

# ***Grizzly*** ***Industrial, Inc.***®

## **MODEL G0656W/G0656XW 8" JOINTER w/MOBILE BASE OWNER'S MANUAL**

*(For models manufactured since 08/16)*



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#WK17789 PRINTED IN CHINA

V3.09.16



## **WARNING!**

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

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

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

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



## **WARNING!**

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

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

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

# Table of Contents

<b>INTRODUCTION .....</b>	<b>2</b>	<b>SECTION 5: ACCESSORIES .....</b>	<b>33</b>
Contact Info.....	2	<b>SECTION 6: MAINTENANCE.....</b>	<b>35</b>
Manual Accuracy .....	2	Schedule .....	35
Identification .....	3	Cleaning & Protecting .....	35
Controls & Components.....	4	Lubrication .....	36
Machine Data Sheet .....	6	<b>SECTION 7: SERVICE .....</b>	<b>37</b>
<b>SECTION 1: SAFETY .....</b>	<b>10</b>	Troubleshooting .....	37
Safety Instructions for Machinery .....	10	Inspecting Knives (G0656W) .....	39
Additional Safety for Jointers .....	12	Setting/Replacing Knives (G0656W) .....	39
<b>SECTION 2: POWER SUPPLY .....</b>	<b>13</b>	Rotating/Replacing Cutterhead Inserts (G0656XW) .....	41
<b>SECTION 3: SETUP .....</b>	<b>15</b>	Calibrating Depth Scale .....	42
Needed for Setup.....	15	Setting Fence Stops .....	43
Unpacking .....	15	Adjusting Gibs.....	44
Inventory .....	16	Tensioning/Replacing Belt .....	45
Cleanup.....	17	Checking/Adjusting Table Parallelism .....	46
Site Considerations.....	18	<b>SECTION 8: WIRING.....</b>	<b>47</b>
Assembly .....	19	Wiring Safety Instructions .....	47
Dust Collection.....	23	Wiring Diagram .....	48
Setting Outfeed Table Height .....	23	<b>SECTION 9: PARTS .....</b>	<b>49</b>
Test Run .....	24	Table .....	49
Recommended Adjustments.....	24	Cutterhead (G0656W).....	50
Tighten Belt.....	24	Cutterhead (G0656XW) .....	51
<b>SECTION 4: OPERATIONS .....</b>	<b>25</b>	Fence .....	52
Operation Overview .....	25	Stand.....	53
Stock Inspection & Requirements.....	26	Labels .....	54
Setting Depth of Cut .....	27	<b>WARRANTY &amp; RETURNS .....</b>	<b>57</b>
Squaring Stock.....	28		
Surface Planing.....	29		
Edge Jointing .....	30		
Bevel Cutting.....	31		
Rabbet Cutting.....	32		

# 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.

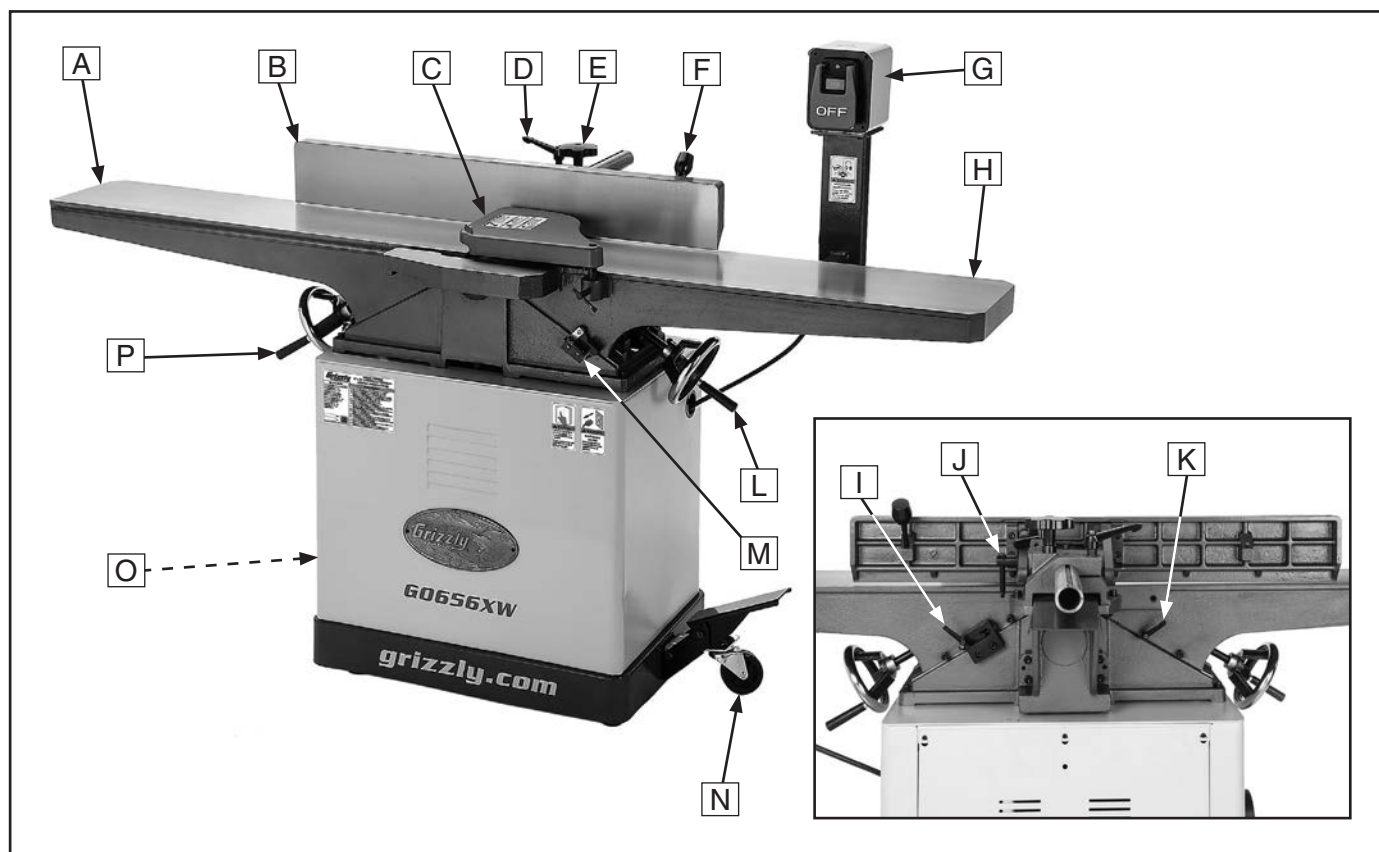
		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Manual before operation.		
Specification:	Safety glasses and respirator.		
Specification:	Correctly adjusted/setup and		
Specification:	power is connected to grounded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

Manufactured for Grizzly in Taiwan



# Identification

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



- |                          |                               |
|--------------------------|-------------------------------|
| A. Outfeed Table         | I. Infeed Table Lock          |
| B. Fence                 | J. Fence Tilt Lock            |
| C. Cutterhead Guard      | K. Outfeed Table Lock         |
| D. Fence Lock            | L. Infeed Table Handwheel     |
| E. Fence Adjustment Knob | M. Depth Scale                |
| F. Fence Tilt Handle     | N. Foot Pedal Caster Assembly |
| G. ON/OFF Switch         | O. Dust Port                  |
| H. Infeed Table          | P. Outfeed Table Handwheel    |

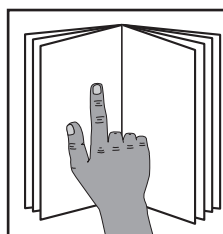
## WARNING

**For Your Own Safety Read Instruction Manual Before Operating Jointer**

- a) Wear eye protection.
- b) Always keep cutterhead and drive guards in place and in proper operating condition. **ALWAYS** replace cutterhead guard after rabbeting operations.
- c) Never make jointing or rabbeting cuts deeper than  $\frac{1}{8}$ " or planing cuts deeper than  $\frac{1}{16}$ ".
- d) Always use hold-down or push blocks when jointing material narrower than 3" or surface planing material thinner than 3".
- e) Never perform jointing, planing, or rabbeting cuts on pieces shorter than 8" in length.



# Controls & Components



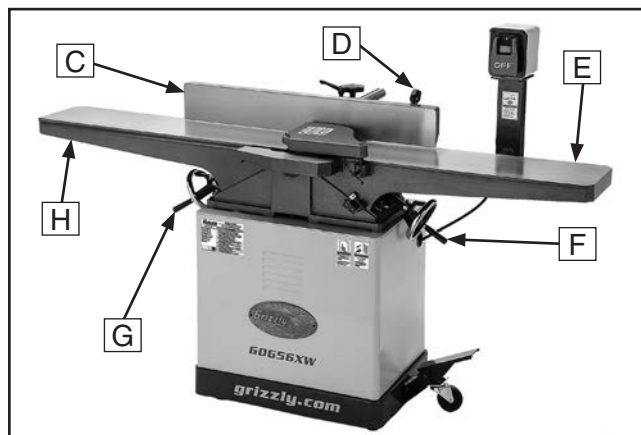
**WARNING**  
To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

Refer to **Figures 1–5** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.



**Figure 1.** ON/OFF controls.

- A. ON Button:** Starts motor and cutterhead.
- B. OFF Paddle:** Cuts power to motor when pushed in.

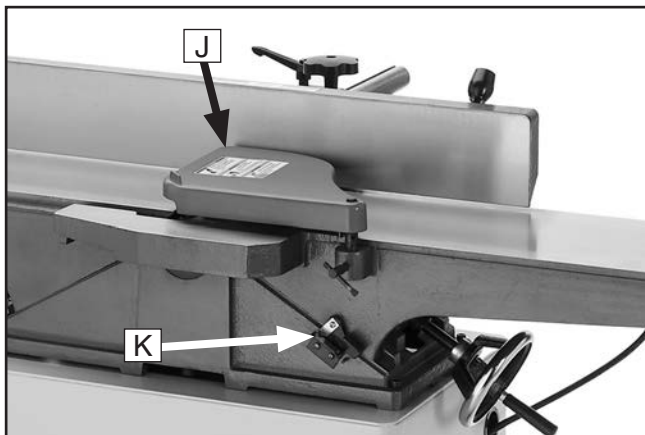


**Figure 2.** Main table controls, fence, and foot pedal caster.

- C. Fence:** Supports workpiece laterally as it moves across cutterhead; determines angle of cut.
- D. Fence Tilt Handle:** Tilts fence throughout its range of motion from 45° inward to 45° outward (135°).
- E. Infeed Table:** Supports workpiece before it reaches cutterhead. Position of infeed table relative to cutterhead determines depth of cut.
- F. Infeed Table Handwheel:** Adjusts position of infeed table, which controls depth of cut.
- G. Outfeed Table Handwheel:** Adjusts position of outfeed table. Only used when setting outfeed table even with cutterhead knives/inserts.
- H. Outfeed Table:** Supports workpiece after it passes over cutterhead. For safety and best results, outfeed table must be properly adjusted relative to cutterhead knives/inserts (refer to **Page 23** for more details).



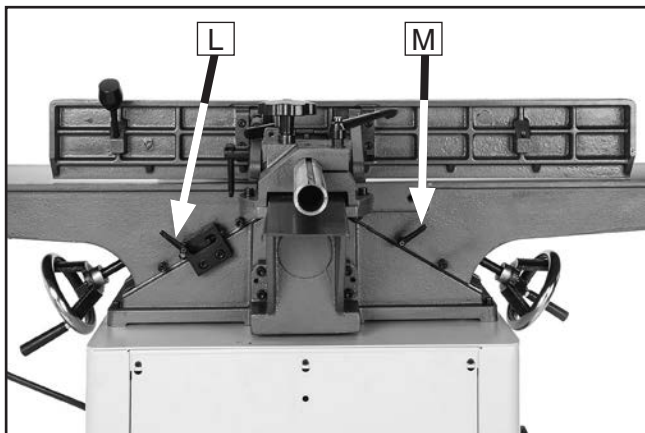




**Figure 3.** Cutterhead guard and cut depth scale.

**J. Cutterhead Guard:** Covers cutterhead until pushed out of the way by workpiece during operation. When workpiece leaves cutterhead, guard springs back to its starting position.

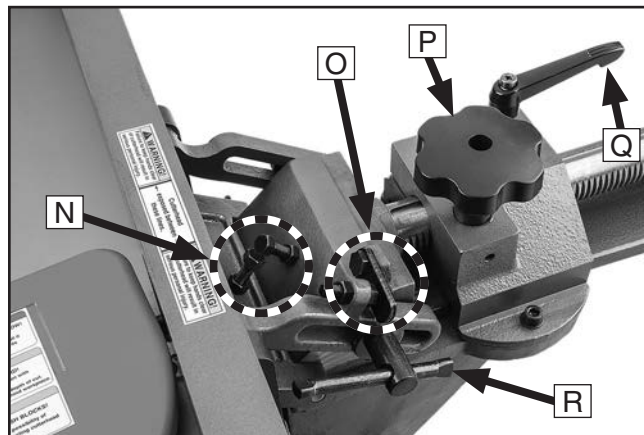
**K. Depth Scale:** Indicates depth of cut.



**Figure 4.** Fence tilt handle and table locks.

**L. Infeed Table Lock:** Tightens to secure infeed table position; loosens to allow adjustment. To adjust preset range of movement for infeed table, refer to **Page 28**.

**M. Outfeed Table Lock:** Tightens to secure outfeed table position; loosens to allow adjustment.



**Figure 5.** Fence controls.

**N. 45° Fence Stops:** Stop fence at 45° inward and 45° outward (135°).

**Note:** Even when fence is resting against stops, tilt lock must be tightened before starting machine.

**O. 90° Fence Stop:** When engaged, stops fence at 90°.

**Note:** Even when fence is resting against tilt stop, tilt lock must be tightened before starting machine.

**Note:** Swing stop must be disengaged for bevel cuts greater than 90°.

**P. Fence Adjustment Knob:** Rotates to adjust lateral position of fence along width of tables.

**Q. Fence Lock:** Tightens to secure fence position along width of tables; loosens to allow adjustment.

**R. Fence Tilt Lock:** Secures fence tilt setting at desired angle.





# MACHINE DATA SHEET

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

## MODEL G0656W 8" X 72" JOINTER WITH MOBILE BASE

### Product Dimensions:

Weight..... 434 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 73 x 32 x 46-1/2 in.  
Footprint (Length x Width)..... 30 x 17-1/2 in.

### Shipping Dimensions:

#### Carton #1

Type..... Wood Crate  
Content..... Machine  
Weight..... 379 lbs.  
Length x Width x Height..... 81 x 23 x 15 in.  
Must Ship Upright..... Yes

#### Carton #2

Type..... Cardboard Box  
Content..... Stand  
Weight..... 139 lbs.  
Length x Width x Height..... 28 x 20 x 27 in.  
Must Ship Upright..... No

### Electrical:

Power Requirement..... 240V, 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..... 12 AWG  
Plug Included..... Yes  
Included Plug Type..... 6-20  
Switch Type..... ON/OFF Push Button Switch w/Large Shut-Off Paddle

### Motors:

#### Main

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





## 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.....	8 in.
Minimum Workpiece Thickness.....	1/2 in.
Maximum Rabbeting Depth.....	1/2 in.
Number of Cuts Per Minute.....	21,400

### Fence Information

Fence Length.....	35 in.
Fence Width.....	1-1/2 in.
Fence Height.....	5 in.
Fence Stops.....	45, 90, 135 deg.

### Cutterhead Information

Cutterhead Type.....	4 Knife
Cutterhead Diameter.....	3 in.
Cutterhead Speed.....	5350 RPM

### Knife Information

Number of Knives.....	4
Knife Type.....	HSS, Single-Sided
Knife Length.....	8-1/16 in.
Knife Width.....	3/4 in.
Knife Thickness.....	1/8 in.
Knife Adjustment.....	Jack Screws

### Table Information

Table Length.....	73 in.
Table Width.....	9-3/8 in.
Table Thickness.....	2 in.
Floor to Table Height.....	32-1/4 in.
Table Adjustment Type.....	Handwheel
Table Movement Type.....	Dovetailed Ways

### Construction

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

### Other Information

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

## Other Specifications:

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	1 Hour
Serial Number Location .....	ID Label
ISO 9001 Factory .....	No
Certified by a Nationally Recognized Testing Laboratory (NRTL) .....	Yes





# MACHINE DATA SHEET

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

## MODEL G0656XW 8" JOINTER WITH SPIRAL CUTTERHEAD

### Product Dimensions:

Weight..... 436 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 73 x 32 x 46-1/2 in.  
Footprint (Length x Width)..... 30 x 17-1/2 in.

### Shipping Dimensions:

#### Carton #1

Type..... Wood Crate  
Content..... Machine  
Weight..... 381 lbs.  
Length x Width x Height..... 81 x 23 x 15 in.  
Must Ship Upright..... Yes

#### Carton #2

Type..... Cardboard Box  
Content..... Stand  
Weight..... 139 lbs.  
Length x Width x Height..... 28 x 20 x 27 in.  
Must Ship Upright..... No

### Electrical:

Power Requirement..... 240V, 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..... 12 AWG  
Plug Included..... Yes  
Included Plug Type..... 6-20  
Switch Type..... ON/OFF Push Button Switch w/Large Shut-Off Paddle

### Motors:

#### Main

Type..... TEFC Capacitor-Start Induction, 240V  
Horsepower..... 3 HP  
Phase..... Single-Phase  
Amps..... 12A  
Speed..... 3450 RPM  
Power Transfer ..... Belt Drive  
Bearings..... Shielded & Permanently Lubricated



## 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.....	8 in.
Minimum Workpiece Thickness.....	1/2 in.
Maximum Rabbeting Depth.....	1/2 in.
Number of Cuts Per Minute.....	21,400

### Fence Information

Fence Length.....	35 in.
Fence Width.....	1-3/8 in.
Fence Height.....	5 in.
Fence Stops.....	45, 90, 135 deg.

### Cutterhead Information

Cutterhead Type.....	Spiral
Cutterhead Diameter.....	3 in.
Number of Cutter Spirals.....	4
Number of Indexable Cutters.....	40
Cutterhead Speed.....	5350 RPM

### Cutter Insert Information

Cutter Insert Type.....	Indexable Carbide
Cutter Insert Length.....	14 mm
Cutter Insert Width.....	14 mm
Cutter Insert Thickness.....	2 mm

### Table Information

Table Length.....	73 in.
Table Width.....	9-3/8 in.
Table Thickness.....	2 in.
Floor to Table Height.....	32-1/4 in.
Table Adjustment Type.....	Handwheels
Table Movement Type.....	Dovetailed Ways

### Construction

Body Assembly.....	Cast Iron
Cabinet.....	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.
Mobile Base.....	Built-In

## Other Specifications:

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	1 Hour
Serial Number Location .....	ID Label
ISO 9001 Factory .....	No
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**

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

## Safety Instructions for Machinery



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

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

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

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

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

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

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



# WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Jointers

## WARNING

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

**KICKBACK.** Occurs when workpiece is ejected from machine at a high rate of speed. To reduce the risk of kickback-related injuries, use quality workpieces, safe feeding techniques, and proper machine setup or maintenance.

**GUARD REMOVAL.** Operating jointer without guard exposes operator to knives/inserts. Except when rabbeting, never remove guards for regular operations or while connected to power. 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 adjusted before resuming regular operations.

**DULL/DAMAGED KNIVES/INSERTS.** Dull knives/inserts can 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 and get stuck, increasing risk of kickback. Setting outfeed table too low may cause workpiece to become tapered from front to back. Always keep outfeed table even with knives/inserts at top dead center (highest point during rotation).

**INSPECTING STOCK.** Impact injuries or fire may result from using poor workpieces. Thoroughly inspect and prepare workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or other foreign material. Workpieces with minor warping should be surface planed first with cupped side facing infeed table.

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

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

**CUTTING LIMITATIONS.** Cutting a workpiece that does not meet the minimum dimension requirements can result in breakup, kickback, or accidental contact with cutterhead during operation. Never perform jointing, planing, or rabbeting cuts on pieces smaller than 8" long,  $\frac{3}{4}$ " wide, or  $\frac{1}{4}$ " thick.

**PUSH BLOCKS.** Not using push blocks when surface planing may result in accidental cutterhead contact. 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.** Loss of workpiece control while feeding can increase risk of kickback or accidental contact with cutterhead. Support workpiece continuously during operation. Position and guide workpiece with fence. Support long or wide stock with auxiliary stands.

**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 back work toward infeed table.

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

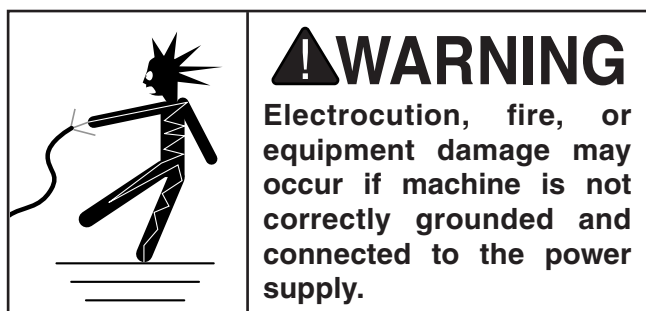




# SECTION 2: POWER SUPPLY

## Availability

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



## Full-Load Current Rating

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

### Full-Load Current Rating at 220V ..... 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 ..... 208V, 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 20 Amps**  
**Plug/Receptacle ..... NEMA 6-20**

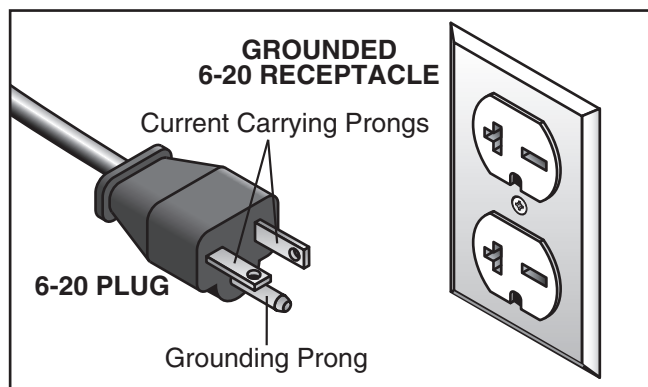




## Grounding Requirements

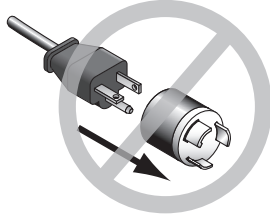
This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

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 6.** 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.

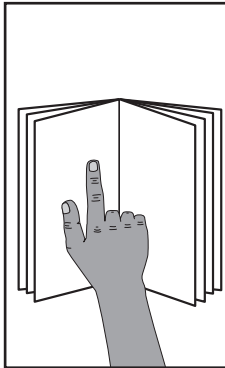
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 ..... 14 AWG**  
**Maximum Length (Shorter is Better).....50 ft.**

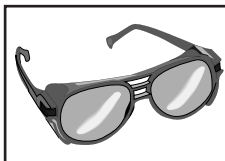


# SECTION 3: SETUP



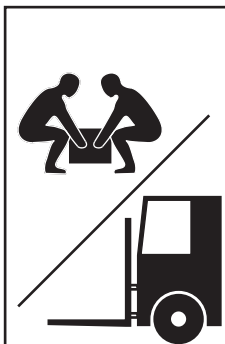
## !WARNING

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

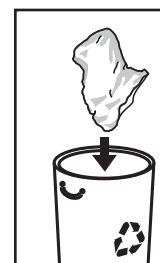
The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Safety Glasses (for each person).....	1
• Solvent/Cleaner .....	1
• Shop Rags.....	1
• Lifting Equipment At Least 750 lb. Rating:	
Forklift.....	1
Lifting Straps .....	2
• Wrench or Socket 12, 13mm .....	1 Ea.
• Hex Wrench 4, 5, 6mm .....	1 Ea.
• Straightedge 4' .....	1
• Phillips Screwdriver #2 .....	1
• Feeler Gauge 0.062" (1/16") .....	1
• Dust Collection System .....	1
• 4" Dust Hose (length as needed) .....	1
• 4" Hose Clamp .....	1
• Another Person .....	1

## 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.*



## !WARNING

### SUFFOCATION HAZARD!

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



# Inventory

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

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

## NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

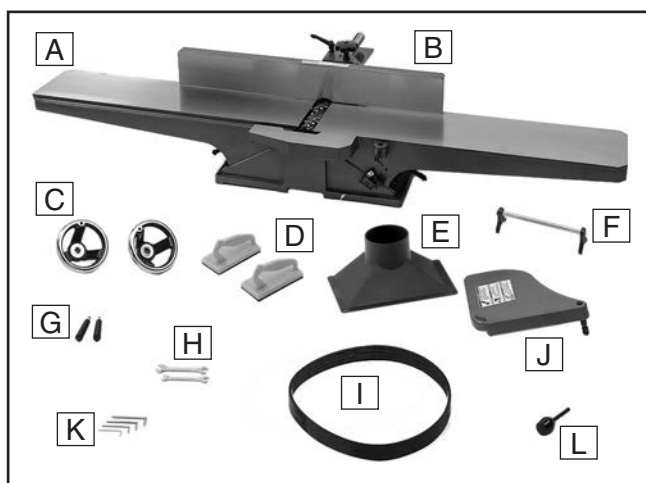


Figure 7. Box 1 inventory contents.



Figure 8. Box 2 inventory contents.

## Wood Crate (Figure 7) Qty

A.	Jointer Assembly .....	1
B.	Fence Assembly, Carriage, & Carriage Mount.....	1 Ea.
C.	Handwheels.....	2
D.	Push Blocks.....	2
E.	Dust Port .....	1
F.	Knife-Setting Jig .....	1
G.	Handles .....	2
H.	Open-End Wrenches 8/10, 11/13mm....	1 Ea.
I.	Belt .....	1
J.	Cutterhead Guard.....	1
K.	Hex Wrenches 3, 4, 5, 6mm.....	1 Ea.
L.	Fence Tilt Lever.....	1

## Cardboard Box (Figure 8) Qty

M.	Stand Assembly w/Motor and Door .....	1
N.	Pedestal Switch Assembly .....	1
O.	Foot Pedal Caster Assembly .....	1

## Fasteners & Tools (Not Shown)..... Qty

•	Cap Screws M8-1.25 x 40 (Jointer/Stand) ..	4
•	Lock Washers 8mm (Jointer/Stand) .....	4
•	Flat Washers 8mm (Jointer/Stand) .....	4
•	Cap Screws M8-1.25 x 45 (Carriage Mount) .....	4
•	Lock Washers 8mm (Carriage Mount) .....	4
•	Cap Screws M8-1.25 x 50 (Wheel/Stand) ..	3
•	Lock Washers 8mm (Wheel/Stand) .....	3
•	Flat Washers 8mm (Wheel/Stand) .....	6
•	Hex Nuts M8-1.25 (Wheel/Stand).....	3
•	Phillips Head Screws M5-.8 x 10 (Dust Port) .....	4
•	Flat Washers 5mm (Dust Port).....	4
•	Key 5 x 5 x 20 (Handwheels) .....	2

## G0656XW Only:

•	Indexable Carbide Inserts .....	5
•	Insert Screws.....	5
•	T-Handle Torx Driver T20 .....	2



# 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.

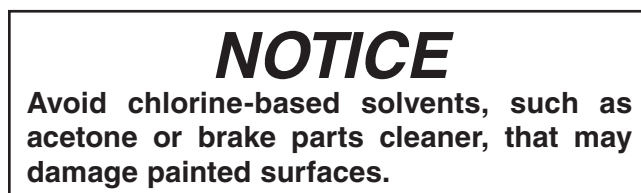
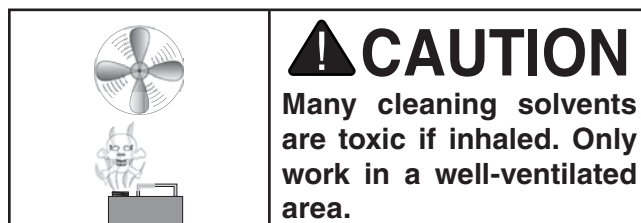
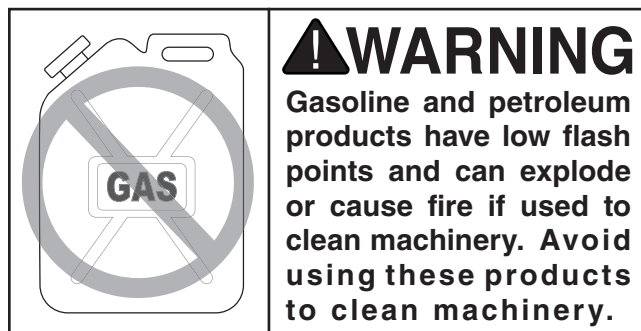
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## 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.



Figure 9. T23692 Orange Power Degreaser.



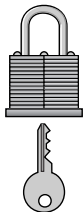
# Site Considerations

## Weight Load

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

## Space Allocation

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

	<b>CAUTION</b> Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.
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## Physical Environment

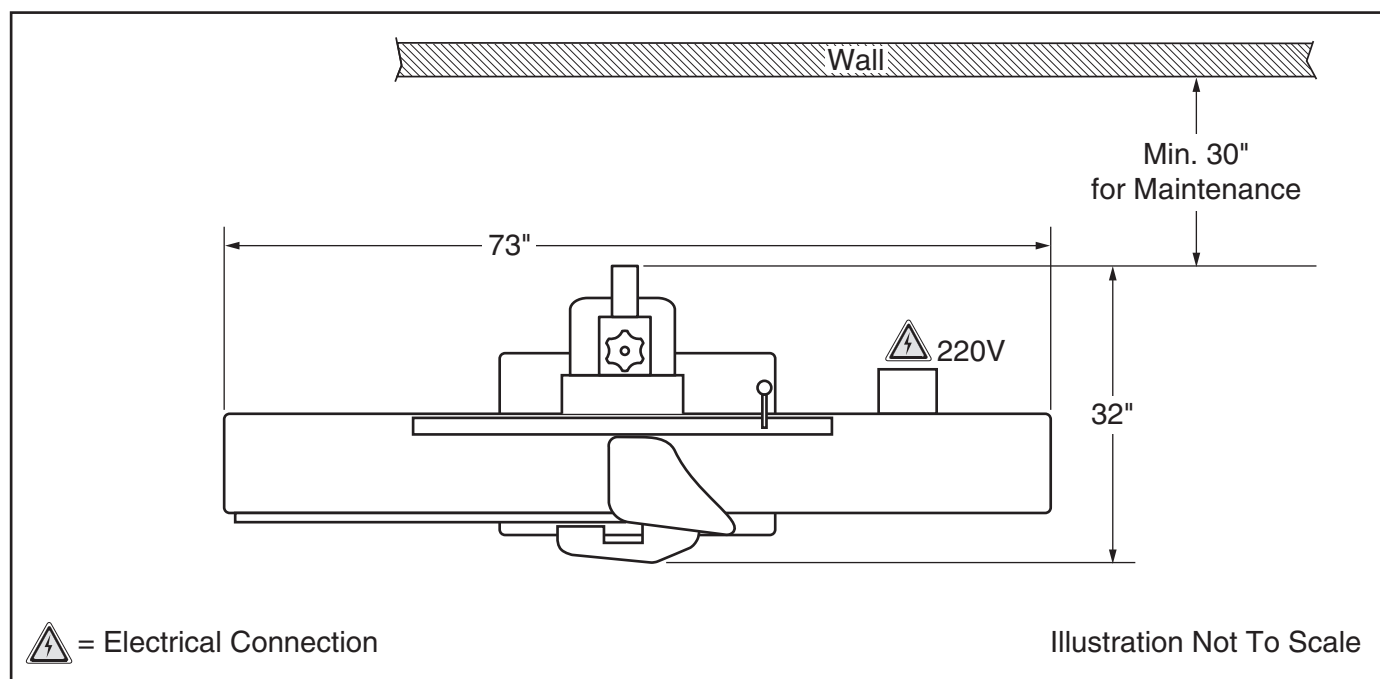
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions 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.

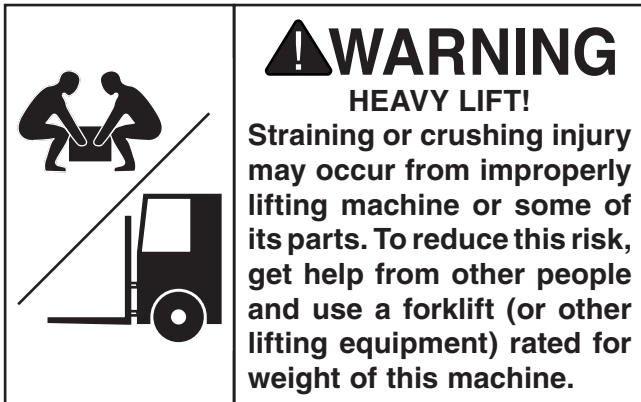


**Figure 10.** Minimum working clearances.



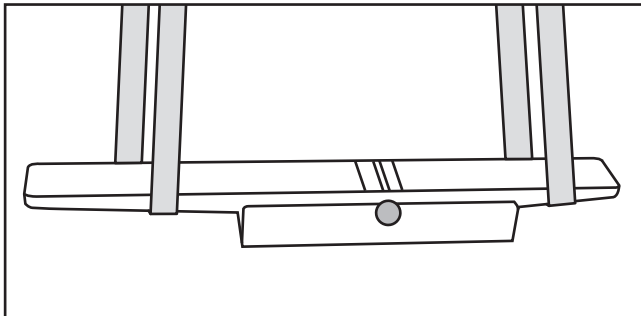


# Assembly



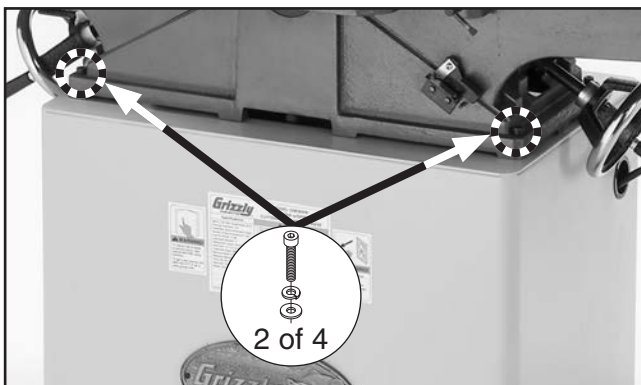
## To assemble jointer:

1. Secure table locks to prevent table movement during lifting, wrap lifting straps around infeed and outfeed table, as illustrated in **Figure 11**, then attach lifting strap ends to forklift forks, a hoist, or other powered lifting equipment.



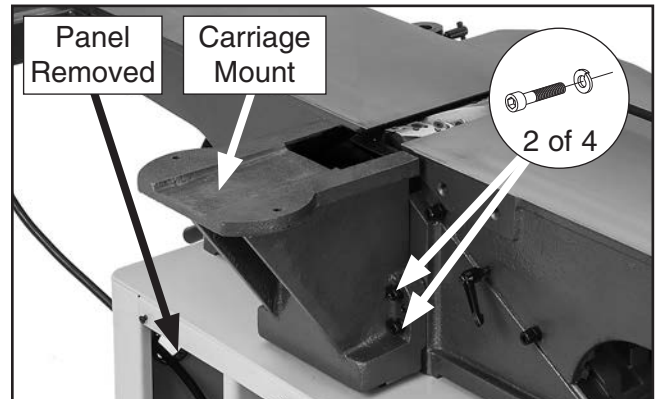
**Figure 11.** Using lifting straps to lift jointer assembly.

2. Lift jointer and secure to stand with (4) M8-1.25 x 40 cap screws, (4) 8mm lock washers, and (4) 8mm flat washers (see **Figure 12**).



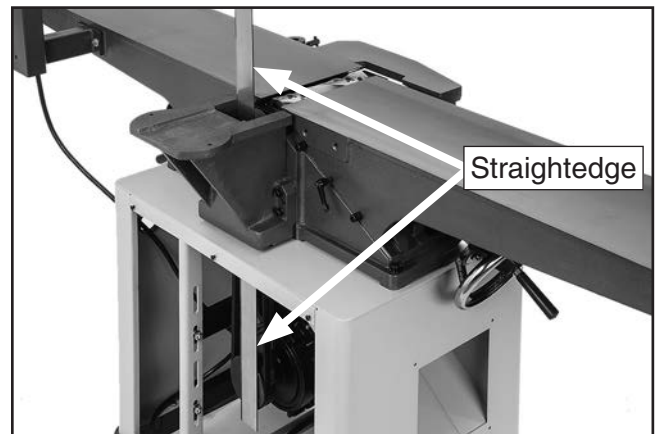
**Figure 12.** Jointer secured to stand.

3. Remove cabinet stand rear access panel, then install carriage mount to jointer using (4) pre-installed cap screws and lock washers (see **Figure 13**).

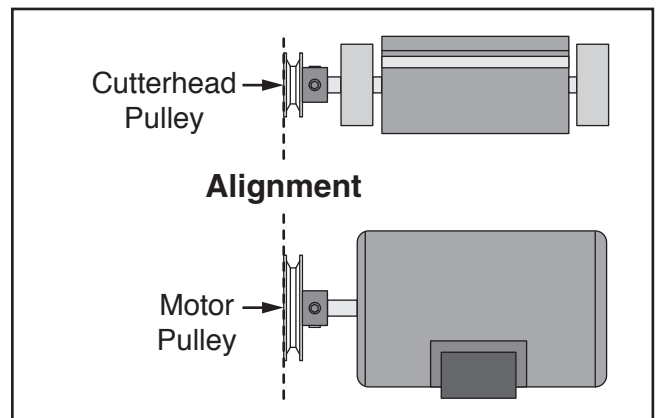


**Figure 13.** Carriage mount installed.

4. Place straightedge against pulleys to check their alignment (see **Figures 14–15**).  
 — If pulleys are aligned, go to **Step 7**.  
 — If pulleys are *not* aligned, do **Steps 5–6**.



**Figure 14.** Checking belt alignment.



**Figure 15.** Pulleys aligned.



5. Loosen motor mount hex bolts/nuts (see **Figure 16**).



**Figure 16.** Location of motor mount hex bolts/nuts (3 of 4 shown).

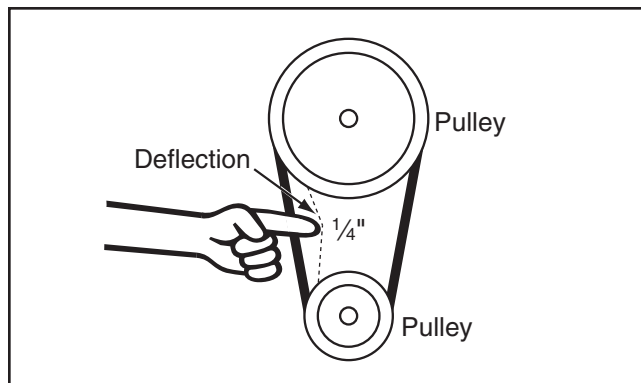
6. Shift motor horizontally as needed to align motor pulley with cutterhead pulley, then tighten motor mount hex bolts/nuts.
7. Loosen motor mount bracket hex bolts/nuts (see **Figure 17**). DO NOT completely remove fasteners.
8. Slide motor upward, place belt around cutterhead pulley and motor pulley, then slide motor down to rest on belt (see **Figure 17**).



**Figure 17.** Location of motor mount bracket hex bolts/nuts (3 of 4 shown).

9. Adjust belt tension by applying downward pressure on motor, until there is approximately  $\frac{1}{4}$ " deflection when belt is pushed with moderate force, as shown in **Figure 18**.

**Note:** After the first 16 hours of operation, re-tension the belt, as it will stretch and seat during this time, which causes it to lose the initial tension you set.



**Figure 18.** Checking for proper belt tension.

10. Tighten motor bracket hex bolts/nuts (see **Figure 17**), and replace rear access panel.
11. Insert cutterhead guard shaft into mounting hole on table, then tighten set screw (see **Figure 19**).



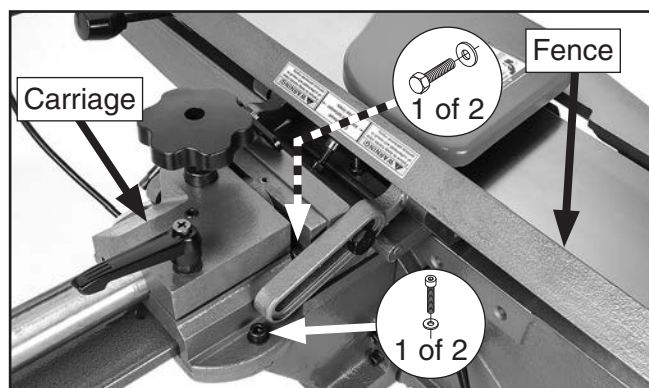
**Figure 19.** Cutterhead guard installed.

12. Rotate guard one revolution counter-clockwise as it appears from above, then have another person hold guard in position while you perform **Steps 13–14**.





13. Install carriage with (2) pre-installed cap screws and flat washers (see **Figure 20**).
14. Attach fence to carriage with (2) pre-installed hex bolts and flat washers (see **Figure 20**).



**Figure 20.** Carriage and fence installed.

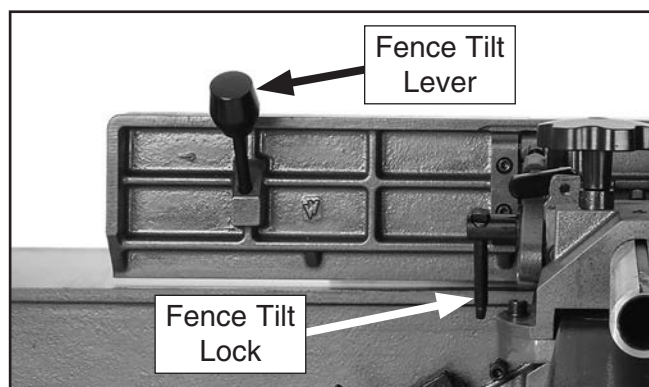
15. Test guard by pulling it back and letting it go. Guard should snap back quickly over cutterhead.

— If guard does *not* snap back, or snaps back slowly, remove guard and fence assembly, repeat **Steps 12–13**, then re-install fence.

## **NOTICE**

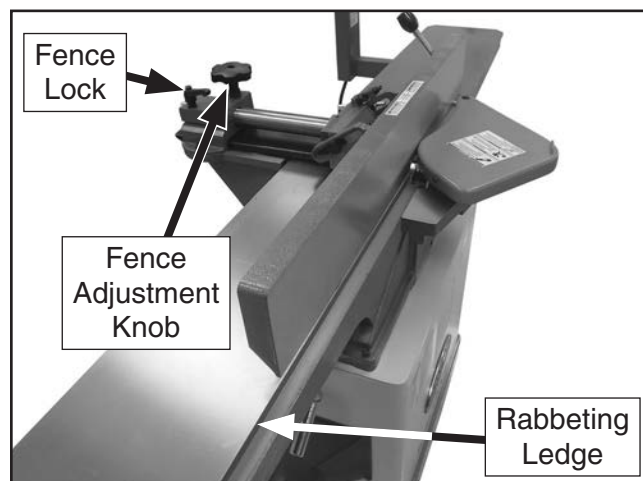
**Cutterhead guard must always return to closed position whenever it is moved. If it does not do this, it must be re-adjusted or re-installed.**

16. Install fence tilt lever (see **Figure 21**).
17. Loosen fence tilt lock (see **Figure 21**), tilt fence to 90°, then tighten lock.



**Figure 21.** Fence tilt lever installed.

18. Loosen fence lock and rotate fence adjustment knob to position fence flush with rabbeting ledge, then tighten fence lock to secure position (see **Figure 22**).

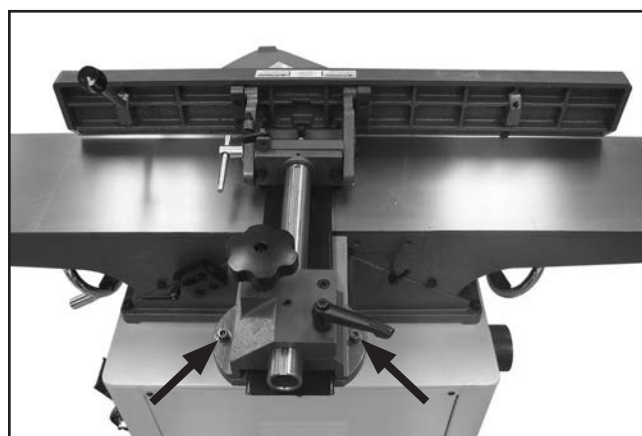


**Figure 22.** Fence positioned flush with rabbeting ledge.

19. Check to make sure fence is parallel with rabbeting ledge (see **Figure 22**).

— If fence *is* parallel with rabbeting ledge, proceed to **Step 20**.

— If fence *is not* parallel with rabbeting ledge, loosen cap screws shown in **Figure 23**, manually move fence until it is parallel with rabbeting ledge, then tighten cap screws to secure adjustment.



**Figure 23.** Location of cap screws for adjusting fence parallelism.

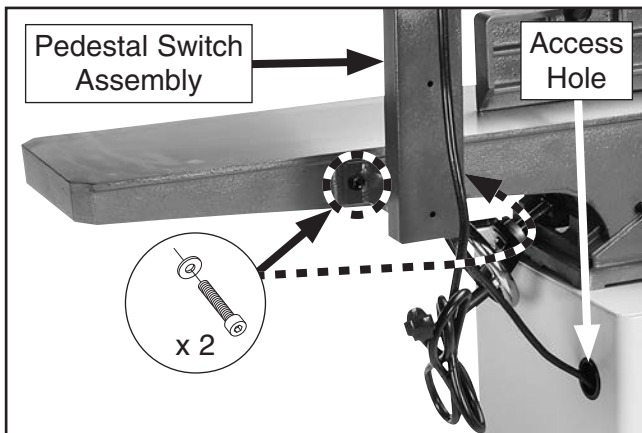


20. Place 5 x 5 x 20 key in each handwheel shaft keyway, then install infeed and outfeed handwheels with the pre-installed cap screws and flat washers (see **Figure 24**).
21. Secure handwheel handle onto each handwheel (see **Figure 24**).



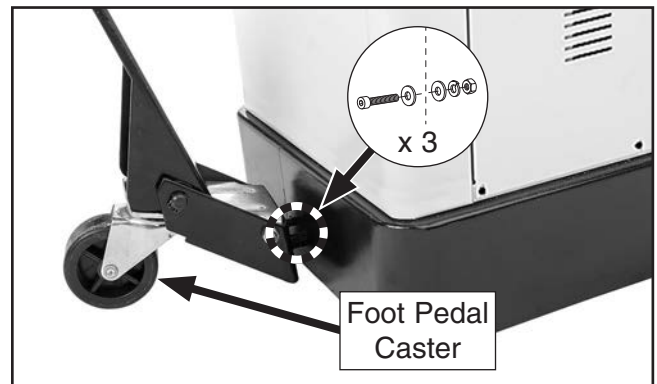
**Figure 24.** Securing the handwheel handle.

22. Mount pedestal switch assembly to jointer with (2) pre-installed M8-1.25 x 20 cap screws and flat washers (see **Figure 25**).
23. Thread excess switch cord through access hole in cabinet stand (see **Figure 25**), and connect it to motor cord.



**Figure 25.** Pedestal switch attached to stand.

24. Mount foot-pedal caster to bottom of stand using (3) M8-1.25 x 50 cap screws, (3) 8mm lock washers, (6) 8mm flat washers, and (3) M8-1.25 hex nuts, then re-install cabinet stand rear access panel (see **Figure 26**).



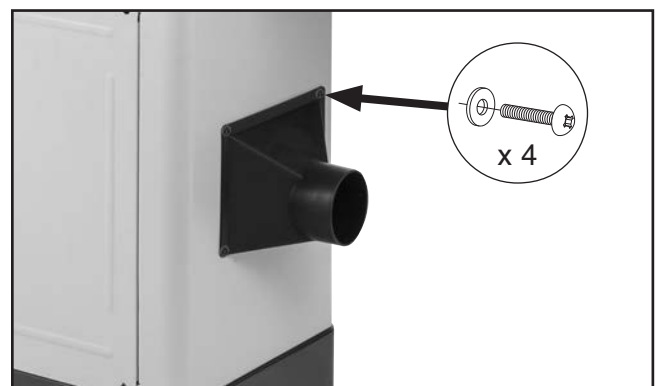
**Figure 26.** Foot pedal and caster installed on bottom of stand.

25. Assemble knife-setting gauge using the knife-setting gauge rod, feet and external retaining rings, as shown in **Figure 27**.



**Figure 27.** Knife-setting gauge assembly.

26. Install dust port as shown in **Figure 28**, using (4) M5-.8 x 10 Phillips head screws and (4) 5mm flat washers.



**Figure 28.** Dust port installed.



# Dust Collection

## ⚠ CAUTION

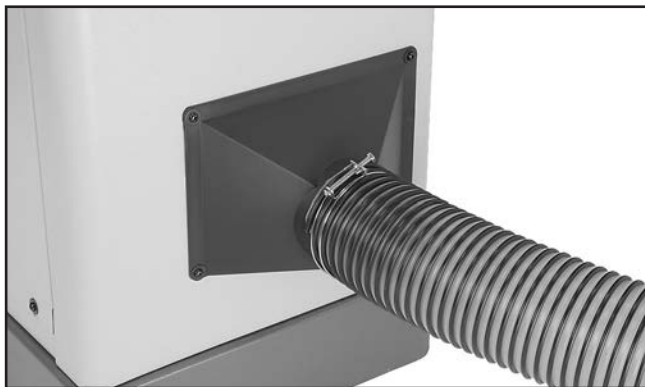
This machine creates substantial amounts of dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust collection system.

### Recommended CFM at Dust Port: 400 CFM

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

### To connect dust collection hose:

1. Fit 4" dust hose over dust port, as shown in **Figure 29**, and secure with a hose clamp.



**Figure 29.** Dust hose attached to dust port.

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

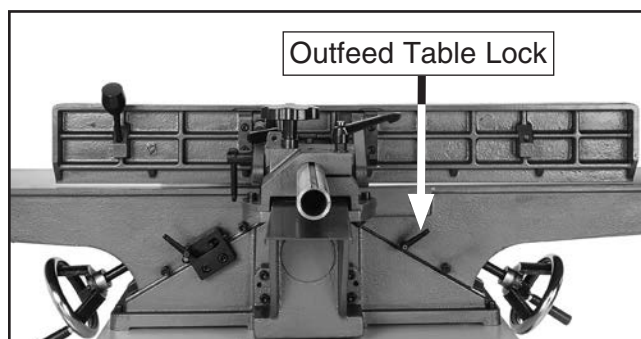
**Note:** A tight fit is necessary for proper performance.

# Setting Outfeed Table Height

To help ensure safe operation and best cutting results, the outfeed table height **MUST** be level with the knives when they are at top-dead-center (TDC). If the outfeed table is set too low, the workpiece will be tapered from front to back or there will be snipe (a gouge in end of board that is uneven with rest of cut). 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.

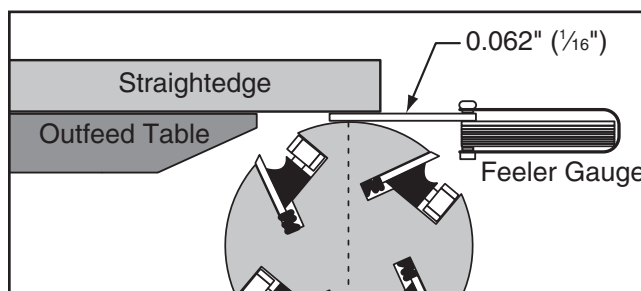
### To set outfeed table height:

1. DISCONNECT MACHINE FROM POWER!
2. Move cutterhead guard out of the way.
3. Loosen outfeed table lock (see **Figure 30**).



**Figure 30.** Location of outfeed table lock.

4. Place straightedge on outfeed table so it extends over cutterhead, lower outfeed table until straightedge is 0.062" ( $\frac{1}{16}$ ") above cutterhead body, as determined by using a feeler gauge (see **Figure 31**), then tighten outfeed table lock.



**Figure 31.** Setting outfeed table height.



# 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 machine:

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

The motor should run smoothly and without unusual problems or noises.

Congratulations! The Test Run is complete. Proceed to **Recommended Adjustments** on the this page.

# Recommended Adjustments

---

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

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

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

### Factory adjustments that should be verified:

1. Knife Settings (**Page 39**).
2. Depth Scale Calibration (**Page 42**).
3. Fence Stop Accuracy (**Page 43**).
4. Table Parallelism (**Page 46**).

# Tighten Belt

---

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belt will stretch and seat into the pulley groove. After this time, you must re-tension the belt to avoid slippage and burn out. Refer to **Page 46** when you are ready to perform this important adjustment.

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

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



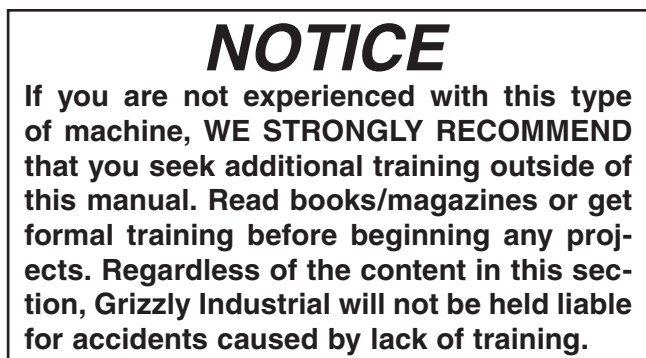
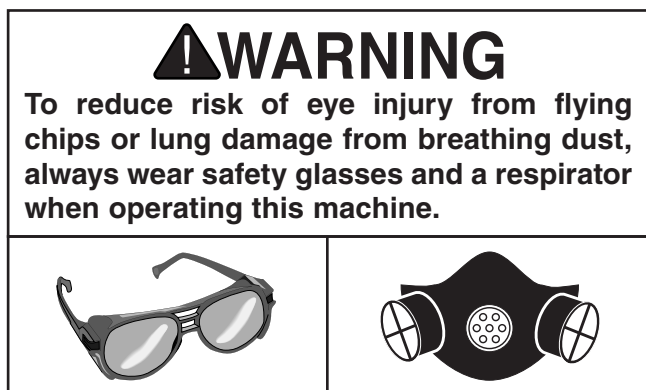


# SECTION 4: OPERATIONS

## Operation Overview

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

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



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

1. Examines workpiece to verify it is safe and suitable for cutting.
2. Adjusts fence for width of workpiece and locks it in place.
3. Adjusts fence tilt, if necessary.
4. Adjusts infeed table height to set depth of cut per pass.
5. Puts on safety glasses, respirator, and ear protection.
6. Locates push blocks.
7. Starts jointer.
8. Holds workpiece firmly against infeed table and fence, and slides it into cutterhead at a steady and controlled rate until entire length of workpiece has advanced beyond cutterhead to outfeed table.
9. Repeats cutting process until desired results are achieved.
10. Stops jointer.

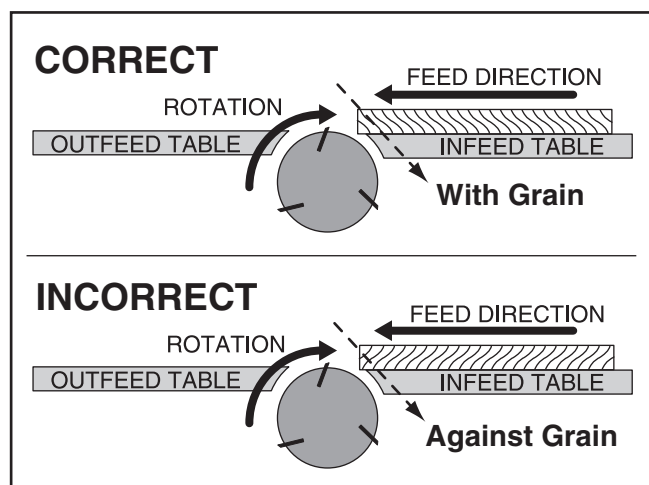


# Stock Inspection & Requirements

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.

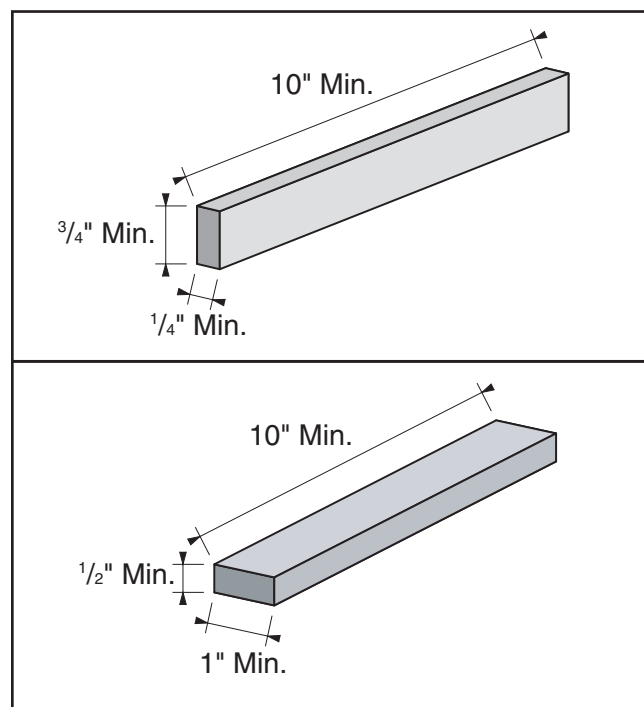


**Figure 32.** Proper grain alignment with the cutterhead.

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

**Note:** Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.
- **Make sure your workpiece exceeds the minimum dimension requirements shown below, before processing it through the jointer, or the workpiece may break or kickback during the operation.**



**Figure 33.** Minimum stock dimensions for jointer.



# Setting Depth of Cut

The depth of cut on a jointer affects the amount of material removed from the bottom of the workpiece as it passes over the cutterhead.

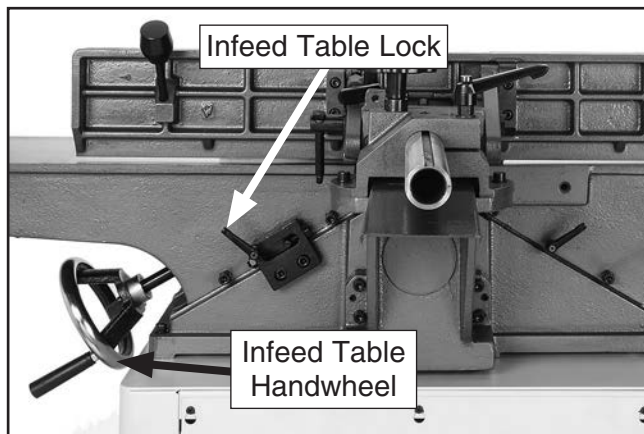
The depth of cut is set by adjusting the height of the infeed table relative to the cutterhead knives/inserts at TDC (top dead center).

The depth stop can be used to set the maximum depth of cut to  $\frac{1}{8}$ " for most jointing operations, and the depth-of-cut scale displays the depth of cut, which goes up to  $\frac{1}{2}$ " for cutting rabbets (see **Figure 36** on this page).

**DO NOT exceed  $\frac{1}{8}$ " depth of cut per pass on this machine or kickback and serious injury may occur!**

## Adjusting Infeed Table Height

To adjust the infeed table height, loosen the infeed table lock, rotate the infeed table handwheel to raise or lower the table, and then tighten the lock to secure the setting (see **Figure 34**).



**Figure 34.** Infeed table controls located on back of machine.

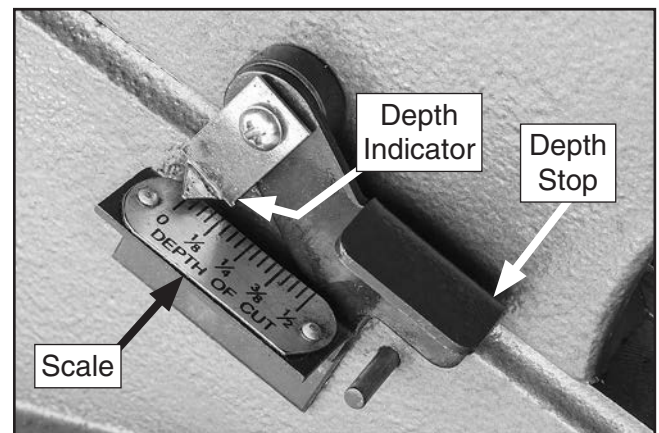
## Depth-of-Cut Scale

The depth of cut can be referenced directly from the depth scale located on the front of the jointer (see **Figures 35–36**).

**Note:** The depth scale can be calibrated or "zeroed" if it is not correct. Refer to **Calibrating Depth Scale** on **Page 42** for more information.



**Figure 35.** Location of depth-of-cut scale.



**Figure 36.** Depth-of-cut scale components.

## Depth Stop

The depth stop (see **Figure 36**) prevents the operator from accidentally exceeding the  $\frac{1}{8}$ " maximum depth-of-cut for normal jointing operations, yet it can easily be bypassed to allow a total cutting depth of up to  $\frac{1}{2}$ " when rabbet cutting.

To engage the lever, position it as shown in **Figure 36**. To disengage the lever, raise the table to "0", then raise the lever out of the way while lowering the table to the desired height.





## Positive Stop-Screws

The infeed table has positive-stop screws (see **Figure 37**) that allow the operator to quickly adjust the infeed table between finish/final cuts and shaping/heavy cuts.

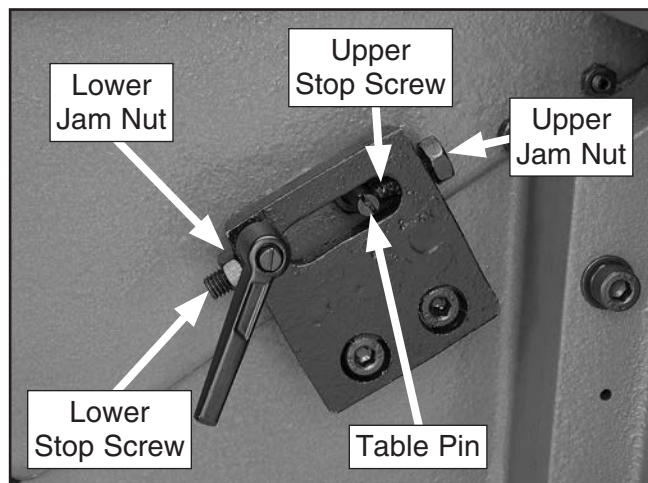
We recommend setting the minimum depth of cut to  $\frac{1}{32}$ " and the maximum depth of cut to  $\frac{1}{8}$ " for most operations.

### Tools Needed

	Qty
Wrench 13mm .....	1
Hex Wrench 4mm.....	1

### To adjust positive-stop screws:

1. Loosen jam nuts and stop screws shown in **Figure 37**, but do not completely remove them.
2. Lower table to maximum desired depth of cut.
3. Tighten lower stop screw until it contacts table pin shown in **Figure 37**, and then tighten lower jam nut to secure stop screw.
4. Raise table to minimum desired depth of cut, then repeat **Step 4** with upper stop screw and jam nut (see **Figure 37**).

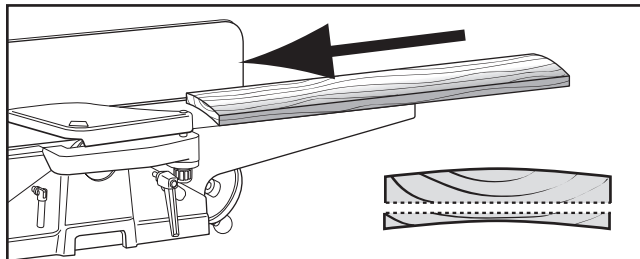


**Figure 37.** Positive-stop components for infeed table.

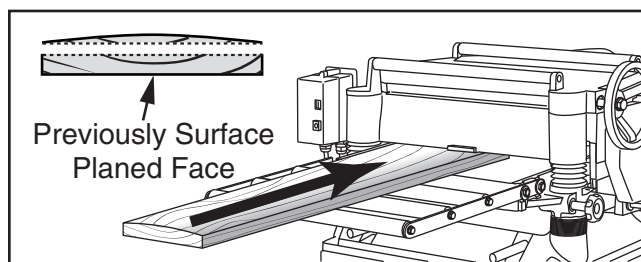
## Squaring Stock

**Squaring stock involves four steps performed in the order below:**

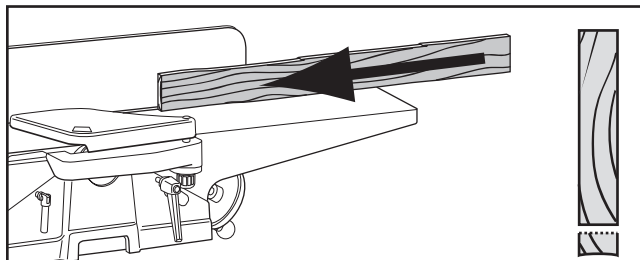
**1. Surface Plane on the Jointer**—The concave face of the workpiece is surface planed flat with the jointer.



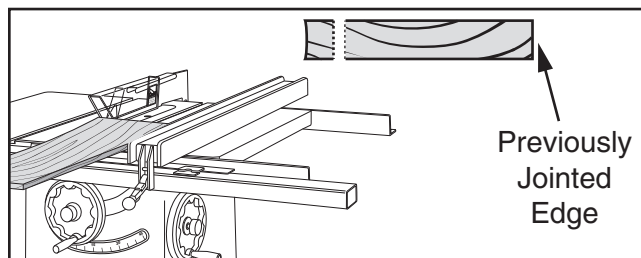
**2. Surface Plane on a Thickness Planer**—The opposite face of the workpiece is surface planed flat with a thickness planer.



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



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

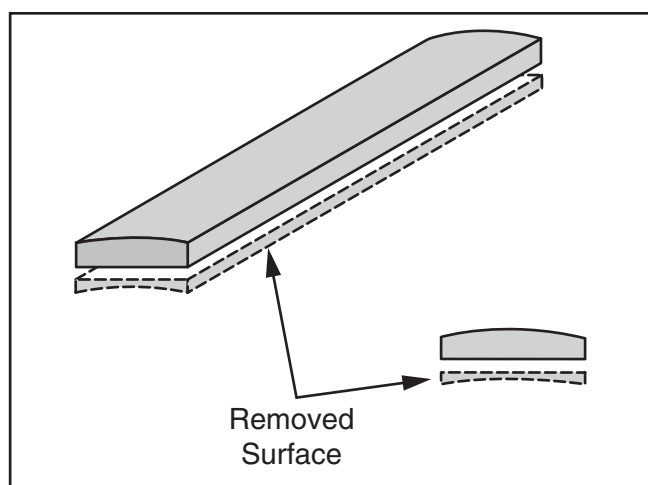


# Surface Planing

The purpose of surface planing (see **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.

## 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.



**Figure 38.** Illustration of surface planing results.



**Figure 39.** Example of surface planing 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:** For safety reasons, do not exceed a cutting depth of  $\frac{1}{16}$ " 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.

## ⚠ 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!

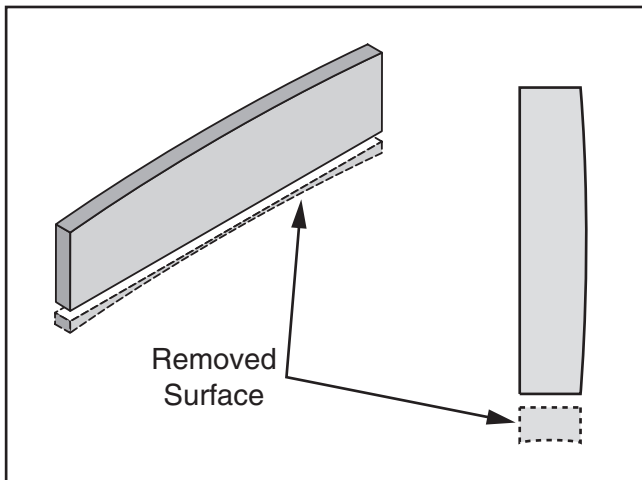


# Edge Jointing

Edge jointing (see **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.

## 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.



**Figure 40.** Illustration of edge jointing results.



**Figure 41.** Example of edge jointing operation.

### To edge joint 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:** For safety reasons, cutting depth should never exceed  $\frac{1}{8}$ " per pass.

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 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.

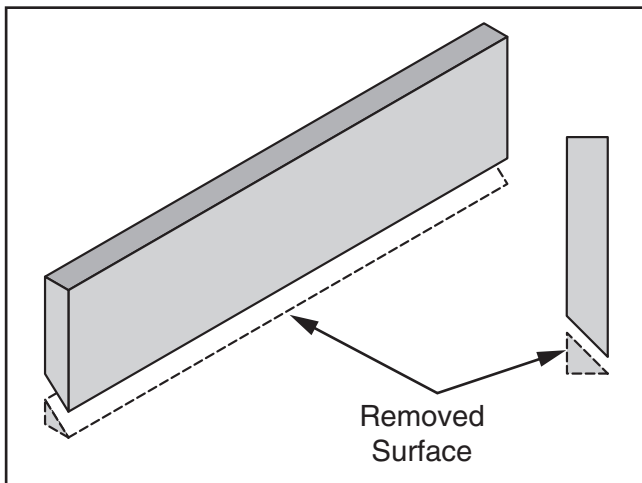


# Bevel Cutting

Bevel cuts (see **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.

## 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.**



**Figure 42.** Illustration of bevel cutting results.



**Figure 43.** Fence setup for a bevel cut of 45°.

## To bevel cut 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 cutting depth desired for each pass.

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

3. Set fence tilt to desired angle of cut.
4. Place workpiece against fence and infeed table with concave side face down.
5. Start jointer.
6. 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.

**Note:** *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!*

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

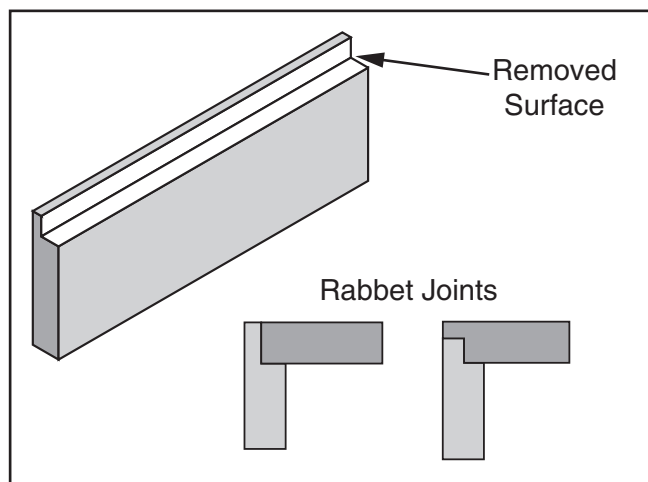


# Rabbet Cutting

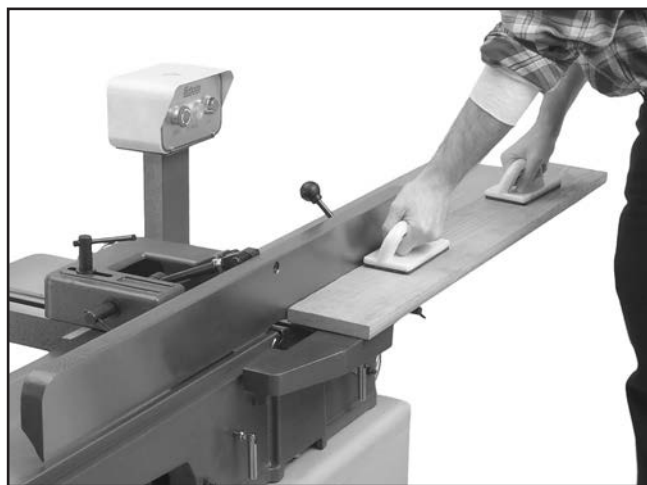
The purpose of rabbet cutting is to remove a section of the workpiece edge (see **Figures** below). When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

## NOTICE

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



**Figure 44.** Illustration of rabbet cutting effects and a few sample joints.



**Figure 45.** Typical rabbet cutting operation.

### To rabbet cut 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:** For safety reasons, cutting depth should never exceed  $\frac{1}{8}$ " per pass.

3. Remove cutterhead guard.
4. Set fence to 90° and near front of jointer, so amount of exposed cutterhead in front of fence matches size of desired rabbet.
5. Start jointer.
6. 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.

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

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

## ⚠ WARNING

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





# SECTION 5: ACCESSORIES

## **! WARNING**

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

## **NOTICE**

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

**G1753—Jointer Pal® Magnetic Knife Gauge (For HSS & Cobalt Knives)**

**G1756—Jointer Pal® Magnetic Knife Gauge (For Carbide Knives)**

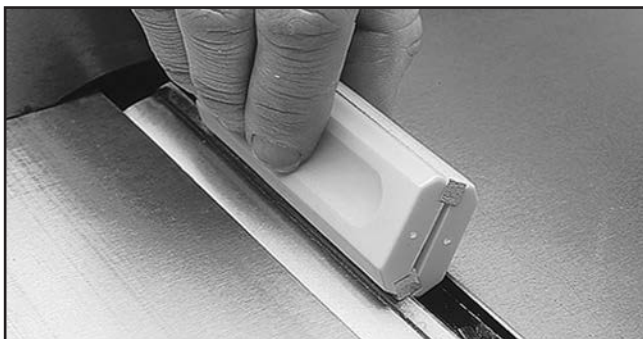
This magnetic knife-setting system lets you set jointer knives in perfect alignment every time!



**Figure 46.** G1753 Jointer Pal® Knife Gauge.

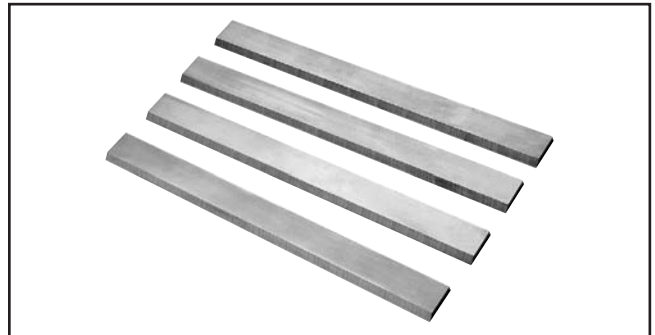
**G3631—Jointer/Planer Knife Hone**

This handy tool sharpens flat and beveled surfaces quickly and easily. Great for touch-ups.



**Figure 47.** Jointer knife hone.

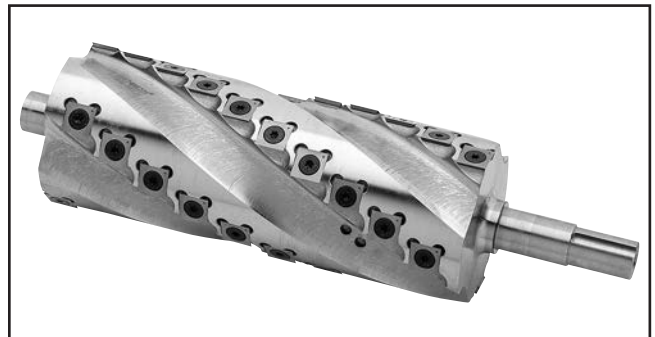
**T27445—8" x 3/4" x 1/8" HSS Jointer Knives**



**Figure 48.** T27445 Jointer Knives for G0656W.

**T27454—8" Spiral Cutterhead for G0656W**

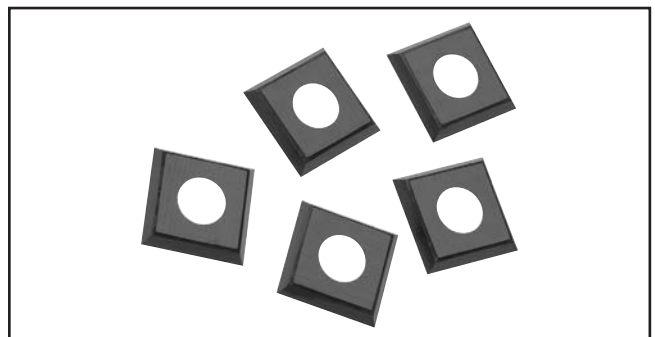
40 indexable carbide inserts on this spiral cutterhead produce a glass-smooth finish on even the toughest hardwoods. Indexable carbide inserts last up to 10x longer than HSS steel.



**Figure 49.** T27454 Spiral Cutterhead Upgrade for G0656W.

**H7319—Indexable Carbide Inserts (G0656XW)**

Designed for use in spiral cutterhead systems, each solid carbide insert provides 4 cutting edges! Size: 14 x 14 x 2mm (10 pack).

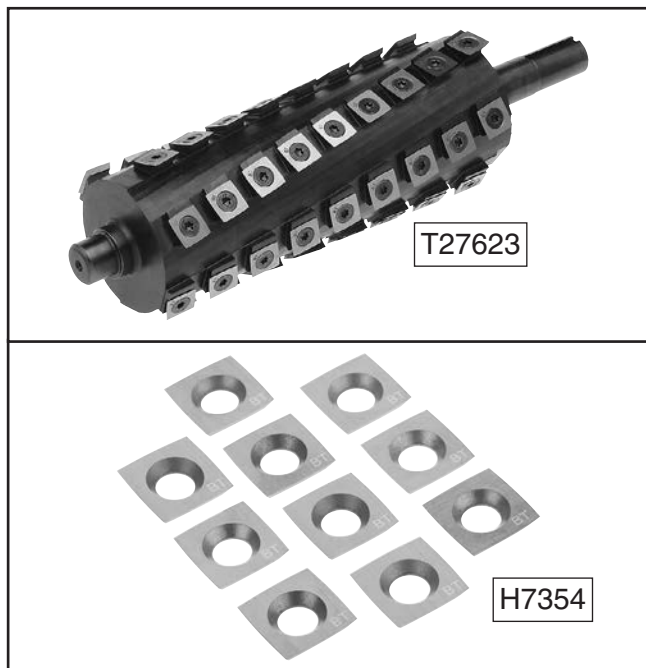


**Figure 50.** H7319 Indexable Carbide Inserts.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



**T27623—8" Shelix Cutterhead**  
**H7354—Shelix Carbide Inserts 15 x 15 x 2.5mm**



**Figure 51.** Shelix 8" cutterhead and indexable carbide inserts.

## Basic Eye Protection

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



**Figure 52.** Assortment of basic eye protection.

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

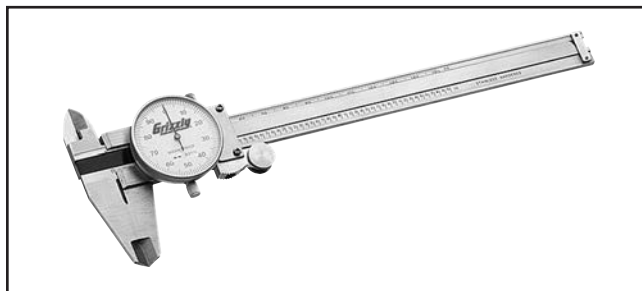
If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



**Figure 53.** Half-mask respirator with disposable cartridge filters.

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

Required for jointing, planing, or sanding to critical tolerances. These calipers are accurate to 0.001" and feature stainless steel, shock-resistant construction and a dust proof display.



**Figure 54.** Grizzly® Dial Calipers.

**SB1365—South Bend Way Oil-ISO 68**



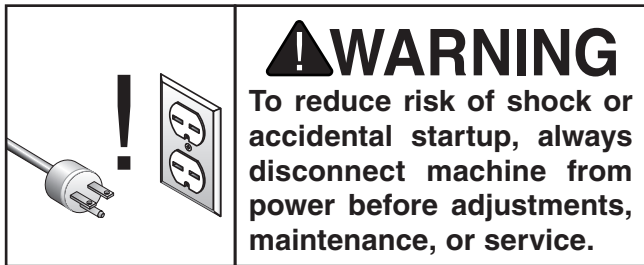
**Figure 55.** Recommended product for machine lubrication.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**





# SECTION 6: MAINTENANCE



## Schedule

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

### Daily

- Vacuum all dust on and around the machine.
- Wipe down tables and all other unpainted cast-iron with a metal protectant.
- Check for/repair worn or damaged wires.
- Check/resolve any other unsafe condition.
- Check/tighten loose mounting bolts.
- Check/replace damaged cutterhead knives/inserts.

### Monthly

- Check belt for proper tension, damage, or wear/replace belt.
- Clean/vacuum dust buildup from inside cabinet and off motor.

## Cleaning & Protecting

The cleaning process for this machine is simple. 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.

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.

**G5562—SLIPIT® 1 Qt. Gel**

**G5563—SLIPIT® 12 Oz. Spray**

**G2871—Boeshield® T-9 12 Oz. Spray**

**G2870—Boeshield® T-9 4 Oz. Spray**

**H3788—G96® Gun Treatment 12 Oz. Spray**

**H3789—G96® Gun Treatment 4.5 Oz. Spray**



**Figure 56.** Recommended products for protecting unpainted cast-iron and steel.



# Lubrication

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

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more grease to them will not yield smooth moving components.

Clean the components below with mineral spirits or other oil/grease solvent cleaner and shop rags.

## Leadscrews

Oil Type ..... SB1365 or ISO 68 Equivalent  
Oil Amount ..... Thin Coat  
Frequency ..... As Needed

Lubricate with light machine oil as needed (see **Figure 57**). Wipe off excess oil and sawdust with a cloth.

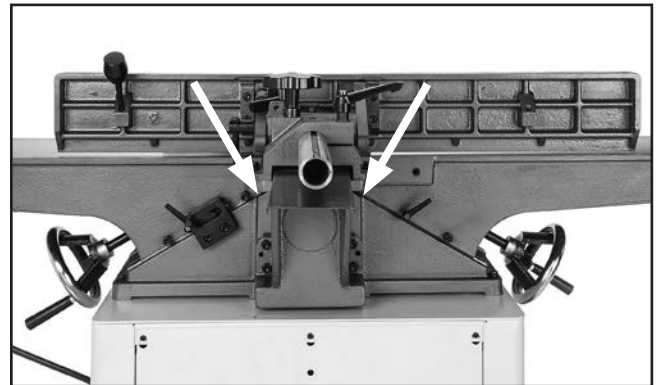


**Figure 57.** Leadscrew lubrication location.

## Table Ways

Oil Type .... Grizzly T23962 or ISO 68 Equivalent  
Oil Amount ..... 1–2 Drops  
Lubrication Frequency ..... As Needed

Lower infeed and outfeed tables to access ways. Place a couple of drops of oil at top of each way as needed and move tables up and down to distribute oil (see **Figure 58**). Wipe off excess oil.

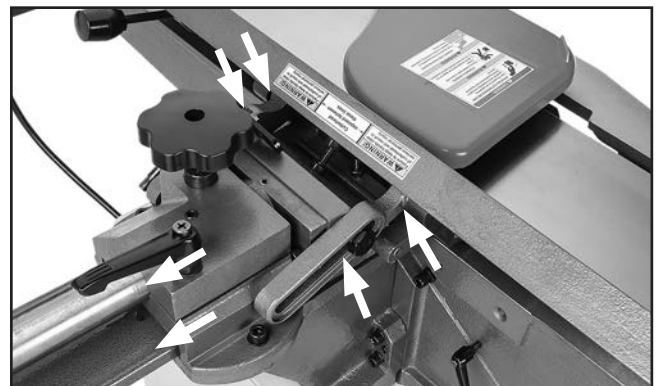


**Figure 58.** Location to lubricate table ways.

## Fence

Oil Type .... Grizzly T23962 or ISO 68 Equivalent  
Oil Amount ..... 1–2 Drops  
Lubrication Frequency ..... As Needed

Place one or two drops of light machine oil on fence pivot points (see **Figure 59**) as needed.



**Figure 59.** Fence lubrication locations.

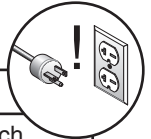


# SECTION 7: SERVICE

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

## Troubleshooting

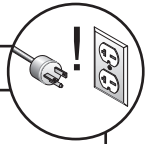
### Motor & Electrical



Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips immediately after startup.	<ol style="list-style-type: none"> <li>1. OFF/STOP button not reset.</li> <li>2. Incorrect power supply voltage/circuit size.</li> <li>3. Power supply circuit breaker tripped/fuse blown.</li> <li>4. Motor wires connected incorrectly.</li> <li>5. Wiring open/has high resistance.</li> <li>6. ON button at fault.</li> <li>7. Centrifugal switch at fault.</li> <li>8. Start capacitor at fault.</li> <li>9. Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Press OFF/STOP button in fully to reset switch.</li> <li>2. Ensure correct power supply voltage/circuit size.</li> <li>3. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.</li> <li>4. Correct motor wiring connections (<b>Page 47</b>).</li> <li>5. Check/fix broken, disconnected, or corroded wires.</li> <li>6. Test/replace switch.</li> <li>7. Adjust/replace centrifugal switch if available.</li> <li>8. Test/replace capacitor.</li> <li>9. Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Workpiece material not suitable.</li> <li>2. Excessive feed rate.</li> <li>3. Excessive cutting depth.</li> <li>4. Dull knives/inserts.</li> <li>5. Dust collection problem, causing internal components to clog up with shavings.</li> <li>6. Belt slipping; oil/grease on belt.</li> <li>7. Pulley loose or not properly aligned.</li> <li>8. Motor overheated.</li> <li>9. Motor wires connected incorrectly.</li> <li>10. Plug/receptacle at fault.</li> <li>11. Run capacitor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Ensure workpiece is suitable for jointing (<b>Page 26</b>).</li> <li>2. Reduce feed rate.</li> <li>3. Reduce cutting depth (<b>Page 27</b>).</li> <li>4. Sharpen/replace knives; rotate/replace insert(s) (<b>Pages 39–41</b>).</li> <li>5. Clear blockages; move machine closer to dust collector; upgrade dust collector.</li> <li>6. Tension/replace belt (<b>Page 46</b>); clean belt; ensure pulleys are aligned (<b>Page 19</b>).</li> <li>7. Re-align pulleys; replace shaft key; tighten pulley set screw.</li> <li>8. Clean motor, let cool, and reduce depth of cut.</li> <li>9. Correct motor wiring connections (<b>Page 47</b>).</li> <li>10. Test for good contacts/correct wiring.</li> <li>11. Test/repair/replace.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor or other component loose.</li> <li>2. Belt worn/loose; belt slapping cover.</li> <li>3. Pulley loose or not properly aligned.</li> <li>4. Motor fan rubbing on fan cover.</li> <li>5. Foot-pedal caster engaged.</li> <li>6. Knives/inserts at fault.</li> <li>7. Cutterhead bearings at fault.</li> <li>8. Centrifugal switch at fault.</li> <li>9. Motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace damaged bolts/nuts; retighten loose bolts/nuts. Use thread-locking fluid if condition repeats.</li> <li>2. Tension/replace belt (<b>Page 46</b>).</li> <li>3. Re-align pulleys; replace shaft key; tighten pulley set screw.</li> <li>4. Fix/replace fan cover; replace loose/damaged fan.</li> <li>5. Release foot-pedal caster to stabilize machine.</li> <li>6. Sharpen/replace knives; set knife alignment/height correctly; rotate/replace inserts (<b>Pages 39–41</b>).</li> <li>7. Replace bearing(s)/realign cutterhead.</li> <li>8. Replace.</li> <li>9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> </ol>



## Machine Operation



Symptom	Possible Cause	Possible Solution
Table(s) difficult to adjust.	<ol style="list-style-type: none"> <li>1. Table lock(s) engaged/partially engaged.</li> <li>2. Infeed table stops blocking movement.</li> </ol>	<ol style="list-style-type: none"> <li>1. Completely loosen table lock(s) (<b>Page 5</b>).</li> <li>2. Loosen/reset infeed table stops (<b>Page 28</b>).</li> </ol>
Excessive snipe (gouge in end of board that is uneven with rest of cut).	<ol style="list-style-type: none"> <li>1. Outfeed table set too low, or knives (G0656W only) set too high.</li> <li>2. Operator pushing down on trailing end of workpiece as it leaves cutterhead.</li> </ol>	<ol style="list-style-type: none"> <li>1. Align outfeed table with cutterhead knife/insert at top dead center (<b>Page 23</b>); adjust height of knives (G0656W) evenly with outfeed table (<b>Page 39</b>).</li> <li>2. Reduce/eliminate downward pressure on trailing end of workpiece as it leaves cutterhead.</li> </ol>
Workpiece stops in middle of cut.	<ol style="list-style-type: none"> <li>1. Outfeed table set too high.</li> </ol>	<ol style="list-style-type: none"> <li>1. Align outfeed table with cutterhead knife/insert at top dead center (<b>Page 23</b>).</li> </ol>
Workpiece chipping, tear-out, or overall rough cuts.	<ol style="list-style-type: none"> <li>1. Not feeding workpiece to cut "with the grain."</li> <li>2. Dull knives/inserts.</li> <li>3. Workpiece not suitable for jointing.</li> <li>4. Nicked or chipped knives/inserts.</li> <li>5. Feeding workpiece too fast.</li> <li>6. Excessive cut depth.</li> <li>7. Lack of proper dust collection or clogged dust port.</li> </ol>	<ol style="list-style-type: none"> <li>1. Turn the workpiece 180° before feeding again.</li> <li>2. Sharpen/replace knives; rotate/replace insert(s) (<b>Pages 39–41</b>).</li> <li>3. Ensure workpiece is suitable for jointing (<b>Page 26</b>).</li> <li>4. Replace knives; rotate/replace insert(s) (<b>Pages 39–41</b>).</li> <li>5. Reduce feed rate.</li> <li>6. Reduce cut depth (<b>Page 27</b>).</li> <li>7. Clear blockages, ensure dust collector is operating efficiently; upgrade dust collector.</li> </ol>
Fuzzy grain.	<ol style="list-style-type: none"> <li>1. Wood has high moisture content.</li> <li>2. Dull knives/inserts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Ensure wood moisture content is less than 20%. Allow to dry if necessary.</li> <li>2. Sharpen/replace knives; rotate/replace insert(s) (<b>Pages 39–41</b>).</li> </ol>
Long lines or ridges that run along length of workpiece.	<ol style="list-style-type: none"> <li>1. Nicked or chipped knives/inserts.</li> <li>2. Loose or incorrectly installed insert(s).</li> <li>3. Dirt or debris under carbide inserts (spiral cutterheads only).</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace knives; rotate/replace insert(s) (<b>Pages 39–41</b>).</li> <li>2. Remove/replace insert(s) and install properly (<b>Page 41</b>).</li> <li>3. Remove inserts, properly clean mounting pocket and re-install (<b>Page 41</b>).</li> </ol>
Uneven cutter marks, wavy surface, or chatter marks across face of workpiece.	<ol style="list-style-type: none"> <li>1. Feeding workpiece too fast.</li> <li>2. Knives not properly adjusted.</li> <li>3. Dirt or debris under carbide inserts (spiral cutterheads only).</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate.</li> <li>2. Properly adjust knives (<b>Page 39</b>).</li> <li>3. Remove inserts, properly clean mounting pocket and re-install (<b>Page 41</b>).</li> </ol>
Glossy surface; scorching or burn marks on workpiece.	<ol style="list-style-type: none"> <li>1. Dull knives/inserts.</li> <li>2. Feed rate too slow.</li> </ol>	<ol style="list-style-type: none"> <li>1. Sharpen/replace knives; rotate/replace insert(s) (<b>Pages 39–41</b>).</li> <li>2. Increase feed rate.</li> </ol>
Workpiece is concave or convex along its length after jointing.	<ol style="list-style-type: none"> <li>1. Workpiece not held with even pressure against outfeed table during cut.</li> <li>2. Workpiece too uneven at start of operation.</li> <li>3. Outfeed table not parallel with infeed table.</li> </ol>	<ol style="list-style-type: none"> <li>1. Apply even downward pressure against workpiece throughout entire travel along outfeed side during cut.</li> <li>2. Take partial cuts to remove extreme high spots before doing a full pass.</li> <li>3. Check/Adjust table parallelism (<b>Page 46</b>).</li> </ol>

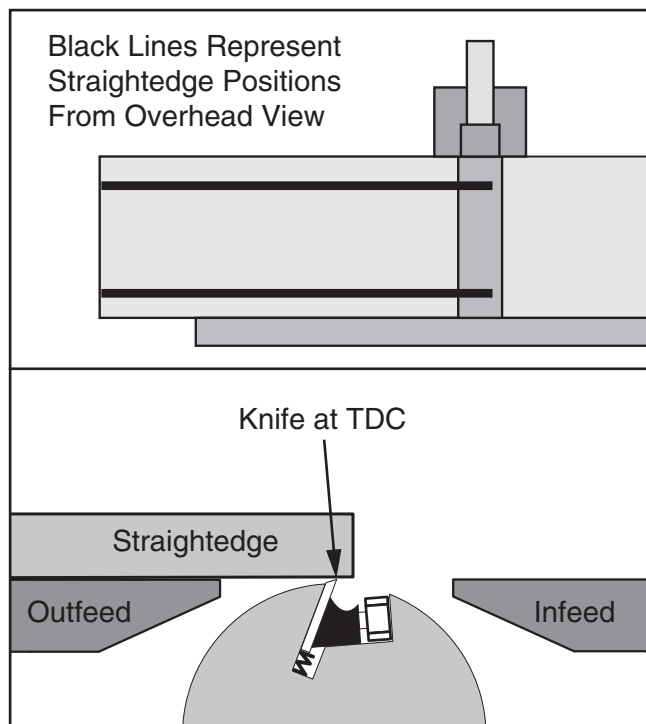


# Inspecting Knives (G0656W)

The height of the knives can be inspected with a straightedge to ensure that they are set even with the outfeed table at their highest point in the cutterhead rotation, or top dead center (TDC).

## To inspect the knives:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard or block it out of the way.
3. Using a straightedge on outfeed table, check height of each knife at positions shown in **Figure 60** below.



**Figure 60.** Using a straightedge to inspect knives.

— The knives are set correctly set when they just touch the bottom of the straightedge at TDC in each of t straightedge positions

# Setting/Replacing Knives (G0656W)

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

There are two options for setting the knives—the straightedge method and the knife-setting jig method. Each option has advantages and disadvantages; the correct one for you will become a matter of personal preference. For best results, the tables must be parallel with each other (refer to **Checking/Adjusting Table Parallelism** on **Page 46**) and the outfeed table height must be properly set (refer to **Setting Outfeed Table Height** on **Page 23**).

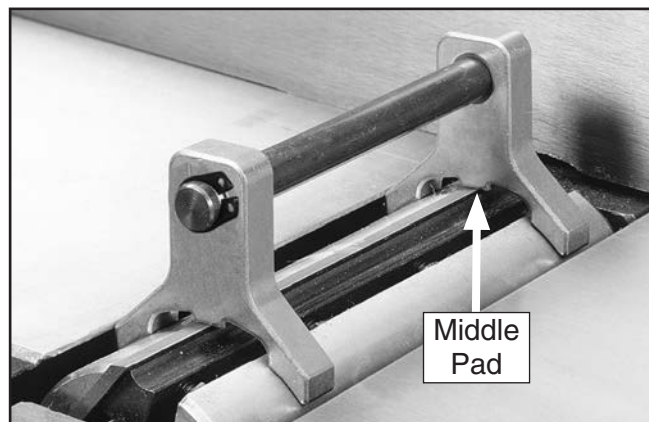
**Straightedge Method:** A high quality straightedge is held flat against the outfeed table and the knife heights are set to the bottom of the straightedge, as shown in **Figure 60**. Because the knife projection height from the cutterhead is dependent on the outfeed table height, the outfeed table must be set as described in **Setting Outfeed Table Height** on **Page 23** for this method to work correctly.

When using the straightedge method to set the knives, you will not need to move the outfeed table once it is set and you will always be assured that the knives are even with the outfeed table in their highest point of rotation (TDC)—even if the cutterhead is not parallel with the outfeed table.





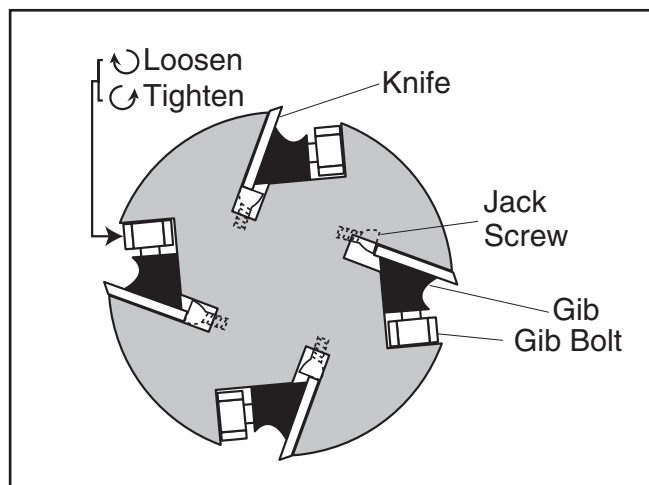
**Knife-Setting Jig Method:** The infeed table is lowered to fit the jig on the cutterhead, as shown in **Figure** , and the knife heights are set to just touch the middle pad of the jig.



**Figure .** Example of knife-setting jig positioned over cutterhead knife.

The knife-setting jig included with the jointer is designed to set all the knives evenly and at the correct height in the cutterhead.

The cutterhead in this jointer is equipped with jack screws that allow for careful positioning of the knives.



**Figure 61.** Cutterhead profile diagram.

Tools Needed		Qty
Knife-Setting Jig .....		1
Hex Wrench 3mm.....		1
Open-End Wrench 10mm.....		1

#### To inspect positioning of knives in cutterhead:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard or block it open.
3. Lower infeed table to  $\frac{1}{2}$ " scale mark.
4. Place knife jig on cutterhead, directly over a knife.
5. Closely examine how jig touches cutterhead and knife. Knife is set correctly when, on each side of cutterhead, both legs of jig sit firmly on cutterhead body and middle pad of jig just touches top edge of knife.

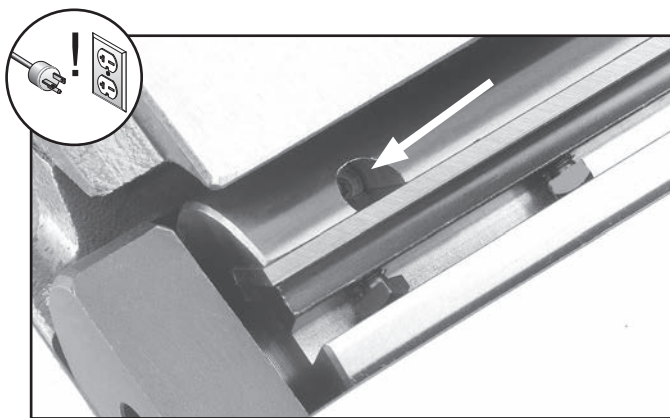
—If jig does not sit as described, then that knife must be reset. (Repeat this inspection with other knives before resetting.)

#### To set or replace knives:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard from table and lower infeed and outfeed tables as far as they go. This will provide unrestricted access to cutterhead.
3. Remove cabinet rear access panel to expose cutterhead pulley.
4. Rotate cutterhead pulley to provide good access to cutterhead knives.

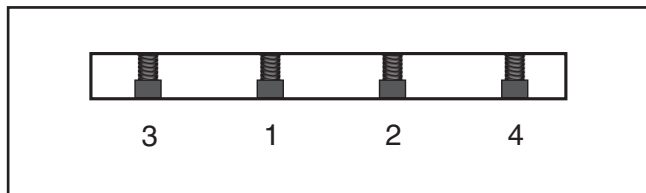


5. Loosen cutterhead gib bolts, starting in the middle, and alternating back and forth until all gib bolts are loose, but not falling out.
6. Position knife jig over knife. Loosen gib bolts until knife is completely loose.
7. Access jack screws through holes in cutterhead. Using a hex wrench, rotate jack screws to raise or lower knife. When knife is set correctly, it will barely touch middle pad of knife jig or bottom of straightedge in each of the straightedge positions. Snug gib bolts just tight enough to hold knife in place. Repeat with remaining knives.



**Figure 62.** Jack screw access hole.

8. Rotate cutterhead to reveal the first knife you started with. Lightly snug all gib bolts, alternating from one side to the other, and working from the ends to the middle. Repeat with remaining knives.



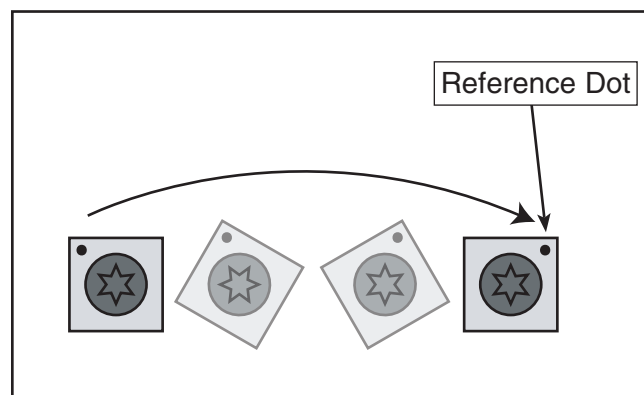
**Figure 63.** Gib bolt tightening sequence.

9. Tighten each gib bolt in the same alternating manner as you did in the previous step.
10. Make sure outfeed table is set even with the new knives at top dead center.
11. Replace cutterhead guard and cabinet rear access panel.

## Rotating/Replacing Cutterhead Inserts (G0656XW)

This spiral cutterhead is equipped with 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 as shown below.

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.



**Figure 64.** Insert rotating sequence.

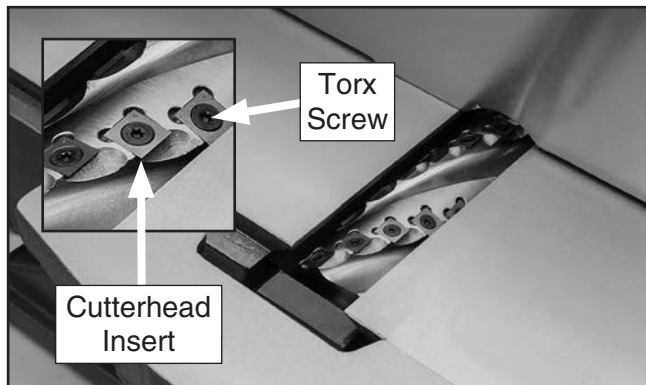
Tools Needed	Qty
Phillips Screwdriver .....	1
Torque Wrench .....	1
T-20 Torx Bit .....	1
Precision Straightedge .....	1

### To rotate or replace spiral cutterhead insert:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard from table, and lower infeed and outfeed tables as far as they go, to provide access to cutterhead.
3. Remove cabinet rear access panel to expose cutterhead pulley.
4. Rotate cutterhead pulley to provide access to insert(s) to be rotated/replaced.



5. Put on heavy leather gloves to protect fingers and hands.
6. Remove any sawdust or debris from head of insert, Torx screw, and surrounding area (see **Figure**).



**Figure 65.** Location of cutterhead inserts and Torx screws.

7. Remove Torx screw and insert, then clean all dust and debris from both parts and pocket they were removed from.

**Note:** Proper cleaning of insert(s), Torx screw, and cutterhead pocket is critical to achieving a smooth finish. Dirt or dust trapped between insert and cutterhead will raise insert, and make marks on your workpiece when jointing.

**Tip:** Use low-pressure compressed air or vacuum nozzle to clean cutterhead pocket.

8. Re-install insert so that a fresh cutting edge faces outward, making sure it is properly seated in cutterhead pocket.

—If all four insert cutting edges have been used, replace insert with a new one. Always position reference dot in same position when installing a new insert to aid in rotational sequencing.

9. Lubricate Torx screw threads with a small amount of light machine oil, wipe excess off, and torque screw to 48–50 inch/pounds.

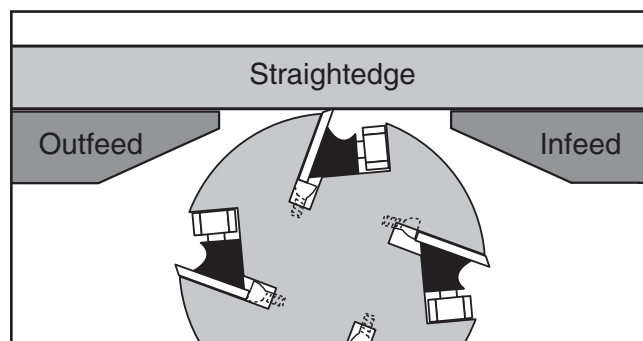
**Note:** If too much oil is applied to the threads, excess will attempt to squeeze out of threaded hole as you install insert and force it to raise slightly, making it out of alignment.

## Calibrating Depth Scale

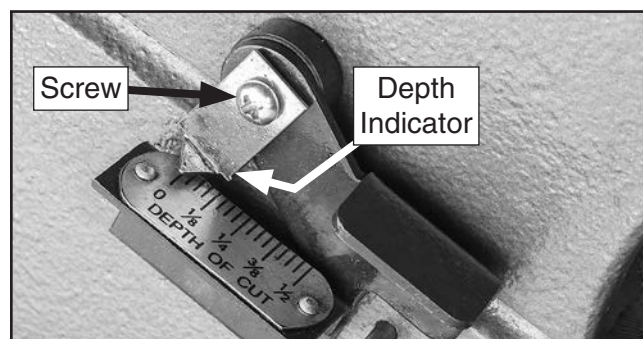
The depth scale can be calibrated or "zeroed" to make sure the cutting depth shown on the scale matches the actual cutting depth (per pass).

**To calibrate the depth scale:**

1. Set the outfeed table height as described in **Setting Outfeed Table Height**.
2. Place a straightedge across the infeed and outfeed tables.
3. Adjust the infeed table until it is level with the outfeed table, as shown below.
4. Using a screwdriver, precisely adjust the scale pointer to "0".



**Figure 66.** Infeed table adjusted even with outfeed table.



**Figure 67.** Depth indicator set to "0".

**Note:** If necessary, loosen upper jam nut and stop screw (see **To adjust positive-stop screws on Page 28**) to prevent obstruction of infeed table movement during **Step 3**.



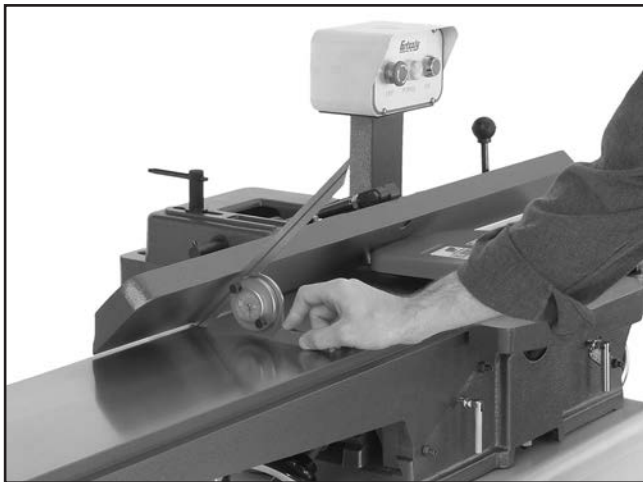
# Setting Fence Stops

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
Open-End Wrench 13mm.....	1

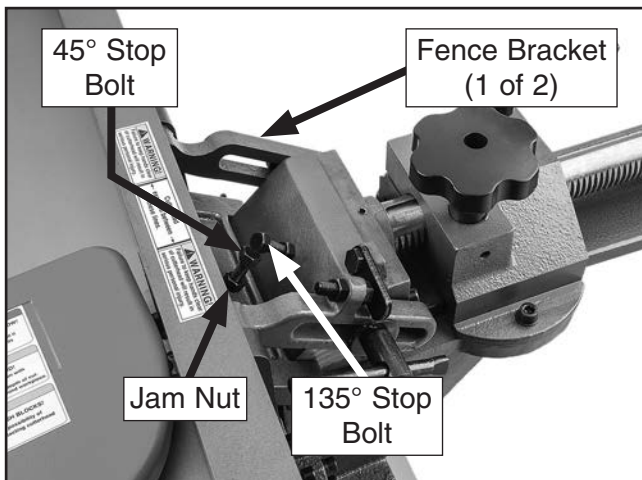
## Setting 45° Inward Fence Stop

1. Use a 45° square to adjust fence to 45° inward position, as shown in **Figure 68**.



**Figure 68.** Example of adjusting fence 45° inward.

2. Loosen jam nut shown in **Figure 69**.

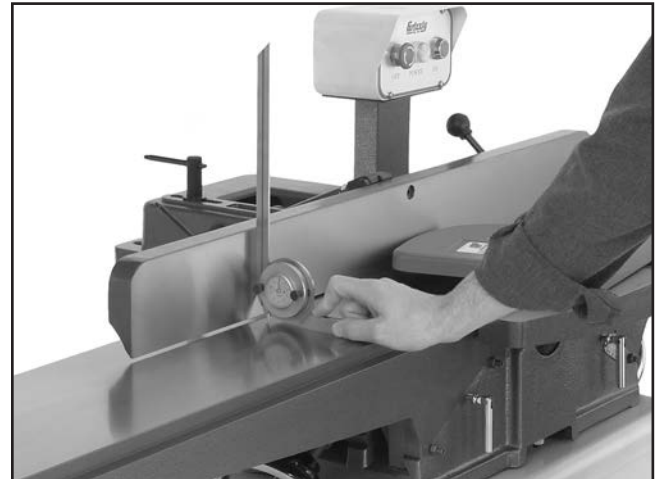


**Figure 69.** 45° inward fence stop bolt.

3. Adjust 45° stop bolt until it makes contact with 135° stop bolt (see **Figure 69**).
4. Retighten jam nut loosened in **Step 2**.

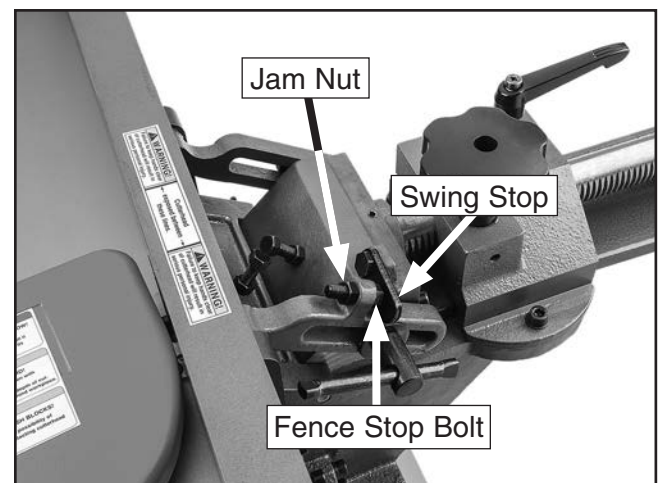
## Setting 90° Fence Stop

1. Use a 90° square to adjust fence to 90° (see **Figure 70**).



**Figure 70.** Example of adjusting fence to 90°.

2. Flip 90° swing stop into position shown in **Figure 71**.



**Figure 71.** 90° swing stop engaged.

3. Loosen jam nut on 90° fence stop bolt (see **Figure 71**).
4. Adjust the 90° fence stop bolt until it makes contact with 90° swing stop.
5. Retighten jam nut loosened in **Step 3**.





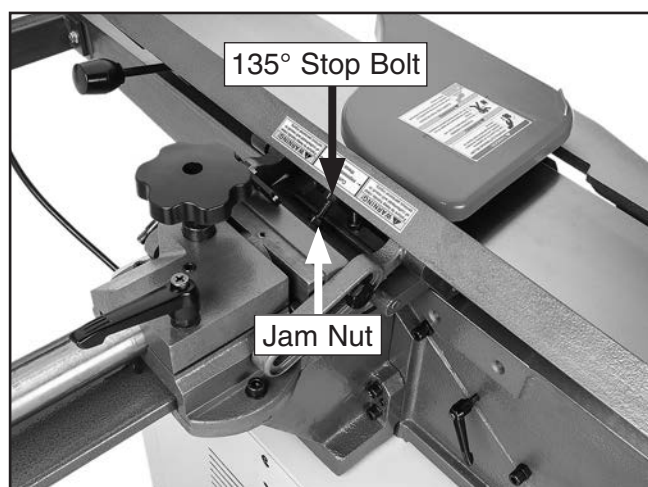
## Setting 135° Fence Stop

1. Disengage swing stop (see **Figure 71** on **Page 43**).
2. Use a sliding bevel adjusted to 135° to adjust fence to 135° (45° outward) position, as shown in **Figure 72**.



**Figure 72.** Example of adjusting fence 45° outward.

3. Loosen jam nut on 135° stop bolt (see **Figure 73**).



**Figure 73.** Location of 135° stop bolt and jam nut.

4. Adjust 135° stop bolt until it makes contact with back of fence.
5. Retighten jam nut loosened in **Step 3**.

## Adjusting Gibs

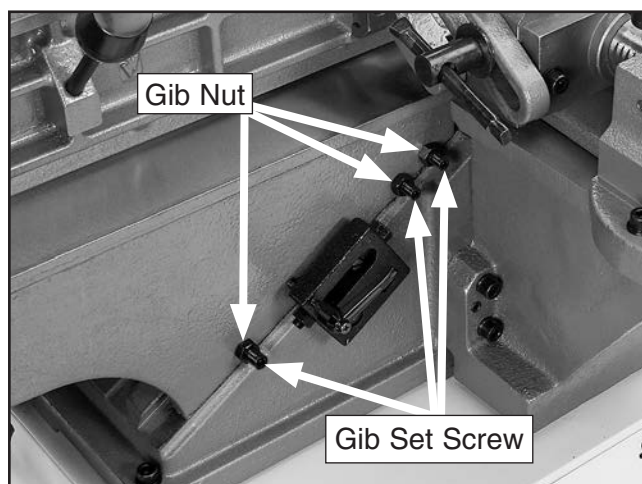
The function of the table gibs is to eliminate excessive play in the table movement. The gibs also control how easy it will be to move the tables up and down.

### Tools Needed

	Qty
Open-End Wrench 13mm.....	1
Hex Wrench 4mm.....	1

### To adjust table gibs:

1. Loosen three infeed table gib nuts on back of jointer base (see **Figure 74**).



**Figure 74.** Infeed table gib controls.

2. Oil table ways and leadscrew if needed (see **Page 36**).
3. Evenly tighten gib set screws a small amount, then check table by moving it up and down. Adjust set screws as needed until friction of table movement is balanced between minimal play and ease of movement.

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

4. Repeat **Steps 1-3** with outfeed table.
5. Set outfeed table height as described in **Setting Outfeed Table Height** on **Page 23**.





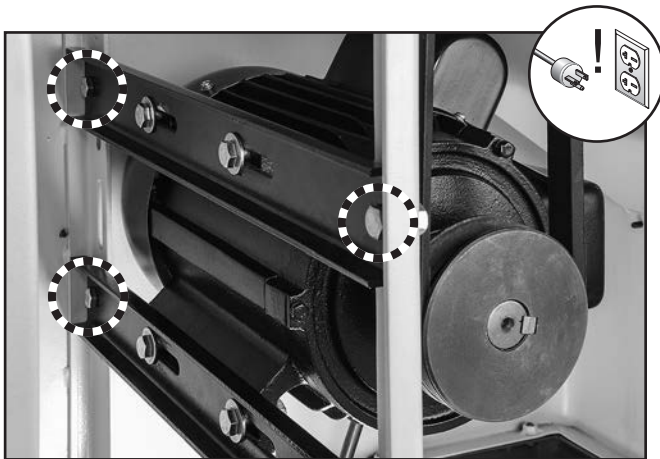
# Tensioning/ Replacing Belt

To ensure optimum power transmission from the motor to the cutterhead, the belt must be in good condition (free from cracks, fraying and wear) and properly tensioned. After the first 16 hours of belt life, re-tension the belt, as it will stretch and seat during this time.

## Tensioning Belt

1. DISCONNECT MACHINE FROM POWER!
2. Remove cabinet rear access panel.
3. Loosen motor mount bracket fasteners shown in **Figure 75**.

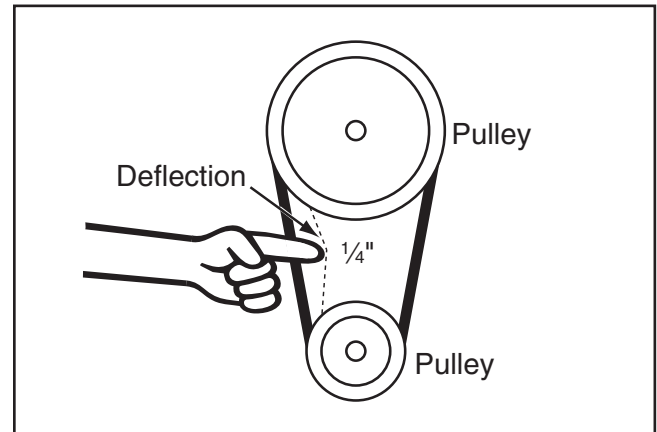
**Note:** *DO NOT* completely remove motor mount bracket fasteners.



**Figure 75.** Location of motor mount bracket fasteners (3 of 4 shown).

4. Press down on motor to keep tension on belt.

5. Press belt with moderate pressure in center to check belt tension. Belt is correctly tensioned when there is approximately  $\frac{1}{4}$ " deflection when pushed, as shown in **Figure 76**.



**Figure 76.** Checking belt tension.

— If there is more than  $\frac{1}{4}$ " deflection when you check belt tension, repeat the tensioning procedure until it is correct.

6. Tighten motor mount bracket fasteners (see **Figure 75**), and replace cabinet rear access panel.

## Replacing Belt

1. DISCONNECT MACHINE FROM POWER!
2. Remove cabinet rear access panel.
3. Loosen motor mount bracket fasteners shown in **Figure 75**.
4. Have another person lift motor as you remove belt and replace it with a new one. It may help to use a 2x4 as a lever to raise motor. Make sure belt is seated in pulley groove.
5. Follow **Steps 4–5** in **Tensioning Belt** procedure to set correct belt tension.
6. Tighten motor mount bracket fasteners (see **Figure 75**), and replace cabinet rear access panel.



# Checking/Adjusting Table Parallelism

The infeed and outfeed tables must be parallel with each other in order to produce a straight, jointed edge. When the tables are not parallel with each other, the jointer will produce workpieces that are cupped (concave) or bowed (convex) along their length.

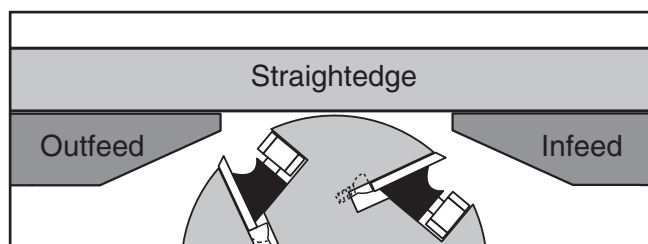
Table parallelism is factory-set, and should not normally need to be adjusted when the machine is new. However, after prolonged use, or if machine has been jarred during lifting or transportation, it may become necessary to adjust the table parallelism.

Table parallelism is adjusted by inserting shims between the dovetailed ways of the outfeed table to make it parallel with the infeed table. Once this adjustment is made, the outfeed table height should not need to be adjusted again.

Items Needed	Qty
Straightedge 4–8' .....	1
Feeler Gauge Set .....	1
Metal Shims .....	As Needed

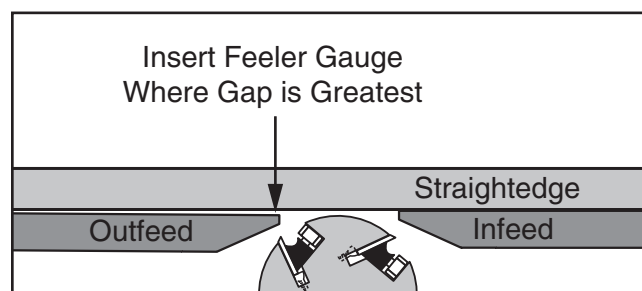
## To check/adjust table parallelism:

1. DISCONNECT MACHINE FROM POWER!
2. Move cutterhead guard out of the way.
3. Set outfeed table height as described in **Setting Outfeed Table Height** on **Page 23**.
4. Rotate cutterhead until knife/insert is no longer at TDC, extend straightedge over both tables, raise infeed table until it contacts straightedge (see **Figure 77**), then lock infeed table.



**Figure 77.** Checking table parallelism.

5. Look down length of straightedge on outfeed side to see if there are any noticeable gaps between straightedge and outfeed table. Do this at both front and rear of table.
  - If there are no gaps, and the straightedge makes full contact with both tables at front and rear, the tables are parallel with each other and no adjustments are necessary.
  - If there are gaps anywhere between one of the tables and the straightedge, the tables are not parallel to each other and must be adjusted. Proceed to **Step 6**.
6. Insert feeler gauge between table and straightedge where gap is greatest (see **Figure 78**). Maximum allowable tolerance is 0.003".



**Figure 78.** Example of feeler gauge location for checking table parallelism.

7. Loosen outfeed table locks. Place shims between dovetailed ways (see **Figure 79**) until outfeed table is within 0.003" of parallel with infeed table at front and rear of tables.



**Figure 79.** Locations to place shims when adjusting table parallelism.

8. Re-check outfeed table height (refer to **Setting Outfeed Table Height** on **Page 23**), and re-adjust if necessary.



# 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](http://www.grizzly.com).

#### COLOR KEY

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



# Wiring Diagram

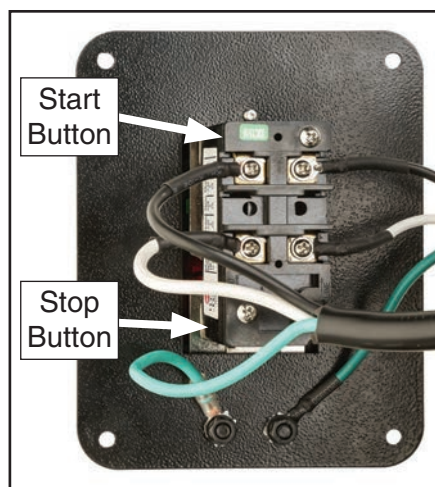
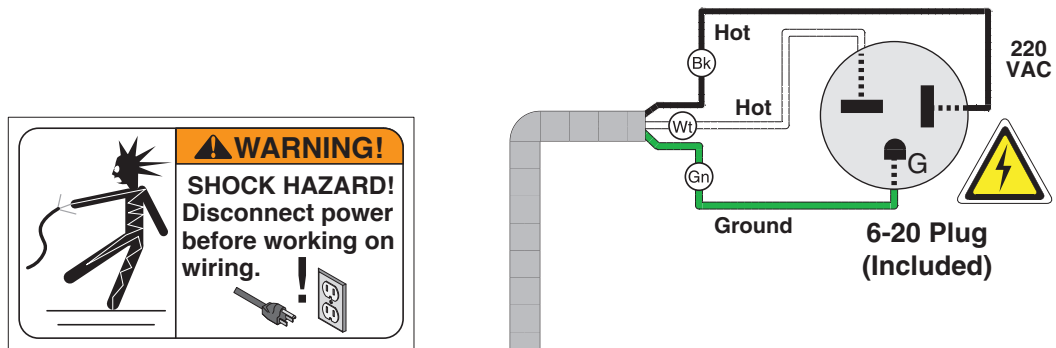
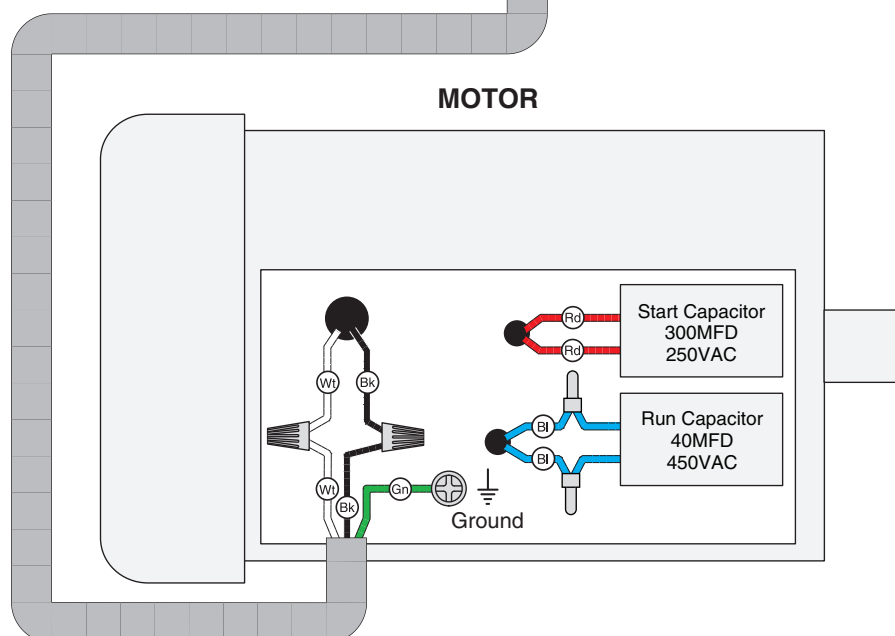
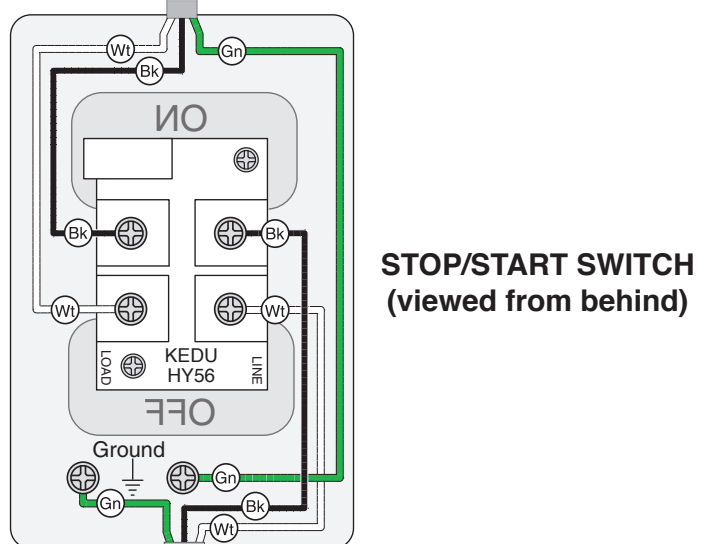
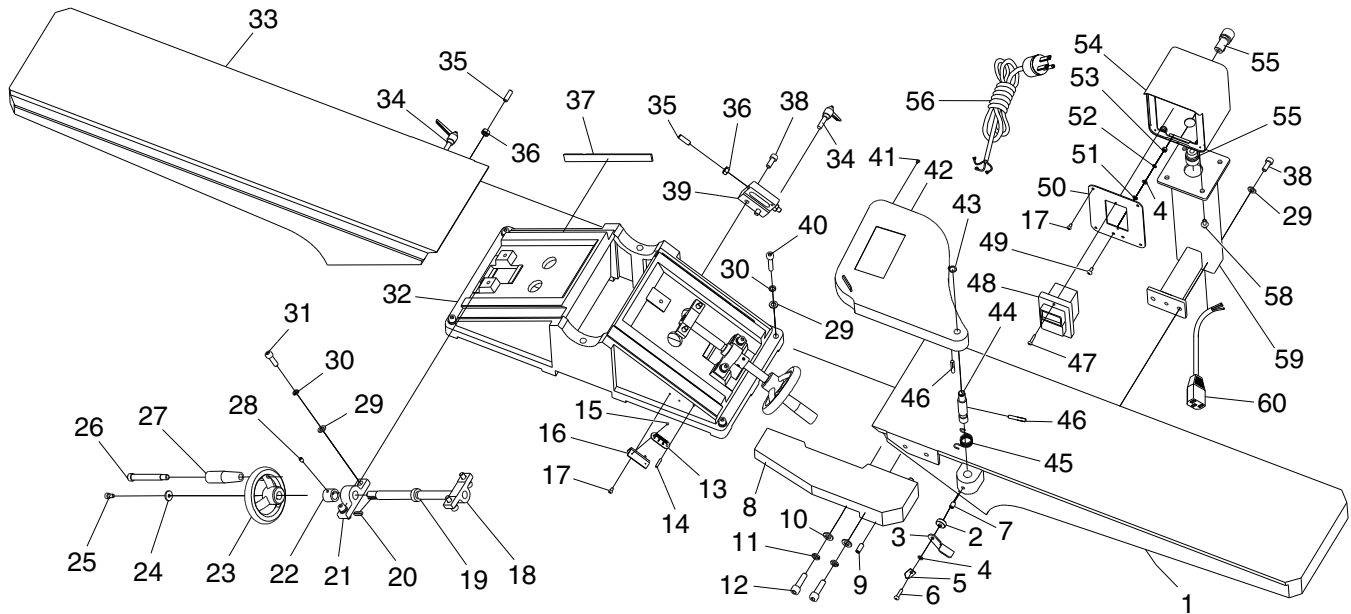


Figure 80. G0656W switch wiring.



# SECTION 9: PARTS

## Table



### REF PART # DESCRIPTION

1	P0656W001	INFEED TABLE
2	P0656W002	STOP PLATE PIVOT SPACER
3	P0656W003	DEPTH LIMIT PLATE
4	P0656W004	FLAT WASHER 5MM
5	P0656W005	DEPTH SCALE POINTER
6	P0656W006	PHLP HD SCR M5-.8 X 20
7	P0656W007	SET SCREW M8-1.25 X 12
8	P0656W008	RABBET TABLE
9	P0656W009	SET SCREW M8-1.25 X 20
10	P0656W010	FLAT WASHER 10MM
11	P0656W011	LOCK WASHER 10MM
12	P0656W012	CAP SCREW M10-1.5 X 35
13	P0656W013	DEPTH SCALE
14	P0656W014	DOWEL PIN 4 X 20
15	P0656W015	RIVET 2 X 6MM
16	P0656W016	DEPTH SCALE BRACKET
17	P0656W017	PHLP HD SCR M4-.7 X 8
18	P0656W018	LEADSCREW NUT
19	P0656W019	TABLE LEADSCREW
20	P0656W020	KEY 5 X 5 X 20
21	P0656W021	LEADSCREW BRACKET
22	P0656W022	LEADSCREW COLLAR
23	P0656W023	HANDWHEEL TYPE-3 148D X 15B-K X M10-1.5
24	P0656W024	FENDER WASHER 6MM
25	P0656W025	CAP SCREW M6-1 X 12
26	P0656W026	SHOULDER SCREW M10-1.5 X 14, 11 X 74
27	P0656W027	HANDWHEEL HANDLE 12 ID X 80L
28	P0656W028	SET SCREW M6-1 X 8
29	P0656W029	FLAT WASHER 8MM
30	P0656W030	LOCK WASHER 8MM

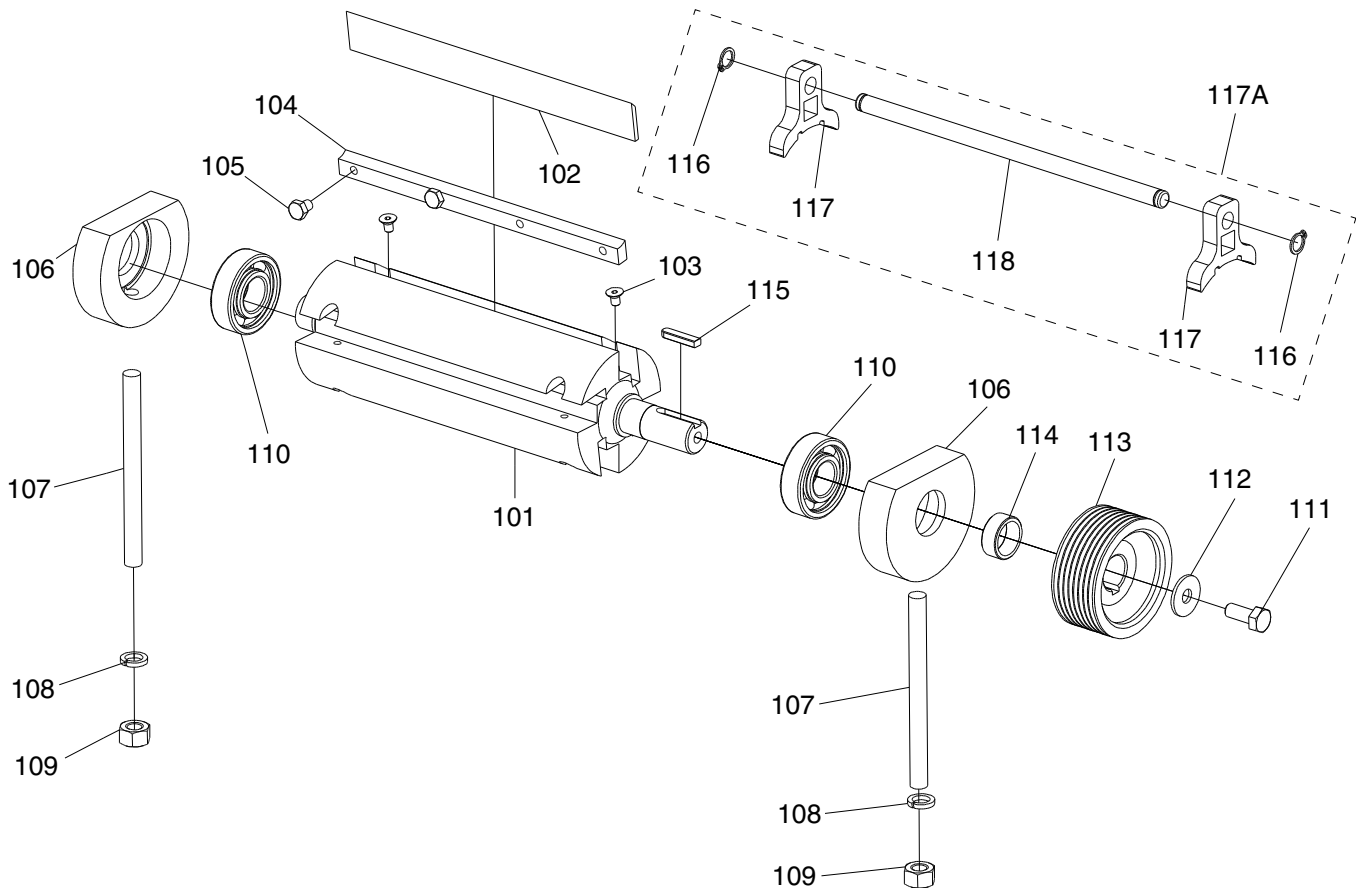
### REF PART # DESCRIPTION

31	P0656W031	CAP SCREW M8-1.25 X 25
32	P0656W032	TABLE BASE
33	P0656W033	OUTFEED TABLE
34	P0656W034	ADJUSTABLE HANDLE M6-1 X 30
35	P0656W035	SET SCREW M8-1.25 X 25
36	P0656W036	HEX NUT M8-1.25
37	P0656W037	GIB
38	P0656W038	CAP SCREW M8-1.25 X 20
39	P0656W039	INFEED TABLE LOCK BLOCK
40	P0656W040	CAP SCREW M8-1.25 X 40
41	P0656W041	RUBBER BUMPER
42	P0656W042	CUTTERHEAD GUARD
43	P0656W043	EXT RETAINING RING 12MM
44	P0656W044	GUARD PIVOT SHAFT
45	P0656W045	TORSION SPRING
46	P0656W046	ROLL PIN 6 X 40
47	P0656W047	PHLP HD SCR M4-.7 X 20
48	P0656W048	PADDLE SWITCH 120/230V
49	P0656W049	PHLP HD SCR M5-.8 X 10
50	P0656W050	SWITCH PLATE
51	P0656W051	INT TOOTH WASHER 5MM
52	P0656W052	LOCK WASHER 5MM
53	P0656W053	HEX NUT M5-.8
54	P0656W054	SWITCH BOX
55	P0656W055	STRAIN RELIEF M20-1.5 TYPE-3
56	P0656W056	POWER CORD 12G 3W 72" 6-20P
58	P0656W058	FLANGE BOLT M6-1 X 12
59	P0656W059	SWITCH PEDESTAL
60	P0656W060	SWITCH CORD 14G 3W 39"





# Cutterhead (G0656W)

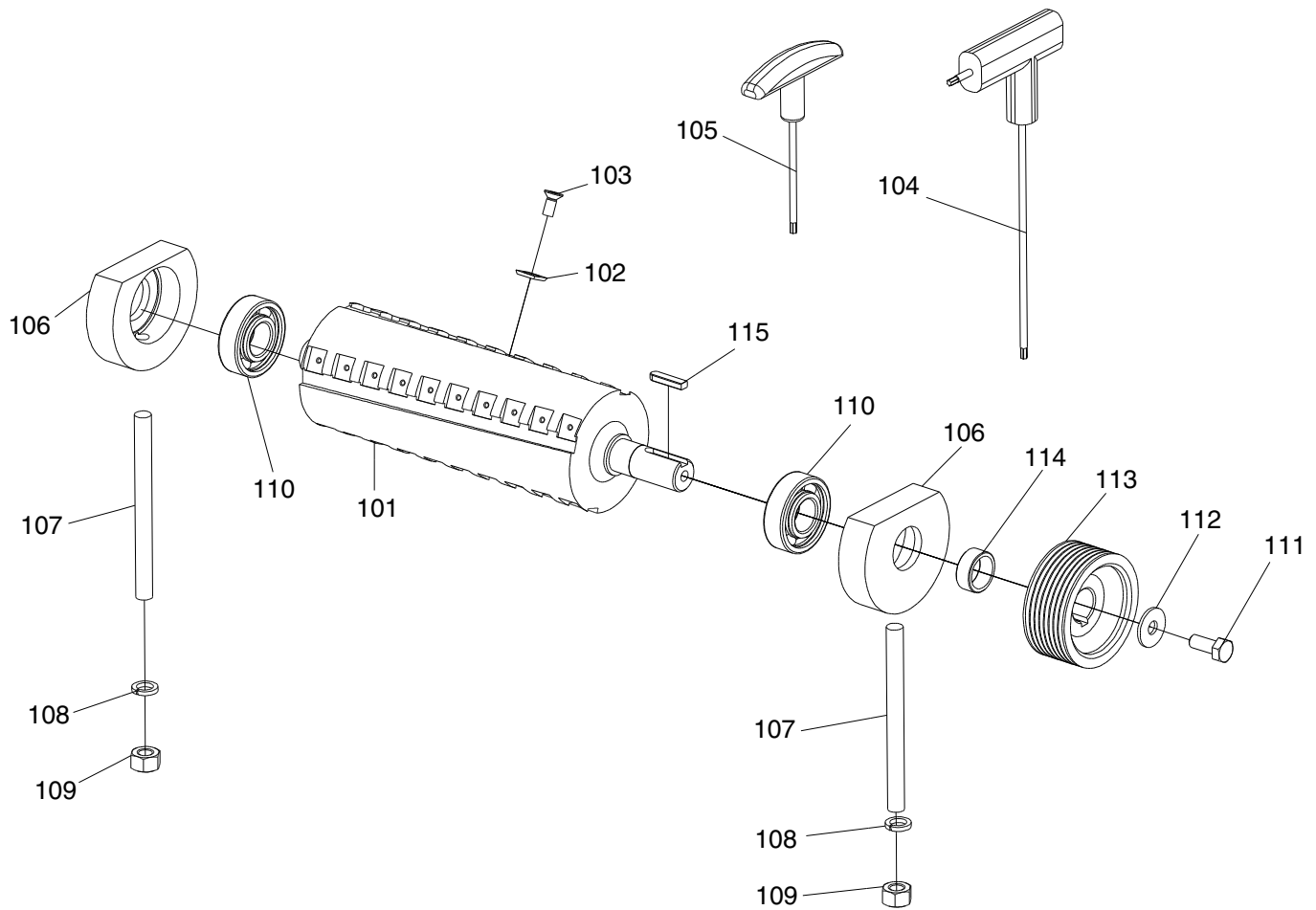


REF	PART #	DESCRIPTION
101	P0656W101	CUTTERHEAD 8" 4-KNIFE (G0656W)
102	P0656W102	JOINTER KNIVES 8" X 3/4" X 1/8" 4PK
103	P0656W103	FLAT HD CAP SCR M5-.8 X 12
104	P0656W104	GIB (G0656W)
105	P0656W105	GIB BOLT M6-1 X 10 (G0656W)
106	P0656W106	BEARING BLOCK
107	P0656W107	STUD-FT M6-1 X 115
108	P0656W108	LOCK WASHER 10MM
109	P0656W109	HEX NUT M10-1.5
110	P0656W110	BALL BEARING 6204-2RS

REF	PART #	DESCRIPTION
111	P0656W111	HEX BOLT M8-1.25 X 20
112	P0656W112	FENDER WASHER 8MM
113	P0656W113	CUTTERHEAD PULLEY
114	P0656W114	COLLAR
115	P0656W115	KEY 6 X 6 X 25
116	P0656W116	EXT RETAINING RING 10MM (G0656W)
117	P0656W117	KNIFE-SETTING JIG FOOT (G0656W)
117A	P0656W117A	KNIFE-SETTING JIG (G0656W)
118	P0656W118	KNIFE-SETTING JIG SHAFT (G0656W)



# Cutterhead (G0656XW)

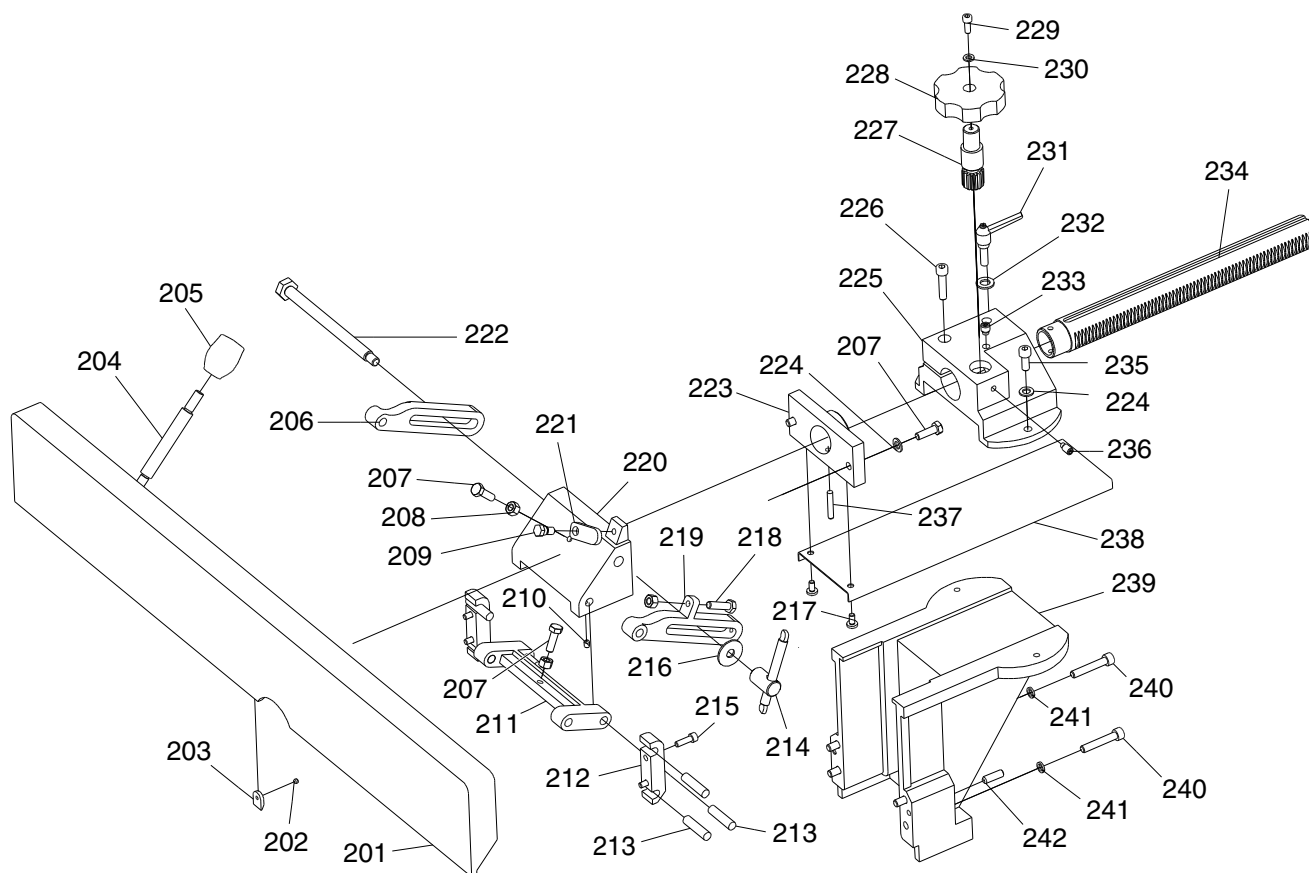


REF	PART #	DESCRIPTION
101	P0656XW101	CUTTERHEAD 8" SPIRAL (G0656XW)
102	P0656XW102	CARBIDE INSERTS 14 X 14 X 2 (10-PK)
103	P0656XW103	FLAT HD CAP SCR M6-1 X 15
104	P0656XW104	L-HANDLE TORX DRIVE T-20 (G0656XW)
105	P0656XW105	T-HANDLE TORX DRIVE T-20 (G0656XW)
106	P0656XW106	BEARING BLOCK
107	P0656XW107	STUD-FT M6-1 X 115
108	P0656XW108	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
109	P0656XW109	HEX NUT M10-1.5
110	P0656XW110	BALL BEARING 6204-2RS
111	P0656XW111	HEX BOLT M8-1.25 X 20
112	P0656XW112	FENDER WASHER 8MM
113	P0656XW113	CUTTERHEAD PULLEY
114	P0656XW114	COLLAR
115	P0656XW115	KEY 6 X 6 X 25



# Fence



## REF PART # DESCRIPTION

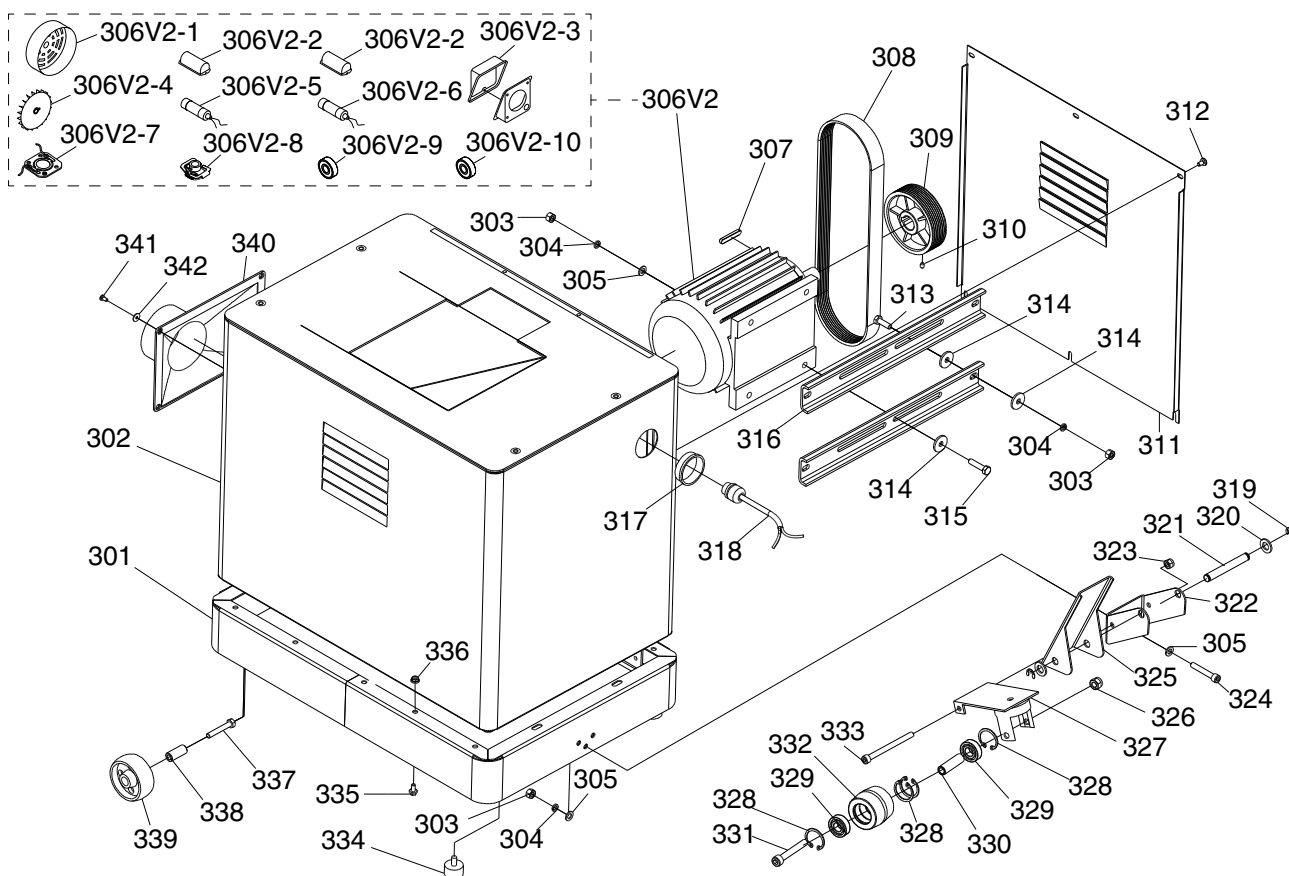
201	P0656W201	FENCE
202	P0656W202	SET SCREW M5-.8 X 4
203	P0656W203	FENCE GUIDE BLOCK
204	P0656W204	STUD UDE M10-1.5 X 100, 12, 30
205	P0656W205	KNOB M10-1.5, 35 DIA, 44L (PLASTIC)
206	P0656W206	FENCE TILT ARM (LEFT)
207	P0656W207	HEX BOLT M8-1.25 X 25
208	P0656W208	HEX NUT M8-1.25
209	P0656W209	SHOULDER BOLT M8-1.25 X 10, 10 X 6
210	P0656W210	SET SCREW M6-1 X 8
211	P0656W211	FENCE TILT SUPPORT
212	P0656W212	FENCE TILT BRACKET
213	P0656W213	DOWEL PIN 10 X 40
214	P0656W214	FENCE TILT LOCK LEVER M10-1.5
215	P0656W215	CAP SCREW M6-1 X 20
216	P0656W216	FENDER WASHER 10MM
217	P0656W217	PHLP HD SCR M6-1 X 10
218	P0656W218	HEX BOLT M8-1.25 X 30
219	P0656W219	FENCE TILT ARM (RIGHT)
220	P0656W220	FENCE STOP BRACKET
221	P0656W221	90° FENCE STOP

## REF PART # DESCRIPTION

222	P0656W222	SHOULDER BOLT M10-1.5 X 15, 12 X 155
223	P0656W223	FENCE RAM SUPPORT
224	P0656W224	FLAT WASHER 8MM
225	P0656W225	FENCE RAM BRACKET
226	P0656W226	CAP SCREW M8-1.25 X 35
227	P0656W227	FENCE RAM PINION
228	P0656W228	STAR KNOB 6-LOBE, 81DIA X 48L
229	P0656W229	CAP SCREW M6-1 X 16
230	P0656W230	FLAT WASHER 6MM
231	P0656W231	ADJUSTABLE HANDLE M10-1.5 X 50
232	P0656W232	FLAT WASHER 10MM
233	P0656W233	SET SCREW M10-1.5 X 16
234	P0656W234	FENCE RAM
235	P0656W235	CAP SCREW M8-1.25 X 20
236	P0656W236	SET SCREW M8-1.25 X 16
237	P0656W237	ROLL PIN 6 X 50
238	P0656W238	BELT GUARD
239	P0656W239	CARRIAGE MOUNT
240	P0656W240	CAP SCREW M8-1.25 X 45
241	P0656W241	LOCK WASHER 8MM
242	P0656W242	SET SCREW M8-1.25 X 25



# Stand

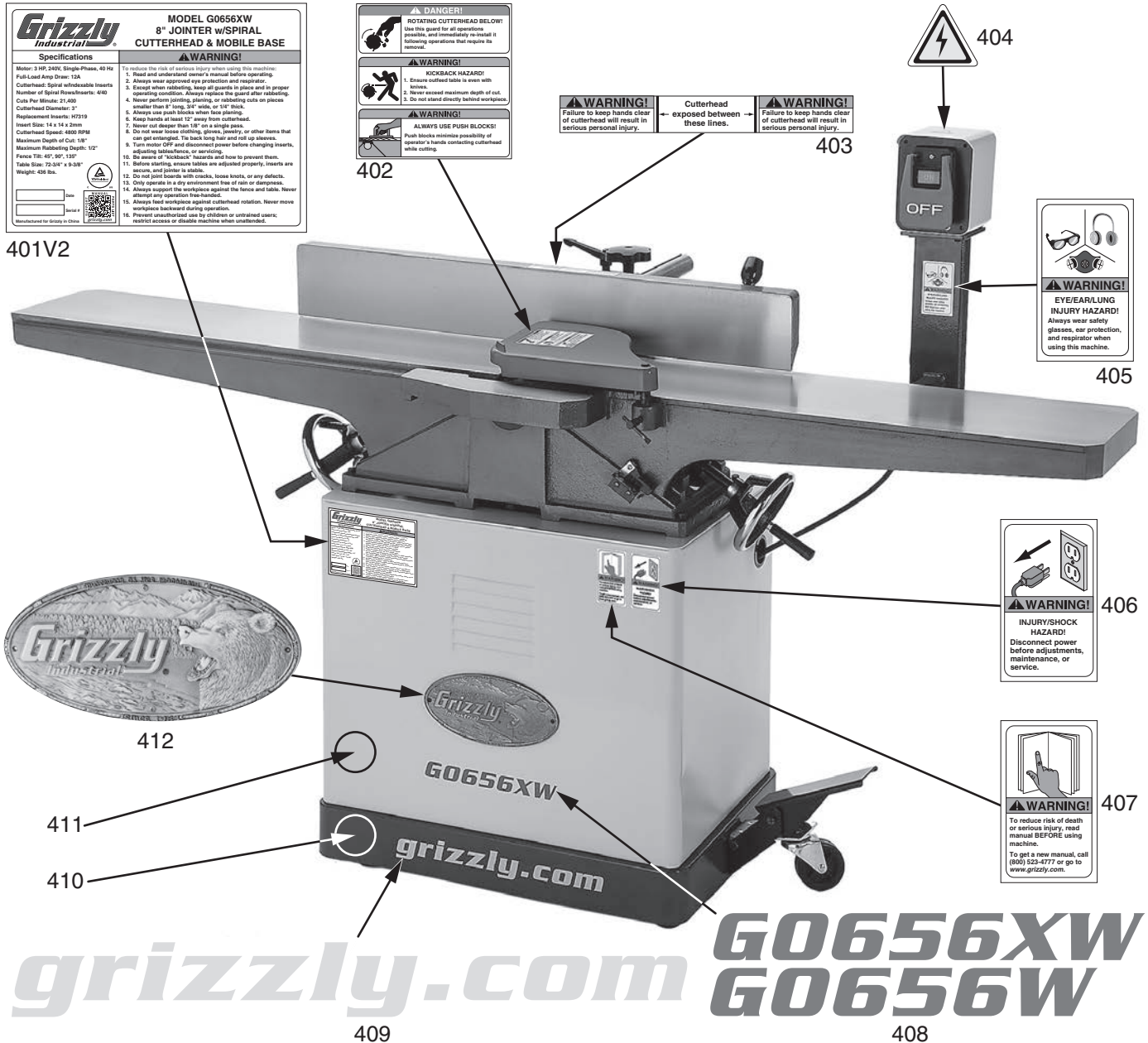


REF	PART #	DESCRIPTION
301	P0656W301	STAND BASE
302	P0656W302	STAND
303	P0656W303	HEX NUT M8-1.25
304	P0656W304	LOCK WASHER 8MM
305	P0656W305	FLAT WASHER 8MM
306V2	P0656W306V2	MOTOR 3HP 240V 1-PH V2.04.16
306V2-1	P0656W306V2-1	MOTOR FAN COVER
306V2-2	P0656W306V2-2	CAPACITOR COVER
306V2-3	P0656W306V2-3	MOTOR JUNCTION BOX
306V2-4	P0656W306V2-4	MOTOR FAN
306V2-5	P0656W306V2-5	S CAPACITOR 300M 250V 1-7/8 X 3-3/4
306V2-6	P0656W306V2-6	R CAPACITOR 40M 450V 1-7/8 X 3-3/4
306V2-7	P0656W306V2-7	CONTACT PLATE
306V2-8	P0656W306V2-8	CENTRIFUGAL SWITCH
306V2-9	P0656W306V2-9	BALL BEARING 6205ZZ (FRONT)
306V2-10	P0656W306V2-10	BALL BEARING 6205ZZ (REAR)
307	P0656W307	KEY 8 X 7 X 40
308	P0656W308	DRIVE BELT 8PK1180
309	P0656W309	MOTOR PULLEY
310	P0656W310	SET SCREW M6-1 X 8
311	P0656W311	BACK COVER
312	P0656W312	PHLP HD SCR M6-1 X 10
313	P0656W313	HEX BOLT M8-1.25 X 25
314	P0656W314	FENDER WASHER 8MM
315	P0656W315	HEX BOLT M8-1.25 X 35
316	P0656W316	MOTOR MOUNT BRACKET

REF	PART #	DESCRIPTION
317	P0656W317	GROMMET 12 X 50MM (PLASTIC)
318	P0656W318	MOTOR CORD 14G 3W 31"
319	P0656W319	E-CLIP 9MM
320	P0656W320	FLAT WASHER 12MM
321	P0656W321	PEDAL PIVOT SHAFT 12 X 100MM
322	P0656W322	FOOT PEDAL BRACKET
323	P0656W323	LOCK NUT M8-1.25
324	P0656W324	CAP SCREW M8-1.25 X 50
325	P0656W325	FOOT PEDAL
326	P0656W326	LOCK NUT M10-1.5
327	P0656W327	FOOT PEDAL BASE ASSEMBLY
328	P0656W328	INT RETAINING RING 35MM
329	P0656W329	BALL BEARING 6202-2RS
330	P0656W330	FOOT PEDAL WHEEL SLEEVE
331	P0656W331	CAP SCREW M10-1.5 X 70
332	P0656W332	FOOT PEDAL WHEEL
333	P0656W333	CAP SCREW M8-1.25 X 100
334	P0656W334	RUBBER FOOT M8-1.25 X 14
335	P0656W335	FLANGE BOLT M6-1 X 12
336	P0656W336	FLANGE NUT M6-1
337	P0656W337	HEX BOLT M8-1.25 X 50
338	P0656W338	REAR WHEEL SLEEVE
339	P0656W339	REAR WHEEL
340	P0656W340	DUST PORT 4"
341	P0656W341	PHLP HD SCR M5-.8 X 10
342	P0656W342	FENDER WASHER 5MM



# Labels



REF	PART #	DESCRIPTION
401V2	P0656W401V2	MACHINE ID LABEL (G0656W) V2.08.16
401V2	P0656XW401V2	MACHINE ID LABEL (G0656XW) V2.08.16
402	P0656W402	CUTTERHEAD WARNING LABEL
403	P0656W403	FENCE WARNING LABEL
404	P0656W404	ELECTRICITY LABEL
405	P0656W405	EYE/EAR/LUNG WARNING LABEL
406	P0656W406	DISCONNECT POWER LABEL

REF	PART #	DESCRIPTION
407	P0656W407	READ MANUAL LABEL
408	P0656W408	MODEL NUMBER LABEL (G0656W)
408	P0656XW408	MODEL NUMBER LABEL (G0656XW)
409	P0656W409	GRIZZLY.COM LABEL
410	P0656W410	GRIZZLY GREEN TOUCH-UP PAINT
411	P0656W411	GRIZZLY BEIGE TOUCH-UP PAINT
412	P0656W412	GRIZZLY NAMEPLATE

## ! WARNING

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







# WARRANTY CARD

Name \_\_\_\_\_  
Street \_\_\_\_\_  
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
Phone # \_\_\_\_\_ Email \_\_\_\_\_  
Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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

1. How did you learn about us?

\_\_\_\_\_ Advertisement \_\_\_\_\_ Friend \_\_\_\_\_ Catalog  
\_\_\_\_\_ Card Deck \_\_\_\_\_ Website \_\_\_\_\_ Other:

2. Which of the following magazines do you subscribe to?

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

3. What is your annual household income?

\_\_\_\_\_ \$20,000-\$29,000 \_\_\_\_\_ \$30,000-\$39,000 \_\_\_\_\_ \$40,000-\$49,000  
\_\_\_\_\_ \$50,000-\$59,000 \_\_\_\_\_ \$60,000-\$69,000 \_\_\_\_\_ \$70,000+

4. What is your age group?

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

5. How long have you been a woodworker/metalworker?

\_\_\_\_\_ 0-2 Years \_\_\_\_\_ 2-8 Years \_\_\_\_\_ 8-20 Years \_\_\_\_\_ 20+ Years

6. How many of your machines or tools are Grizzly?

\_\_\_\_\_ 0-2 \_\_\_\_\_ 3-5 \_\_\_\_\_ 6-9 \_\_\_\_\_ 10+

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

\_\_\_\_\_ Yes \_\_\_\_\_ No

8. Would you recommend Grizzly Industrial to a friend?

\_\_\_\_\_ Yes \_\_\_\_\_ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

**Note:** We never use names more than 3 times.

\_\_\_\_\_ Yes \_\_\_\_\_ No

10. Comments: \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

FOLD ALONG DOTTED LINE

\_\_\_\_\_  
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\_\_\_\_\_



Place  
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P.O. BOX 2069  
BELLINGHAM, WA 98227-2069



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Send a Grizzly Catalog to a friend:

Name_____
Street_____
City_____State_____Zip_____

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# WARRANTY & RETURNS

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

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

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

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

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

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



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