

# READ THIS FIRST



Model G0815

**\*\*\*IMPORTANT UPDATE\*\*\***

For Machines Mfd. Since 03/16  
and Owner's Manual Revised 05/21

For questions or help with this product contact Tech Support at (570) 546-9663 or [techsupport@grizzly.com](mailto:techsupport@grizzly.com)

The following change was recently made since the owner's manual was printed:

- Instructions for checking gearbox oil level have been revised.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or [techsupport@grizzly.com](mailto:techsupport@grizzly.com).

(Replaces section on Page 20 in Manual)

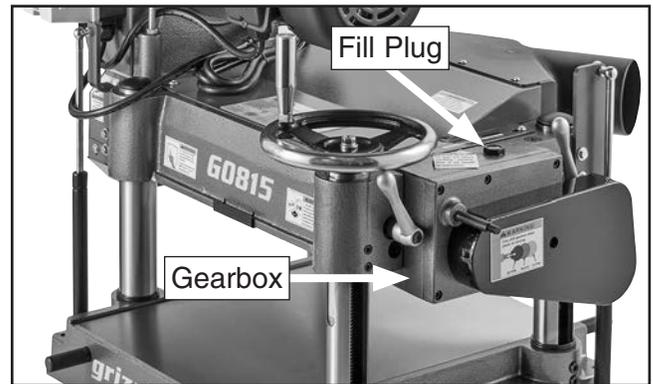
## Checking Gearbox Oil Level

Before starting your machine for the first time, check the gearbox oil level. The gearbox uses ISO 320 gear oil.

Items Needed	Qty
Screwdriver 6" .....	1
Open-End Wrench or Socket 22mm .....	1
Tape Measure .....	1
Shop Rags.....	As Needed

### To check gearbox oil level:

1. Remove gearbox fill plug (see **Figure 18**).
2. Insert clean 6" screwdriver inside fill hole until it touches bottom of gearbox (see **Figure 18**), then remove it.



**Figure 18.** Gearbox components.

3. Measure length of screwdriver coated with oil.
  - If measurement *is between* 1"–1 $\frac{3}{16}$ ", then gearbox oil level is okay. Replace fill plug and continue setup.
  - If measurement *is less than* 1", oil must be added. If measurement *is more than* 1 $\frac{3}{16}$ ", oil must be removed. See **Gearbox Oil** on **Page 32** for instructions.

**Note:** We recommend that you replace the gearbox oil after the first 20 hours of operation. This is a normal break-in procedure and will help maximize the service life of the machine by flushing away any particles from the break-in and manufacturing process.



COPYRIGHT © JANUARY, 2023 BY GRIZZLY INDUSTRIAL, INC.  
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**  
#MN22544 PRINTED IN TAIWAN

# *Grizzly* **Industrial, Inc.**®

## **MODEL G0815** **15" HEAVY-DUTY PLANER** **OWNER'S MANUAL**

*(For models manufactured since 03/20)*



*Shown with optional stand:  
Model T27650*



COPYRIGHT © FEBRUARY, 2016 BY GRIZZLY INDUSTRIAL, INC., REVISED MAY, 2021 (MN)  
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#WK17990 PRINTED IN TAIWAN

V3.05.21

 **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>28</b>
Contact Info.....	2	<b>SECTION 6: MAINTENANCE</b> .....	<b>29</b>
Manual Accuracy .....	2	Schedule .....	29
Identification .....	3	Cleaning & Protecting .....	29
Controls & Components.....	4	Lubrication .....	30
Internal Components.....	5	<b>SECTION 7: SERVICE</b> .....	<b>33</b>
Machine Data Sheet .....	6	Troubleshooting .....	33
<b>SECTION 1: SAFETY</b> .....	<b>8</b>	Tensioning/Replacing V-Belts.....	35
Safety Instructions for Machinery .....	8	Tensioning Height Chain .....	36
Additional Safety for Planers .....	10	Feed Rollers & Chip Breaker Heights.....	37
<b>SECTION 2: POWER SUPPLY</b> .....	<b>11</b>	Adjusting Roller Spring Tension .....	40
<b>SECTION 3: SETUP</b> .....	<b>13</b>	Positioning Chip Deflector .....	41
Needed for Setup.....	13	Anti-Kickback Fingers .....	41
Unpacking .....	13	<b>SECTION 8: WIRING</b> .....	<b>42</b>
Inventory .....	14	Wiring Safety Instructions .....	42
Site Considerations.....	16	Wiring Diagram .....	43
Lifting & Placing .....	17	<b>SECTION 9: PARTS</b> .....	<b>44</b>
Bench Mounting .....	18	Main .....	44
Stand Mounting.....	18	Table & Columns .....	47
Assembly .....	19	Labels & Cosmetics .....	48
Dust Collection.....	20	<b>WARRANTY &amp; RETURNS</b> .....	<b>49</b>
Checking Gearbox Oil Level.....	20		
Test Run .....	21		
<b>SECTION 4: OPERATIONS</b> .....	<b>22</b>		
Operation Overview .....	22		
Workpiece Inspection.....	23		
Wood Types.....	23		
Planing Tips .....	24		
Cutting Problems .....	24		
Depth of Cut.....	25		
Setting Feed Rate.....	26		
Adjusting/Replacing Knives .....	26		

# 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](http://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:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety glasses/respirator are properly 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. Do not use while impaired by drowsiness, fatigue, or use of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
Manufactured for Grizzly in Taiwan			

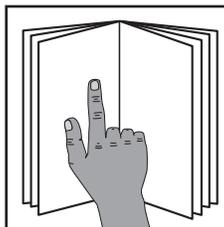
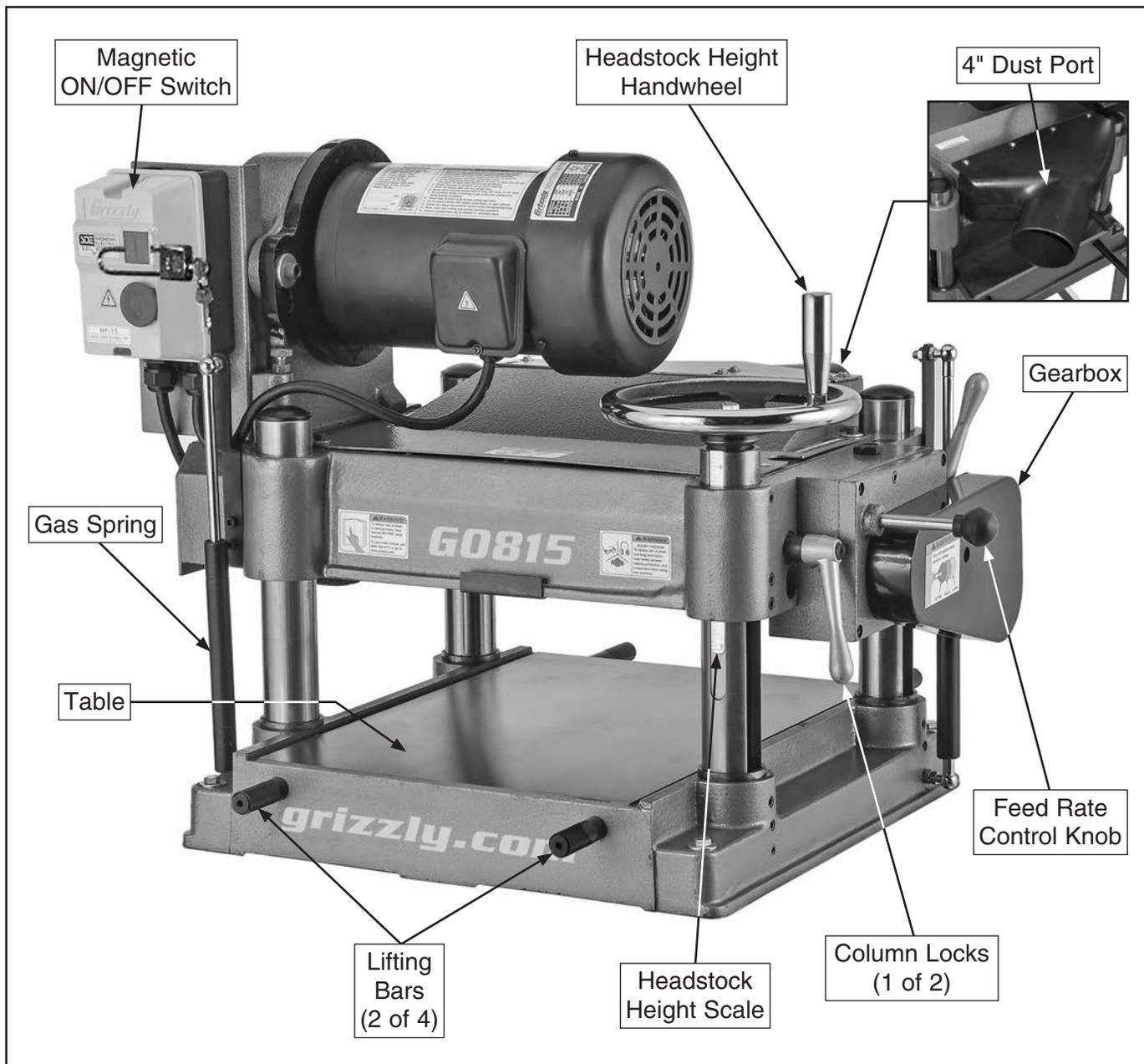
**Manufacture Date** [ ]

**Serial Number** [ ]



# Identification

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



## **⚠️ WARNING**

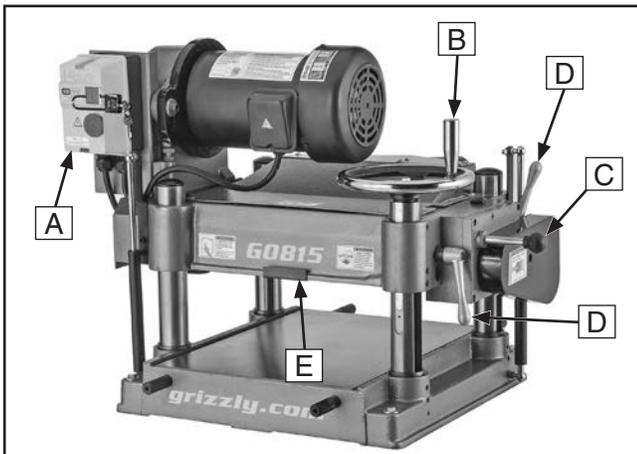
To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.



# Controls & Components



Refer to **Figures 1–3** 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.** Main controls and components.

**A. Magnetic ON/OFF Switch:** Green start button turns motor **ON** when pressed. Red Stop button turns motor **OFF** when pressed.

**Note:** Green start button can be locked with included padlock, as shown in **Figure 1**, to prevent unauthorized usage.

**B. Headstock Height Handwheel:** Raises and lowers headstock to accommodate different workpiece thicknesses. One complete revolution moves the table approximately  $\frac{5}{32}$ ".

**C. Feed Rate Control Knob:** Selects 30 FPM feed rate when pushed in, and 16 FPM feed rate when pulled out.

**D. Column Locks:** Secure headstock height position when tightened.

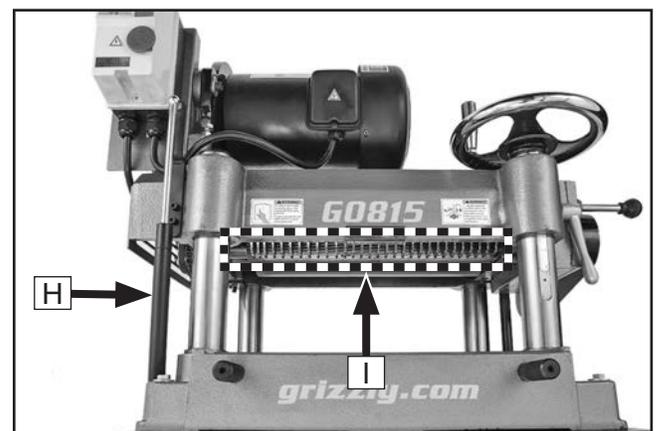
**E. Depth Limiter:** Limits depth of cut to a maximum of  $\frac{1}{8}$ " at full width.



**Figure 2.** Lifting bars and dust port.

**F. Lifting Bars (4):** Used for lifting machine with forklift. Pull out for lifting and placing. Leave pushed in for planing operations.

**G. Dust Port:** Connects to a dust collection system to extract shavings and dust during operation.



**Figure 3.** Anti-kickback fingers and gas springs.

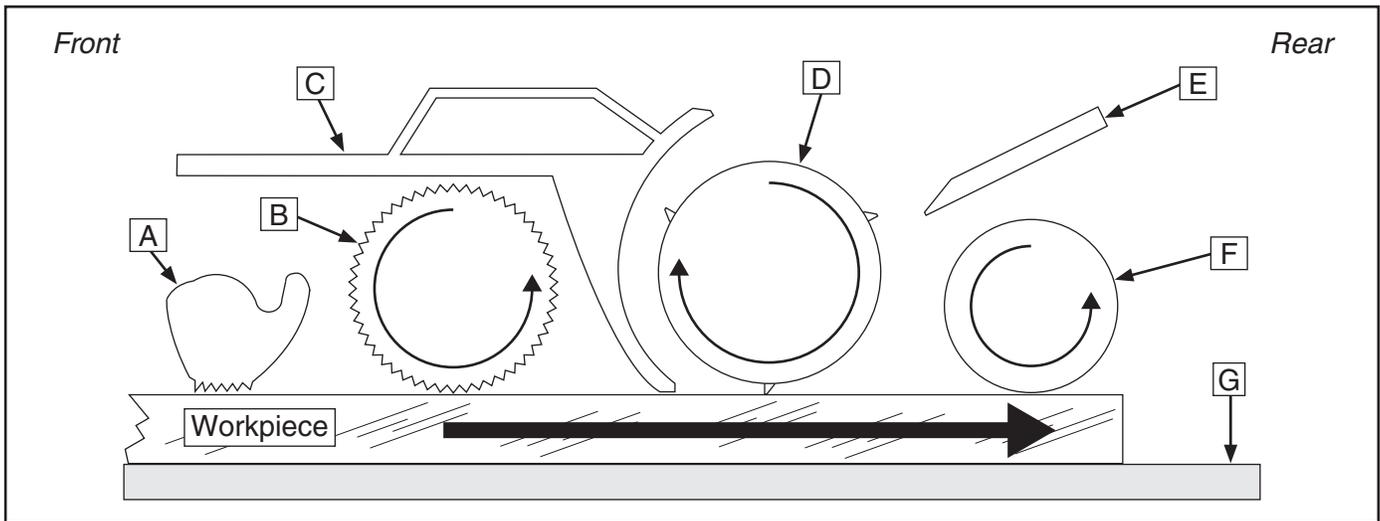
**H. Gas Springs (2):** Provide lifting assistance when raising headstock.

**I. Anti-Kickback Fingers:** "Grab" workpiece if a kickback occurs, reducing the risk of kickback related injuries.

**Note:** Headstock height **MUST** be properly adjusted for anti-kickback fingers to function.



# Internal Components



**Figure 4.** Workpiece path and major planing components (side cutaway view).

- A. Anti-Kickback Fingers:** "Grab" workpiece if a kickback occurs, reducing the risk of kickback related injuries.
- B. Serrated Infeed Roller:** Pulls the workpiece toward the cutterhead.
- C. Chip Breaker:** Breaks off freshly cut chips/shavings as they're lifted by the cutterhead to prevent tear-out and divert them toward the dust hood for improved overall extraction.
- D. Cutterhead:** Holds the knives that remove material from the workpiece.
- E. Chip Deflector:** Directs chips/shavings into the dust hood as they travel over the cutterhead, helping to prevent them from coming back down to the workpiece and interfering with the quality of the cut.
- F. Outfeed Roller:** Pulls the workpiece through the planer.
- G. Planer Table:** Provides a smooth and level path for the workpiece as it travels through the planer.

## **WARNING**

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





# MACHINE DATA SHEET

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

## MODEL G0815 15" 3 HP HEAVY-DUTY PLANER

### Product Dimensions:

Weight..... 350 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 32 x 28 x 23-1/2 in.  
 Footprint (Length x Width)..... 20 x 20-1/2 in.

### Shipping Dimensions:

Type..... Wood Crate  
 Content..... Machine  
 Weight..... 388 lbs.  
 Length x Width x Height..... 33 x 30 x 25 in.  
 Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 240V, Single-Phase, 60 Hz  
 Full-Load Current Rating..... 14A  
 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..... Magnetic Switch w/Overload Protection

### Motors:

#### Main

Horsepower..... 3 HP  
 Phase..... Single-Phase  
 Amps..... 14A  
 Speed..... 3450 RPM  
 Type..... TEFC Capacitor-Start Induction  
 Power Transfer ..... Triple V-Belt Drive  
 Bearings..... Shielded & Permanently Lubricated  
 Centrifugal Switch/Contacts Type..... External

### Main Specifications:

#### Main Specifications

Planer Size..... 15 in.  
 Max. Cut Width..... 15 in.  
 Min. Stock Length..... 6-3/8 in.  
 Min. Stock Thickness..... 1/4 in.  
 Max. Stock Thickness..... 8-1/4 in.  
 Number of Cuts Per Inch..... 151, 81  
 Number of Cuts Per Minute..... 15,000  
 Cutterhead Speed..... 5000 RPM  
 Planing Feed Rate..... 16, 30  
 Max. Cut Depth Planing Full Width..... 1/8 in.  
 Max. Cut Depth Planing 6-Inch Wide Board..... 3/16 in.



**Cutterhead Info**

Cutterhead Type..... Straight  
Cutterhead Diameter ..... 3 in.  
Number of Knives..... 3  
Knife Type..... HSS  
Knife Size Length..... 15 in.  
Knife Size Width..... 1 in.  
Knife Size Thickness..... 1/8 in.  
Knife Adjustment..... Jack Screws

**Table Info**

Table Bed Size Length..... 20-1/8 in.  
Table Bed Size Width..... 15 in.  
Table Bed Size Thickness..... 3-1/2 in.  
Floor-to-Table Height..... 3-1/2 in.

**Construction**

Table..... Precision-Ground Cast Iron  
Body..... Cast Iron  
Cutterhead Assembly..... Steel  
Infeed Roller..... Serrated Steel  
Outfeed Roller..... Rubber  
Paint Type/Finish..... Enamel

**Other**

Measurement Scale..... Inch  
Number of Dust Ports..... 1  
Dust Port Size..... 4 in.

**Other Specifications:**

Country of Origin ..... Taiwan  
Warranty ..... 1 Year  
Approximate Assembly & Setup Time ..... 30 Minutes  
Serial Number Location ..... ID Label  
Sound Rating ..... 92 dB  
Certified by a Nationally Recognized Testing Laboratory (NRTL) ..... Yes

**Features:**

- Straight Cutterhead with 3 Knives
- Triple V-Belt Drive
- Heavy-Duty, Precision-Ground Cast-Iron Table and Body
- Height Scale in Inches
- Pedestal-Mounted Power Switch
- Thick Enamel Finish
- Chip Breaker and Pressure Bar
- Gas Spring-Assisted Head Height Adjustment
- Heavy-Duty 3 HP Motor
- Two-Speed Automatic Board Feed
- Headstock Locks Prevent Movement while Planing
- 4" Dust Port
- Drive Gears Run in Oil Bath

**Accessories Included:**

Knife-Setting Jig

**Accessories Recommended:**

T27650 Planer Stand for G0815



# 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.

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

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

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

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

## Safety Instructions for Machinery

### ⚠ WARNING

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

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

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

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

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

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

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



# WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Planers

## WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

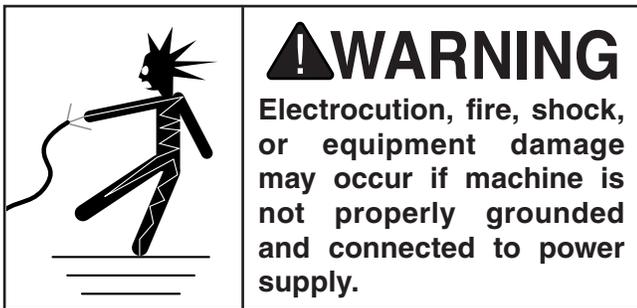
**SECURE KNIVES/INSERTS.** Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation.



# SECTION 2: POWER SUPPLY

## Availability

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



## Full-Load Current Rating

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

### Full-Load Current Rating at 240V ..... 14 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!

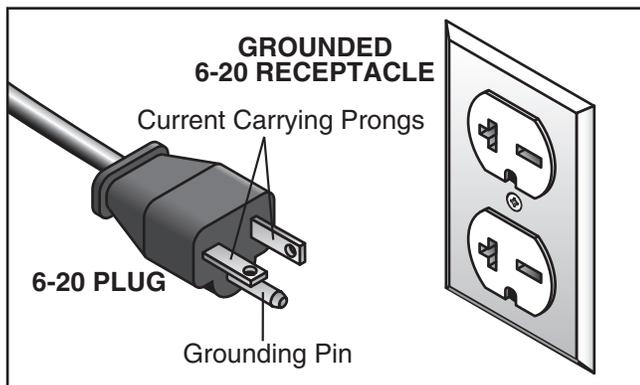
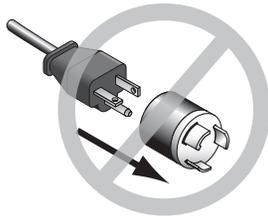


Figure 5. Typical 6-20 plug and receptacle.

## CAUTION



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

## WARNING

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

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

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

## Extension Cords

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

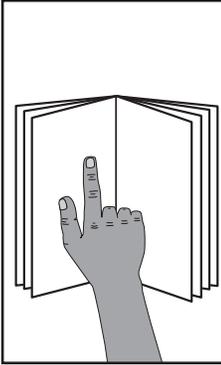
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

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



# SECTION 3: SETUP



## **!WARNING**

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



## **!WARNING**

Wear safety glasses during the entire setup process!



## **!WARNING**

### **HEAVY LIFT!**

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

## Needed for Setup

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

Description	Qty
• Additional People .....	1
• Safety Glasses .....	1 Per Person
• Forklift or Lifting Equipment (Rated for at least 500 lbs.) .....	1
• Cleaner/Degreaser .....	As Needed
• Shop Rags.....	As Needed
• Screwdriver Phillips #2 .....	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.***



# 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.

Inventory (Figure 6)	Qty
A. Dust Hood .....	1
B. Lifting Bars .....	4
—Phillips Head Screws 10-24 x 3/8" .....	4
C. Knife-Setting Jig .....	1
—E-Clips 9mm .....	2
—Jig Feet .....	2
—Jig Rod .....	1
D. Feed Rate Control Knob 3/8"-16 .....	1
E. Open-End Wrenches 8/10, 12/14mm ...	1 Ea.
F. T-Handle Hex Wrench 5mm .....	1
G. Hex Wrenches 2.5, 3, 4, 6mm .....	1 Ea.

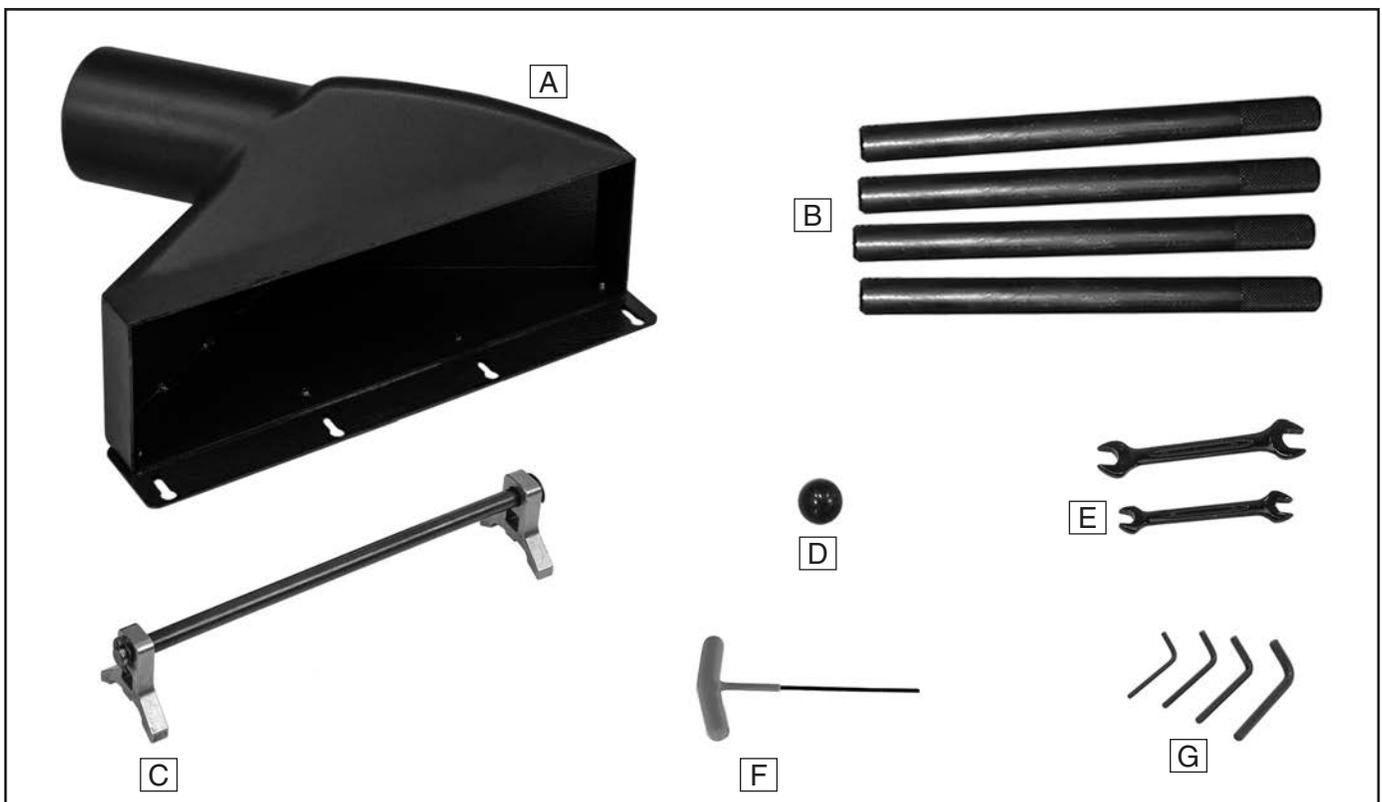


Figure 6. Model G0815 loose inventory.



# 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.

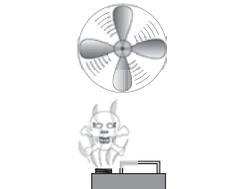
## Before cleaning, gather the following:

- 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.

	<b>⚠️ WARNING</b> Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.
--	---

	<b>⚠️ CAUTION</b> Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.
--	--

<b>NOTICE</b> Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.
---

## T23692—Orange Power Degreaser

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

<p>Call <b>1-800-523-4777</b> To Order</p>	
--	---



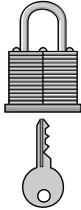
# Site Considerations

## 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.**

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

## Physical Environment

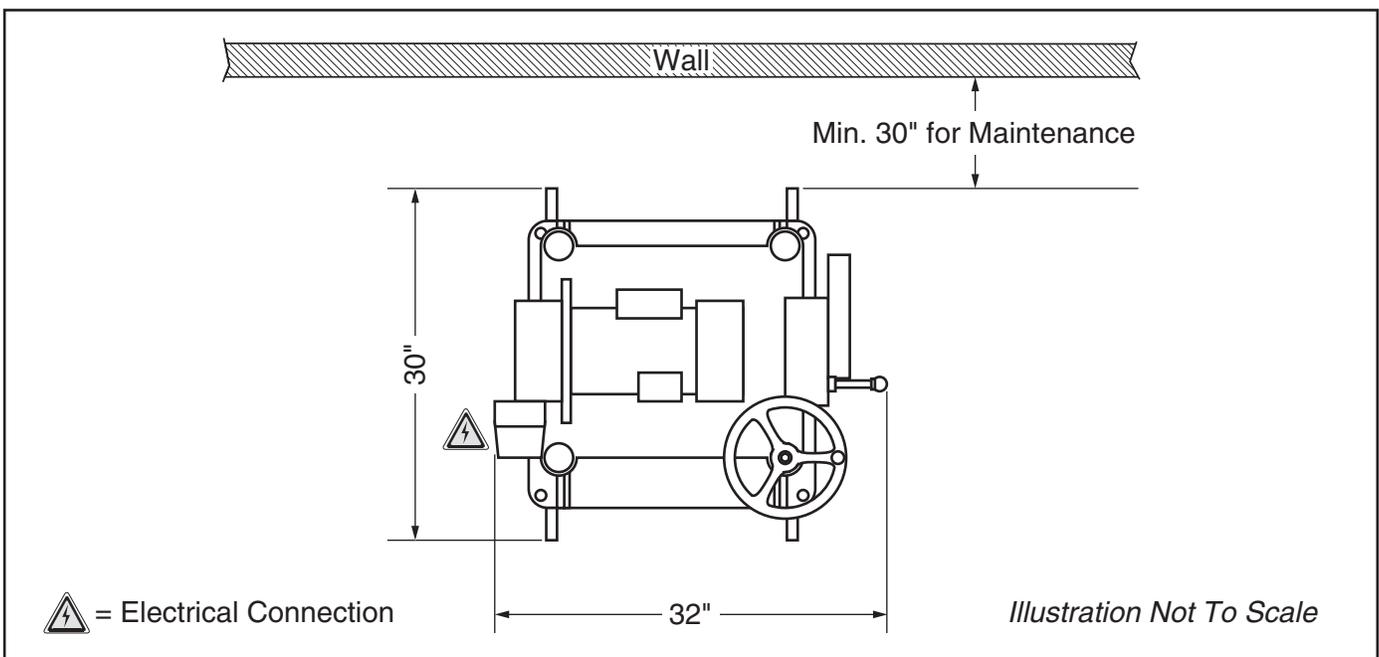
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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

## Electrical Installation

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

## Lighting

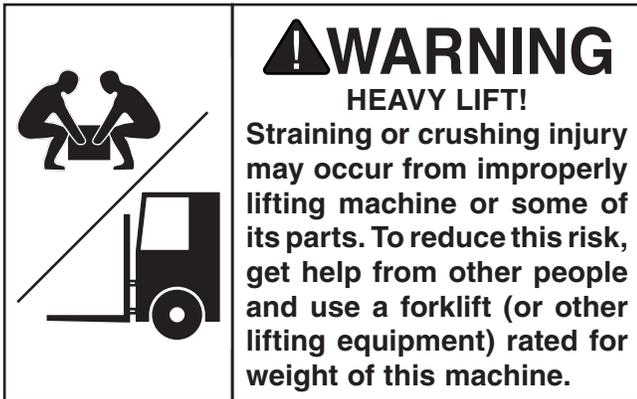
Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.



**Figure 7.** Minimum working clearances.



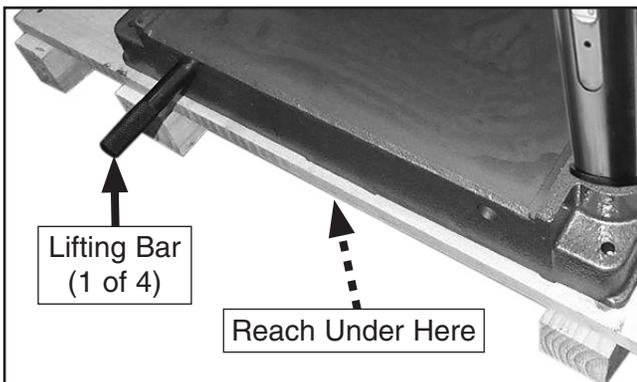
# Lifting & Placing



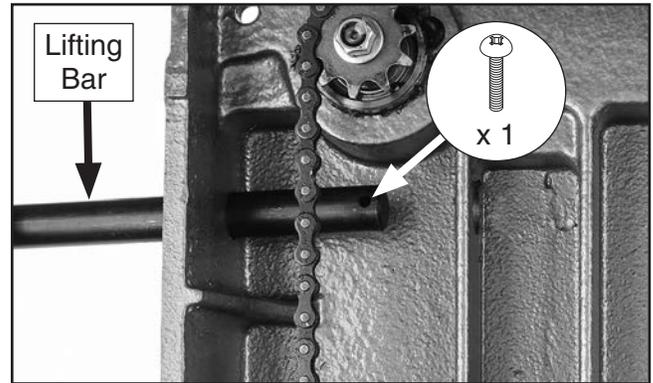
The planer comes with four lifting bars that must be installed in order to lift and place the planer.

## To install lifting bars:

1. Remove pre-installed Phillips head screw from lifting bar, then insert lifting bar through hole in planer base (see **Figure 8**).
2. Reach underneath shipping pallet and thread Phillips head screw into threaded hole in lifting bar (see **Figures 8–9**).



**Figure 8.** Machine on shipping pallet, and lifting bar inserted into hole in base (1 of 4 shown).



**Figure 9.** Lifting bar inserted through planer base (viewed from under machine).

3. Repeat **Steps 1–2** with remaining three lifting bars.

## To lift and place machine:

1. Move shipping crate next to intended location of planer, then remove top portion of crate from shipping pallet.
2. Unbolt planer from pallet, then set aside all loose inventory.
3. Extend lifting bars, then use forklift to lift planer off pallet (see **Figure 10**).

**Tip:** When positioning lift forks, place shop rags or cardboard between forks and planer body stand to avoid scratching paint.



**Figure 10.** Lifting planer with forklift.

4. Set planer down on intended location.

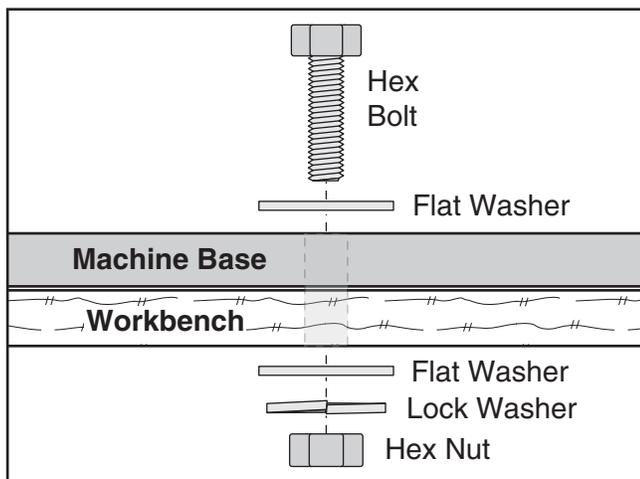


# Bench Mounting

**Number of Mounting Holes ..... 4**  
**Diameter of Mounting Hardware Needed .. 3/8"**

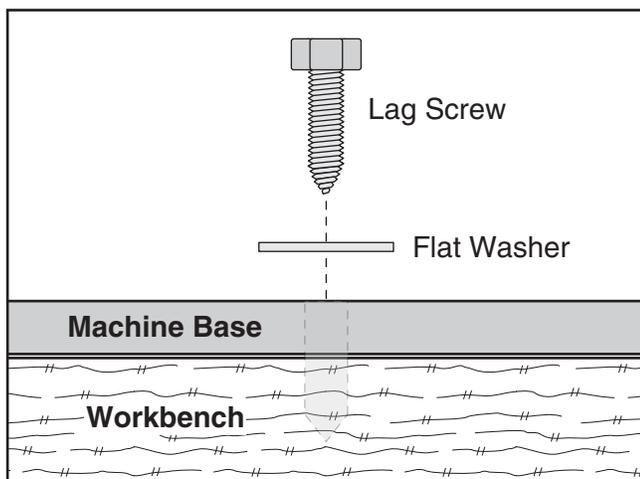
The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

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



**Figure 11.** "Through Mount" setup.

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



**Figure 12.** "Direct Mount" setup.

# Stand Mounting

This machine can be mounted to an optional stand: Model T27650 (see **Page 28** for details).

To mount the planer to the stand, use a forklift to set the planer on the stand (see **Figure 13**), then secure it with 3/8" diameter mounting hardware.



**Figure 13.** Planer mounted to optional stand.

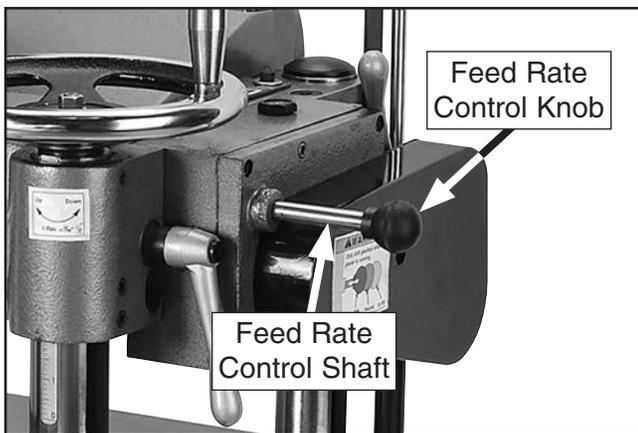


# Assembly

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

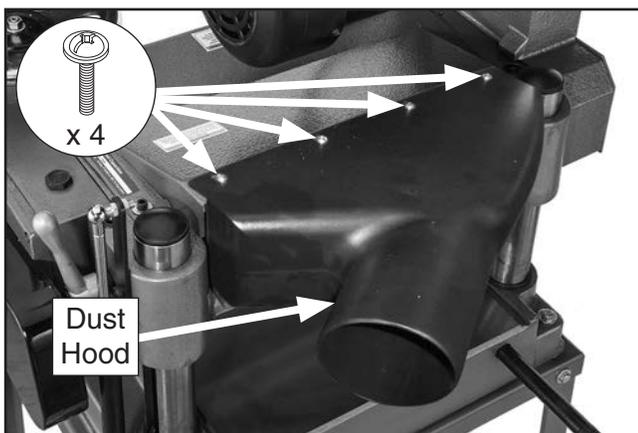
## To assemble machine:

1. Thread feed rate control knob onto feed rate shaft (see **Figure 14**).



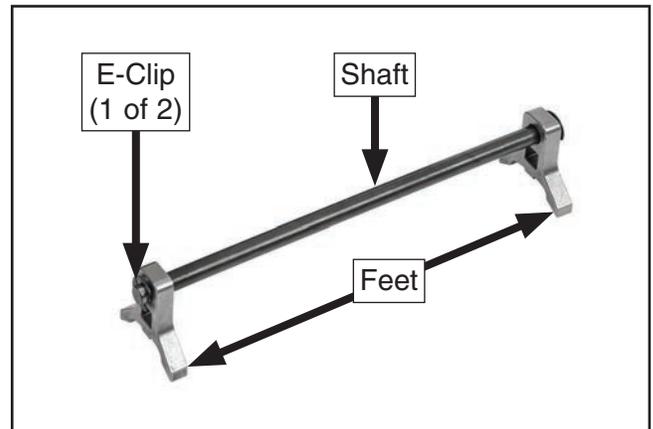
**Figure 14.** Feed rate control knob installed.

2. Install dust hood using four pre-installed flange screws (see **Figure 15**).



**Figure 15.** Dust hood installed.

3. Assemble knife-setting jig (see **Figure 16**) using jig rod, feet, and (2) 9mm E-clips.



**Figure 16.** Example of assembled knife-setting jig components.



# Dust Collection

## ⚠ CAUTION

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

### Minimum 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 system to machine:

1. Fit the 4" dust hose over the dust port, as shown in **Figure 17**, and secure in place with a hose clamp.



**Figure 17.** Dust hose attached to dust port.

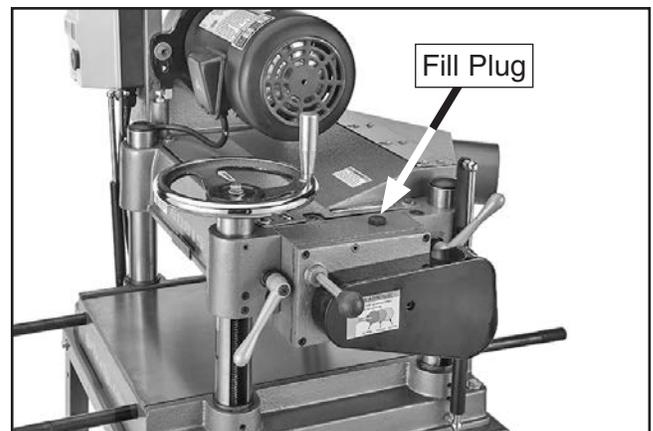
2. Tug the hose to make sure it does not come off. **Note:** A tight fit is necessary for proper performance.

# Checking Gearbox Oil Level

Before starting your machine for the first time, check the gearbox oil level. The proper oil level is just even with the bottom of the fill plug hole. The gearbox uses ISO 320, SAE 140 gear oil, or SAE 85W-140 multi-weight gear oil. DO NOT mix oil types.

### To check gearbox oil level:

1. Remove gearbox fill plug (see **Figure 18**).



**Figure 18.** Location of gearbox fill plug.

2. Dip short end of a clean 6mm hex wrench inside fill hole, and then remove it.
  - If the end of the hex wrench *is* coated with oil, then the gearbox oil level is okay. Replace the fill plug and continue setup.
  - If the end of the hex wrench *is not* coated with oil, then you need to add more oil. Refer to **Gearbox Oil** on **Page 32** for instructions on how to do this.

**Note:** We recommend that you replace the gearbox oil after the first 20 hours of operation. This is a normal break-in procedure and will help maximize the service life of the machine by flushing away any particles from the break-in and manufacturing process.



# Test Run

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

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

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the STOP button safety feature functions properly.

## **!WARNING**

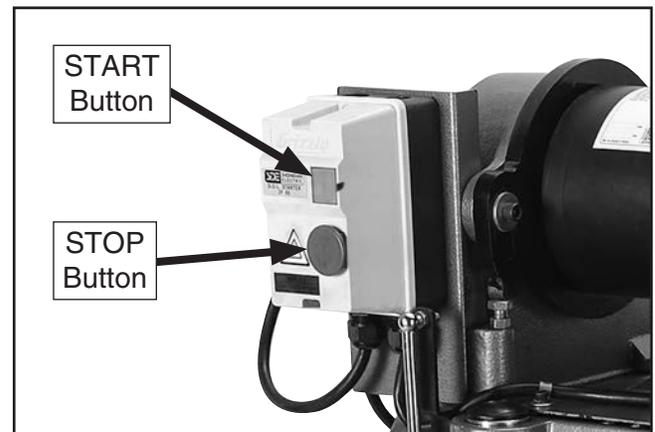
Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

## **!WARNING**

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

### To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power by inserting power cord plug into a matching receptacle.
3. Press START button (see **Figure 19**) to turn machine **ON**. Verify motor starts up and runs smoothly without any unusual problems or noises.
4. Press STOP button (see **Figure 19**) to turn machine **OFF**.



**Figure 19.** Location of START and STOP buttons.

Congratulations! The Test Run is complete.

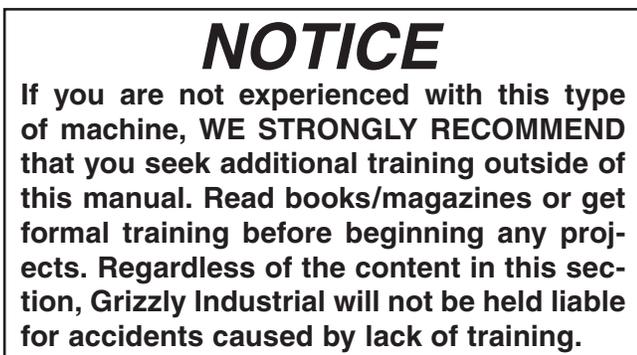
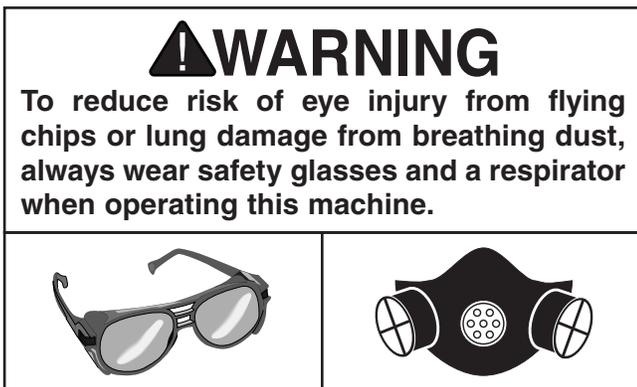


# SECTION 4: OPERATIONS

## Operation Overview

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

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



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

1. Examines workpiece to make sure it is suitable for planing.
2. Puts on safety glasses or face shield, a respirator, and ear protection.
3. Places workpiece on table with flat side down and correctly adjusts headstock height for workpiece thickness and depth of cut.
  - If workpiece is bowed, operator surface planes workpiece on a jointer until one side is flat. Doing so ensures that it sits solidly on planer table during operation.
4. When all safety precautions have been taken, turns planer **ON**.
5. Stands to one side of planer path to reduce risk of kickback injuries, then feeds workpiece into planer until infeed roller grabs it.

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

  - If cut is too deep and bogs down planer, operator immediately reduces depth of cut.
6. Once workpiece is clear of outfeed roller and stops moving, operator removes workpiece from outfeed table and measures workpiece thickness. If further planing is required, operator lowers headstock slightly (approximately 1/4- to 1/2-turn of the handwheel), then feeds workpiece into front of planer again.
7. Operator continues process until desired thickness is achieved, then turns machine **OFF**.



# Workpiece Inspection

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

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

# Wood Types

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

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

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

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

**Figure 20.** Janka Hardness Rating for some common wood species.



# Planing Tips

---

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

# Cutting Problems

---

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

## Chipped Grain

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

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

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

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



## Pitch & Glue Build-up

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

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

## Chip Marks or Indentations

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

- Wood chips/sawdust not being properly expelled from the cutterhead.
- The type of lumber being planed. Certain species have a tendency to chip bruise.
- A high moisture content (over 20%) or surface moisture (refer to **Page 23**).
- Dull knives.
- Excessive depth of cut.

### Solution:

- Use a proper dust collection system; adjust chip deflector in or out as necessary.
- 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.

## Rippled Cut

**Problem:** Regularly spaced indentations across face of workpiece are caused by excessive outfeed roller pressure or excessive feed rate.

**Solution:** Reduce outfeed roller pressure; reduce feed rate.



# Depth of Cut

## Table Movement per Handwheel Revolution

One Full Revolution .....  $\frac{5}{32}$ "

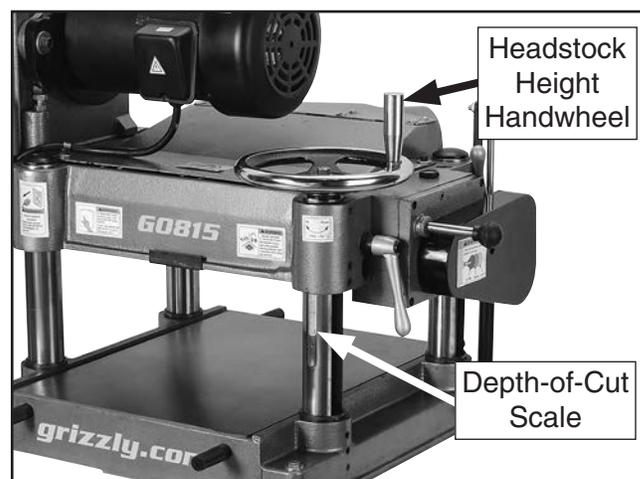
The depth of cut on a planer means the amount of material that is removed from the top of the workpiece as it passes underneath the cutterhead.

The depth of cut is set by adjusting the distance of the cutterhead above the table. This distance is the thickness of the workpiece minus the depth of cut. The planing depth of cut is controlled by using the headstock height handwheel on the right side of the machine. Rotating the handwheel clockwise raises the headstock.

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend the maximum depth of cut (per pass) be no more than  $\frac{1}{16}$ ". A series of light cuts will give better end results and put less stress on the planer than trying to take off too much material in a single pass.

The depth of cut can be referenced directly from the inch scale on the front of the planer, as shown in **Figure 21**. The range of material thickness that can be planed is  $\frac{1}{4}$ "– $8\frac{1}{4}$ ".

**Note:** *The scale functions as a general guide only, and is not intended for precision results.*



**Figure 21.** Depth-of-cut indicator and scale.

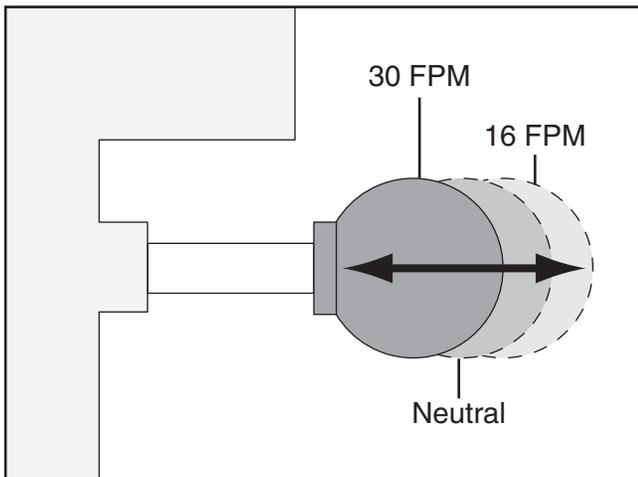
# Setting Feed Rate

The infeed and outfeed rollers move the workpiece through the planer while keeping it flat and providing a consistent rate of movement. The speed that these rollers move the workpiece through the planer is the feed rate.

Generally, low feed rates are used for dimensioning passes, while higher feed rates are used for finishing passes.

**Figure 22** illustrates the three different positions of the feed rate control knob:

- Push knob in to use high feed rate of 30 FPM.
- Pull the knob out to use the low feed rate of 16 FPM.
- Move knob to center position to place gearbox in neutral.

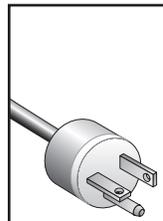


**Figure 22.** Feed rate control knob positions.

## NOTICE

**Only change the feed rate when the planer is running, but DO NOT attempt to change the feed rate during any cutting operations or damage to the gearbox will result.**

# Adjusting/Replacing Knives



## WARNING

**To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.**

## CAUTION

**Cutterhead knives are extremely sharp. Accidental contact with knives can result in severe cuts. Take great caution whenever working with or around cutterhead knives. Wear heavy leather gloves to reduce risk of severe cuts.**

## NOTICE

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

Setting the height of the knives correctly is crucial to the proper operation of your planer and is very important in keeping the knives sharp. If one knife protrudes higher than the others, it will do the majority of the work, dull much faster, and produce poor cutting results.

The knife-setting jig that is included with the Model G0815 is designed to set the knives 0.049" higher than the cutterhead surface.

**Note:** *If you need to replace or sharpen a knife, you can remove the knife from the cutterhead during **Step 4** of the following procedure. Thoroughly clean out any debris from the knife slots before replacing the knives.*

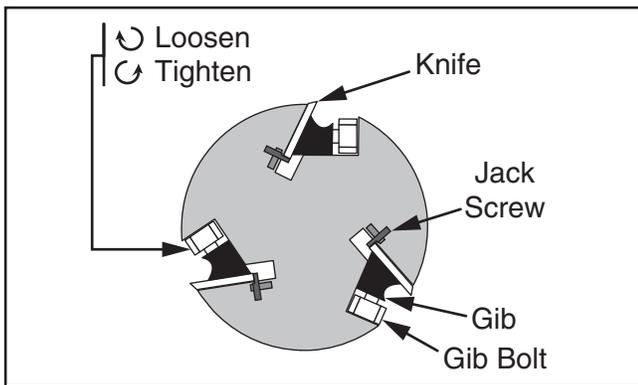
*Replacement knives are available through Grizzly (refer to **Page 28** for options).*



Tools Needed	Qty
Screwdriver Phillips #2 .....	1
Open-End Wrench 10mm.....	1
Hex Wrench 2.5mm, 5mm.....	1 Ea.
Knife-Setting Jig .....	1

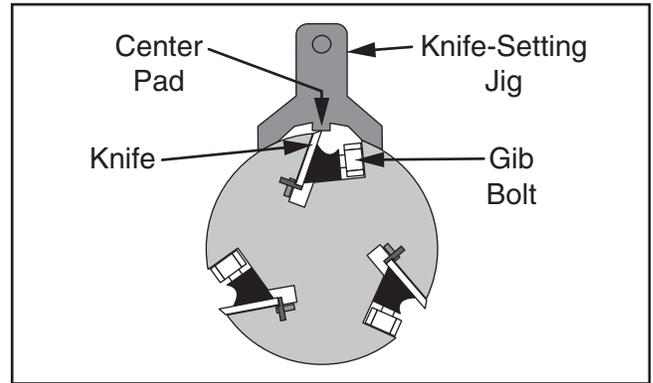
**To adjust height of knives:**

1. DISCONNECT MACHINE FROM POWER!
2. Remove headstock cover and dust hood assembly to expose cutterhead.
3. Put on heavy leather gloves.
4. Remove upper belt cover, then rotate cutterhead pulley to provide access to one of the knives.



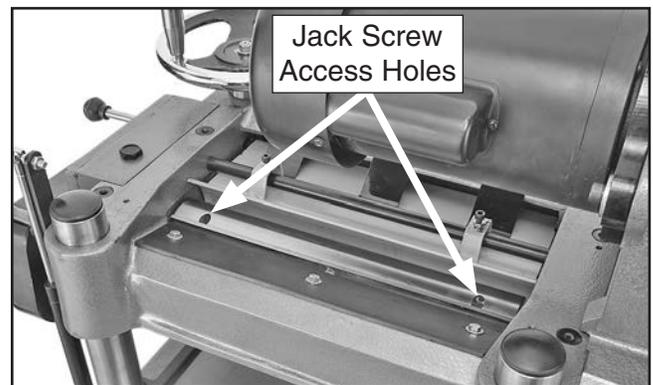
**Figure 23.** Cutterhead components.

5. Loosen cutterhead gib bolts until knife is completely loose.
  - If you are replacing the knives, remove the old knife and install the new one, making sure the beveled edge of the new knife is facing the correct direction.
6. Position knife-setting jig over knife so that knife edge is directly under center pad, as shown in **Figure 24**.



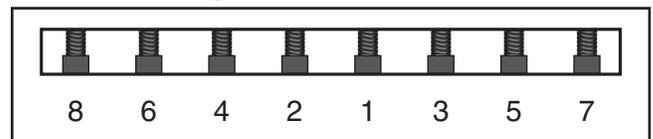
**Figure 24.** Knife-setting jig correctly positioned.

7. Insert hex wrench into jack screws through access holes in cutterhead (see **Figure 25**). Rotate jack screws to raise or lower knife until it barely touches center pad of knife-setting jig with all legs of jig still firmly on cutterhead, then snug gib bolts enough to firmly hold knife in place without fully tightening gib bolts.



**Figure 25.** Location of jack screw access holes.

8. Incrementally snug gib bolts in an even manner, starting at middle and working your way to ends by alternating left and right, as illustrated in **Figure 26**.



**Figure 26.** Gib bolt tightening sequence.

9. Repeat **Step 8**, snugging gib bolts a little more.
10. Repeat **Step 8**, this time fully tightening all gib bolts.
11. Repeat **Steps 4–8** for remaining knives.



# 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.

### **T27650—Planer Stand for G0815**

An open-frame stand designed especially for the G0815 15" Benchtop Planer. An excellent choice if you have the floor space but not the benchtop space for this machine.



Figure 27. T27650 Planer Stand.

### **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

T20456—DAKURA Safety Glasses, Black/Clear



Figure 28. Assortment of basic eye protection.

**G6701—15 x 1 x 1/8" HSS Planer Knives**

**T10152—15 x 1 x 1/8" High-Moly Planer Knives**

These high-quality planer knives come in a set of 3.

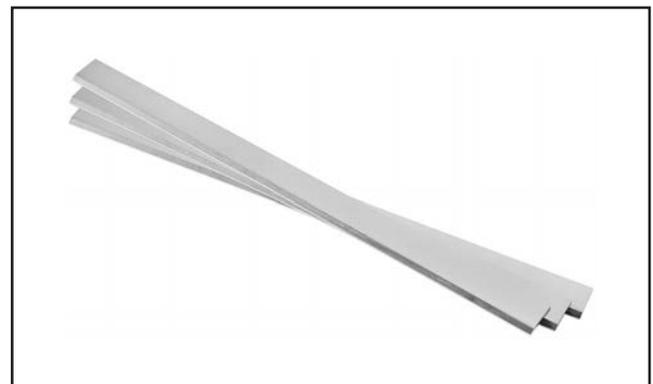
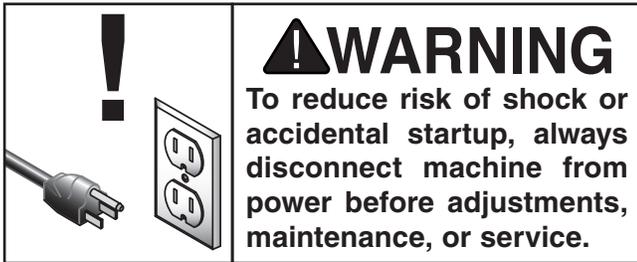


Figure 29. Grizzly planer knives.

**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.

**Note:** *This maintenance schedule is based on average daily usage. Adjust the maintenance schedule to match your usage, to keep your planer running smoothly, and to protect your investment.*

### Every 8 Hours of Operation:

- Clean machine and protect unpainted cast-iron.
- Lubricate feed roller bushings (**Page 30**).
- Tighten loose mounting bolts.
- Check/sharpen/replace damaged or worn knives (**Page 26**).
- Check/repair/replace worn or damaged wires.
- Resolve any other unsafe condition.

### Every 40 Hours of Operation:

- Clean cutterhead and check knife height (**Page 26**).
- Lubricate columns and leadscrews (**Page 31**).

### Every 160 Hours of Operation:

- Check/tension/replace V-belts (**Page 35**).
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Lubricate height chain and sprockets (**Page 31**).
- Lubricate drive chain and sprockets (**Page 32**).

### Yearly:

- Change gearbox oil (**Page 32**).

## Cleaning & Protecting

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

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table 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 30.** Recommended products for protecting unpainted cast iron/steel parts on machinery.



# Lubrication

**SB1365—South Bend Way Oil-ISO 68**  
**T26419—Syn-O-Gen Synthetic Grease**



**Figure 31.** Recommended products for machine lubrication.

***NOTICE***

Failure to follow reasonable lubrication practices as instructed in this manual for your machine could lead to premature failure of components and void the warranty.

Your planer features bearings that are lubricated and sealed at the factory. These bearing do not require any further attention unless they need to be replaced. If a bearing fails, your planer will probably develop a noticeable rumble or vibration, which will increase when the machine is under a load. The bearings are standard sizes and can be replaced through Grizzly.

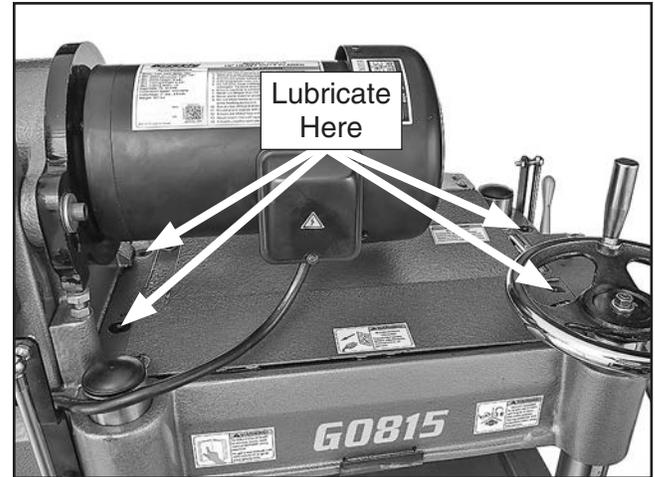
Follow the maintenance schedule on **Page 29** and the following procedures to properly lubricate the other planer components, which are essential for long life and trouble-free operation of your planer.

<b>Tools Needed</b>	<b>Qty</b>
Wrench or Socket $\frac{7}{8}$ " .....	1
Wrench or Socket $\frac{1}{4}$ " .....	1

## Feed Roller Bushings

Oil Type..... SB1365 or ISO 68 Equivalent  
 Oil Amount.....2–3 Drops  
 Frequency..... Every 8 Hours of Operation

The infeed and outfeed rollers rotate inside bushing blocks on both ends of the rollers. Add 2–3 drops of ISO 68 machine oil to the center hole of the four feed roller tension adjustment bolts on top of the head casting (see **Figure 32**).



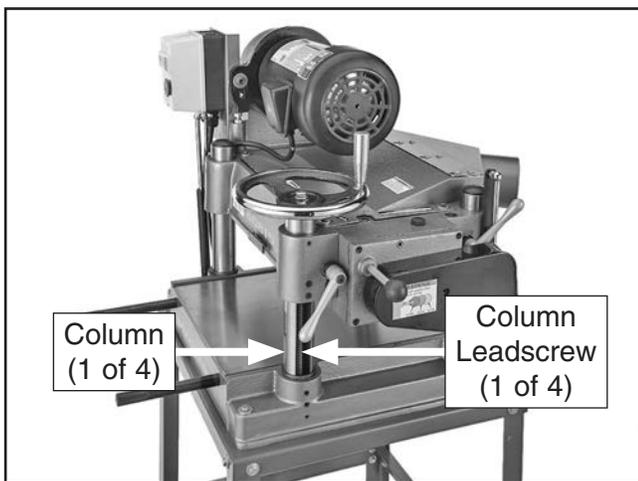
**Figure 32.** Lubrication of feed roller bushings.



## Columns & Leadscrews

Oil Type ..... SB1365 or ISO 68 Equivalent  
Oil Amount ..... Thin Coat  
Grease Type ..... NLGI#2 Equivalent  
Frequency ..... Every 40 Hours of Operation

The headstock rides on the columns and is moved by the rotation of the leadscrews inside the columns (see **Figure 33**). Apply a thin coat of ISO 68 machine oil to the outside surface of the columns and brush on a light application of multi-purpose grease to the leadscrew threads. Move the headstock up and down to distribute the lubricant.

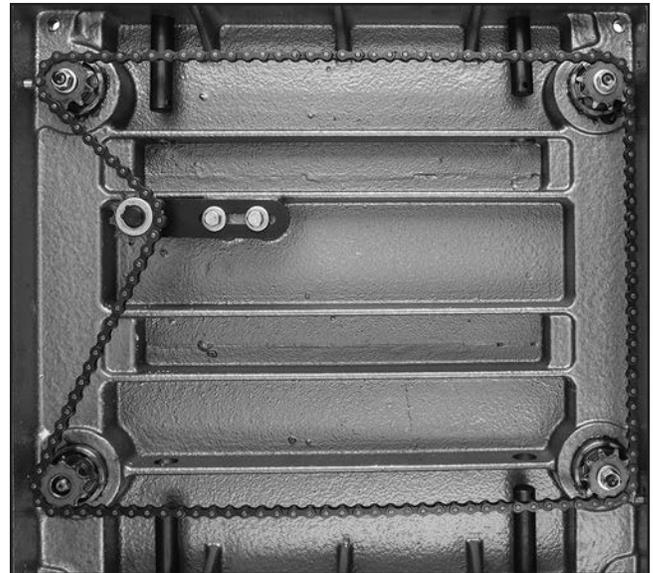


**Figure 33.** Location of column dust sleeve.

## Height Chain & Sprockets

Grease Type ..... NLGI#2 Equivalent  
Frequency ..... Every 160 Hours of Operation

The column leadscrews are synchronized by the height chain and sprockets located underneath the planer base (see **Figure 34**). Use shop rags and mineral spirits to clean away debris and grime, then brush on a light coat of multi-purpose grease to the chain and sprockets.



**Figure 34.** Example of height chain and sprockets as viewed from underneath the base.



## Drive Chain & Sprockets

Grease Type..... NLGI#2 Equivalent  
Frequency..... Every 160 Hours of Operation

The infeed and outfeed rollers receive the transferred power from the cutterhead through the drive chain system on the right side of the machine (see **Figure 35**).

Remove the drive chain cover to access these parts.

Use shop rags and mineral spirits to clean away any debris and grime, then brush on a light coat of multi-purpose grease to the chain and sprockets.



**Figure 35.** Location of drive chain and sprockets.

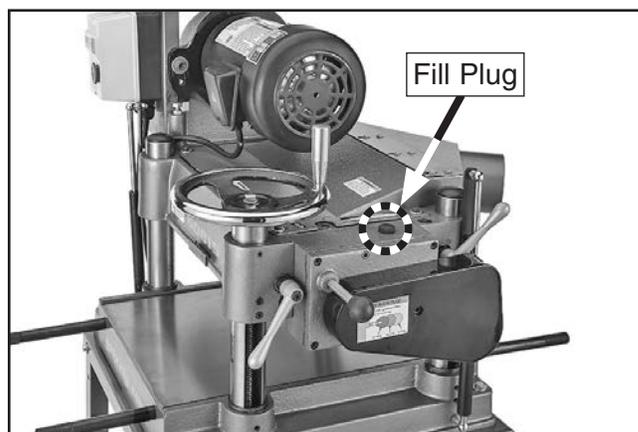
## Gearbox Oil

Oil Type..... ISO 320 Gear Oil  
Oil Amount..... 4 Oz.  
Frequency..... After First 20 Hours, Then Yearly

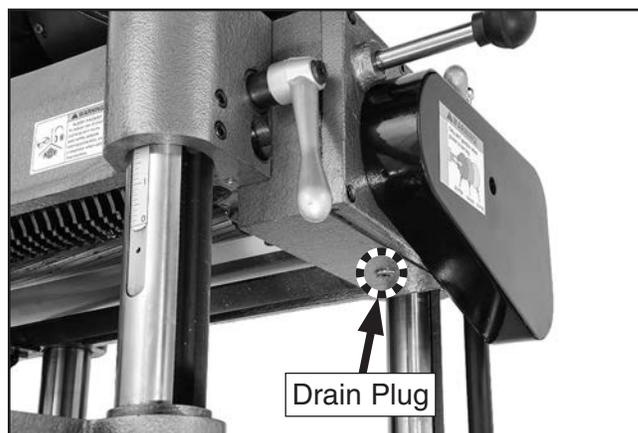
**Note:** SAE 85W-140 multi-weight gear oil may also be used. DO NOT mix oil types!

**Note:** We recommend that you replace the gearbox oil after the first 20 hours of operation. This is a normal break-in procedure and will help maximize the service life of the machine by flushing away any particles from the break-in and manufacturing process.

Raise the headstock and place a suitable container under the drain plug. Remove the fill plug first (see **Figure 36**), then remove the drain plug (see **Figure 37**) to drain the oil. After the oil completely drains, replace the drain plug and refill the gearbox with 4 oz. of ISO 320 or equivalent oil. Replace the fill plug.



**Figure 36.** Gearbox fill plug.



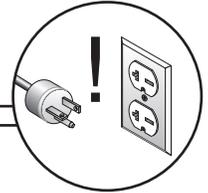
**Figure 37.** Gearbox drain plug.



# SECTION 7: SERVICE

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

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>1. Incorrect power supply voltage or circuit size.</li> <li>2. Power supply circuit breaker tripped or fuse blown.</li> <li>3. Thermal overload relay has tripped.</li> <li>4. Motor wires connected incorrectly.</li> <li>5. Wiring open/has high resistance.</li> <li>6. ON/OFF switch at fault.</li> <li>7. Centrifugal switch at fault.</li> <li>8. Start capacitor at fault.</li> <li>9. Contactor not energized; at fault.</li> <li>10. Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Ensure correct power supply voltage and circuit size.</li> <li>2. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.</li> <li>3. Reset; contact Tech Support if relay frequently trips.</li> <li>4. Correct motor wiring connections.</li> <li>5. Check/fix broken, disconnected, or corroded wires.</li> <li>6. Test/replace.</li> <li>7. Adjust/replace centrifugal switch if available.</li> <li>8. Test/replace.</li> <li>9. Test all legs for power/replace.</li> <li>10. Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Taking too deep of cut; feed rate too high.</li> <li>2. Workpiece material not suitable.</li> <li>3. Motor overheated.</li> <li>4. Belts slipping; improper belt tension or oil/grease on belts.</li> <li>5. Dull knives.</li> <li>6. Dust collection problem causing internal components to clog up with shavings.</li> <li>7. Motor wired incorrectly.</li> <li>8. Pulley/sprocket slipping on shaft.</li> <li>9. Motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce depth of cut/feed rate.</li> <li>2. Only cut wood/ensure moisture is below 20%.</li> <li>3. Allow motor to cool, reset overload if necessary, and reduce depth of cut/feed rate.</li> <li>4. Clean/tension/replace belts (<b>Page 35</b>).</li> <li>5. Sharpen/replace knives (<b>Page 26</b>).</li> <li>6. Clear blockages in dust chute/ducting. Ensure dust collector is operating efficiently.</li> <li>7. Wire motor correctly.</li> <li>8. Tighten loose pulley; replace pulley/shaft if damaged.</li> <li>9. Test/repair/replace.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor or component loose; planer not resting evenly on stand/workbench.</li> <li>2. V-belt(s) worn, loose, or slapping cover.</li> <li>3. Pulley loose.</li> <li>4. Plastic chip deflector hitting knives.</li> <li>5. Motor fan rubbing on fan cover.</li> <li>6. Knives/gibs at fault.</li> <li>7. Motor bearings at fault.</li> <li>8. Cutterhead bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect/tighten loose bolts/nuts; replace damaged components; shim under planer.</li> <li>2. Tension belts/replace with a matched set (<b>Page 35</b>).</li> <li>3. Re-align/replace shaft, pulley set screw, and key.</li> <li>4. Adjust chip deflector; replace if damaged (<b>Page 41</b>).</li> <li>5. Fix/replace fan cover; replace loose/damaged fan.</li> <li>6. Resharpen/replace knives; set knife alignment/height correctly (<b>Page 26</b>).</li> <li>7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>8. Replace bearing(s).</li> </ol>



## Machine Operation

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in end of board that is uneven with rest of cut).  Note: A small amount of snipe is inevitable with all planers. The key is minimizing it as much as possible.	<ol style="list-style-type: none"> <li>1. Chipbreaker set too low.</li> <li>2. Workpiece is not supported as it leaves planer.</li> <li>3. Some snipe is inevitable.</li> </ol>	<ol style="list-style-type: none"> <li>1. Raise height of chipbreaker (<b>Page 37</b>).</li> <li>2. Hold workpiece up slightly as it leaves outfeed end of planer.</li> <li>3. Plane lumber longer than your intended workpiece length, then cut off excess after planing complete.</li> </ol>
Workpiece stops/ slows in middle of cut.	<ol style="list-style-type: none"> <li>1. Taking too deep of a cut.</li> <li>2. Chipbreaker set too low.</li> <li>3. Feed rollers set too low or too high.</li> <li>4. Pitch and glue build up on planer components.</li> </ol>	<ol style="list-style-type: none"> <li>1. Take a smaller depth of cut. (Reduce cutting depth when planing hard woods.)</li> <li>2. Raise height of chipbreaker (<b>Page 37</b>).</li> <li>3. Lower/raise feed rollers (<b>Page 37</b>).</li> <li>4. Clean internal planer components with a pitch/resin dissolving solvent.</li> </ol>
Chipping (consistent pattern).	<ol style="list-style-type: none"> <li>1. Knots or conflicting grain direction in wood.</li> <li>2. Taking too deep of a cut.</li> <li>3. Feed rate set too fast.</li> <li>4. Mis-adjusted chipbreaker.</li> <li>5. Nicked or chipped knife.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect workpiece for knots and grain direction; only use clean stock, and cut WITH the grain.</li> <li>2. Reduce depth of cut. (Always reduce cutting depth when planing hard woods.)</li> <li>3. Slow down feed rate (<b>Page 26</b>).</li> <li>4. Adjust both sides of chipbreaker to correct height (<b>Page 37</b>).</li> <li>5. Replace affected knife (<b>Page 26</b>), or have it sharpened.</li> </ol>
Chipping/indentation in workpiece surface (inconsistent pattern).	<ol style="list-style-type: none"> <li>1. Chips aren't being properly expelled from cutterhead.</li> <li>2. Chip breaker not set correctly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use a proper dust collection system (<b>Page 20</b>).</li> <li>2. Correctly adjust chip breaker (<b>Page 37</b>).</li> </ol>
Fuzzy grain.	<ol style="list-style-type: none"> <li>1. Wood may have high moisture content or surface wetness.</li> <li>2. Dull knives.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check moisture content is below 20% and allow to dry if moisture is too high.</li> <li>2. Replace knives (<b>Page 26</b>) or have them professionally sharpened.</li> </ol>
Long lines or ridges that run along length of board.	<ol style="list-style-type: none"> <li>1. Nicked or chipped knife.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace knives (<b>Page 26</b>) or have them professionally sharpened.</li> </ol>
Uneven cutting` marks, wavy surface, or chatter marks across face of board.	<ol style="list-style-type: none"> <li>1. Feed rate set too fast.</li> <li>2. Chipbreaker set unevenly or not low enough.</li> <li>3. Knives not installed evenly in cutterhead.</li> <li>4. Worn cutterhead bearings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Slow down feed rate (<b>Page 26</b>).</li> <li>2. Adjust height of chipbreaker (<b>Page 37</b>).</li> <li>3. Adjust knives with knife-setting gauge (<b>Page 26</b>).</li> <li>4. Replace cutterhead bearings.</li> </ol>
Glossy surface.	<ol style="list-style-type: none"> <li>1. Dull knives.</li> <li>2. Feed rate set too slow.</li> <li>3. Cutting depth too shallow.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace knives (<b>Page 26</b>) or have them professionally sharpened.</li> <li>2. Increase feed rate (<b>Page 26</b>).</li> <li>3. Increase depth of cut (<b>Page 25</b>).</li> </ol>
If workpiece twists in machine.	<ol style="list-style-type: none"> <li>1. Feed rollers not parallel with table.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust feed rollers (<b>Page 37</b>).</li> </ol>



# Tensioning/ Replacing V-Belts

## NOTICE

After approximately 16 hours of operation, V-belts will stretch and seat into pulley grooves and need to be properly tensioned to avoid severely reducing life of V-belts.

Three V-belts transfer power from the motor to the cutterhead, and then to the infeed and outfeed rollers with the use of the drive chain system. To ensure efficient transfer of power to these systems, make sure the V-belts are always properly tensioned and in good condition.

If the V-belts are worn, cracked, or damaged, replace them. Always replace the V-belts with a matched set of three, or belt tension may not be even among the belts, causing premature belt failure.

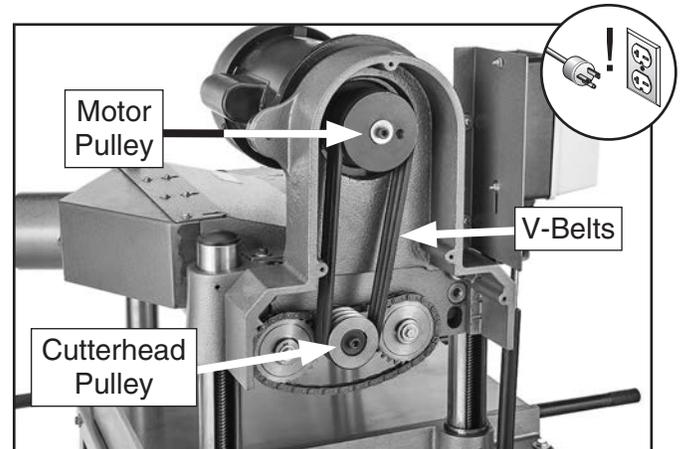
## CAUTION

V-belts and pulleys will be hot after operation. Allow them to cool before handling.

Tools Needed	Qty
Phillips Screwdriver #2 .....	1
Hex Wrench 8mm.....	1
Open-End Wrench 14, 17mm .....	1 Ea.

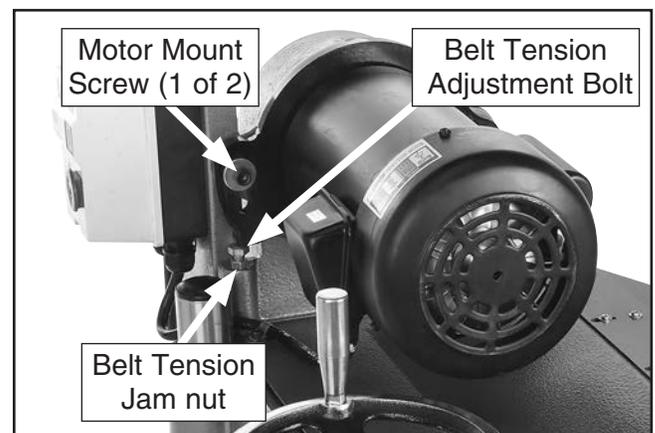
### To tension/replace V-belts:

1. DISCONNECT MACHINE FROM POWER!
2. Remove upper and lower V-belt cover from left side of machine to expose belts, as shown in **Figure 38**.



**Figure 38.** Belt covers removed to expose V-belts and pulleys.

3. Loosen motor mount screws and belt tension jam nut shown in **Figure 39**.
4. If V-belts need to be replaced, rotate belt tension adjustment bolt (see **Figure 39**) to lower motor and release belt tension. Roll belts off pulleys, then replace with a matched set of 3.



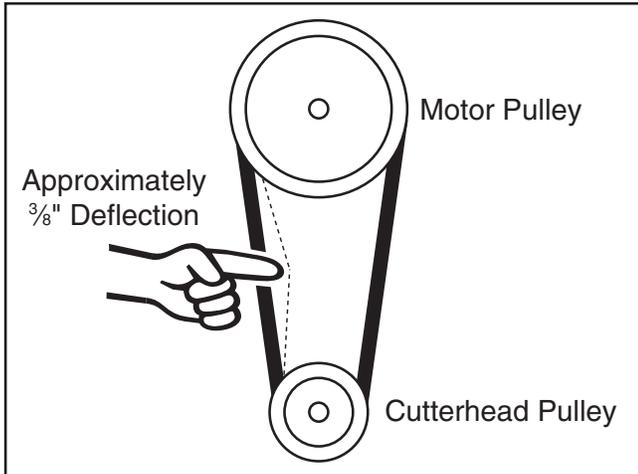
**Figure 39.** Belt tension controls.

Continued on next page →



- To adjust V-belt tension, rotate belt tension adjustment bolt (see **Figure 39**) to raise or lower motor until belts are correctly tensioned.

**Note:** V-belts are correctly tensioned when there is approximately  $\frac{3}{8}$ " deflection when moderate pressure is applied to them midway between pulleys, as illustrated in **Figure 40**.



**Figure 40.** Belt deflection when V-belts are correctly tensioned.

- After V-belts are correctly tensioned, tighten belt tension jam nut and motor mount screws, then re-install belt covers.

## Tensioning Height Chain

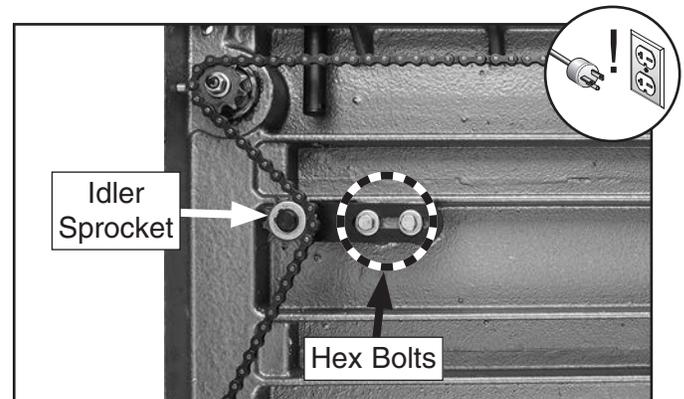
The height chain transfers movement from the headstock height handwheel to the columns that control headstock height. The chain drive can be adjusted to remove slack if the chain stretches over time.

**Note:** You must first unbolt and raise planer off of stand/workbench with a forklift or other suitable lifting device (see **Page 17**) before proceeding.

<b>Tools Needed</b>	<b>Qty</b>
Wrench or Socket $\frac{1}{2}$ " .....	1

### To adjust height chain tension:

- DISCONNECT MACHINE FROM POWER!
- Loosen hex bolts, then push idler sprocket against chain with moderate pressure. While maintaining pressure on idler sprocket, re-tighten hex bolts (see **Figure 41**).



**Figure 41.** Example of headstock height chain adjustment.

- Clean and lubricate chain and sprockets (refer to **Height Chain & Sprockets** on **Page 31** for detailed instructions).

## **NOTICE**

**DO NOT** let chain fall off sprockets. It can be very difficult to return chain to its proper location on sprockets without changing table adjustments.



# Feed Rollers & Chip Breaker Heights

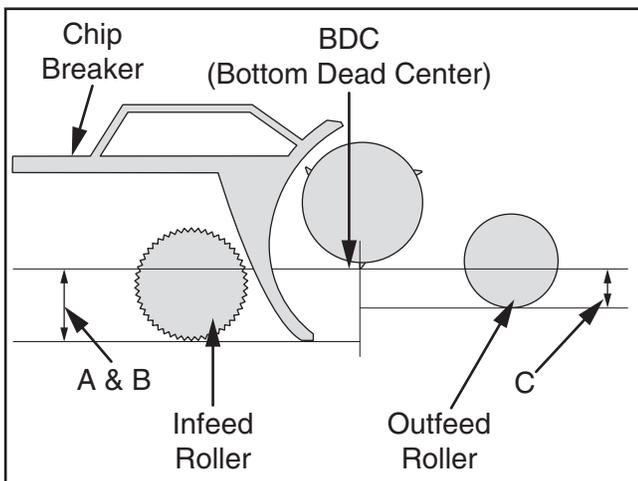
It is essential that the feed rollers and chip breaker are set at the correct distance below the cutterhead knives at BDC (bottom dead center) to ensure that the workpiece moves through the planer evenly and the correct distance from the cutterhead knives.

To ensure accurate results and make the adjustment process quicker and easier, we recommend using a Rotacator for these adjustments.

If a Rotacator is not available, a 6' 2x4 cut into two even sized pieces and a feeler gauge set can be used, but care must be taken when jointing the wood to achieve accurate results.

## Dist. Below Knife at BDC (Figure 42)

- A. Infeed Roller ..... 0.040"
- B. Chip Breaker..... 0.040"
- C. Outfeed Roller ..... 0.020"



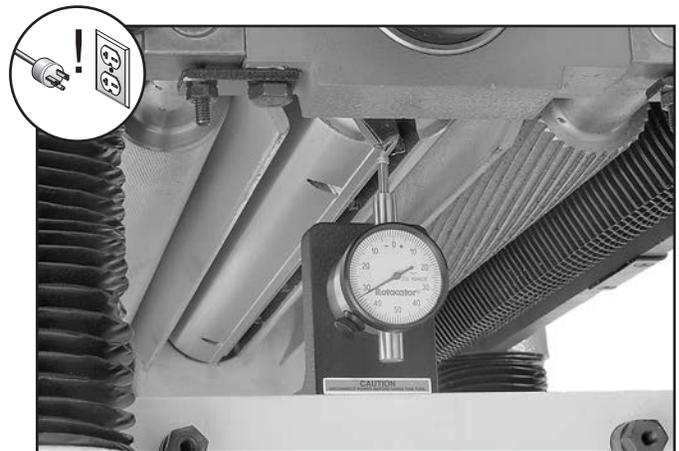
**Figure 42.** Planer component recommended clearances (illustration is not to scale).

## Using a Rotacator

Tools Needed	Qty
Phillips Screwdriver #2 .....	1
Hex Wrench 4, 5mm.....	1 Ea.
Open-End Wrench or Socket 8, 10mm .....	1 Ea.
Rotacator .....	1

### To use a rotacator:

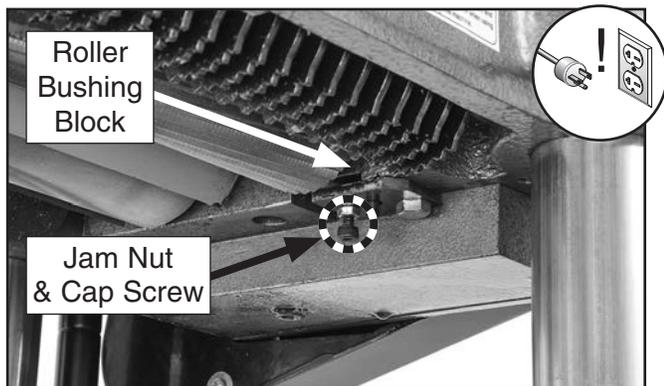
1. DISCONNECT MACHINE FROM POWER!
2. Make sure knives are set to correct height (refer to **Adjusting/Replacing Knives** on **Page 26** for detailed instructions).
3. Raise headstock at least 4" above table, then lock it in place.
4. Remove dust hood, top cover, belt covers, and drive chain cover.
5. Using Rotacator, find bottom dead center (BDC) of any knife edge by slowly rocking cutterhead pulley back and forth, then set Rotacator dial to "0" (see **Figure 43**).



**Figure 43.** Example of using a Rotacator to find BDC of knife edge.



6. Move feed speed knob to neutral position to allow infeed roller to freely rotate.
7. Keeping Rotacator dial at "0", position it under right-hand side of infeed roller and find BDC of a serrated edge by rocking infeed roller back and forth.
8. Loosen jam nuts and use cap screws on each side of feed roller (see **Figure 44**) to adjust height of infeed roller bushing block until Rotacator dial shows 0.040", which is the recommended distance for infeed roller below cutterhead.



**Figure 44.** Location of infeed roller height adjustment controls.

9. Repeat **Steps 7–8** on left side of infeed roller.
10. Re-check both sides of infeed roller and, if necessary, make further adjustments until infeed roller height from side-to-side is 0.040" below BDC of cutterhead knife, then retighten both jam nuts.
11. Keeping same "0" reference on Rotacator dial from **Step 5**, repeat **Steps 7–10** for outfeed roller, but adjust it until it is 0.020" below BDC of cutterhead knife.

12. Using same "0" reference on Rotacator dial from **Step 5**, perform similar steps as described above to adjust height of chip breaker to its recommended specification given at beginning of this subsection. The adjustment controls are shown in **Figure 45**.



**Figure 45.** Example of adjusting the chip breaker height.

13. Re-install belt cover, top cover, drive chain cover, and dust hood.



## Using Wood Blocks

### Tools Needed

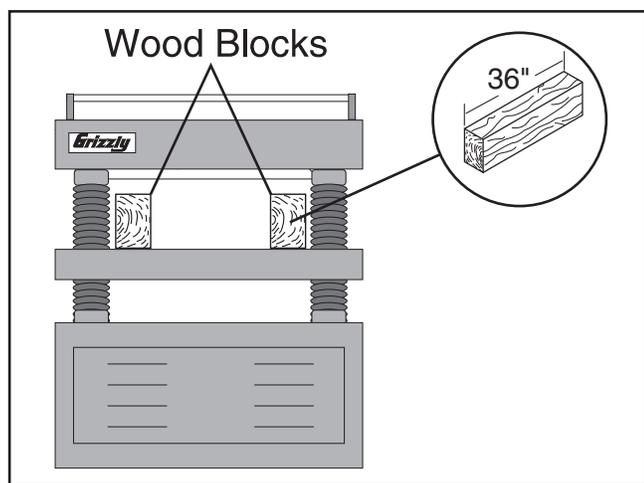
	Qty
Phillips Screwdriver #2 .....	1
Hex Wrench 4, 5mm.....	1 Ea.
Open-End Wrench or Socket 8, 10mm .....	1 Ea.
2x4 6' Long.....	1
Feeler Gauge Set.....	1

### To use wood blocks:

1. Build wood blocks by cutting a *straight* 6-foot-long 2x4 in half.

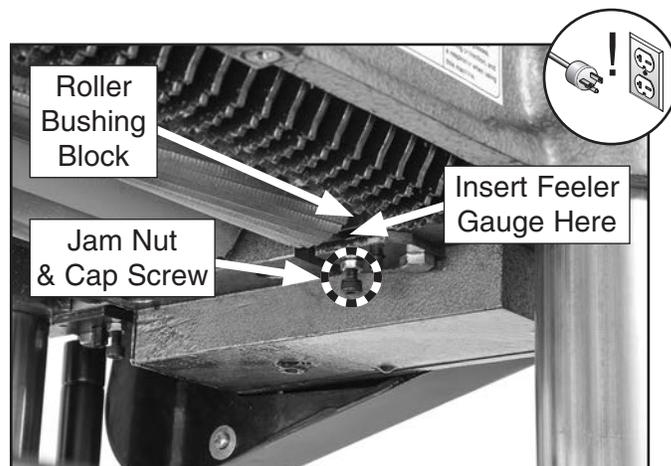
**Note:** *Having the wood blocks at an even height is critical to the accuracy of your overall adjustments. For best results, make the 2x4 square with a jointer and table saw before cutting it in half.*

2. Make sure knives are set to correct height (refer to **Adjusting/Replacing Knives** on **Page 26** for detailed instructions).
3. **DISCONNECT MACHINE FROM POWER!**
4. Raise headstock approximately 5" above table surface.
5. Place wood blocks along sides of table, as illustrated in **Figure 46**.



**Figure 46.** Wood blocks properly positioned on the planer table.

6. Remove dust hood, top cover, belt cover, and drive chain cover.
7. Lower headstock until cutterhead gets close to wood blocks.
8. Use belts to rotate cutterhead and continue lowering headstock until blocks just barely touch cutterhead knife at its lowest point of rotation (BDC).
9. Lock headstock in place. Upward pressure of wood blocks will be holding infeed and outfeed rollers, and chip breaker at same level as knife at BDC.
10. Loosen jam nuts and cap screws on each side of infeed roller (see **Figure 47**).
11. Using a feeler gauge, adjust set screw so it is 0.040" from roller bushing block (see **Figure 47**), then tighten jam nut. Repeat on other side of infeed roller.

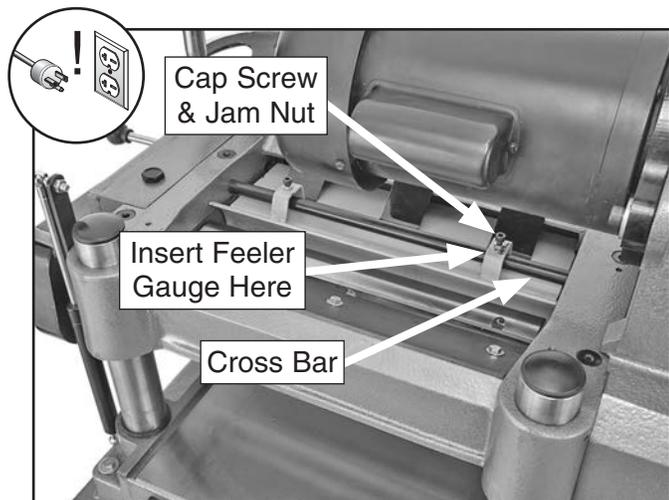


**Figure 47.** Feeler gauge location for adjusting infeed roller height when using wood blocks.

*Continued on next page* →



12. Repeat **Steps 10–11** with outfeed roller, only adjust the gaps to 0.020".
13. Loosen jam nuts and cap screws on each side of chip breaker (see **Figure 48**).
14. Using a feeler gauge, adjust cap screw so it is 0.040" from cross bar (see **Figure 48**), then tighten jam nut. Repeat on other side of chip breaker.



**Figure 48.** Feeler gauge location for adjusting chip breaker height when using wood blocks.

15. Re-install belt cover, top cover, drive chain cover, and dust hood.

## Adjusting Roller Spring Tension

The infeed and outfeed rollers keep the workpiece moving through the planer. There are springs that exert downward pressure on the rollers while still allowing them to raise with an uneven workpiece surface. Proper roller spring tension is crucial to keep the workpiece moving through the planer during operation.

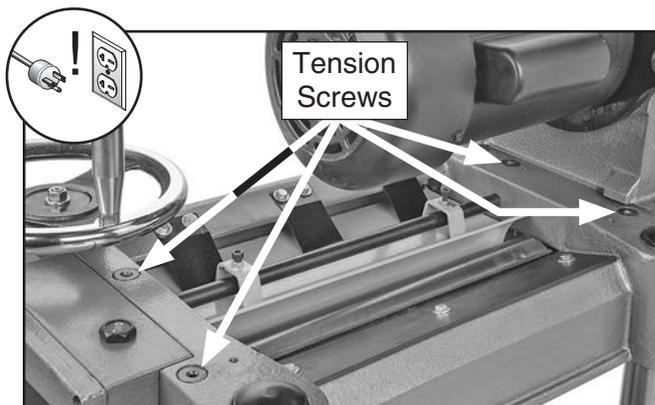
Roller spring tension will vary depending upon the type of wood you are planing. When adjusting the roller spring tension keep the following in mind:

- If you are planing milled lumber with a relatively consistent surface, use less spring tension.
- If you are planing rough lumber with inconsistent surfaces, use greater spring tension to keep the stock moving through the planer.
- If the workpiece consistently stops feeding during operation, the roller spring tension may need to be increased.

Tools Needed	Qty
Hex Wrench 6mm.....	1

### To adjust roller spring tension:

1. DISCONNECT MACHINE FROM POWER!
2. Rotate tension screws clockwise to increase tension, and counterclockwise to decrease tension (see **Figure 49**).



**Figure 49.** Roller spring tension adjustment screws.



# Positioning Chip Deflector

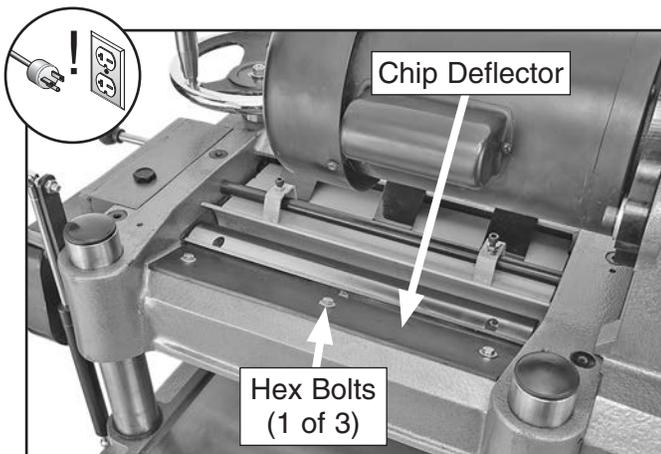
Chip Deflector Gap Setting .....  $\frac{1}{16}''$ – $\frac{1}{8}''$

When properly distanced from the cutterhead, the chip deflector directs the chips into the dust hood, and keeps them from falling onto the outfeed roller and being pressed into the workpiece.

Tools Needed	Qty
Phillips Screwdriver #2 .....	1
Hex Wrench 5mm.....	1
Open-End Wrench or Socket 10mm .....	1
Fine Ruler or Calipers .....	1

## To adjust chip deflector gap:

1. DISCONNECT MACHINE FROM POWER!
2. Remove dust hood, top cover, and belt covers.
3. Use cutterhead pulley to rotate cutterhead until a knife reaches closest distance to chip deflector (see **Figure 50**), then measure distance between knife and chip deflector.



**Figure 50.** Chip deflector and securing flange bolts.

4. If distance measured in **Step 3** is *not*  $\frac{1}{16}''$ – $\frac{1}{8}''$ , then loosen flange screws that secure chip deflector and adjust gap to  $\frac{1}{16}''$ – $\frac{1}{8}''$ .
5. Retighten flange screws, then replace belt covers, top cover, and dust hood.

# Anti-Kickback Fingers

The anti-kickback fingers are an important safety feature of your planer. The fingers hang from a rod suspended across the head casting and in front of the infeed roller, as shown in **Figure 51**. This design allows the workpiece to easily enter the planer but reduces the risk of kickback by digging into the workpiece if it moves backward.



**Figure 51.** Anti-kickback fingers.

Check the anti-kickback fingers regularly to ensure they swing freely and easily. If the fingers do not swing freely and easily, first clean them with a wood resin solvent, then inspect them for damage. If any of the fingers are damaged, the device must be replaced before using the machine.

Do not apply oil or other lubricants to the anti-kickback fingers that will attract dust and restrict free movement of the fingers.

**⚠ WARNING**

Proper operation of anti-kickback fingers is critical for safe operation of this planer. **DO NOT** operate planer if anti-kickback fingers are not operating correctly. Failure to heed this warning could result in serious personal injury.



# 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

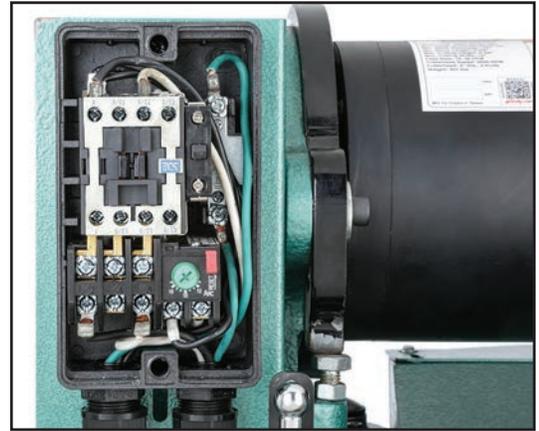
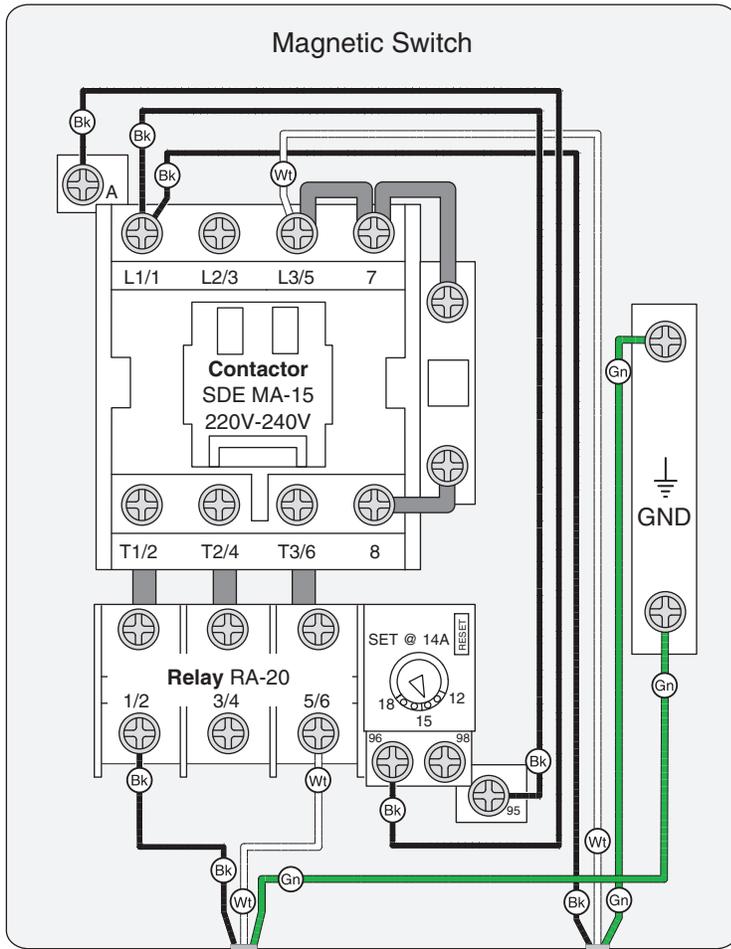


Figure 52. Magnetic switch with cover removed.

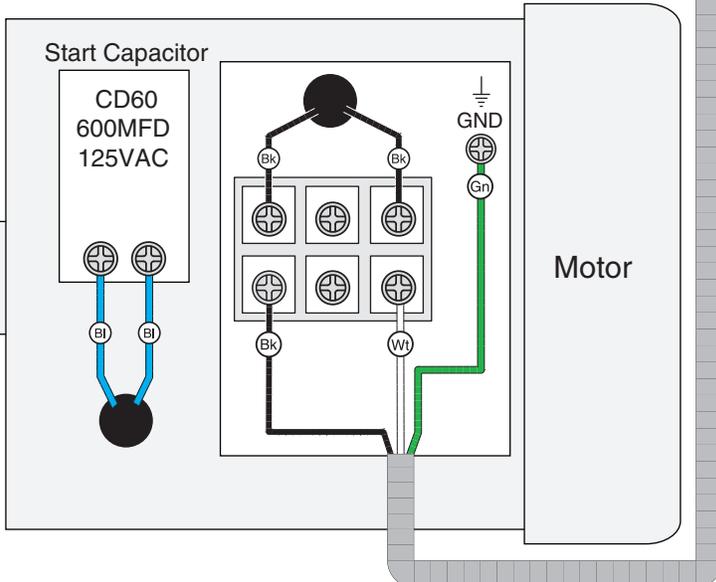
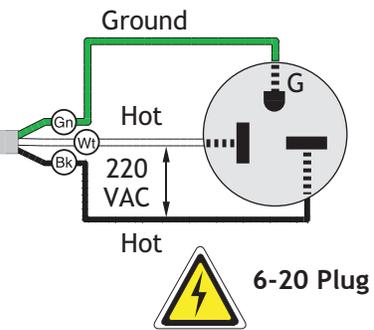


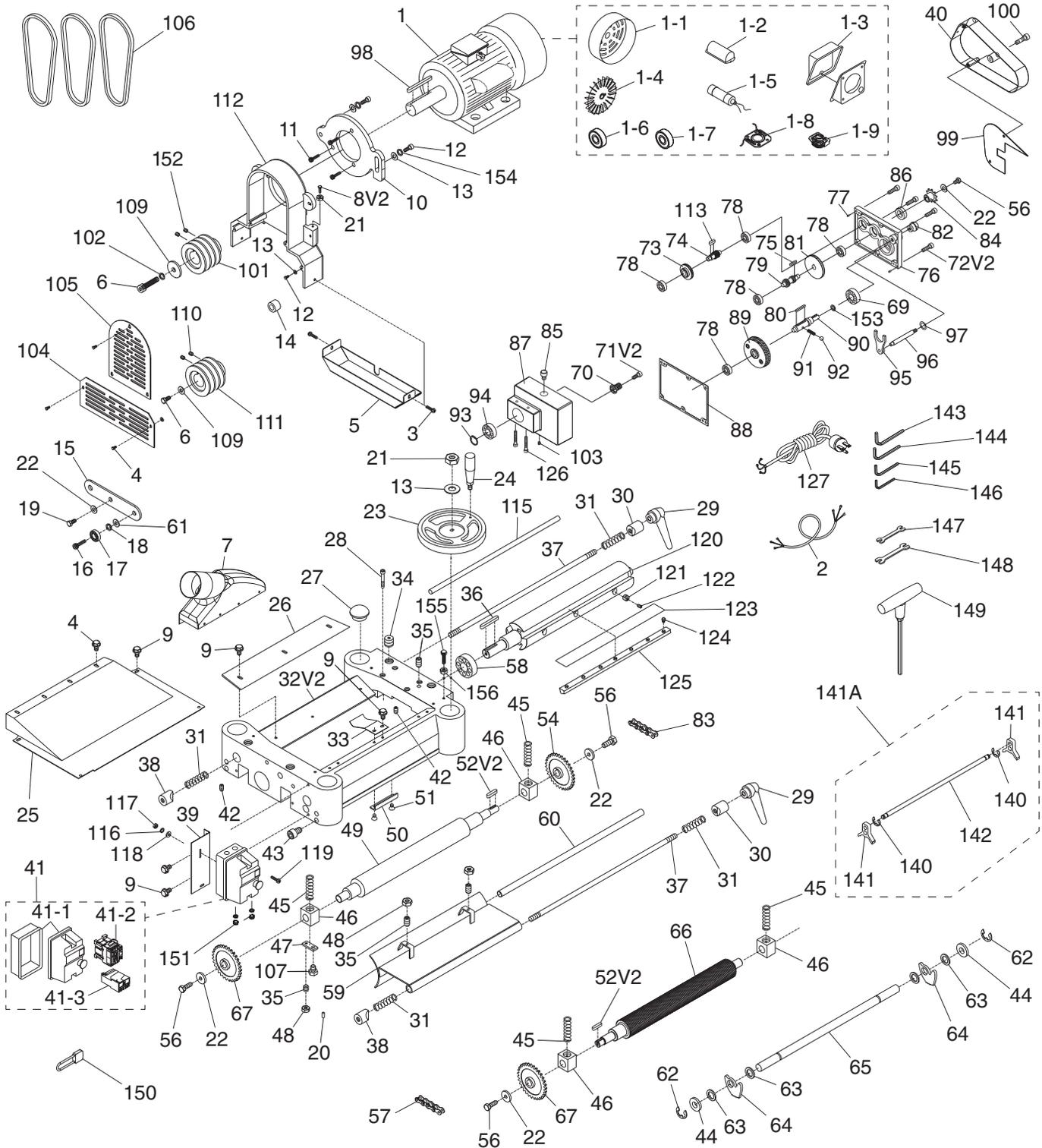
Figure 53. Motor wiring.



# SECTION 9: PARTS

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

## Main



# Main Parts List

REF	PART #	DESCRIPTION
1	P0815001	MOTOR 3HP 220V 1-PH
1-1	P0815001-1	MOTOR FAN COVER
1-2	P0815001-2	CAPACITOR COVER
1-3	P0815001-3	MOTOR JUNCTION BOX
1-4	P0815001-4	MOTOR FAN
1-5	P0815001-5	S CAPACITOR 600M 125V 1-3/4 X 3-3/8
1-6	P0815001-6	MOTOR BEARING 6205ZZ (FRONT)
1-7	P0815001-7	MOTOR BEARING 6203ZZ (REAR)
1-8	P0815001-8	CONTACT PLATE
1-9	P0815001-9	CENTRIFUGAL SWITCH
2	P0815002	MOTOR CORD 12G 3W 20"
3	P0815003	FLANGE SCREW 1/4-20 X 3/8
4	P0815004	FLANGE SCREW 10-24 X 3/8
5	P0815005	BELT HOUSING LOWER COVER
6	P0815006	CAP SCREW M8-1.25 X 25
7	P0815007	DUST PORT 4"
8V2	P0815008V2	HEX BOLT 3/8-16 X 2 V2.03.19
9	P0815009	FLANGE SCREW 1/4-20 X 5/16
10	P0815010	MOTOR PLATE
11	P0815011	CAP SCREW M8-1.25 X 20
12	P0815012	CAP SCREW 3/8-16 X 1-1/4
13	P0815013	FLAT WASHER 3/8
14	P0815014	BUSHING
15	P0815015	PLATE
16	P0815016	CAP SCREW M10-1.25 X 20
17	P0815017	BALL BEARING 6000-2RS
18	P0815018	LOCK WASHER 10MM
19	P0815019	FLANGE SCREW 1/4-20 X 3/8
20	P0815020	ROLL PIN 5 X 15
21	P0815021	HEX NUT 3/8-16
22	P0815022	FLAT WASHER 1/4
23	P0815023	HANDWHEEL TYPE-3 8.5 D X 3/8B-K X 3/8-16
24	P0815024	REVOLVING HANDLE 3/8-16 X 5/8, 1 X 4
25	P0815025	HEADSTOCK COVER
26	P0815026	CHIP DEFLECTOR
27	P0815027	COLUMN CAP
28	P0815028	CAP SCREW 3/8-16 X 2-1/2
29	P0815029	ADJUSTABLE HANDLE M12-1.75, 125L
30	P0815030	COLUMN GIB
31	P0815031	COMPRESSION SPRING 3 X 12.7 X 40
32V2	P0815032V2	HEAD CASTING V2.05.21
33	P0815033	PLATE SPRING
34	P0815034	OIL PORT M22-1.5 X 20
35	P0815035	SET SCREW 1/4-20 X 5/8
36	P0815036	KEY 8 X 8 X 36
37	P0815037	COLUMN LOCK ROD
38	P0815038	COLUMN GIB (THREADED)
39	P0815039	SWITCH MOUNT BRACKET
40	P0815040	DRIVE CHAIN COVER
41	P0815041	MAG SWITCH ASSY SDE MP-15 240V 3HP
41-1	P0815041-1	MAG SWITCH BOX
41-2	P0815041-2	CONTACTOR SDE MA-15 220V
41-3	P0815041-3	OL RELAY SDE RA-20 12-18A
42	P0815042	SET SCREW 5/16-18 X 1/2
43	P0815043	CAP SCREW 1/4-20 X 5/8

REF	PART #	DESCRIPTION
44	P0815044	FLAT WASHER 3/4
45	P0815045	COMPRESSION SPRING 3.5 X 19 X 70
46	P0815046	BUSHING BLOCK
47	P0815047	ROLLER ADJUSTMENT PLATE
48	P0815048	HEX NUT 1/4-20
49	P0815049	OUTFEED ROLLER
50	P0815050	DEPTH LIMITER
51	P0815051	FLAT HD SCR 1/4-20 X 5/16
52V2	P0815052V2	KEY 5 X 5 X 15 V2.07.16
54	P0815054	SPROCKET 31T
56	P0815056	HEX BOLT 1/4-20 X 5/8
57	P0815057	CHAIN 06B X 59
58	P0815058	BALL BEARING 6205-2RS
59	P0815059	CHIP BREAKER
60	P0815060	CHIP BREAKER ADJUSTMENT ROD
61	P0815061	FLAT WASHER 10MM
62	P0815062	E-CLIP 15MM
63	P0815063	SPACER
64	P0815064	ANTI-KICKBACK FINGER
65	P0815065	ANTI-KICKBACK SHAFT
66	P0815066	INFEED ROLLER
67	P0815067	SPROCKET 27T
69	P0815069	BALL BEARING 6204-2RS
70	P0815070	CUTTERHEAD DRIVE GEAR 14T
71V2	P0815071V2	CAP SCREW M6-1 X 20 V2.09.16
72V2	P0815072V2	CAP SCREW 1/4-20 X 3/4 V2.06.16
73	P0815073	GEAR 46T
74	P0815074	GEARED SHAFT 18T
75	P0815075	KEY 5 X 5 X 10
76	P0815076	GEARBOX COVER
77	P0815077	GEARBOX COVER PIN
78	P0815078	BALL BEARING 6201-2RS
79	P0815079	COMBO GEAR 14T/22T
80	P0815080	KEY 5 X 5 X 40
81	P0815081	GEAR 72T
82	P0815082	ROUND KNOB 3/8-16, 1-1/4 DIA
83	P0815083	CHAIN 06B X 55
84	P0815084	SPROCKET 15T
85	P0815085	OIL PLUG 5/8 NPT (PLASTIC)
86	P0815086	OIL SEAL 20 X 35 X 8
87	P0815087	GEARBOX
88	P0815088	GEARBOX GASKET
89	P0815089	COMBO GEAR 71T/79T
90	P0815090	GEAR SHAFT
91	P0815091	COMPRESSION SPRING 0.5 X 4.8 X 18
92	P0815092	STEEL BALL 5MM
93	P0815093	INT RETAINING RING 47MM
94	P0815094	BALL BEARING 6204-2RS
95	P0815095	SHIFTER FORK
96	P0815096	FEED RATE SHIFTER SHAFT
97	P0815097	O-RING 12MM
98	P0815098	KEY 5 X 5 X 30
99	P0815099	CHAIN COVER PLATE
100	P0815100	CAP SCREW 5/16-18 X 1



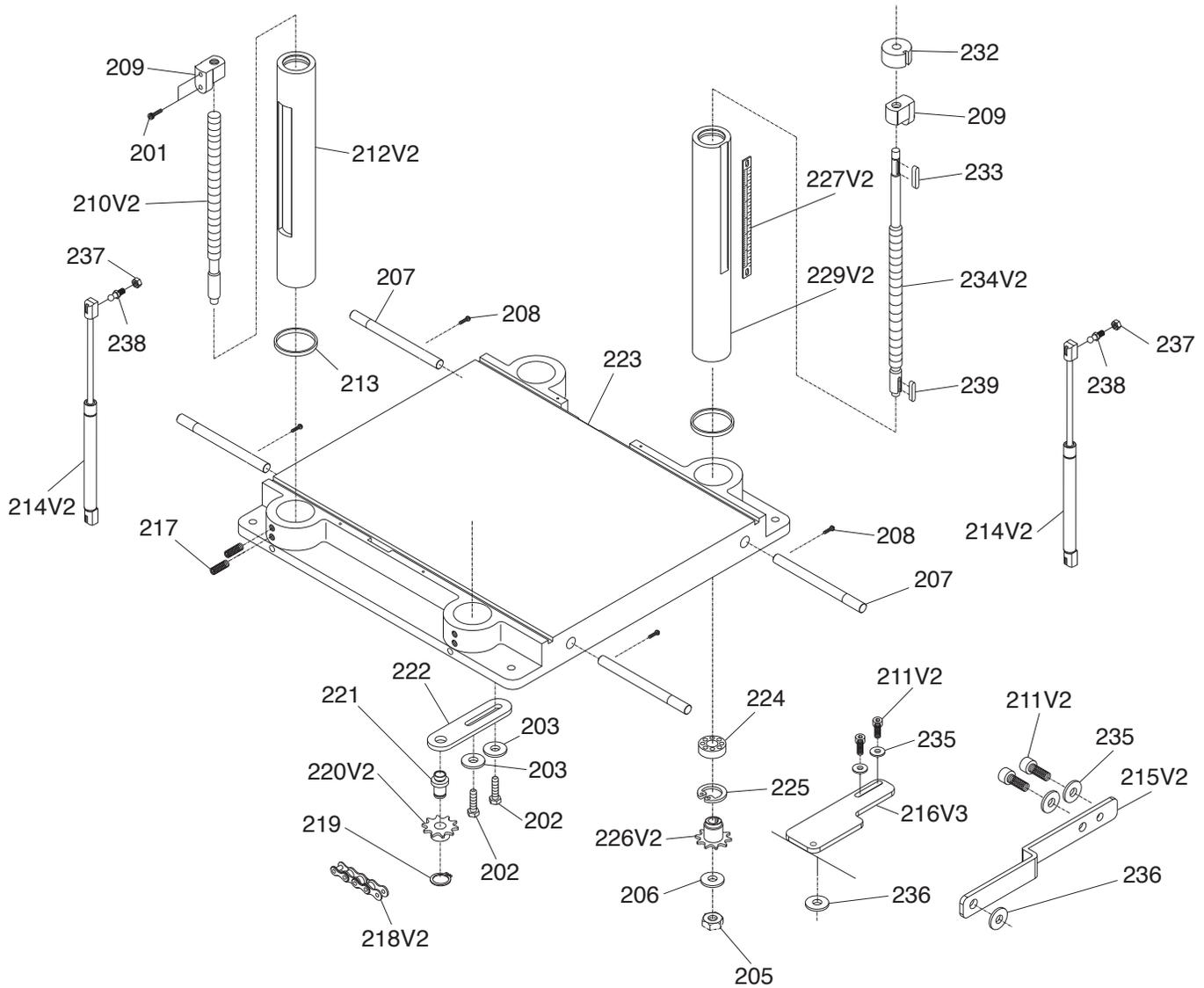
# Main Parts List (Cont.)

REF	PART #	DESCRIPTION
101	P0815101	MOTOR PULLEY
102	P0815102	LOCK WASHER 8MM
103	P0815103	DRAIN PLUG 1/4 NPT
104	P0815104	PULLEY COVER (LOWER)
105	P0815105	PULLEY COVER (UPPER)
106	P0815106	V-BELT M28 3L280
107	P0815107	HEX BOLT 5/16-18 X 3/4
109	P0815109	FENDER WASHER 8MM
110	P0815110	SET SCREW 1/4-20 X 3/16
111	P0815111	CUTTERHEAD PULLEY
112	P0815112	BELT HOUSING
113	P0815113	KEY 5 X 5 X 12
115	P0815115	SHAFT
116	P0815116	LOCK WASHER #10
117	P0815117	HEX NUT 10-24
118	P0815118	FLAT WASHER #10
119	P0815119	PHLP HD SCR 10-24 X 5/8
120	P0815120	CUTTERHEAD 15" 3-KNIFE
121	P0815121	KNIFE ADJUSTMENT SEAT
122	P0815122	JACK SCREW M5-.8 X 12
123	P0815123	PLANER KNIVES 15" X 1" X 1/8" 3-PK
124	P0815124	GIB BOLT

REF	PART #	DESCRIPTION
125	P0815125	GIB
126	P0815126	CAP SCREW 3/8-16 X 2-1/2
127	P0815127	POWER CORD 12AWG 3W 72" 6-20P
140	P0815140	E-CLIP 9MM
141A	P0815141A	KNIFE-SETTING JIG ASSEMBLY
141	P0815141	KNIFE-SETTING JIG FOOT
142	P0815142	KNIFE-SETTING JIG ROD
143	P0815143	HEX WRENCH 6MM
144	P0815144	HEX WRENCH 2.5MM
145	P0815145	HEX WRENCH 4MM
146	P0815146	HEX WRENCH 3MM
147	P0815147	WRENCH 8 X 10MM OPEN-ENDS
148	P0815148	WRENCH 12 X 14MM OPEN-ENDS
149	P0815149	T-HANDLE HEX WRENCH 5MM
150	P0815150	PADLOCK WITH KEYS
151	P0815151	STRAIN RELIEF TYPE-3 M20-1.5
152	P0815152	SET SCREW 1/4-20 X 3/4
153	P0815153	EXT RETAINING RING 20MM
154	P0815154	LOCK WASHER 3/8
155	P0815155	HEX BOLT 5/16-18 X 1-1/2
156	P0815156	HEX NUT 5/16-18



# Table & Columns

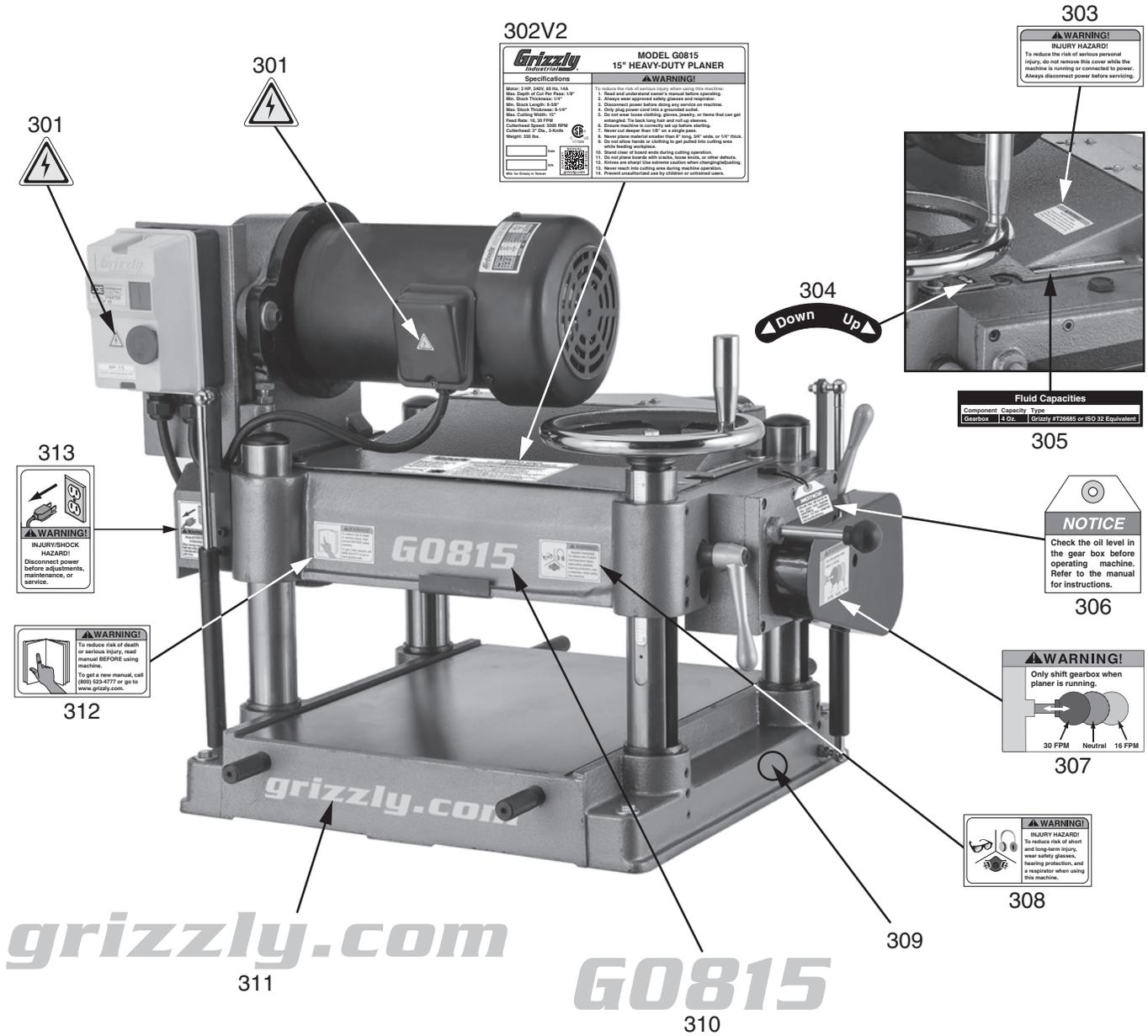


REF	PART #	DESCRIPTION
201	P0815201	CAP SCREW 1/4-20 X 5/8
202	P0815202	HEX BOLT 5/16-18 X 3/4
203	P0815203	FLAT WASHER 5/16
205	P0815205	HEX NUT 3/8-16
206	P0815206	LOCK WASHER 3/8
207	P0815207	SUPPORT ROD
208	P0815208	PHLP HD SCR 10-24 X 3/8
209	P0815209	LEADSCREW NUT
210V2	P0815210V2	ELEVATION LEADSCREW V2.09.18
211V2	P0815211V2	CAP SCREW 1/4-20 X 5/8 V2.01.19
212V2	P0815212V2	COLUMN V2.09.18
213	P0815213	COLUMN BUSHING
214V2	P0815214V2	GAS SPRING ASSEMBLY V2.09.18
215V2	P0815215V2	GAS SPRING BRACKET (FRONT) V2.09.18
216V3	P0815216V3	GAS SPRING BRACKET (REAR) V3.05.21
217	P0815217	SET SCREW 3/8-16 X 1/2
218V2	P0815218V2	HEIGHT CHAIN #25 X 274 V2.03.20
219	P0815219	EXT RETAINING RING 15MM

REF	PART #	DESCRIPTION
220V2	P0815220V2	ELEVATION IDLER SPROCKET 24T V2.03.20
221	P0815221	IDLER SHAFT
222	P0815222	IDLER BRACKET
223	P0815223	TABLE BASE
224	P0815224	BALL BEARING 6302ZZ
225	P0815225	INT RETAINING RING 42MM
226V2	P0815226V2	ELEVATION SPROCKET 24T V2.03.20
227V2	P0815227V2	DEPTH SCALE V2.09.18
229V2	P0815229V2	DRIVE COLUMN V2.09.18
232	P0815232	LEADSCREW BUSHING
233	P0815233	KEY 4 X 4 X 20 RE
234V2	P0815234V2	ELEVATION DRIVE LEADSCREW V2.09.18
235	P0815235	FLAT WASHER 1/4
236	P0815236	FLAT WASHER 8MM
237	P0815237	HEX NUT M8-1.25
238	P0815238	GAS SPRING BALL JOINT M8-1.25 X 14
239	P0815239	KEY 5 X 5 X 20 RE



# Labels & Cosmetics



REF	PART #	DESCRIPTION
301	P0815301	ELECTRICITY LABEL
302V2	P0815302V2	MACHINE ID LABEL V2.09.18
303	P0815303	DO NOT OPEN COVER LABEL
304	P0815304	HANDWHEEL ROTATION LABEL
305	P0815305	FLUID CAPACITY LABEL
306	P0815306	CHECK OIL NOTICE LABEL
307	P0815307	FEED SPEED SHIFT WARNING LABEL

REF	PART #	DESCRIPTION
308	P0815308	EYE/EAR/LUNG INJURY WARNING LABEL
309	P0815309	TOUCH-UP PAINT, GRIZZLY GREEN
310	P0815310	MODEL NUMBER LABEL
311	P0815311	GRIZZLY.COM LABEL
312	P0815312	READ MANUAL LABEL
313	P0815313	DISCONNECT POWER LABEL

## ! WARNING

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



# WARRANTY & RETURNS

---

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

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

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

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

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

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

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



# *grizzly.com*<sup>®</sup>

**TOOL WEBSITE**

Buy Direct and Save with Grizzly<sup>®</sup> – Trusted, Proven and a Great Value!  
~Since 1983~

*Visit Our Website Today For  
Current Specials!*

**ORDER  
24 HOURS A DAY!  
1-800-523-4777**

