



# MODEL G0663

## 12 $\frac{1}{2}$ " PLANER

### OWNER'S MANUAL



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#JB10201 PRINTED IN CHINA



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.**

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

**The owner of this machine/equipment 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, blade/cutter integrity, and the usage of personal protective equipment.**

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



## **WARNING!**

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

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

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

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# INTRODUCTION

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## Foreword

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We are proud to offer the Model G0663 12½" Planer. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0663 when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

## Contact Info

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

Grizzly Industrial, Inc.  
c/o Technical Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: [manuals@grizzly.com](mailto:manuals@grizzly.com)

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

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Web Site: <http://www.grizzly.com>







# MACHINE DATA SHEET

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

## MODEL G0663 12<sup>1</sup>/<sub>2</sub>" PLANER

### Product Dimensions:

Weight ..... 62 lbs.  
Length/Width/Height ..... 25" x 23<sup>5</sup>/<sub>8</sub>" x 19<sup>1</sup>/<sub>8</sub>"  
Foot Print (Length/Width)..... 21<sup>1</sup>/<sub>8</sub>" x 12<sup>5</sup>/<sub>8</sub>"

### Shipping Dimensions:

Type ..... Cardboard  
Content..... Machine  
Weight..... 68 lbs.  
Length/Width/Height..... 26<sup>3</sup>/<sub>16</sub>" x 15<sup>3</sup>/<sub>16</sub>" x 19<sup>7</sup>/<sub>8</sub>"

### Electrical:

Switch..... ON/OFF Safety Toggle  
Cord Length ..... 7 ft.  
Cord Gauge ..... 16 AWG  
Recommended Breaker Size ..... 15A  
Plug..... Yes

### Motors:

#### Main

Type..... Universal Brush Type  
Horsepower ..... 1.5 HP  
Voltage ..... 110V  
Phase ..... Single  
Amps ..... 12A  
Speed ..... 17,500 RPM  
Cycle..... 60 Hz  
Number Of Speeds..... 1  
Power Transfer..... Belt Drive  
Bearings ..... Shielded and Lubricated

### Main Specifications:

#### Operation Information

Max. Cut Width..... 12<sup>1</sup>/<sub>2</sub>"  
Max. Cut Height..... 6"  
Min. Stock Length..... 9<sup>1</sup>/<sub>2</sub>"  
Min. Stock Width ..... <sup>13</sup>/<sub>64</sub>"  
Min. Stock Thickness ..... <sup>1</sup>/<sub>8</sub>"  
No. Of Cuts Per Inch ..... 71  
No. Of Cuts Per Minute ..... 18,800  
Cutterhead Speed ..... 9400 RPM  
Planing Feed Rate..... 22 FPM  
Max. Cut Depth Planing Full Width ..... <sup>1</sup>/<sub>32</sub>"  
Max. Cut Depth Planing 5 Inch Wide Board ..... <sup>3</sup>/<sub>32</sub>"



### Cutterhead Info

Cutterhead Type.....	2 Knife
Cutterhead Dia. ....	2"
No. of Knives.....	2
Knife Type .....	Straight Double Edged
Knife Size Length .....	12 <sup>5</sup> / <sub>8</sub> "
Knife Size Width .....	1 <sup>5</sup> / <sub>32</sub> "
Knife Size Thickness .....	1/ <sub>16</sub> "
Knife Adjustment .....	Gibs

### Table Info

Table Bed Size Length .....	12 <sup>1</sup> / <sub>2</sub> "
Table Bed Size Width.....	9 <sup>5</sup> / <sub>16</sub> "
Extension Wing Size Length .....	12 <sup>1</sup> / <sub>2</sub> "
Extension Wing Size Width .....	6 <sup>13</sup> / <sub>16</sub> "

### Construction

Table Construction .....	Steel and Cast Aluminum
Body Construction .....	Cast Aluminum
Cutterhead Assembly Construction.....	Steel
Infeed Roller Construction.....	Rubber
Outfeed Roller Construction .....	Rubber
Paint .....	Epoxy

### Other

Measurement Scale .....	Inch and Metric
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### Other Specifications:

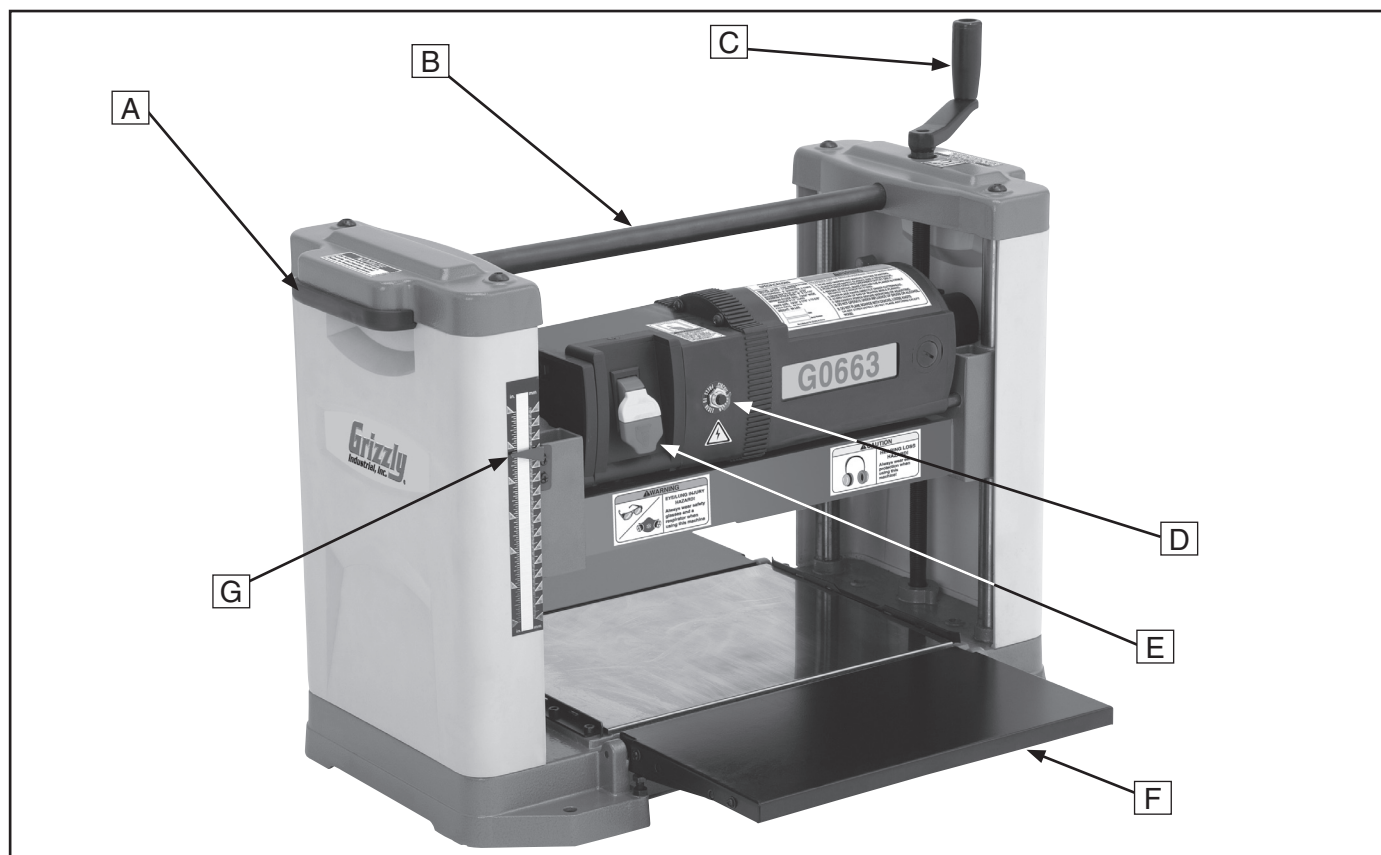
Country Of Origin .....	China
Warranty.....	1 Year
Serial Number Location .....	Machine ID label on top of Machine
Assembly Time .....	15 minutes

### Features:

Top Mounted Return Rollers  
Extra Large Table Extensions  
1/<sub>16</sub>" Thick Knives  
Includes Knife Setting Jig and Wrench  
Fold-Down Extension Tables  
Top Mounted Depth Adjustment  
Thermal Overload Protection  
Convenient Carry Handles on Side  
Height Scale



# Identification



**Figure 1.** Identification.

- A. Carrying Handle
- B. Return Roller
- C. Cutterhead Elevation Handle
- D. Reset Button
- E. ON/OFF Switch
- F. Infeed Table
- G. Depth Indicator



# SECTION 1: SAFETY

## WARNING

### For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words 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.



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.

## WARNING

### Safety Instructions for Machinery

- 1. READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



# WARNING

## Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Maintain stability and balance at all times.
23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.



# **WARNING**

## **Additional Safety for Planers**

1. **INSTRUCTION MANUAL.** This machine presents significant safety hazards to untrained users. Read/understand this entire manual before starting the planer.
2. **REACHING INSIDE PLANER.** Never reach inside planer or remove cover when the planer is connected to power.
3. **INFEED CLEARANCE SAFETY.** The infeed roller is designed to pull material into the cutterhead. Always keep hands, clothing, and long hair away from the infeed roller during operation to prevent being pulled in.
4. **BODY POSITION WHILE OPERATING.** The workpiece may kick out during operation. To avoid getting hit, stand to the side of the planer during the entire operation.
5. **PLANING CORRECT MATERIAL.** Only plane natural wood stock with this planer. DO NOT plane MDF, plywood, laminates, metal, stone, plastic, drywall, backerboard, or synthetic products.
6. **GRAIN DIRECTION.** Planing across the grain is hard on the planer and may cause the workpiece to kick out. Always plane in the same direction or at a slight angle with the wood grain.
7. **LOOKING INSIDE PLANER.** Wood chips fly around inside the planer at a high rate of speed. DO NOT look inside the planer or remove guards/covers during operation.
8. **CUTTING LIMITATIONS.** The planer may kick out a workpiece at the operator or be damaged if pushed beyond these limits.
  - Maximum Depth of Cut <5" Wide .....  $\frac{3}{32}$ "
  - Maximum Depth of Cut >5" Wide .....  $\frac{1}{32}$ "
  - Minimum Board Length.....  $9\frac{1}{2}$ "
  - Minimum Board Thickness .....  $\frac{1}{8}$ "
  - Maximum # of Boards at One Time..... 1
9. **CLEAN STOCK.** Planing stock with nails, staples, or loose knots MAY cause debris to kick out at the operator and WILL damage your cutters when they contact the cutterhead. Always thoroughly inspect and prepare stock to avoid these hazards.
10. **REMOVING JAMMED WORKPIECES.** To avoid serious injury, always stop the planer and disconnect power before removing jammed workpieces.
11. **DULL/DAMAGED KNIVES.** The planer may kick out a workpiece at the operator or give poor finish results if it is operated with dull or damaged knives.
12. **UNPLUGGING DURING ADJUSTMENTS.** When connected to power, the planer can be accidentally turned **ON**. Always disconnect power when servicing or adjusting the components of the planer.
13. **WORKPIECE CLEARANCE.** Always verify workpiece has enough room to exit the planer before starting.

### **WARNING**

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

### **CAUTION**

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



# SECTION 2: CIRCUIT REQUIREMENTS

## 110V Operation

### ⚠ WARNING

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



### ⚠ WARNING

Electrocution or fire could result if machine is not grounded and installed in compliance with electrical codes. Compliance **MUST** be verified by a qualified electrician!

### Full Load Amperage Draw

Motor Draw ..... 12 Amps

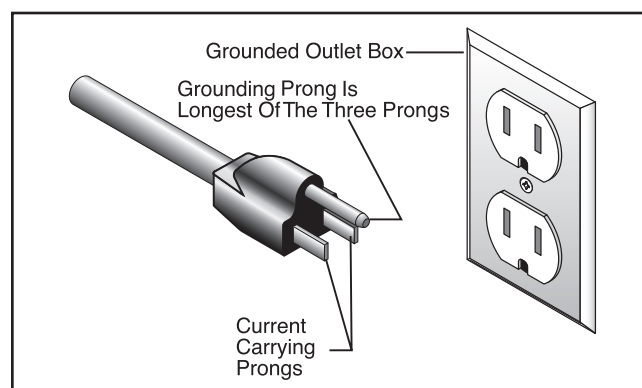
### Circuit Requirements

You **MUST** connect your machine to a grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

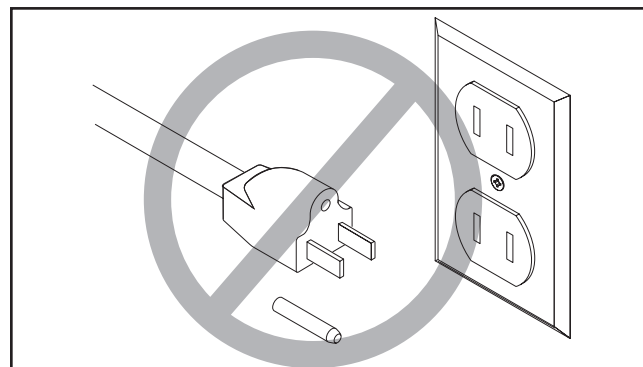
Minimum Circuit Size..... 15 Amps

### Power Connection Device

The Model G0663 comes with a 5-15 plug, similar to **Figure 2**, to connect the machine to power.



**Figure 2.** Typical 5-15 plug and receptacle.



### ⚠ CAUTION

**This machine **MUST** have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.**

### Extension Cords

We do not recommend using extension cords, but if you find it absolutely necessary:

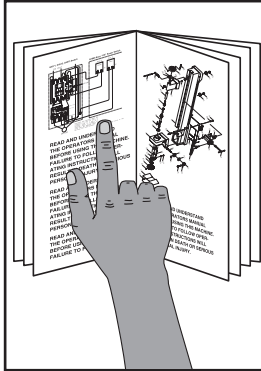
- Use at least a 14 gauge cord that does not exceed 50 feet in length!
- The extension cord must have a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.





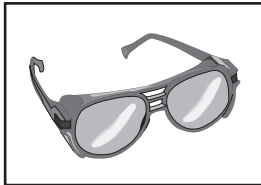
# SECTION 3: SETUP

## Setup Safety



### **!WARNING**

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



### **!WARNING**

Wear safety glasses during the entire setup process!

## Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

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

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

## Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Items: (Figure 3)	Qty
A. Planer (Not Shown) .....	1
B. Elevation Handle .....	1
C. Magnets.....	2
D. Hex Wrench 4mm.....	1
E. Cap Screw M5-.8 x 25 (Handle).....	1
F. Lock Washer 5mm (Handle) .....	1

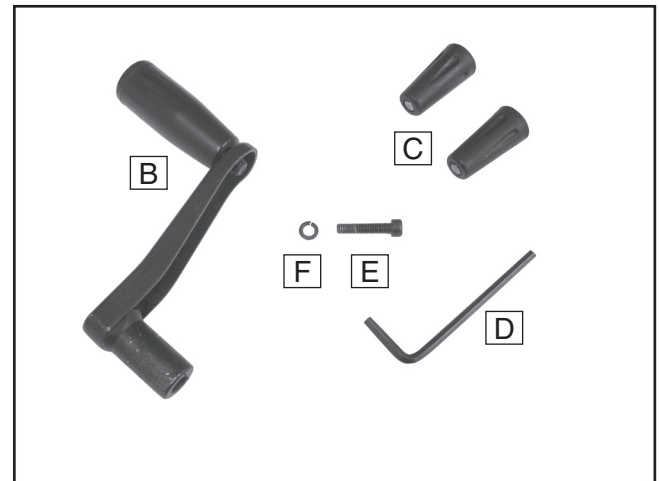
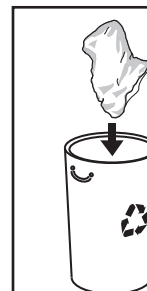


Figure 3. Inventory.

If any nonproprietary 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.



### **!WARNING**


**SUFFOCATION HAZARD!**  
Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

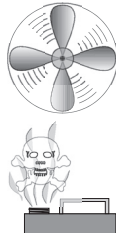




# Clean Up

The unpainted surfaces (including the knife and cutterhead) are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. For thorough cleaning, some parts must be removed. **For optimum performance from your machine, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

	<b>! WARNING</b> Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. <b>DO NOT</b> use these products to clean the machinery.
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	<b>! CAUTION</b> Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.
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## G7895—Grizzly Citrus Degreaser

This natural, citrus-based degreaser is a great solution for removing export grease, and it's much safer to work around than nasty solvents.

<p>Call <b>1-800-523-4777</b> To Order</p>	
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Figure 1. Grizzly citrus degreaser.

# Site Considerations

## Workbench Load

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

## Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

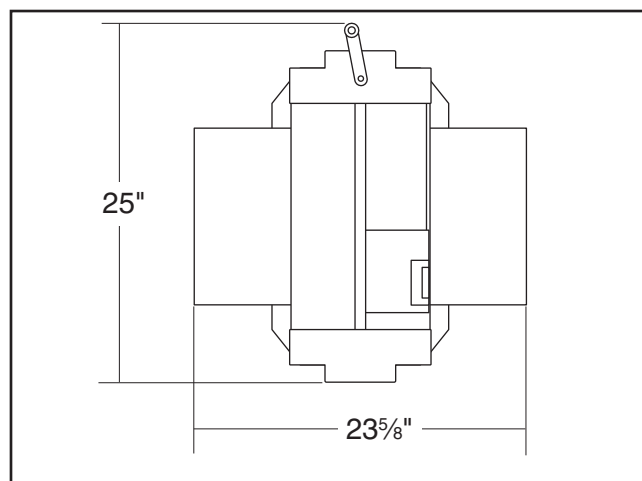


Figure 4. Minimum working clearances.

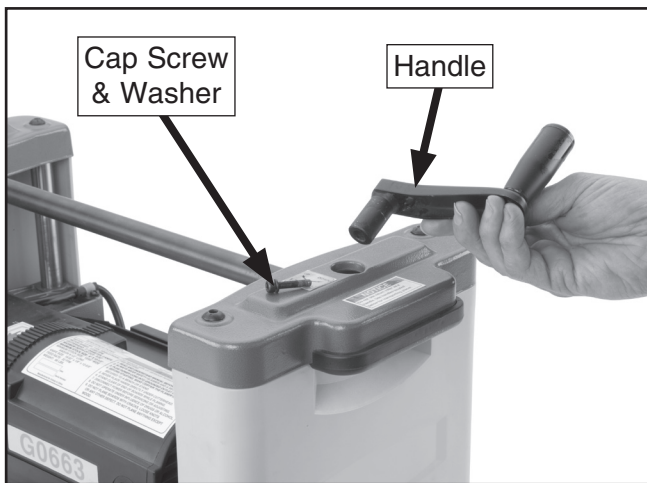
	<b>! CAUTION</b> Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.
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# Assembly

## To attach the elevation handle assembly:

1. Align the flat portion inside the handle bore with the flat portion on the shaft.
2. Insert the handle assembly on the elevation shaft.
3. Thread the M5-.8 x 25mm cap screw with the lock washer through the handle and into the shaft to secure the handle in place, as shown in **Figure 5**. DO NOT over-tighten.



**Figure 5.** Attaching handle.

## Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the safety disabling mechanism on the switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 25**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

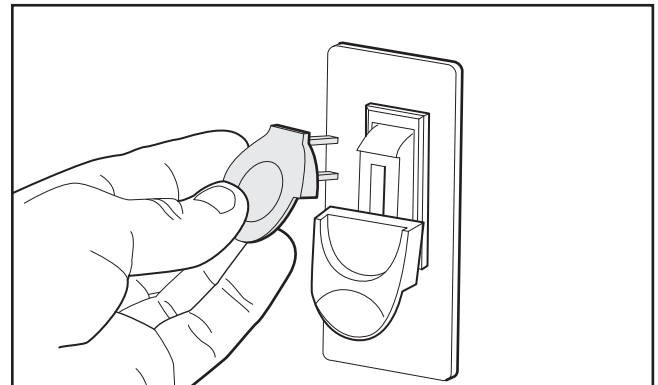
## To test run the machine:

1. Connect the machine to the power source.
2. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
3. Make sure all tools and objects used during setup are cleared away from the machine.
4. Verify that the machine is operating correctly by turning the machine **ON**.

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

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

5. Turn the machine **OFF**.
6. Remove the switch disabling key, as shown in **Figure 6**.



**Figure 6.** Removing switch key from paddle switch.

7. Try to start the machine with the paddle switch.

—If the machine does not start, the switch disabling feature is working as designed.

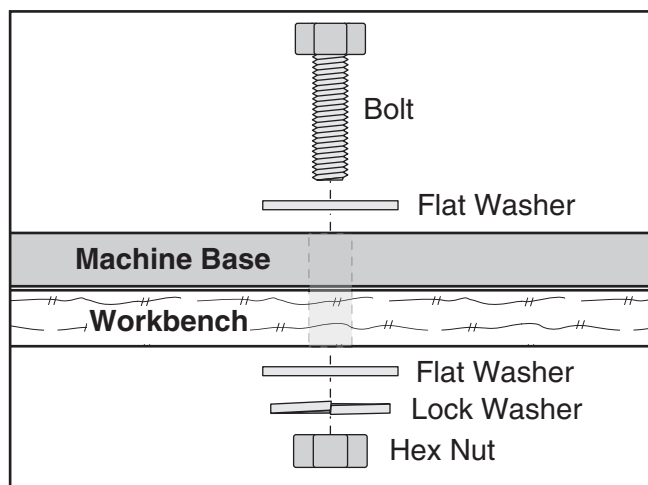
—If the machine starts, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.



# Mounting

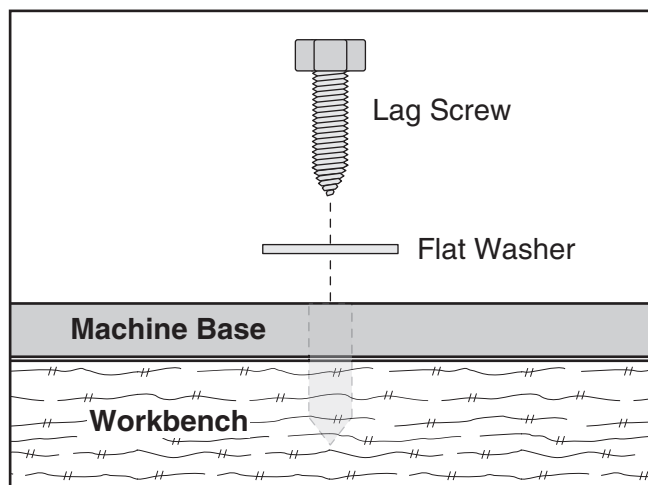
Once you have confirmed that your machine is running properly, mount it to a workbench through the holes in the base.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the drill press to the workbench.



**Figure 7.** Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.



**Figure 8.** Example of a direct mount setup.

# Dust Collection

Use of a portable dust collector will greatly reduce the amount of wood chips and saw dust in the work area. In addition, dust collectors help extract wood chips and dust from the cutterhead area. This lessens the potential for damaging the workpiece or the planer when wood chips become caught between the knife and the workpiece during the planing process.

Dust collectors can be found in the Grizzly catalog or website and attachments suited specifically to the Model G0663 Planer are shown in **Accessories, Page 19.**

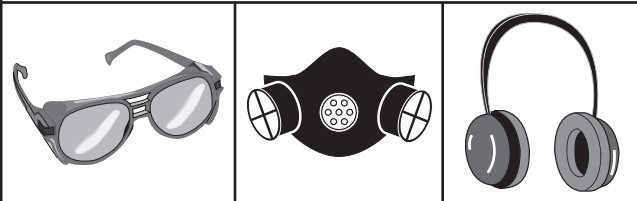


# SECTION 4: OPERATIONS

## Operation Safety

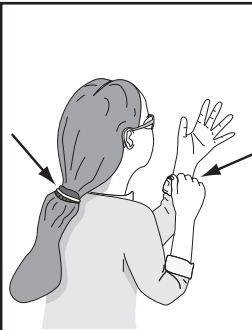
### **!WARNING**

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



### **!WARNING**

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

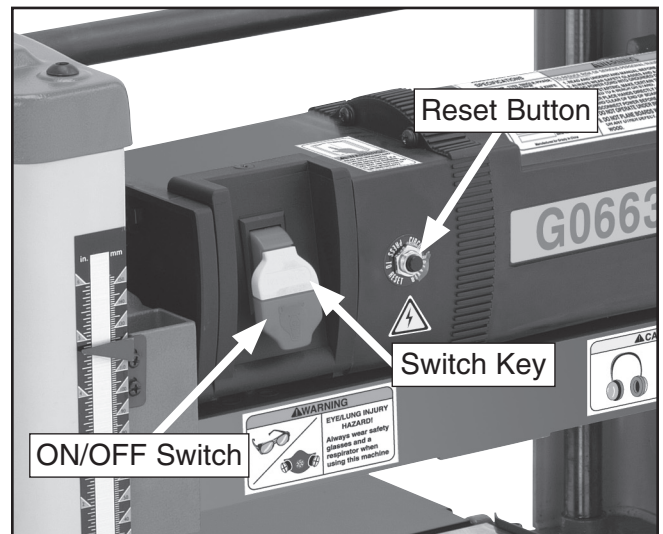


## **NOTICE**

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

## ON/OFF Switch

The ON/OFF switch is located on the front of the planer. The switch has a key that, when removed, allows it to be locked in the *OFF* position. To use the locking feature, push the switch to the *OFF* position and pull the switch key out. If the key is removed when the planer is *ON*, it can still be turned *OFF*, but it will not be able to be restarted until the key is replaced (**Figure 9**).



**Figure 9.** Location of switch and reset button.

## Reset Button

The Model G0663 Planer comes equipped with a thermal overload protection switch which will trip if the motor gets too hot. To reset the button, turn the switch to the *OFF* position, wait a few minutes and then depress the reset button. If the reset button does not stay depressed, wait longer before resetting to allow the motor to cool.



# Functional Overview

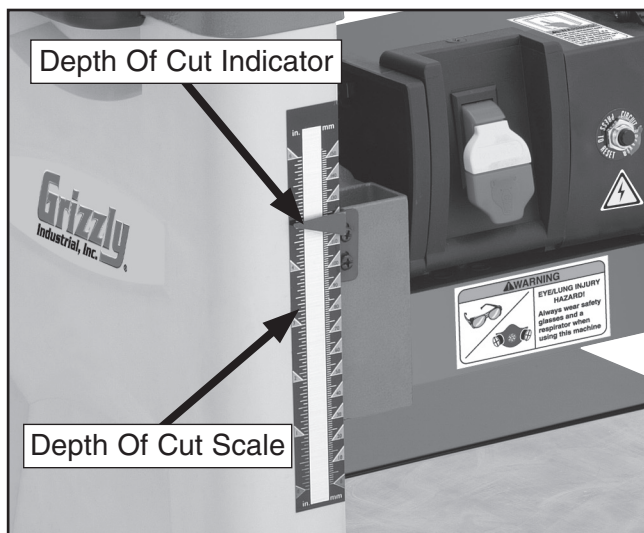
The Model G0663 Planer allows the user to plane material from the surface of boards in precise increments which are determined by the depth of cut. The depth of cut is adjusted with the cutterhead elevation handle. One turn of the handle is equal to  $\frac{1}{16}$ ".

Once the depth of cut is adjusted, the board is fed into the infeed roller which pulls the board into the cutterhead, where material is removed. The outfeed roller then pulls the board away from the cutterhead. After the board is completely free from the outfeed roller, it can be returned to the infeed side of the machine. Larger workpieces can be passed across the return roller located on top of the machine.

The depth of cut is again adjusted, and the process is continued until the desired board thickness is reached.

## Depth Of Cut

The planing depth is controlled by the cutterhead elevation handle on top of the planer. Turning the handle clockwise raises the cutterhead and turning it counterclockwise lowers the cutterhead (see **Figure 11**).



**Figure 11.** Depth of cut scale and indicator.

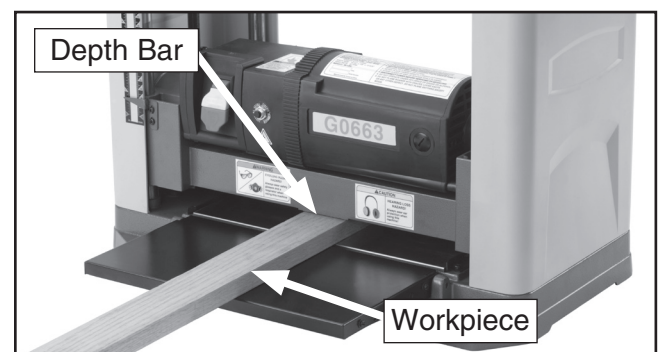
Depth-of-cut is read directly from the inch/millimeter scale located on the left-hand side of the planer. One complete turn of the handle raises or lowers the cutterhead approximately  $\frac{1}{16}$ ".

The maximum depth-of-cut varies according to the hardness of the wood and how wide of a board is passed under the cutterhead. Generally, we recommend a maximum depth of no more than  $\frac{1}{32}$ " on boards over 5" wide and no more than  $\frac{3}{32}$ " on boards under 5" wide. A series of light cuts will give a better end result than trying to take off too much material in a single pass, plus there will be less strain on the motor.

## Basic Operations

**To use the planer:**

1. Put on safety glasses.
2. Unless your workpiece is very flat, surface plane the workpiece on a jointer until one side is flat—having the face flat will ensure that it sits flat on the planer table during operation.
3. Place your workpiece on the infeed table and lower the cutterhead case until the depth bar just touches the workpiece, as shown in **Figure 10**.



**Figure 10.** Setting depth of cut.



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

4. Turn the elevation handle  $\frac{1}{4}$  turn clockwise to raise the cutterhead approximately  $\frac{1}{64}$ ". This will set the depth of cut to  $\frac{1}{32}$ ". Remove the workpiece from the planer.
5. Turn the planer **ON**.
6. With the flat side of the board down on the table, feed the workpiece into the front of the planer, making sure not to stand directly in front or behind the workpiece to reduce the risk of a kickback injury.

—If the cut is too deep and bogs down the planer, turn the planer **OFF** immediately, allow it to come to a complete stop, raise the cutterhead, remove the workpiece, reduce the depth of cut, then repeat **Step 6**.

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

7. Once the workpiece is clear of the outfeed roller, measure the workpiece thickness. If further planing is needed, lower the cutterhead by turning the elevation handle  $\frac{1}{2}$  turn ( $\frac{1}{32}$ "), return the workpiece to the infeed table, then continue.
8. Continue this process until the desired thickness is reached. The depth of cut indicator scale shows the approximate thickness of the workpiece after it has been cut. Use this indicator to judge when the thickness is approximately correct. For more precise applications, use a caliper to measure the workpiece thickness.

## Planing Tips

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- Inspect your lumber for twisting or cupping, and surface one face on a jointer if necessary.
- Scrape off all glue when planing glued-up panels.
- DO NOT plane more than one piece at a time.
- Never remove more than the recommended amount of material on each pass. Remove less material on each pass when planing wide or dense stock.
- Support the workpiece on both ends. Get assistance if you are planing long lumber, or use roller stands to support the workpiece.
- Measure the workpiece thickness with calipers to get exact results.
- Carefully inspect all stock to make sure it is free of large knots or foreign objects that may damage your knives, cause kickback or eject from the planer.
- When possible, plane equal amounts on each side of the board to reduce the chance of twisting or cupping.
- Use the entire width of the planer to wear knives evenly.
- Always plane WITH the grain direction of the wood. Never plane cross-grain or end-grain.



# Wood Characteristics

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

## Chipped Grain

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

*Solution:* Decrease depth of cuts. Inspect your lumber and determine if its grain pattern is causing the problem. If the lumber does not show substantial crossgrain, replace your knives.

## Fuzzy Grain

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

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

## Snipe

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

*Solution:* The best way to deal with snipe is by planing lumber longer than your intended work length and then cutting off the excess after planing is completed.

## Pitch & Glue Build-up

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

*Solution:* Clean the rollers and cutterhead.

## Chip Marks or Indentations

*Problem:* Chip indentation or chip bruising is the result of wood chips not being thrown away from the cutterhead and out of the machine. Instead they are carried around the cutterhead, deposited on the planed surface and crushed by the outfeed roller. Chip indentations can be caused by a number of reasons, some of which are:

- The type of lumber being planed. Certain species have a tendency to chip bruise.
- A high moisture content (over 15%) or surface moisture. Typically found in air-dried stock where the surface is dry but the inside needs a longer time to season.
- Dull knives.
- Too much material being removed in one pass.

*Solution:*



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



# Wood Types



The species of wood, as well as its condition, has a dramatic effect on the depth of cut the planer can effectively take with each pass. The harder the wood (as illustrated by its shear strength), the shallower the depth of cut should be.

Commonly used hardwoods and their associated shear strengths are illustrated in **Figure 12**.

	Type	Shear (PSI)
 Increasing Difficulty 	Black Locust	2,480
	Sugar Maple	2,330
	Pecan Hickory	2,080
	White Oak	2,000
	White Ash	1,950
	Black Cherry	1,700
	American Elm	1,510
	Black Walnut	1,370
	Red Alder	1,080
	Basswood	980
	Cottonwood	930

**Figure 12.** Common hardwood shear strengths.

Similarly, common softwood shear strengths are displayed in **Figure 13**.

	Type	Shear (PSI)
 Increasing Difficulty 	Western Larch	1,410
	Tamarack	1,280
	Douglas Fir	1,160
	Alaska Cedar	1,130
	Sitka Spruce	1,150
	Sugar Pine	1,050
	Cypress	1,000
	Redwood (OG)	940
	Red Cedar	860
	White Pine	850
	Balsam Fir	710

**Figure 13.** Common softwood shear strengths.





# SECTION 5: ACCESSORIES

## **T20413—12½" Replacement Knives**

Set of two reversible replacement knives for the Model G0663 12½" Planer.

## **T20501—Face Shield, 4" Crown, Clear**

## **T20502—Face Shield, 7" Crown, Clear**

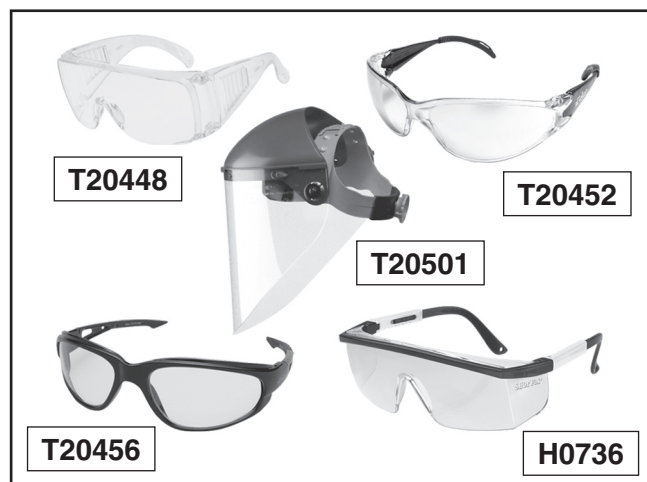
## **T20448—Economy Clear Safety Glasses**

## **T20452—"Kirova" Anti-Reflective Glasses**

## **T20456—"Dakura" Clear Safety Glasses**

## **H0736—Shop Fox® Safety Glasses**

These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!



**Figure 14.** Our most popular eye protection.

## **G7313—700 lb Capacity SHOP FOX® Stand**

A perfect stand for mounting your smaller machines on. Sturdy and rugged for everyday shop use.



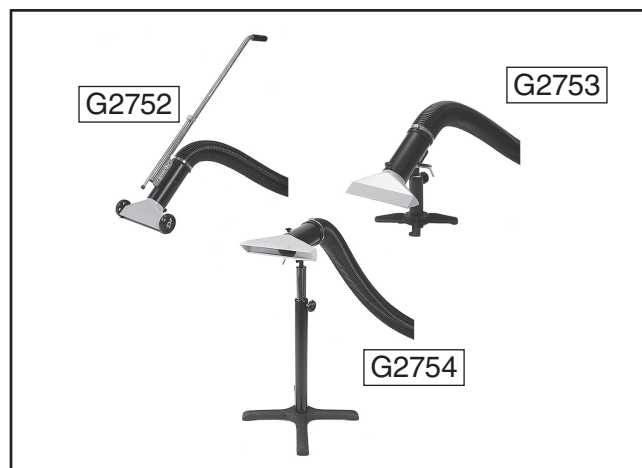
**Figure 15.** G7313 SHOP FOX® Stand.

## **G2752—4" Rolling Floor Sweep**

## **G2753—4" Bench Dust Collection Attachment**

## **G2754—4" Floor Dust Collection Attachment**

These attachments are indispensable for collecting dust at machines without a port. The rolling floor sweep is also a convenient way to keep the shop floor or workbench top clean! Designed for use with 4" flexible hose (not included).



**Figure 16.** Dust collection attachments.

## **H4978—Deluxe Earmuffs - 27dB**

## **H4979—Twin Cup Hearing Protector - 29dB**

## **H4977—Work-Tunes Radio Earmuffs - 25dB**

Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.

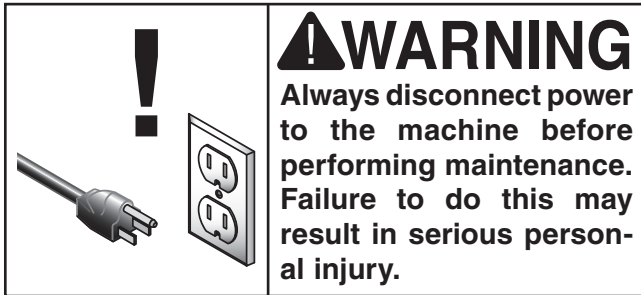


**Figure 17.** Our most popular earmuffs.

**Call 1-800-523-4777 To Order**



# SECTION 6: MAINTENANCE



## Schedule

For optimum performance from your machine, follow this maintenance schedule:

### Daily

- Check/correct loose hardware.
- Check/correct damaged knives.
- Check/correct worn or damaged wires.
- Correct any other unsafe condition.

### Every Ten Hours of Service

- Lubricate chains and gears, (Page 24).

### Monthly

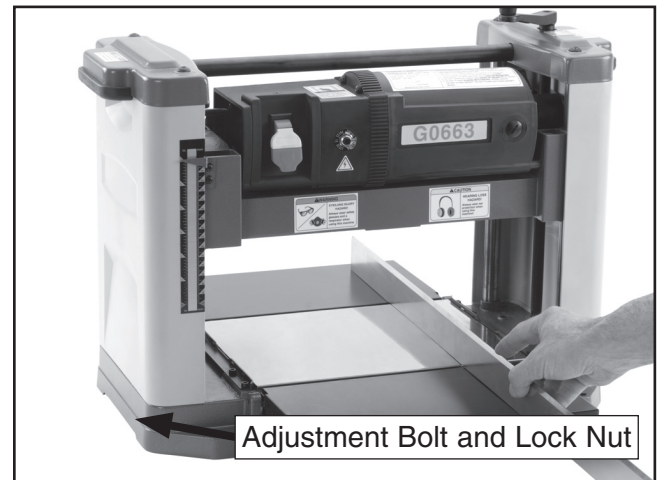
- Check for belt tension, damage, or wear.
- Remove cutterhead guard and thoroughly clean all built-up sawdust from the cutterhead area.

## Cleaning

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

## Extension Wings

Your planer is equipped with front and rear extension wings. Each wing folds up for machine mobility and folds down for machine operation. To check the alignment, lay a straightedge across the bed and both wings (see **Figure 18**).



**Figure 18.** Aligning extension wings.

If adjustment is necessary, proceed as follows:

1. Loosen the lock nuts and adjustment bolts underneath each extension wing.
2. Hold a straightedge across the bed and both wings, and turn the adjustment bolts so the wings and the table are on the same plane.
3. Without turning the adjustment bolts, tighten the lock nuts. Recheck to ensure consistency from side-to-side.



# Knife Replacement

## CAUTION

The cutterhead knives on the Model G0663 are extremely sharp. Brushing your finger along the edge can result in a severe cut. Take extreme caution when doing any of the adjustments involving the cutterhead knives. Wear thick gloves anytime it is necessary to manually rotate the cutterhead assembly.

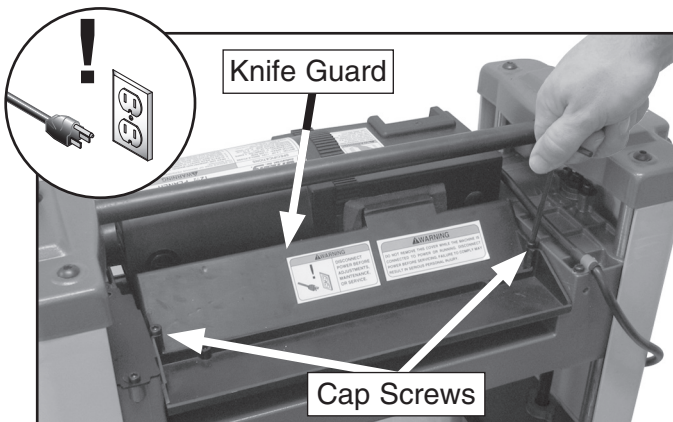
The condition of the knives on the Model G0663 Planer will affect the precision of the cut. During operation, watch for the following signs of dulled knives.

- Raised grain occurring as a result of dull knives hammering at the surface of the wood.
- A "fuzzy" appearance on the surface of the wood as a result of dull knives tearing, rather than cutting the wood fibers.
- Grooves as a result of nicks along the knife edge.

If any of these signs become apparent during use, the knives must be reversed or replaced. Do not attempt to sharpen the knives.

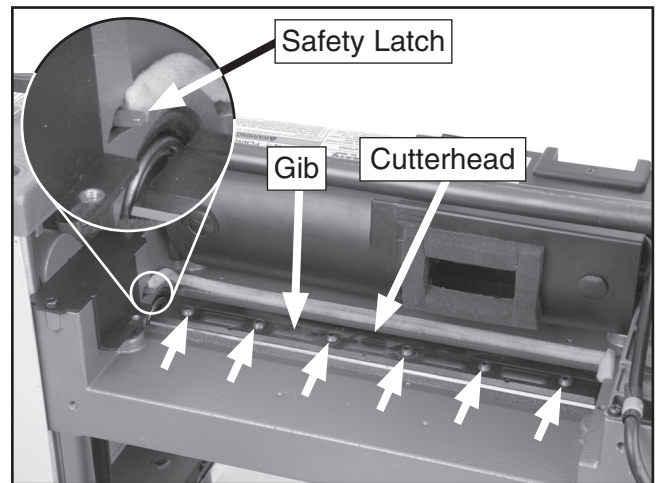
### To remove the knives:

1. DISCONNECT PLANER FROM POWER!
2. Remove the cap screws from the knife guard, then remove the guard (**Figure 19**).



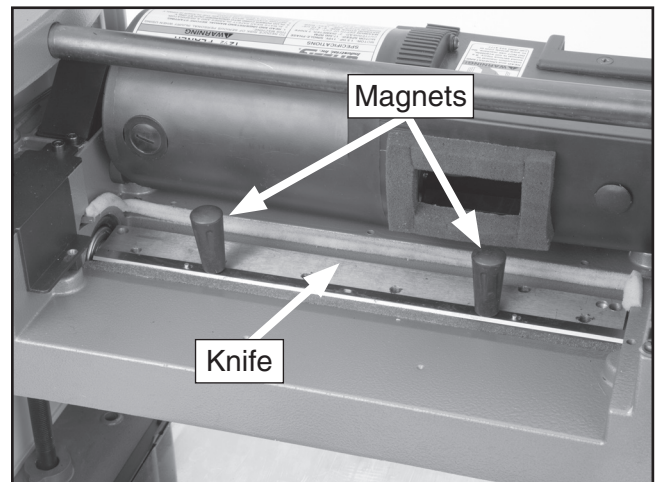
**Figure 19.** Removing knife guard.

3. Wearing gloves, carefully turn the cutterhead towards you until the safety latch engages and the cutterhead no longer turns (**Figure 20**).



**Figure 20.** Exposed cutterhead.

4. Remove the six button head cap screws from the gib.
5. Use the included magnets, as shown in **Figure 21**, to first remove the gib, then the knife.



**Figure 21.** Knife removal.

6. Depress the safety latch, then carefully rotate the cutterhead towards you approximately ¼ turn. Release the safety latch and continue rotating the cutterhead until the second knife is exposed and the safety latch again engages.
7. Repeat **Steps 4** and **5** for the second knife.





Before re-installing the knives, the cutterhead, gib and knife must be inspected. Neglecting to inspect these components may result in damage to the planer.

#### To inspect the cutterhead, gib, and knives:

1. DISCONNECT PLANER FROM POWER!
2. Carefully clean the cutterhead with a rag and inspect the following:
  - Make sure the threaded screw holes do not contain wood material or sawdust.
  - Make sure that the hex socket and the threads of all hex screws are in good condition. Replace if questionable.
  - Make sure any resin or glue buildup on the cutterhead, gib, and knives is removed so the knife and gib will sit flat on the cutterhead.
  - Make sure the knives are free of cracks. If any cracks exist, replace both knives.

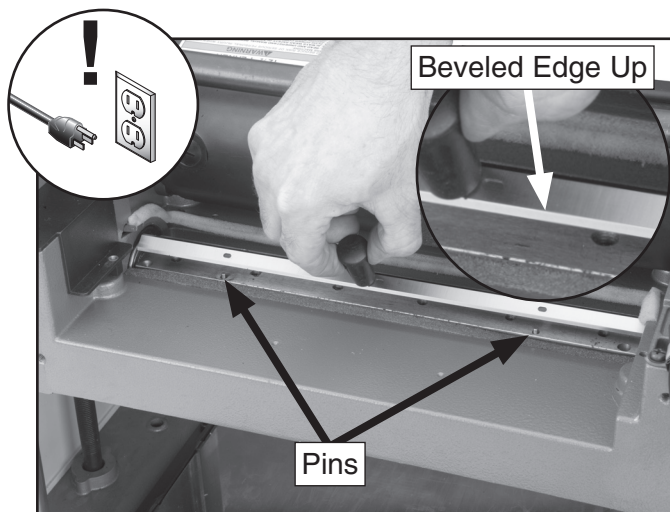
## NOTICE

To maintain accurate and consistent planing results, we do not recommend sharpening the knives. Instead, replace the knives when they get dull.

The knives on the Model G0663 Planer are reversible and should always be reversed or replaced as a matched set. To avoid downtime, we recommend having an extra set of knives for your planer (Model T20413 in the Grizzly catalog or website). Once the cutterhead, gib, and knives have been inspected and prepared, install the knives.

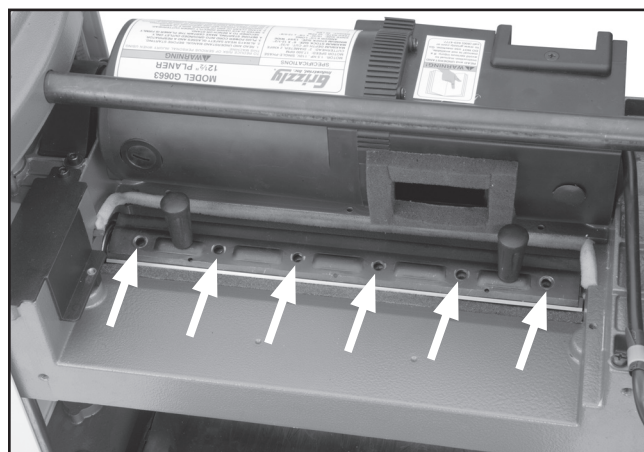
#### To install the knives:

1. DISCONNECT PLANER FROM POWER!
2. Using the magnets, position the knife over the two pins on the cutterhead. Be sure the knife is oriented with the beveled edge up, as shown in **Figure 22**.



**Figure 22.** Knife installation.

3. Using the magnets, replace the gib over the knife. Secure the gib with the six screws in the locations shown in **Figure 23**.



**Figure 23.** Gib installation.

4. Depress the safety latch, then carefully rotate the cutterhead towards you approximately  $\frac{1}{4}$  turn. Release the safety latch and continue rotating the cutterhead until the second knife slot is exposed and the safety latch again engages.
5. Repeat **Steps 2** and **3** for the second knife, then replace the knife guard.



# Motor

Keep the motor as clean as possible. Prevent any water, oil, or wood chips from penetrating inside the motor. Be sure to clean the machine after every use.

The bearings inside the motor are shielded and lubricated for the life of the bearing and require no routine maintenance.

This motor is equipped with long life carbon brushes. However, brush life expectancy is affected by motor loading. Planing very wide, dense boards or cutting too deep will reduce brush life. Check brushes after every ten to fifteen hours of operation (**Figure 24**).



**Figure 24.** Brush holder location (another brush is located on the other side of the motor from the one shown in this picture).

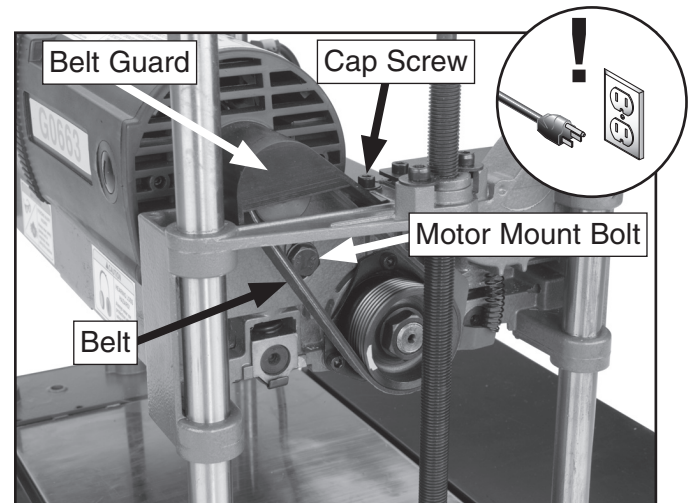
When the brushes are worn down to  $\frac{1}{4}$ " (6mm), it is time for replacement. When checking brushes, be sure to return each brush in the same position that it came from. When replacing old brushes, be sure to replace both brushes at the same time.

# Belt

The cutterhead is driven by a belt that is located on the right-hand side of the motor and cutterhead assembly (when facing the front of the machine). The belt is very durable, but with extended use may begin to slip, indicating the need for replacement.

## To replace the belt:

1. DISCONNECT PLANER FROM POWER!
2. Remove the elevation handle and the two button head cap screws on the right-side top plate. Remove the top plate, then pull the right side cover off.
3. Remove the belt guard shown in **Figure 25** by removing the cap screw that secures it.



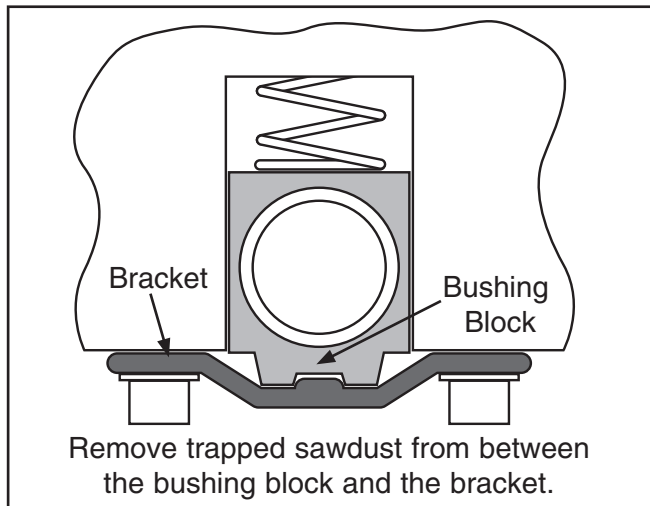
**Figure 25.** Cutterhead drive components.

4. Loosen the motor mount bolt, shown in **Figure 25**, to release tension on the belt.
5. Remove the belt.
6. Place the new belt over both pulleys. Lift the motor by hand using moderate force to apply tension to the belt, then tighten the motor mount bolt.
7. Replace the belt guard, side cover, top plate, button head cap screws, and cutterhead elevation handle.



# Feed Rollers

The feed rollers rotate in bushing blocks that are spring loaded. The feed rollers ride up on the board so that the roller pressure is maintained. If chips or sawdust build up between the bracket and bushing block, the amount of roller vertical travel will be reduced, potentially causing improper feeding of lumber through the machine (**Figure 26**).



**Figure 26.** Location of potential trapped sawdust.

Periodically check and clean chips and sawdust from between the bushing blocks and brackets. Remove the elevation handle, the top covers, and the sides. This provides easy access to depress the rollers so that chips and sawdust can be easily removed.

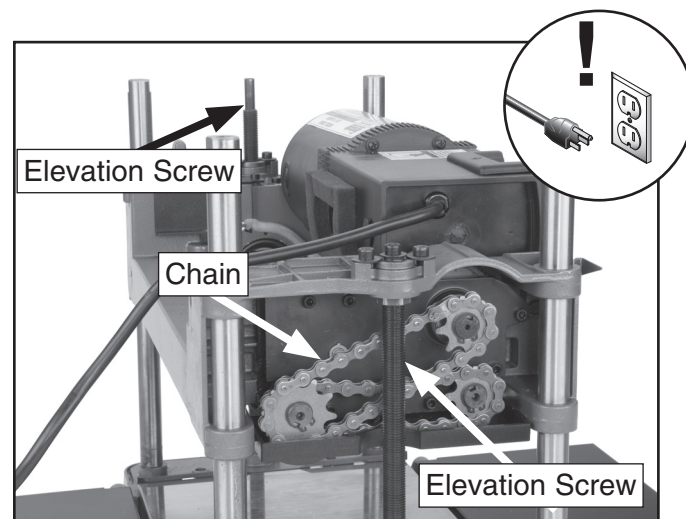
## To clean the feed rollers:

1. **DISCONNECT PLANER FROM POWER!**
2. Place a 4" high block of wood between one of the feed rollers and the planer bed. Ensure that the block of wood is not under the cutterhead.
3. Lower the cutterhead assembly down just enough so that the roller is pushed up against the spring and pressure is off of the two brackets.

4. Remove any trapped material from between the roller assembly and bracket.
5. Raise the cutterhead assembly and remove the block of wood.
6. Repeat **Steps 1-4** for the other feed roller.
7. Replace the sides, top plates, and elevation handle.

# Lubrication

There are two primary points that require periodic lubrication—the head elevation screws and the feed roller chain drive. Access for lubrication requires removing the cover and sides of the machine first (**Figure 27**).



**Figure 27.** Lubrication points of chain and elevation screws.

The elevation screws on each side of the machine should be coated with a light multi-purpose grease to lubricate the threads.

The chain drive can be lubricated with a spray oil. Saturate each chain link, then wipe off the excess so that sawdust will not be attracted.

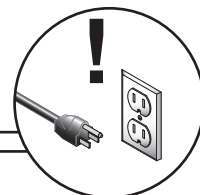
Replace the sides, cover, and handle when complete.



# SECTION 7: SERVICE

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

## Troubleshooting

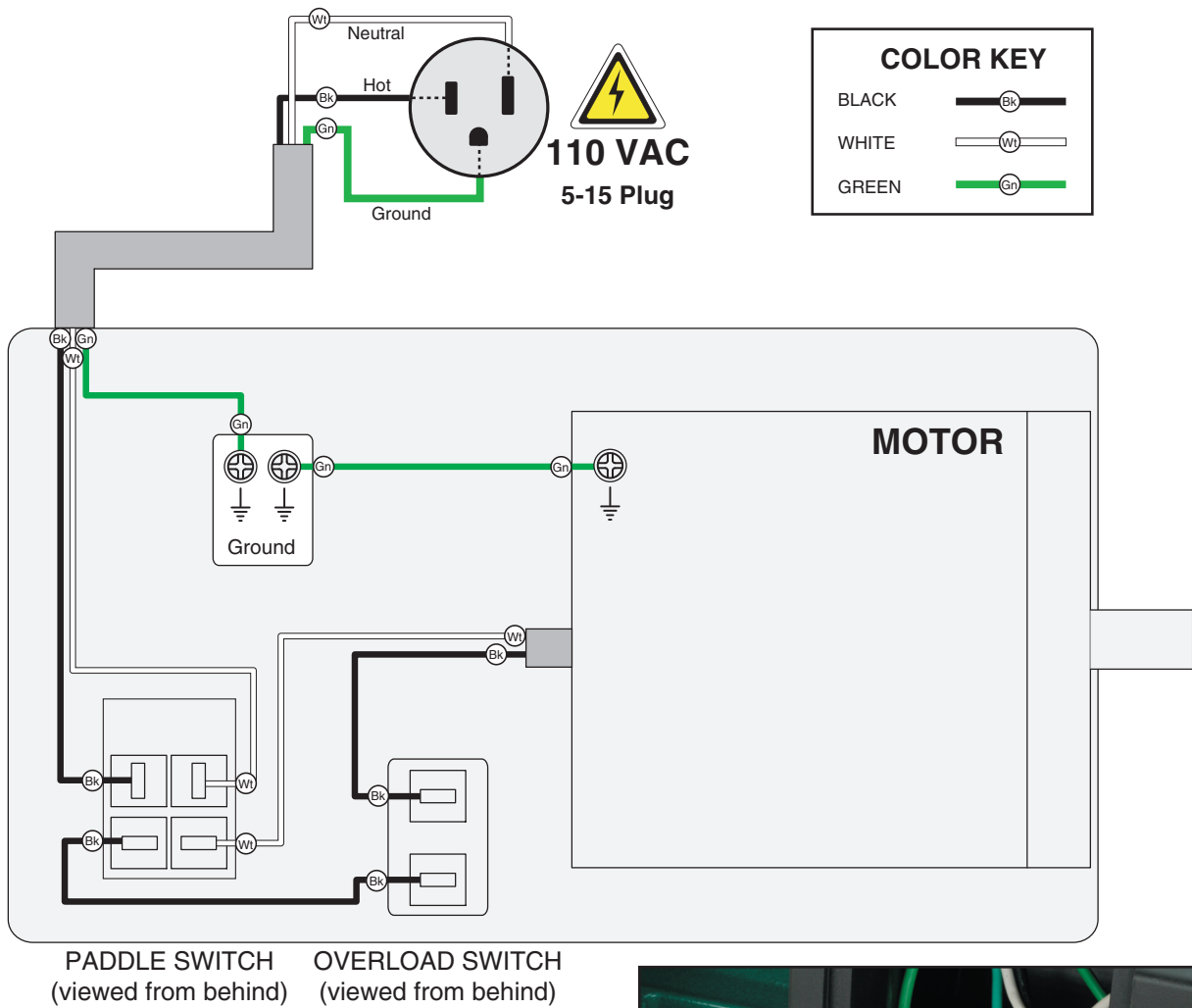


Symptom	Possible Cause	Possible Solution
Motor will not run.	<ol style="list-style-type: none"> <li>1. No power to planer</li> <li>2. Motor overload protection tripped.</li> <li>3. Defective switch or loose wiring.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power supply.</li> <li>2. Turn planer <b>OFF</b>. Reset overload protection (<b>Page 14</b>).</li> <li>3. Inspect all lead connections on motor for loose or open connections.</li> </ol>
Fuses or circuit breakers blow.	<ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug.</li> </ol>	<ol style="list-style-type: none"> <li>1. Repair or replace cord or plug for damaged insulation and shorted wires.</li> </ol>
Motor overheats or operates at limited RPM.	<ol style="list-style-type: none"> <li>1. Motor overloaded during operation.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce cutting load; take lighter cuts.</li> </ol>
Motor stalls or shuts off during a cut.	<ol style="list-style-type: none"> <li>1. Cut is too deep.</li> <li>2. Motor overload protection tripped.</li> <li>3. Short circuit in motor or loose connections.</li> <li>4. Circuit breaker tripped.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce depth of cut.</li> <li>2. Turn planer <b>OFF</b>. Reset overload protection (<b>Page 14</b>).</li> <li>3. Repair or replace connections on motor for loose or shorted terminals or worn insulation.</li> <li>4. Install correct or repair circuit breaker; reduce number of machines running on that circuit.</li> </ol>
Cutterhead slows or squeals when cutting, especially on start-up.	<ol style="list-style-type: none"> <li>1. Belt worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace belt (<b>Page 23</b>).</li> </ol>
Infeed/outfeed rollers not rotating.	<ol style="list-style-type: none"> <li>1. Chain and sprockets are worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace chain and sprockets.</li> </ol>
Vibration when running or cutting.	<ol style="list-style-type: none"> <li>1. Loose or damaged cutterhead.</li> <li>2. Damaged belt.</li> <li>3. Worn cutterhead bearings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten or replace cutterhead.</li> <li>2. Replace (<b>Page 23</b>).</li> <li>3. Check/replace cutterhead bearings.</li> </ol>
Boards don't feed properly into machine.	<ol style="list-style-type: none"> <li>1. Knives are dull.</li> <li>2. Sawdust in feed rollers.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace knives.</li> <li>2. Clean feed roller (<b>Page 24</b>)</li> </ol>





# Wiring Diagram

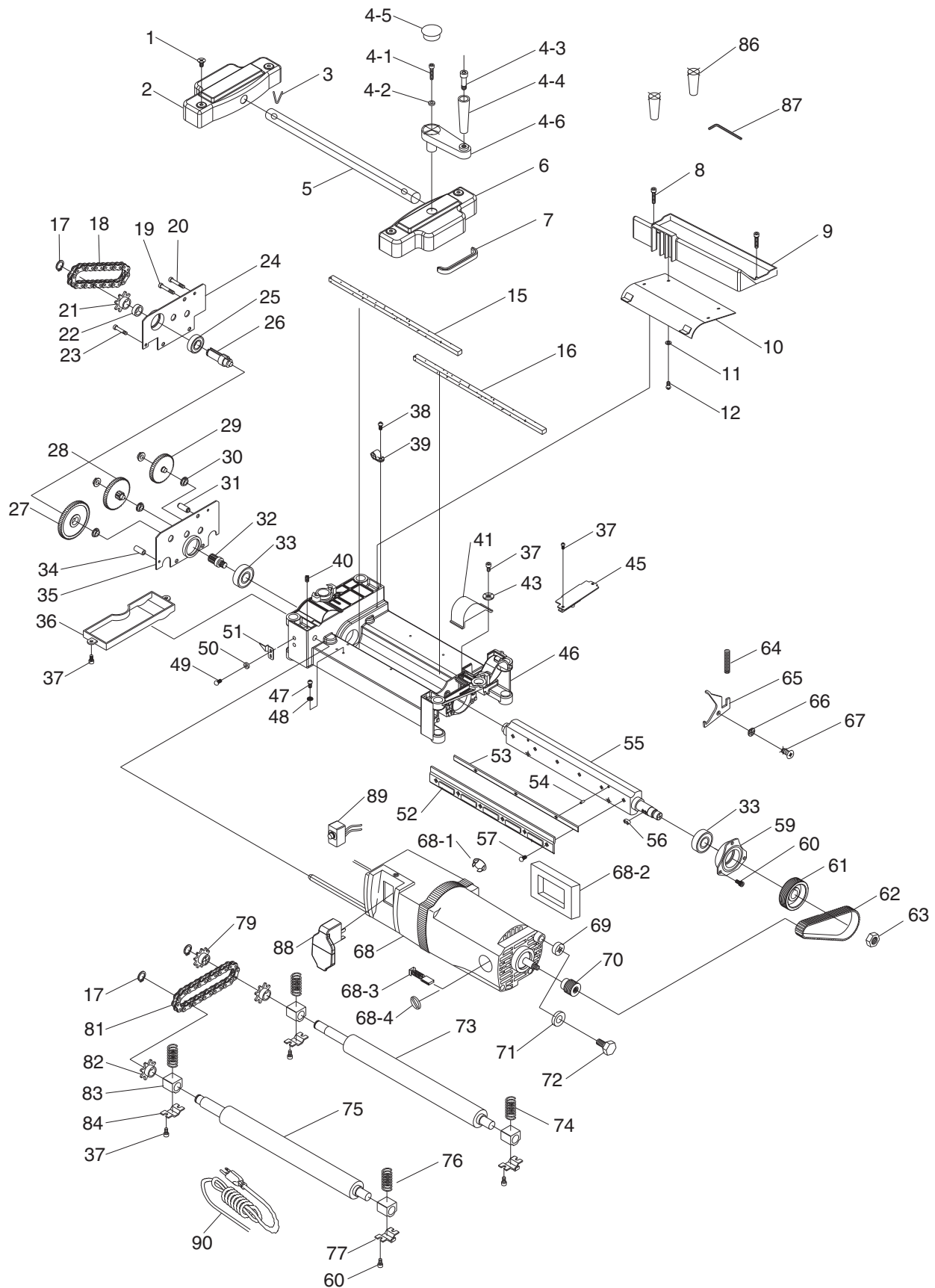


**Figure 28. Switch wiring.**





# Cutterhead Case Breakdown



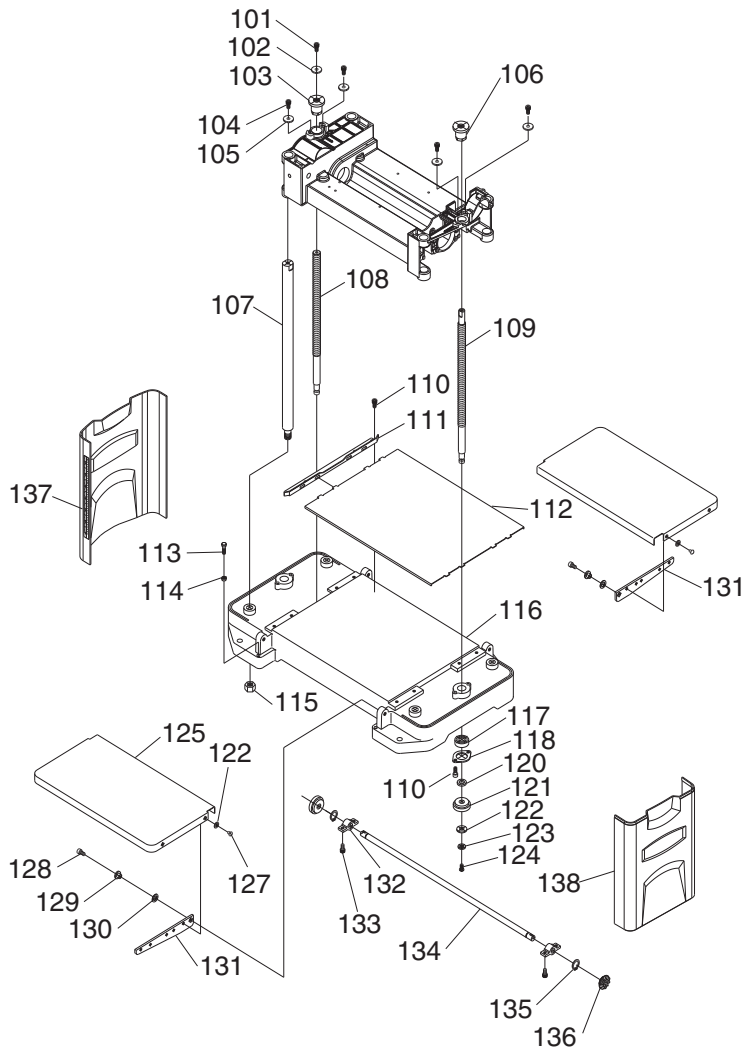
# Cutterhead Case Parts List

REF	PART #	DESCRIPTION
1	PSBS03M	BUTTON HD CAP SCR M8-1.25 X 16
2	P0663002	LEFT CAP
3	P0663003	COTTER PIN 2.5MM X 32MM
4-1	PSB38M	CAP SCREW M5-.8 X 25
4-2	PLW01M	LOCK WASHER 5MM
4-3	PSB13M	CAP SCREW M8-1.25 X 30
4-4	P0663004-4	KNOB
4-5	P0663004-5	HANDLE CAP
4-6	P0663004-6	HANDLE
5	P0663005	ROLLER
6	P0663006	RIGHT CAP
7	P0663007	GRIP
8	PSB78M	CAP SCREW M5-.8 X 40
9	P0663009	DUST GUIDE
10	P0663010	DUST PLATE
11	PW02M	FLAT WASHER 5MM
12	PHTEK37M	TAP SCREW M5 X 12
15	P0663015	LOWER GASKET
16	P0663016	UPPER GASKET
17	PR05M	EXT RETAINING RING 15MM
18	P0663018	CHAIN
19	PSB79M	CAP SCREW M5-.8 X 35
20	PSB38M	CAP SCREW M5-.8 X 25
21	P0663021	SPROCKET
22	P0663022	SPACER
23	PSB95M	CAP SCREW M5-.8 X 30
24	P0663024	OUTSIDE COVER
25	P6002	BALL BEARING 6002ZZ
26	P0663026	SHAFT
27	P0663027	GEAR 70T
28	P0663028	DOUBLE GEAR 58T/12T
29	P0663029	DOUBLE GEAR 52T/12T
30	P0663030	BUSHING
31	P0663031	SPACER
32	P0663032	PINION
33	P6203	BALL BEARING 6203ZZ
34	P0663034	SPACER
35	P0663035	INSIDE COVER
36	P0663036	COVER
37	PSB50M	CAP SCREW M5-.8 X 10
38	PS09M	PHLP HD SCR M5-.8 X 10
39	P0663039	CORD CLAMP
40	PSS05M	SET SCREW M5-.8 X 10
41	P0663041	BELT GUARD
43	PWF05M	FENDER WASHER 5MM
45	P0663045	GUARD

REF	PART #	DESCRIPTION
46	P0663046	ROLLERCASE
47	PS05M	PHLP HD SCR M5-.8 X 8
48	PTLW02M	EXT TOOTH WASHER 5MM
49	PS07M	PHLP HD SCR M4-.7 X 8
50	PW05M	FLAT WASHER 4MM
51	P0663051	POINTER
52	P0663052	GIB
53	P0663053	KNIFE
54	P0663054	PIN
55	P0663055	CUTTERHEAD
56	P0663056	KEY
57	PSB115M	BUTTON HD CAP SCR M6-1 X 16
59	P0663059	BEARING RETAINER
60	PSB33M	CAP SCREW M5-.8 X 12
61	P0663061	CUTTERHEAD PULLEY
62	P0663062	BELT
63	P0663063	SPECIAL NUT
64	P0663064	SPRING
65	P0663065	CUTTERHEAD LOCK
66	P0663066	SPACER
67	PFH39M	FLAT HD SCR M5-.8 X 16
68	P0663068	MOTOR 1.5HP 110V 60HZ 1 PH
68-1	P0663068-1	HOLE PLUG
68-2	P0663068-2	PORT GASKET
68-3	P0663068-3	MOTOR BRUSH
68-4	P0663068-4	MOTOR BRUSH CAP
69	P0663069	SPACER
70	P0663070	MOTOR PULLEY
71	PW01M	FLAT WASHER 8MM
72	PB09M	HEX BOLT M8-1.25 X 20
73	P0663073	OUTFEED ROLLER
74	P0663074	SPRING OUTFEED
75	P0663075	INFEED ROLLER
76	P0663076	SPRING INFEED
77	P0663077	RETAINER RH
79	P0663079	SPROCKET
81	P0663081	CHAIN
82	P0663082	SPROCKET
83	P0663083	BEARING BLOCK
84	P0663084	RETAINER LH
86	P0663086	MAGNET
87	PAW04ML	HEX WRENCH 4MM 5-1/2 LONG
88	P0663088	ON/OFF SWITCH
89	P0663089	MOTOR OVERLOAD SWITCH
90	P0663090	POWER CORD



# Planer Base Breakdown & List

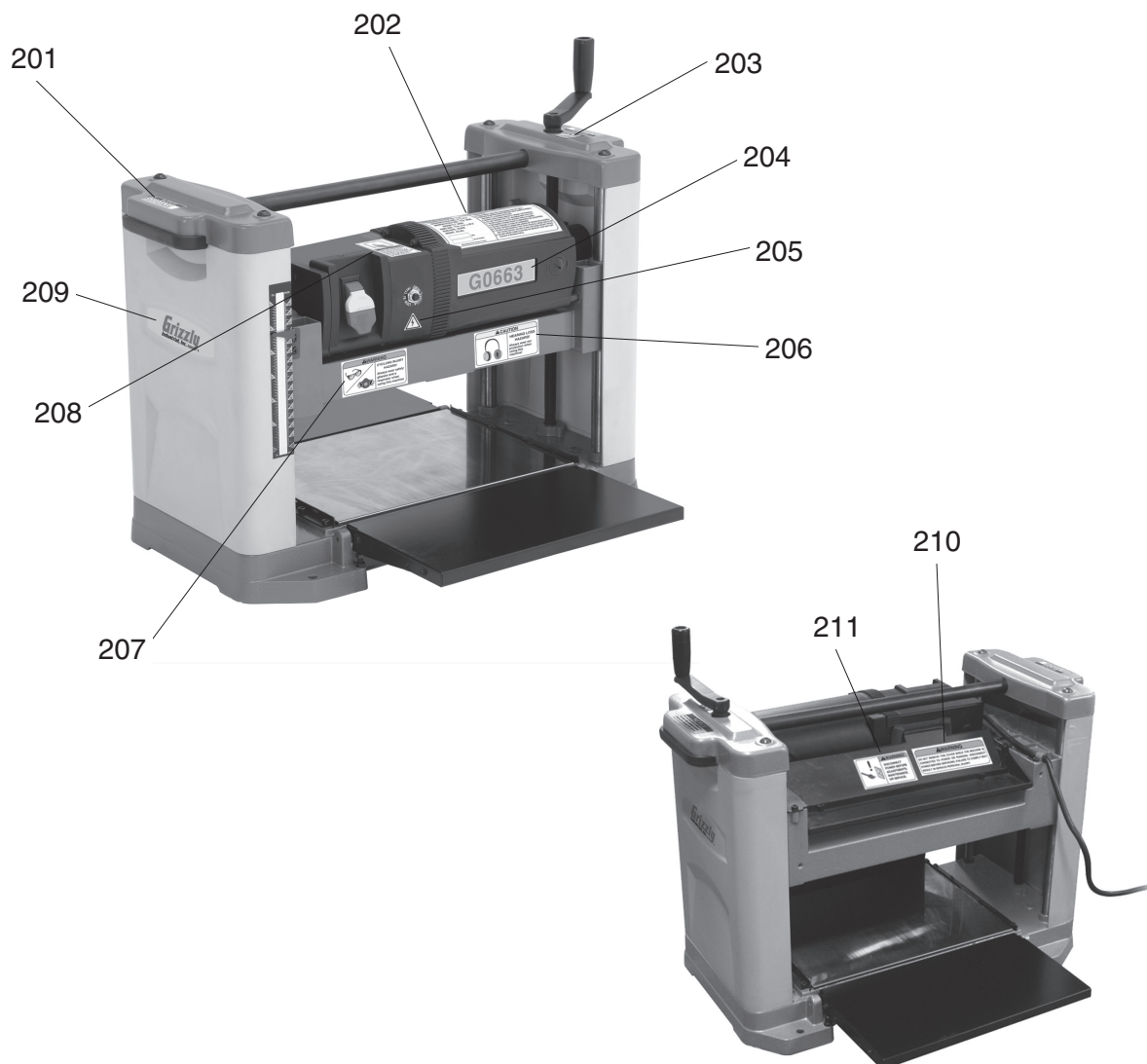


REF	PART #	DESCRIPTION
101	PSB33M	CAP SCREW M5-.8 X 12
102	PW02M	FLAT WASHER 5MM
103	P0663103	ELEVATING NUT LH
104	PSB01M	CAP SCREW M6-1 X 16
105	PW03M	FLAT WASHER 6MM
106	P0663106	ELEVATING NUT RH
107	P0663107	COLUMN
108	P0663108	ELEVATING SCREW LH
109	P0663109	ELEVATING SCREW RH
110	PSB50M	CAP SCREW M5-.8 X 10
111	P0663111	GUIDE
112	P0663112	PLATEN
113	PB08M	HEX BOLT M6-1 X 20
114	PN01M	HEX NUT M6-1
115	PN09M	HEX NUT M12-1.75
116	P0663116	BASE
117	P6000	BALL BEARING 6000ZZ
118	P0663118	LOWER BEARING RETAINER

REF	PART #	DESCRIPTION
120	P0663120	SPACER
121	P0663121	GEAR
122	PW05M	FLAT WASHER 4MM
123	PLW02M	LOCK WASHER 4MM
124	PSBS26M	BUTTON HD CAP SCR M4-.7 X 12
125	P0663125	INFEED/OUTFEED TABLE
127	PS17M	PHLP HD SCR M4-.7 X 6
128	PSB02M	CAP SCREW M6-1 X 20
129	P0663129	TABLE BUSHING
130	PW03M	FLAT WASHER 6MM
131	P0663131	TABLE SUPPORT
132	P0663132	SHAFT SUPPORT
133	PSB33M	CAP SCREW M5-.8 X 12
134	P0663134	SHAFT
135	PR01M	EXT RETAINING RING 10MM
136	P0663136	GEAR
137	P0663137	SCALE
138	P0663138	SIDE COVER



# Warning Labels Breakdown and List



REF	PART #	DESCRIPTION
201	P0663201	HANDLE NOTICE LABEL
202	P0663202	MACHINE ID LABEL
203	P0663203	HANDLE TURN LABEL
204	P0663204	MACHINE NUMBER LABEL
205	PLABEL-14	ELECTRICITY LABEL
206	P0663206	HEARING LOSS LABEL

REF	PART #	DESCRIPTION
207	P0663207	EYE/LUNG INJURY LABEL
208	P0663208	READ MANUAL LABEL
209	P0663209	GRIZZLY LABEL
210	P0663210	DO NOT REMOVE COVER LABEL
211	P0663211	DISCONNECT POWER LABEL

## WARNING

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





# WARRANTY CARD

Name \_\_\_\_\_

Street \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

Phone # \_\_\_\_\_ Email \_\_\_\_\_ Invoice # \_\_\_\_\_

Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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

1. How did you learn about us?

\_\_\_\_\_ Advertisement

\_\_\_\_\_ Friend

\_\_\_\_\_ Catalog

\_\_\_\_\_ Card Deck

\_\_\_\_\_ Website

\_\_\_\_\_ Other:

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

\_\_\_\_\_ Cabinet Maker

\_\_\_\_\_ Popular Mechanics

\_\_\_\_\_ Today's Homeowner

\_\_\_\_\_ Family Handyman

\_\_\_\_\_ Popular Science

\_\_\_\_\_ Wood

\_\_\_\_\_ Hand Loader

\_\_\_\_\_ Popular Woodworking

\_\_\_\_\_ Wooden Boat

\_\_\_\_\_ Handy

\_\_\_\_\_ Practical Homeowner

\_\_\_\_\_ Woodshop News

\_\_\_\_\_ Home Shop Machinist

\_\_\_\_\_ Precision Shooter

\_\_\_\_\_ Woodsmith

\_\_\_\_\_ Journal of Light Cont.

\_\_\_\_\_ Projects in Metal

\_\_\_\_\_ Woodwork

\_\_\_\_\_ Live Steam

\_\_\_\_\_ RC Modeler

\_\_\_\_\_ Woodworker West

\_\_\_\_\_ Model Airplane News

\_\_\_\_\_ Rifle

\_\_\_\_\_ Woodworker's Journal

\_\_\_\_\_ Modeltec

\_\_\_\_\_ Shop Notes

\_\_\_\_\_ Other:

\_\_\_\_\_ Old House Journal

\_\_\_\_\_ Shotgun News

3. What is your annual household income?

\_\_\_\_\_ \$20,000-\$29,000

\_\_\_\_\_ \$30,000-\$39,000

\_\_\_\_\_ \$40,000-\$49,000

\_\_\_\_\_ \$50,000-\$59,000

\_\_\_\_\_ \$60,000-\$69,000

\_\_\_\_\_ \$70,000+

4. What is your age group?

\_\_\_\_\_ 20-29

\_\_\_\_\_ 30-39

\_\_\_\_\_ 40-49

\_\_\_\_\_ 50-59

\_\_\_\_\_ 60-69

\_\_\_\_\_ 70+

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

\_\_\_\_\_ 0-2 Years

\_\_\_\_\_ 2-8 Years

\_\_\_\_\_ 8-20 Years

\_\_\_\_\_ 20+ Years

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

\_\_\_\_\_ 0-2

\_\_\_\_\_ 3-5

\_\_\_\_\_ 6-9

\_\_\_\_\_ 10+

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

\_\_\_\_\_ Yes

\_\_\_\_\_ No

8. Would you recommend Grizzly Industrial to a friend?

\_\_\_\_\_ Yes

\_\_\_\_\_ No

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

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

\_\_\_\_\_ Yes

\_\_\_\_\_ No

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

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_



Place  
Stamp  
Here



**GRIZZLY INDUSTRIAL, INC.**  
**P.O. BOX 2069**  
**BELLINGHAM, WA 98227-2069**



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____
Street_____
City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

# WARRANTY AND 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.

# ***grizzly.com***

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