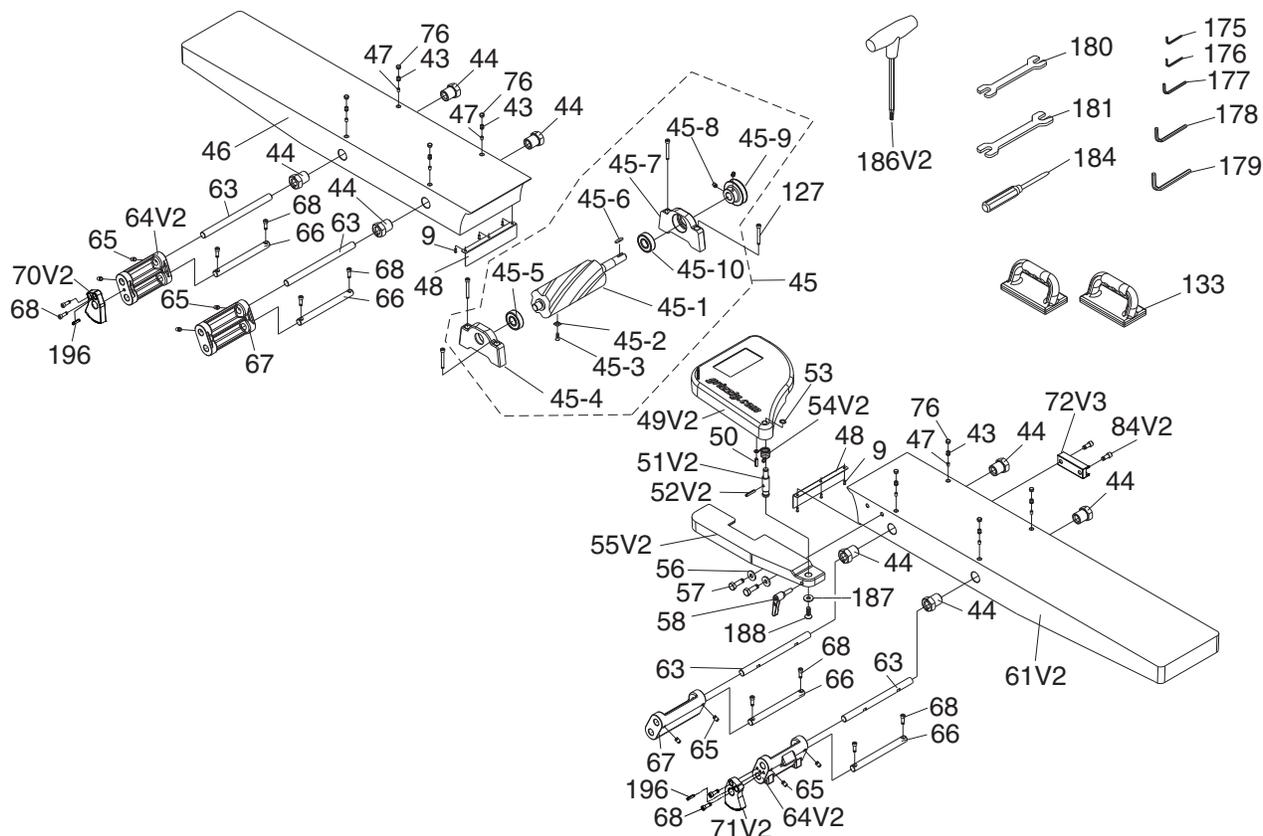
Base Parts List

| REF | PART # | DESCRIPTION |
|------|-------------|----------------------------|
| 4 | P0495X004 | ROLL PIN 4 X 25 |
| 26 | P0495X026 | HEX NUT 5/16-18 |
| 77 | P0495X077 | KNOB |
| 78 | P0495X078 | GUARD COVER |
| 79 | P0495X079 | DOUBLE-END STUD |
| 81 | P0495X081 | BALL BEARING 6000ZZ |
| 82 | P0495X082 | PINION GEAR |
| 83V2 | P0495X083V2 | SHAFT V2.08.20 |
| 87 | P0495X087 | HEX BOLT 5/16-18 X 1-3/4 |
| 88 | P0495X088 | HEX BOLT 5/16-18 X 1 |
| 89 | P0495X089 | HEX BOLT 3/8-16 X 2 |
| 90 | P0495X090 | FLAT WASHER 10MM |
| 91V2 | P0495X091V2 | LIFTING ROD V2.08.20 |
| 92 | P0495X092 | KNOB M4-.7, D46, 7-LOBE |
| 93 | P0495X093 | HANDWHEEL ASSEMBLY |
| 94 | P0495X094 | BALL BEARING 6002ZZ |
| 95 | P0495X095 | KEY 5 X 5 X 10 |
| 96V2 | P0495X096V2 | SPIRAL GEAR SHAFT V2.08.20 |
| 98V3 | P0495X098V3 | BASE V3.08.20 |
| 100 | P0495X100 | FLAT WASHER 5MM |
| 140 | P0495X140 | BUSHING |
| 144 | P0495X144 | RIGHT DUST PLATE |
| 145 | P0495X145 | LEFT DUST PLATE |
| 154 | P0495X154 | PHLP HD SCR 10-24 X 1/4 |
| 158 | P0495X158 | POINTER |
| 164 | P0495X164 | FLAT WASHER 6MM |
| 165 | P0495X165 | FLAT WASHER 5MM |
| 166 | P0495X166 | CAP SCREW 10-24 X 1/2 |

| REF | PART # | DESCRIPTION |
|----------|----------------|------------------------------|
| 167 | P0495X167 | FLAT WASHER 8MM |
| 168V2 | P0495X168V2 | DRO REPLACEMENT KIT V2.02.19 |
| 168V2-1 | P0495X168V2-1 | FLAT WASHER 8MM |
| 168V2-2 | P0495X168V2-2 | DRO PLATE |
| 168V2-3 | P0495X168V2-3 | FLAT WASHER 8MM |
| 168V2-4 | P0495X168V2-4 | CAP SCREW 5/16-18 X 3/4 |
| 168V2-5 | P0495X168V2-5 | BUTTON HD CAP SCR M3-.5 X 15 |
| 168V2-6 | P0495X168V2-6 | FLAT WASHER 3MM |
| 168V2-7 | P0495X168V2-7 | BALL BEARING 606ZZ |
| 168V2-8 | P0495X168V2-8 | BUSHING |
| 168V2-9 | P0495X168V2-9 | HEX BOLT M6-1 X 12 |
| 168V2-10 | P0495X168V2-10 | FLAT WASHER 6MM |
| 168V2-11 | P0495X168V2-11 | LOCK NUT M3-.5 |
| 168V2-12 | P0495X168V2-12 | BALL BEARING HOUSING |
| 168V2-13 | P0495X168V2-13 | DIGITAL READOUT |
| 168V2-14 | P0495X168V2-14 | LOCK NUT M6-1 |
| 168V2-15 | P0495X168V2-15 | COVER |
| 168V2-16 | P0495X168V2-16 | FLAT WASHER 5MM |
| 168V2-17 | P0495X168V2-17 | PHLP HD SCR M5-.8 X 8 |
| 168V2-18 | P0495X168V2-18 | CAP SCREW M5-.8 X 12 |
| 168V2-19 | P0495X168V2-19 | MAGNETIC SCALE |
| 168V2-20 | P0495X168V2-20 | FLAT WASHER 5MM |
| 168V2-21 | P0495X168V2-21 | FLAT WASHER 5MM |
| 169 | P0495X169 | CAP SCREW M8-1.25 X 12 |
| 170 | P0495X170 | PHLP HD SCR M4-.7 X 6 |
| 171 | P0495X171 | DIAL |
| 174 | P0495X174 | BUTTON HD CAP SCR M6-1 X 16 |
| 197 | P0495X197 | EXT RETAINING RING 16MM |



Table

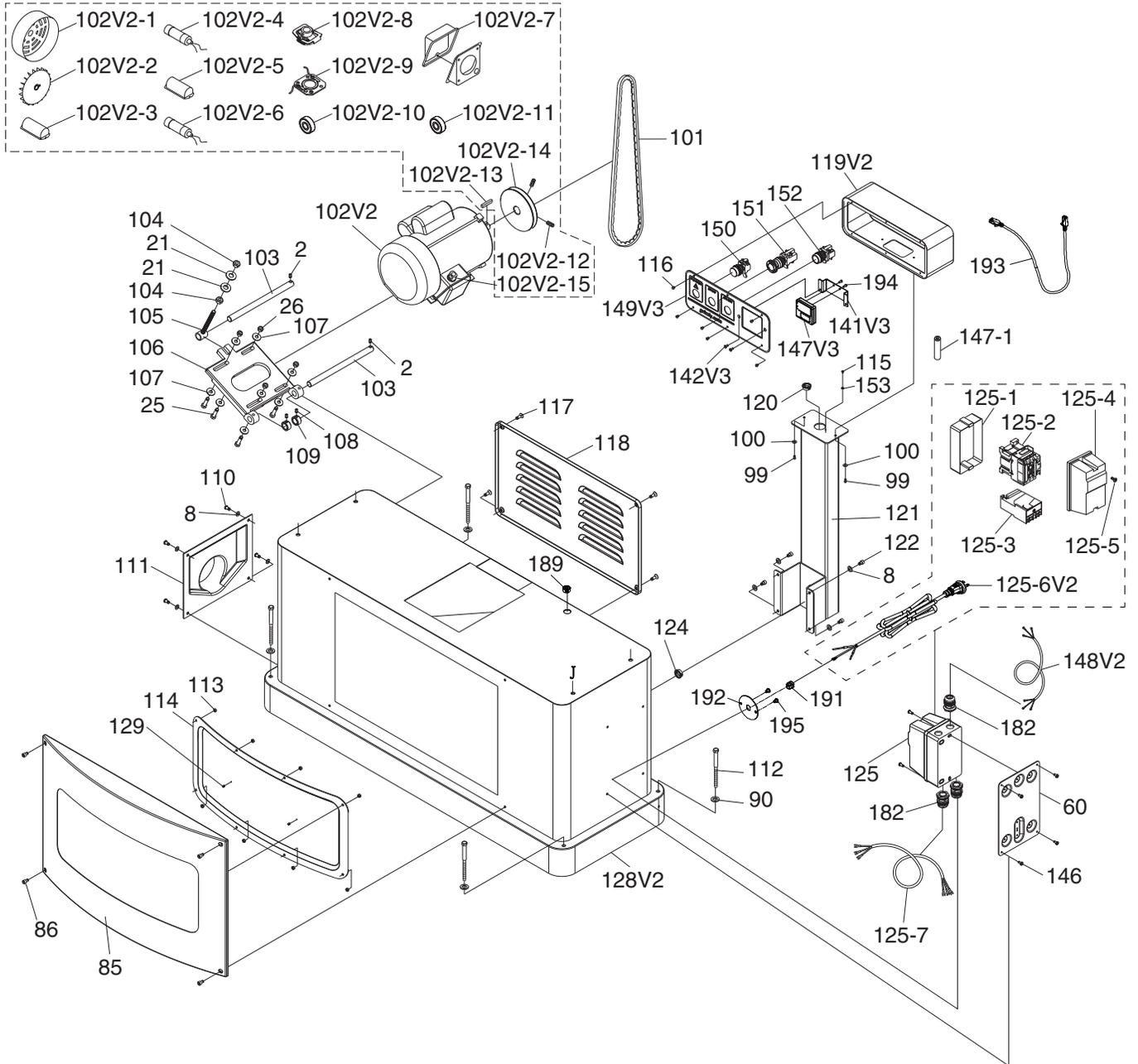


| REF | PART # | DESCRIPTION |
|-------|--------------|---|
| 9 | P0495X009 | CAP SCREW 1/4-20 X 3/8 |
| 43 | P0495X043 | SET SCREW 5/16-18 X 3/8 |
| 44 | P0495X044 | ECCENTRIC BUSHING |
| 45 | P0495X045 | HELICAL CUTTERHEAD ASSEMBLY |
| 45-1 | P0495X045-1 | HELICAL CUTTERHEAD 8" |
| 45-2 | P0495X045-2 | CARBIDE INSERT 15 X 15 X 2.5 |
| 45-3 | P0495X045-3 | FLAT HD TORX SCR #10-32 X 1/2 |
| 45-4 | P0495X045-4 | LEFT BEARING SUPPORT BLOCK |
| 45-5 | P0495X045-5 | BALL BEARING 6203ZZ |
| 45-6 | P0495X045-6 | KEY 5 X 5 X 30 |
| 45-7 | P0495X045-7 | RIGHT BEARING SUPPORT BLOCK |
| 45-8 | P0495X045-8 | SET SCREW M4-.7 X 10 |
| 45-9 | P0495X045-9 | CUTTERHEAD PULLEY |
| 45-10 | P0495X045-10 | BALL BEARING 6203ZZ |
| 46 | P0495X046 | OUTFEED TABLE |
| 47 | P0495X047 | BUSHING |
| 48 | P0495X048 | CHIP BREAKER |
| 49V2 | P0495X049V2 | BLADE GUARD V2.07.19 |
| 50 | P0495X050 | ROLL PIN 6 X 28 |
| 51V2 | P0495X051V2 | SHAFT V2.06.19 |
| 52V2 | P0495X052V2 | ROLL PIN 5 X 26 V2.06.19 |
| 53 | P0495X053 | EXT RETAINING RING 11MM |
| 54V2 | P0495X054V2 | TORSION SPRING V2.06.19 |
| 55V2 | P0495X055V2 | RABBETING TABLE V2.07.19 |
| 56 | P0495X056 | FLAT WASHER 10MM |
| 57 | P0495X057 | HEX BOLT 3/8-16 X 1-1/4 |
| 58 | P0495X058 | ADJUSTABLE HANDLE 5/16-18 x 1", 1-1/2"L |

| REF | PART # | DESCRIPTION |
|-------|-------------|------------------------------------|
| 61V2 | P0495X061V2 | INFEED TABLE V2.02.19 |
| 63 | P0495X063 | SHAFT |
| 64V2 | P0495X064V2 | BRACKET V2.02.19 |
| 65 | P0495X065 | SET SCREW 5/16-18 X 1/2 |
| 66 | P0495X066 | ROD SHAFT |
| 67 | P0495X067 | ROD BRACKET |
| 68 | P0495X068 | CAP SCREW 1/4-20 X 3/4 |
| 70V2 | P0495X070V2 | LEFT ELEVATE BRACKET V2.02.19 |
| 71V2 | P0495X071V2 | RIGHT ELEVATE BRACKET V2.02.19 |
| 72V3 | P0495X072V3 | SENSOR MOUNT BLOCK V3.02.19 |
| 76 | P0495X076 | SCREW COVER |
| 84V2 | P0495X084V2 | CAP SCREW M6-1 X 20 V2.02.19 |
| 127 | P0495X127 | CAP SCREW 5/16-18 X 1-3/4 |
| 133 | P0495X133 | PUSH BLOCK |
| 175 | P0495X175 | HEX WRENCH 3MM |
| 176 | P0495X176 | HEX WRENCH 4MM |
| 177 | P0495X177 | HEX WRENCH 5MM |
| 178 | P0495X178 | HEX WRENCH 6MM |
| 179 | P0495X179 | HEX WRENCH 8MM |
| 180 | P0495X180 | WRENCH 12 X 14 |
| 181 | P0495X181 | WRENCH 14 X 17 |
| 184 | P0495X184 | PHILLIPS SCREWDRIVER #1 |
| 186V2 | P0495X186V2 | T-HANDLE T-25 TORX DRIVER V2.06.11 |
| 187 | P0495X187 | FLAT WASHER 6MM |
| 188 | P0495X188 | BUTTON HD CAP SCR M6-1 X 12 |
| 196 | P0495X196 | ROLL PIN 4 X 10 |



Stand



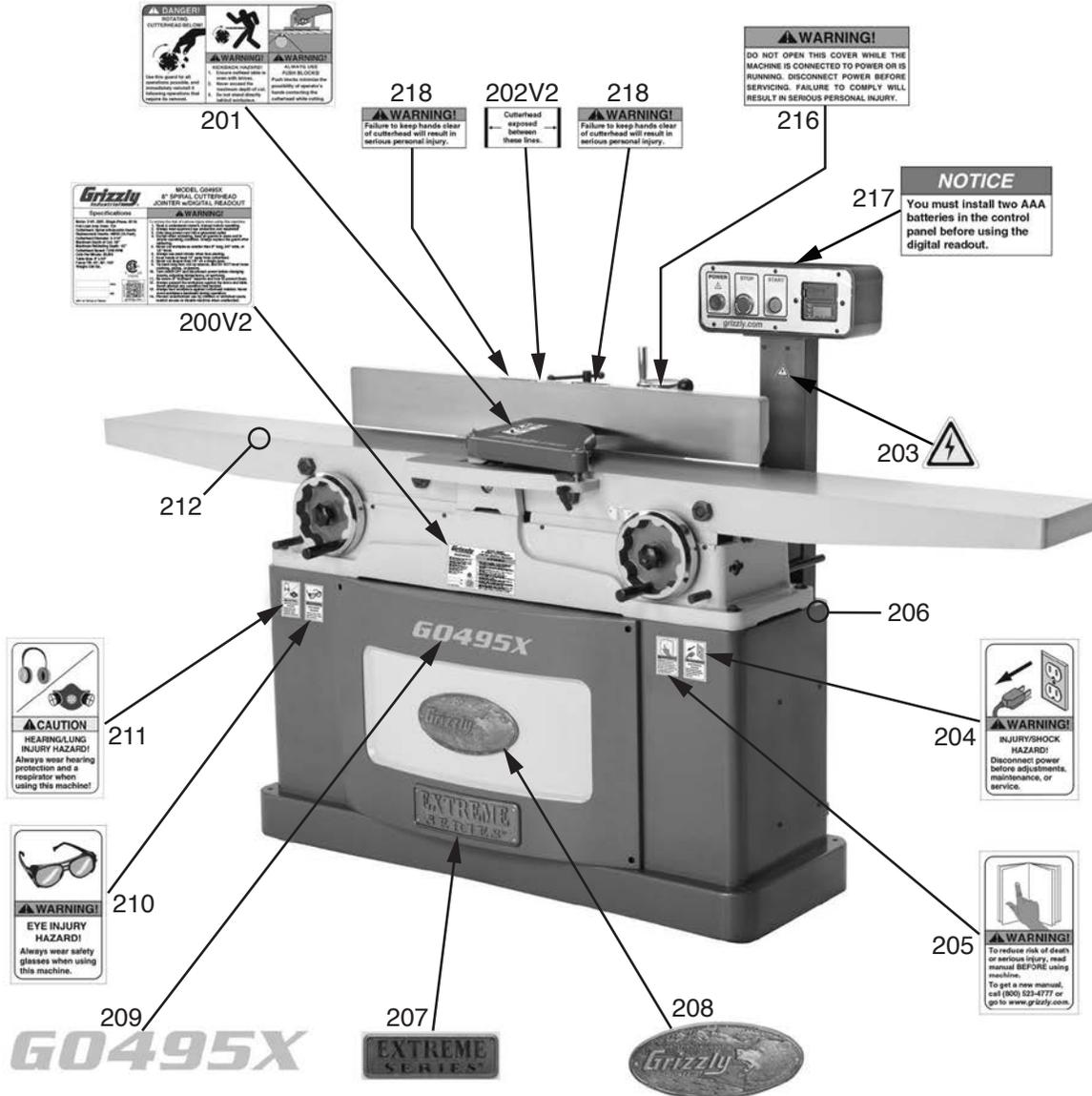
Stand Parts List

| REF | PART # | DESCRIPTION |
|----------|----------------|-------------------------------------|
| 2 | P0495X002 | SET SCREW 1/4-20 X 3/8 |
| 8 | P0495X008 | FLAT WASHER 6MM |
| 21 | P0495X021 | FLAT WASHER 10MM |
| 25 | P0495X025 | HEX BOLT 5/16-18 X 1-1/4 |
| 26 | P0495X026 | HEX NUT 5/16-18 |
| 60 | P0495X060 | SWITCH PLATE |
| 85 | P0495X085 | CAP |
| 86 | P0495X086 | CAP SCREW M6-1 X 10 |
| 90 | P0495X090 | FLAT WASHER 10MM |
| 99 | P0495X099 | CAP SCREW M5-.8 X 8 |
| 100 | P0495X100 | FLAT WASHER 5MM |
| 101 | P0495X101 | V-BELT A-51 |
| 102V2 | P0495X102V2 | MOTOR 3HP 230V 1-PH V2.02.19 |
| 102V2-1 | P0495X102V2-1 | MOTOR FAN COVER |
| 102V2-2 | P0495X102V2-2 | MOTOR FAN |
| 102V2-3 | P0495X102V2-3 | S CAPACITOR COVER |
| 102V2-4 | P0495X102V2-4 | S CAPACITOR 400M 125V 1-1/2 X 3-1/2 |
| 102V2-5 | P0495X102V2-5 | R CAPACITOR COVER |
| 102V2-6 | P0495X102V2-6 | R CAPACITOR 70M 250V 1-1/2 X 3-1/2 |
| 102V2-7 | P0495X102V2-7 | JUNCTION BOX |
| 102V2-8 | P0495X102V2-8 | CENTRIFUGAL SWITCH |
| 102V2-9 | P0495X102V2-9 | CONTACT PLATE |
| 102V2-10 | P0495X102V2-10 | BALL BEARING 6205ZZ (FRONT) |
| 102V2-11 | P0495X102V2-11 | BALL BEARING 6203ZZ (REAR) |
| 102V2-12 | P0495X102V2-12 | SET SCREW 1/4-20 X 3/8 |
| 102V2-13 | P0495X102V2-13 | KEY 5 X 5 X 30 |
| 102V2-14 | P0495X102V2-14 | MOTOR PULLEY |
| 102V2-15 | P0495X102V2-15 | STRAIN RELIEF PGA 13.5-11B |
| 103 | P0495X103 | SHAFT |
| 104 | P0495X104 | HEX NUT M10-1.5 |
| 105 | P0495X105 | ADJUSTING SHAFT |
| 106 | P0495X106 | MOTOR PLATE |
| 107 | P0495X107 | FLAT WASHER 8MM |
| 108 | P0495X108 | SET SCREW M6-1 X 8 |
| 109 | P0495X109 | COLLAR |
| 110 | P0495X110 | PHLP HD SCREW 1/4-20 X 1/2 |
| 111 | P0495X111 | DUST CHUTE |
| 112 | P0495X112 | HEX BOLT 3/8-16 X 6 |
| 113 | P0495X113 | HEX NUT M5-.8 |

| REF | PART # | DESCRIPTION |
|---------|---------------|--------------------------------------|
| 114 | P0495X114 | FRONT COVER |
| 115 | P0495X115 | PHLP HD SCR M4-.7 X 8 |
| 116 | P0495X116 | BUTTON HD CAP SCR M4-.7 X 12 |
| 117 | P0495X117 | FLAT HD SCR 1/4-20 X 3/4 |
| 118 | P0495X118 | REAR ACCESS PLATE |
| 119V2 | P0495X119V2 | CONTROL PANEL COVER V2.02.19 |
| 120 | P0495X120 | STRAIN RELIEF NB-2430 |
| 121 | P0495X121 | SWITCH BRACKET ASSEMBLY |
| 122 | P0495X122 | CAP SCREW 1/4-20 X 1/2 |
| 124 | P0495X124 | STRAIN RELIEF NB-1722 |
| 125 | P0495X125 | MAG SWITCH ASSY SDE |
| 125-1 | P0495X125-1 | MAG SWITCH BACK COVER |
| 125-2 | P0495X125-2 | CONTACTOR SDE MA-18 220V |
| 125-3 | P0495X125-3 | OL RELAY SDE RA-20 12-18A |
| 125-4 | P0495X125-4 | MAG SWITCH FRONT COVER |
| 125-5 | P0495X125-5 | NYLON SCREW M10-1.5 X 22 |
| 125-6V2 | P0495X125-6V2 | POWER CORD 14G 3W 10' 6-20P V2.02.19 |
| 125-7 | P0495X125-7 | CONTROL PANEL CORD 16AWG X 5C |
| 128V2 | P0495X128V2 | STAND V2.02.19 |
| 129 | P0495X129 | PHLP HD SCR M4-.7 X 8 |
| 141V3 | P0495X141V3 | DIGITAL READOUT BRACKET V3.02.19 |
| 142V3 | P0495X142V3 | CAP SCREW M5-.8 X 8 V3.02.19 |
| 146 | P0495X146 | PHLP HD SCR M5-.8 X 8 |
| 147V3 | P0495X147V3 | DIGITAL READOUT ASSEMBLY V3.02.19 |
| 147-1 | P0495X147-1 | BATTERY AAA |
| 148V2 | P0495X148V2 | MOTOR CORD 14G 3W 72" V2.02.19 |
| 149V3 | P0495X149V3 | SWITCH PLATE V3.02.19 |
| 150 | P0495X150 | LIGHT 250V 1.2W JG18 |
| 151 | P0495X151 | STOP SWITCH |
| 152 | P0495X152 | START SWITCH |
| 153 | P0495X153 | EXT TOOTH WASHER 4MM |
| 182 | P0495X182 | STRAIN RELIEF 1/2" |
| 189 | P0495X189 | STRAIN RELIEF 1/2"-3/4" SNAP-IN ST |
| 191 | P0495X191 | STRAIN RELIEF 1/2"-3/4" SNAP-IN ST |
| 192 | P0495X192 | BACKING BOARD |
| 193 | P0495X193 | DRO CORD |
| 194 | P0495X194 | PHLP HD SCR M3-.5 X 8 |
| 195 | P0495X195 | PHLP HD SCR M6-1 X 8 |



Labels & Cosmetics



| REF | PART # | DESCRIPTION |
|-------|-------------|---------------------------------|
| 200V2 | P0495X200V2 | MACHINE ID LABEL V2.02.19 |
| 201 | P0495X201 | CUTTERHEAD GUARD LABEL |
| 202V2 | P0495X202V2 | FENCE/CUTTERHEAD LABEL V2.06.22 |
| 203 | P0495X203 | ELECTRICITY LABEL |
| 204 | P0495X204 | DISCONNECT POWER LABEL |
| 205 | P0495X205 | READ MANUAL LABEL |
| 206 | P0495X206 | TOUCH-UP PAINT, GRIZZLY GREEN |
| 207 | P0495X207 | EXTREME SERIES PLATE |

| REF | PART # | DESCRIPTION |
|-----|-----------|-------------------------------|
| 208 | P0495X208 | GRIZZLY NAMEPLATE-LARGE |
| 209 | P0495X209 | MODEL NUMBER LABEL |
| 210 | P0495X210 | SAFETY GLASSES LABEL |
| 211 | P0495X211 | HEARING/RESPIRATOR LABEL |
| 212 | P0495X212 | TOUCH-UP PAINT, GRIZZLY PUTTY |
| 216 | P0495X216 | DO NOT OPEN COVER LABEL |
| 217 | P0495X217 | BATTERY INSTALL LABEL |
| 218 | P0495X218 | CUTTERHEAD WARNING LABEL |

! WARNING

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



WARRANTY & RETURNS

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

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

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

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

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

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

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



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