



MODEL G0821
6" BENCHTOP JOINTER
w/SPIRAL CUTTERHEAD
OWNER'S MANUAL
(For models manufactured since 03/18)



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V2.05.18



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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


Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

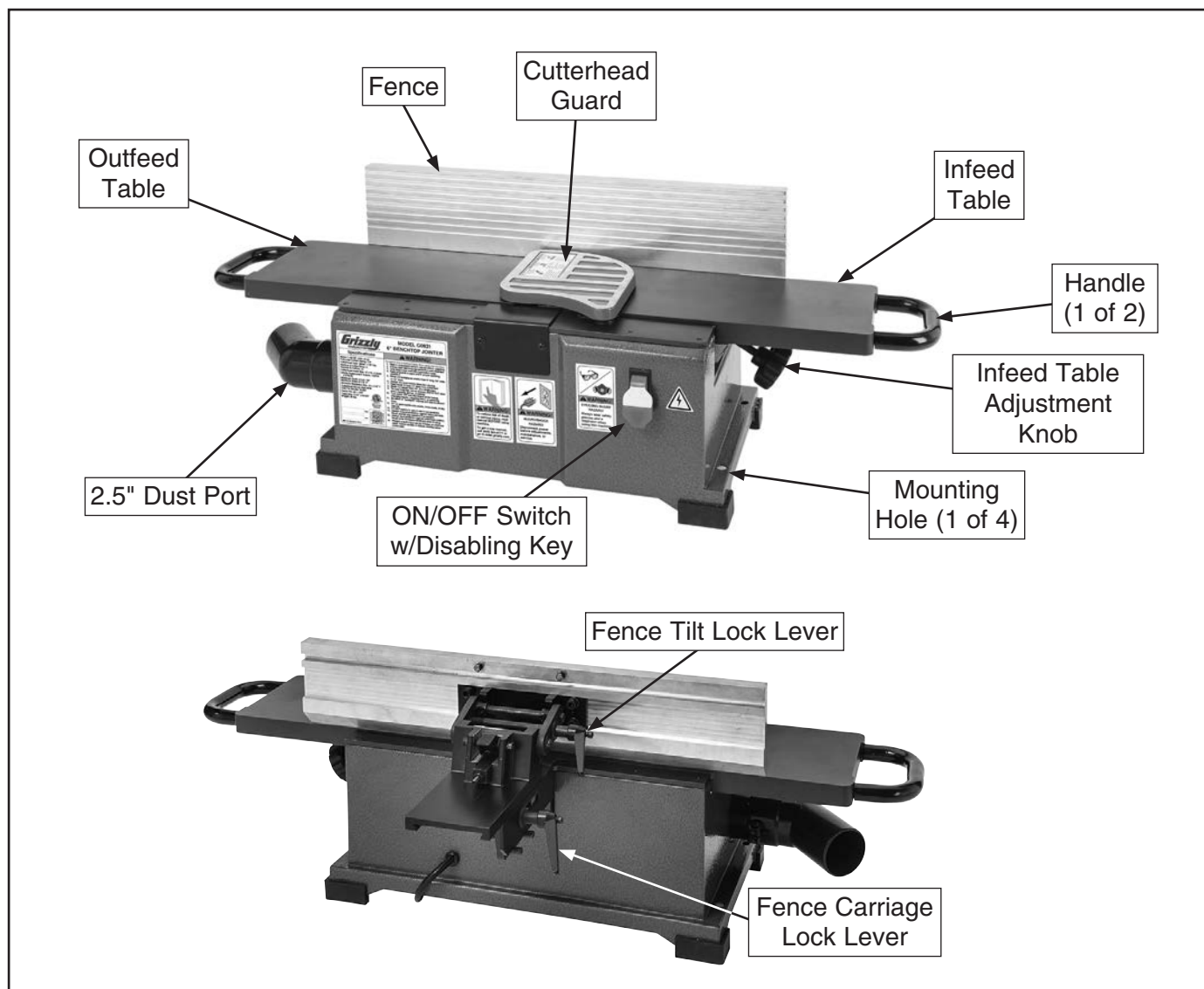
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

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

Manufactured for Grizzly in Taiwan



Identification



WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

- a) Wear eye and hearing protection.
- b) Always keep cutterhead and drive guards in place and in proper operating condition.
- c) Always use hold-down or push blocks when jointing material narrower than 3" or surface planing material thinner than 3".
- d) Never perform jointing or planing on pieces shorter than 8" in length.



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.

Component Descriptions

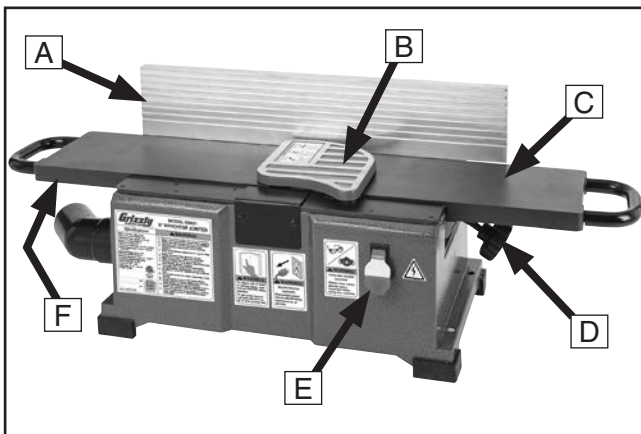


Figure 1. Main table controls.

- A. Fence:** Supports workpiece laterally as it moves across cutterhead; determines angle of cut when edge or bevel joining.
- B. Cutterhead Guard:** Covers cutterhead until pushed aside by workpiece during operation. When workpiece leaves cutterhead, guard springs back to its starting position. **DO NOT** operate jointer if guard is not functioning properly.
- C. Infeed Table:** Supports workpiece before it reaches cutterhead. Height of infeed table determines depth of cut.
- D. Infeed Table Adjustment Knob:** Adjusts height of infeed table, which determines depth of cut.
- E. ON/OFF Switch w/Disabling Key:** Turns motor **ON** when flipped up; turns motor **OFF** when pressed down. Removal of yellow key disables switch so motor cannot start.
- F. Outfeed Table:** Supports workpiece after it passes over cutterhead. For optimum cutting results and safe operation, outfeed table must be properly adjusted even with highest point or TDC (Top Dead Center) of cutterhead inserts.



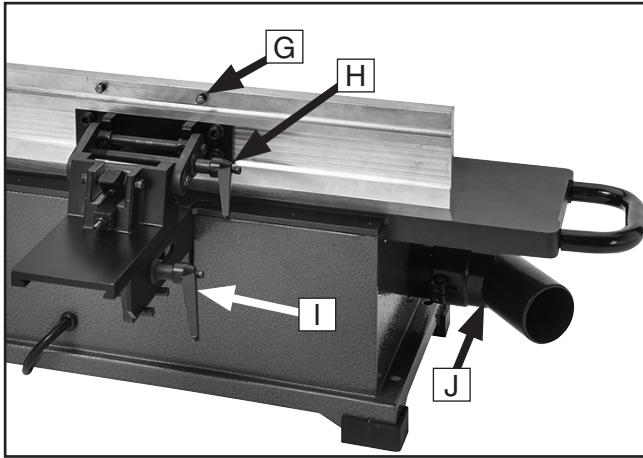


Figure 2. Fence controls.

- G. 45° Outward (135°) Fence Stop:** Stops fence at 45° outward (135°) position for bevel cuts.

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

- H. Fence Tilt Lock Lever:** Secures fence tilt angle. Fence can be quickly set to 90° (perpendicular to both tables), 45° inward, and 45° outward (135°) by setting and using fence stops on bracket assembly.
- I. Fence Carriage Lock Lever:** Tightens to secure fence position; loosens to allow lateral adjustment. ALWAYS firmly tighten lock before beginning operations.
- J. Dust Port:** Mounts to included collection bag, or connects directly to a dust collector or shop vacuum.

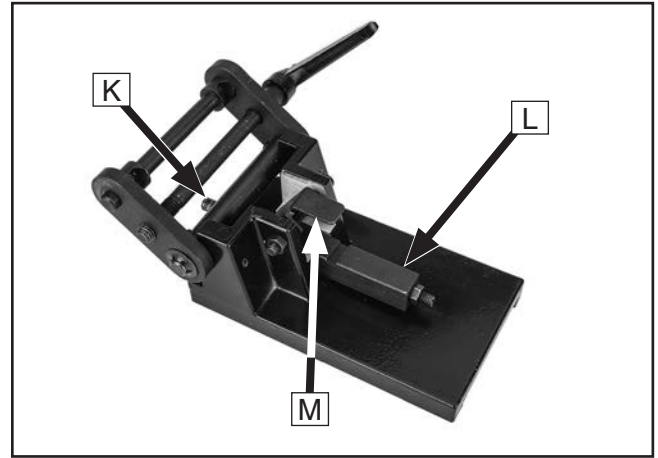


Figure 3. Fence carriage components.

- K. 45° Inward Fence Stop:** Stops fence at 45° inward position for bevel cuts.

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

- L. Limit Block:** Features indents to quickly adjusts angle of fence carriage to 90°.
- M. Limit Plate:** Locks into limit block indents at preset fence angles to set a starting angle prior to precision adjustments.





MACHINE DATA SHEET

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

MODEL G0821 6" X 30" BENCHTOP JOINTER WITH SPIRAL CUTTERHEAD

Product Dimensions:

Weight..... 50 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 36 x 19 x 12-1/2 in.
Footprint (Length x Width)..... 19-1/2 x 11 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 56 lbs.
Length x Width x Height..... 38 x 16 x 13 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 12A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6 ft.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 1.5 HP
Phase..... Single-Phase
Amps..... 12A
Speed..... 20,000 RPM
Type..... Universal
Power Transfer..... Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... N/A

Main Specifications:

Main Specifications

Jointer Size..... 6 in.
Bevel Jointing..... 0 – 45 deg. L/R
Maximum Width of Cut..... 6 in.
Maximum Depth of Cut..... 1/8 in.
Minimum Workpiece Length..... 8 in.
Minimum Workpiece Thickness..... 1/2 in.
Number of Cuts Per Minute..... 24,000



Fence Information

Fence Length..... 22-1/2 in.
Fence Width..... 13/16 in.
Fence Height..... 4-1/4 in.
Fence Stops..... 45, 90, 135 deg.

Cutterhead Information

Cutterhead Type..... Spiral
Cutterhead Diameter..... 1-7/8 in.
Number of Cutter Spirals..... 3
Number of Indexable Cutters..... 18
Cutterhead Speed..... 8000 RPM

Cutter Insert Information

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

Table Information

Table Length..... 30-3/8 in.
Table Width..... 6-1/4 in.
Table Thickness..... 1 in.
Floor to Table Height..... 8-1/4 in.
Table Adjustment Type..... Knob
Table Movement Type..... Swing

Construction

Body Assembly..... Pre-Formed Steel
Fence Assembly..... Extruded Aluminum
Guard..... Aluminum
Table..... Aluminum
Paint Type/Finish..... Powder Coated

Other Information

Number of Dust Ports..... 1
Dust Port Size..... 2-1/2 in.

Other Specifications:

Country of Origin China
Warranty 1 Year
Approximate Assembly & Setup Time 10 Minutes
Serial Number Location ID Label
ISO 9001 Factory Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) Yes

Features:

45, 90, 135-Degree Stops
2-1/2 in. Dust Port
Included Push Blocks
Spiral Cutterhead
Grab Handles for Portability
Aluminum Top with Non-Stick Coating
Built-in Dust Collection System Works Stand-Alone or with Dust Collector/Shop Vacuum



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.



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



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



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

NOTICE

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

Safety Instructions for Machinery



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 Jointers

WARNING

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

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

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

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

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

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

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

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

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

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

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

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

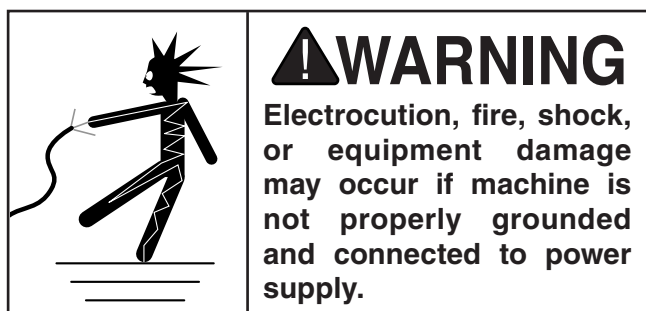
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can be thrown from cutterhead with dangerous force. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than $\frac{1}{8}$ " (0.125") from cutterhead body.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 110V..... 12 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

!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.

110V 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 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps

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.*



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!

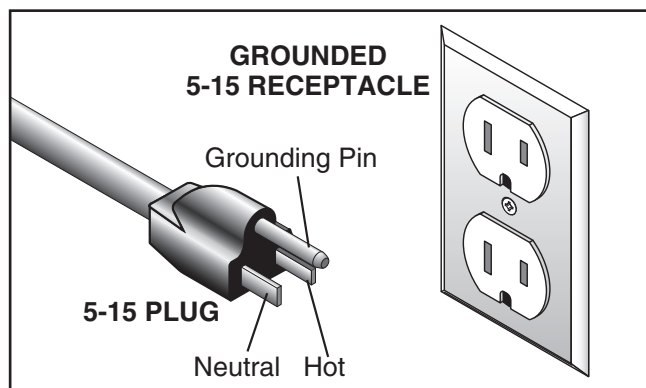
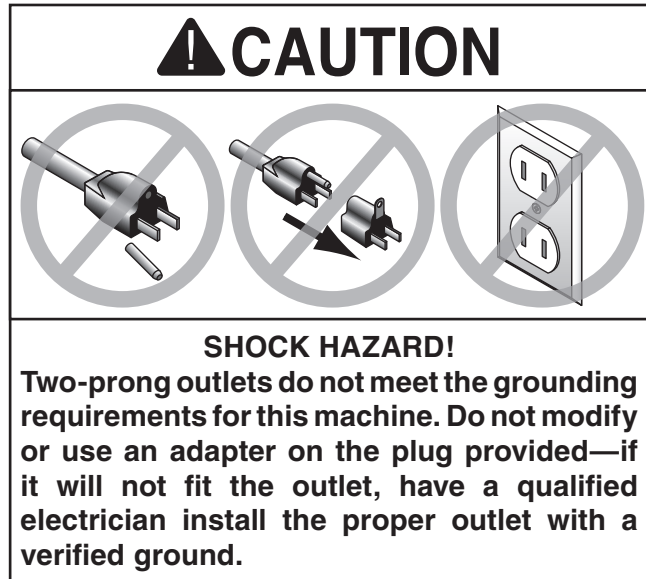


Figure 4. Typical 5-15 plug and receptacle.



! 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.

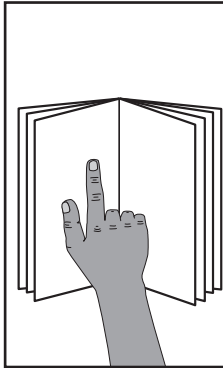
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 Size14 AWG
Maximum Length (Shorter is Better).....50 ft.

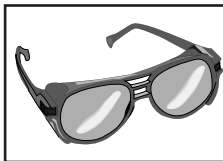


SECTION 3: SETUP



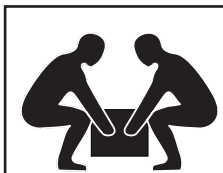
!WARNING

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

This machine and its components are very heavy. Get lifting help if needed.

Needed for Setup

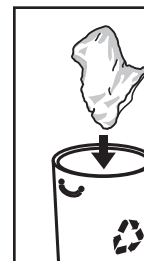
The following are needed to complete the setup process, but are not included with your machine.

| Description | Qty |
|--------------------------------------|-----------|
| • Safety Glasses | 1 |
| • Cleaner/Degreaser | As Needed |
| • Disposable Shop Rags..... | As Needed |
| • Additional People | 1 |
| • Straightedge 2' | 1 |
| • Phillips Head Screwdriver #2 | 1 |
| • Hex Wrench 3mm..... | 1 |
| • Hex Wrench 4mm..... | 1 |
| • Hex Wrench 6mm..... | 1 |

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. *You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.*



!WARNING

SUFFOCATION HAZARD!

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



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.

Jointer Inventory (Figures 5–6)

| | Qty |
|--------------------------------------|-------|
| A. Jointer Bed Assembly..... | 1 |
| B. Fence..... | 1 |
| C. Dust Collection Bag Clamp | 1 |
| D. Dust Chute | 1 |
| E. Dust Collection Bag..... | 1 |
| F. Push Blocks..... | 2 |
| G. Handles | 2 |
| H. Fence Carriage Lock Lever..... | 1 |
| I. Fence Tilt Lock Lever | 1 |
| J. Replacement Inserts (5-Pack)..... | 1 |
| K. Carriage Mounting Bracket..... | 1 |
| L. Carriage Assembly | 1 |
| M. Fence Pivot Assembly..... | 1 |
| N. Limit Block..... | 1 |
| O. Locking Pin Plate..... | 1 |
| P. Hex Wrenches 5, 6mm..... | 1 Ea. |
| Q. T-Handle Torx Wrench T25 | 2 |
| R. Beveled Washers 10 x 3.5mm | 2 |

Fasteners (See Hardware Recognition Chart)

- Cap Screws M6-1 x 20..... 4
- Cap Screws M8-1.25 x 30..... 4
- Cap Screws M8-1.25 x 20..... 2
- Flat Head Torx Screws M5-.8 x 10..... 10
- Flat Washers 6mm..... 4
- Flat Washers 8mm..... 2
- Lock Washers 6mm..... 6
- Lock Washers 8mm..... 2

NOTICE

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

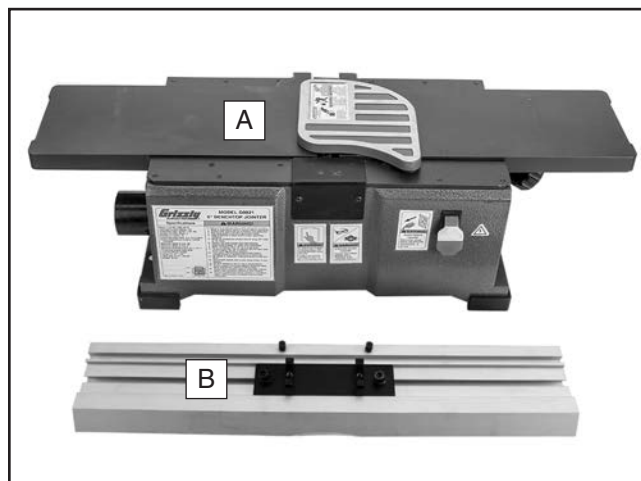


Figure 5. Large components.

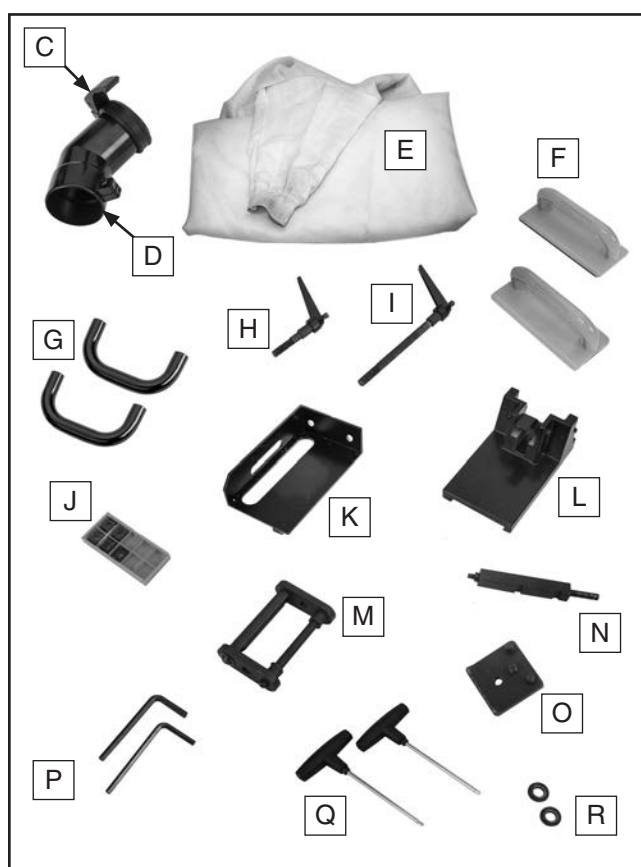
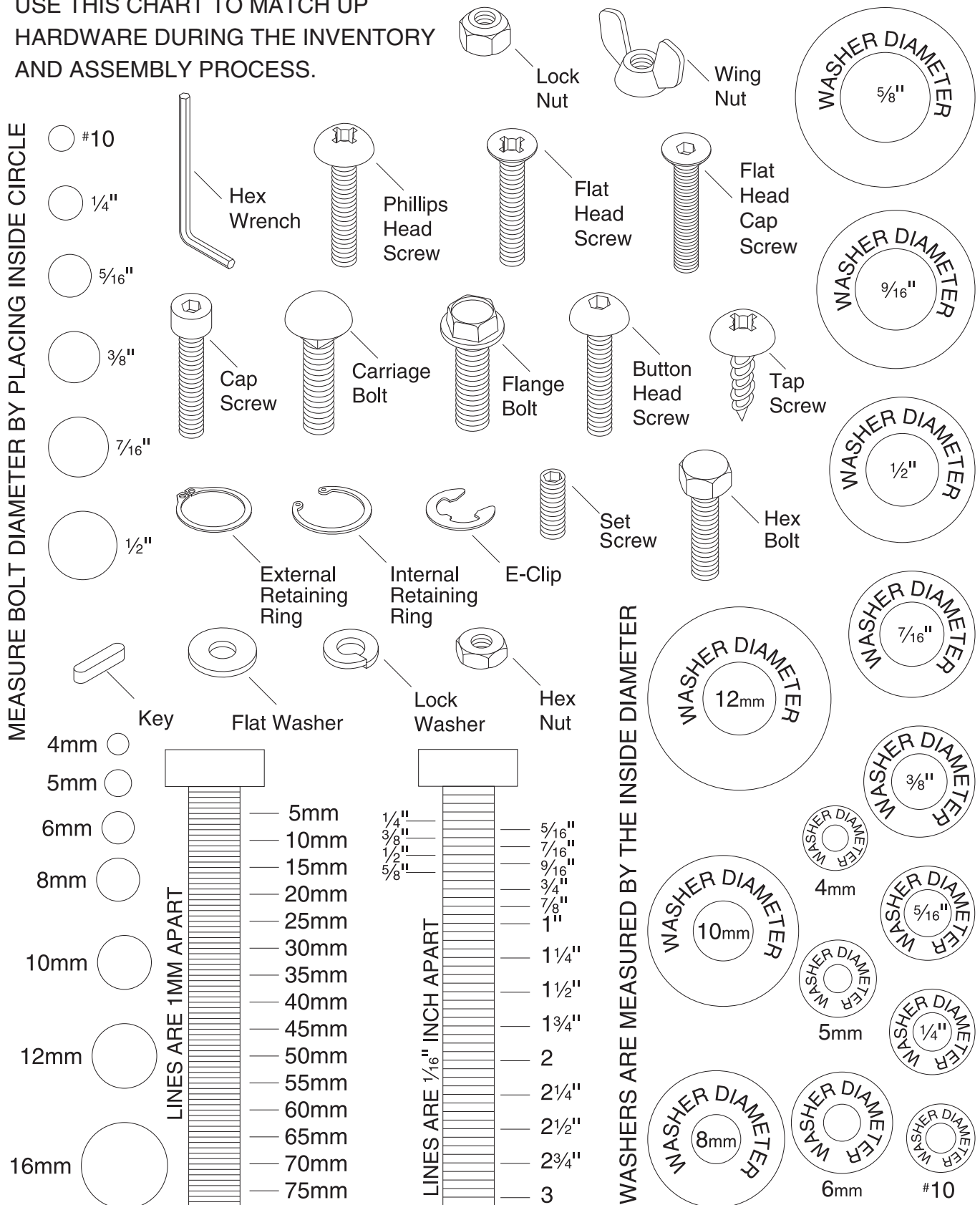


Figure 6. Small components.



Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE INVENTORY
AND ASSEMBLY PROCESS.



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.

NOTICE

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

Site Considerations

Workbench Load

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

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

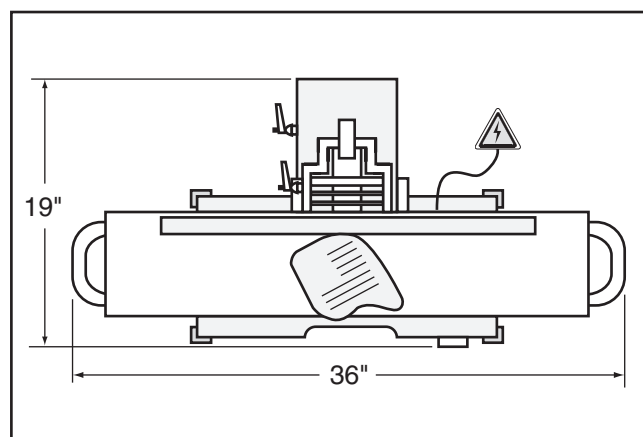
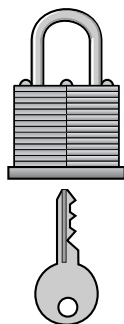


Figure 7. Minimum working clearances.



CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.



Bench Mounting

Number of Mounting Holes 4
Dia. of Mounting Hardware Needed 5/16"

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.

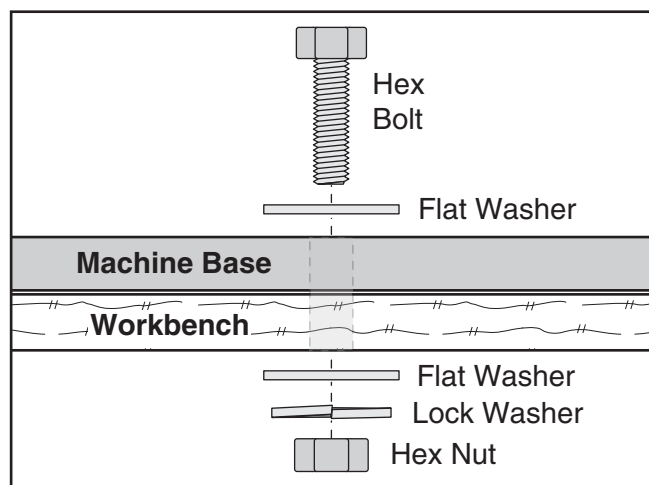


Figure 8. Typical "Through Mount" setup.

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

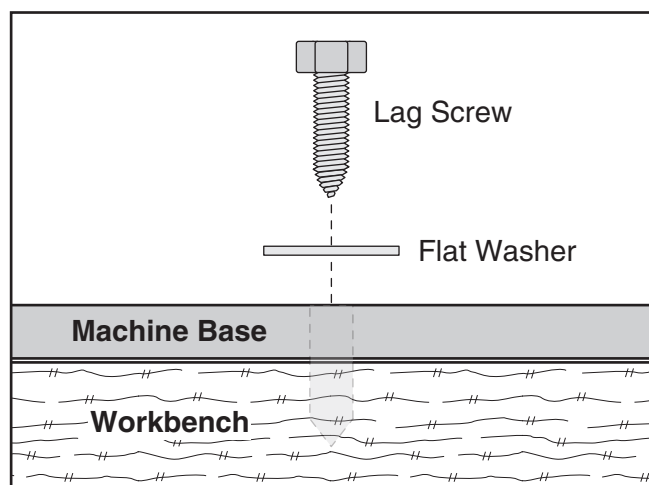


Figure 9. Typical "Direct Mount" setup.



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).

1. Use (2) M8-1.25 x 20 cap screws, (2) 8mm flat washers, and (2) 8mm lock washers to attach carriage support to jointer (see **Figure 10**).

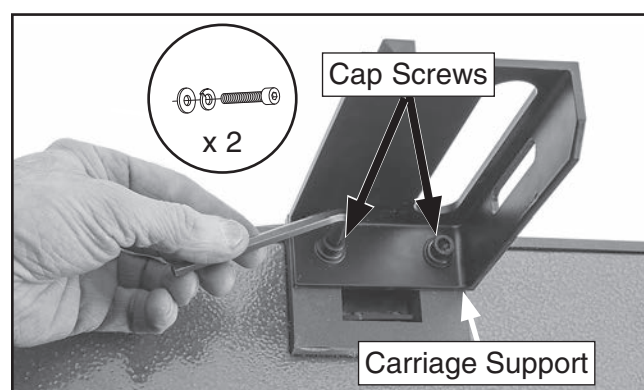


Figure 10. Attaching carriage support to bed assembly.

2. Insert locking plate assembly into carriage support, so locking plate pins are against bottom edge of carriage support (see **Figure 11**). Then attach fence carriage lock lever and 10 x 3.5mm beveled washer to locking plate assembly, as shown in **Figure 12** on **Page 18**).

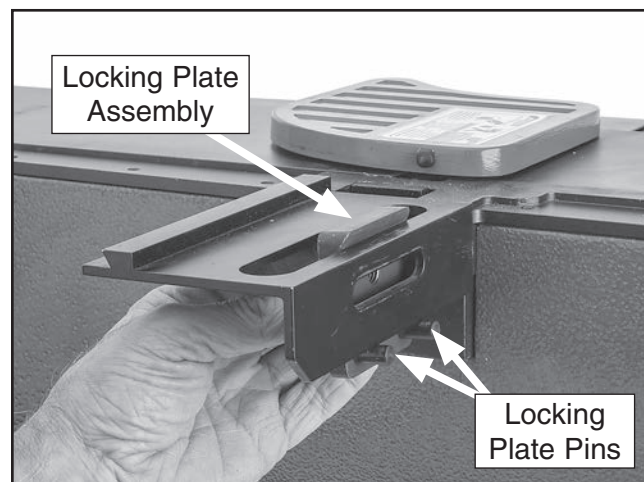


Figure 11. Inserting locking plate assembly.

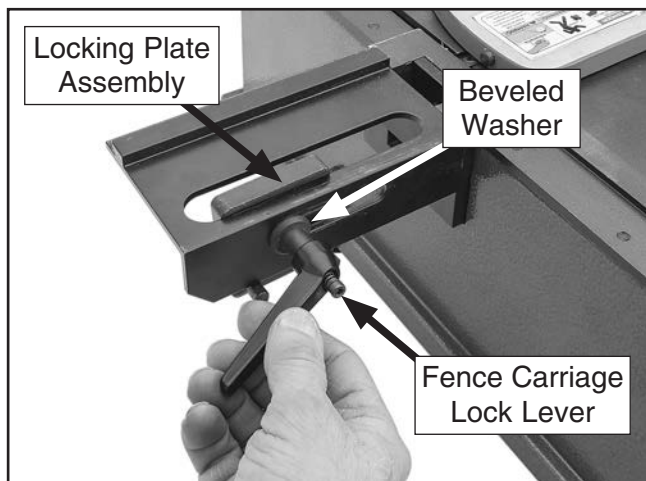


Figure 12. Securing locking plate assembly with fence carriage lock lever and beveled washer.

Note: Do not fully tighten yet.

4. Press down on limit plate tab on carriage assembly, and insert limit block with notched side facing upward (see **Figure 13**).
5. Use (2) M6-1 x 20 cap screws and (2) 6mm lock washers to attach fence to fence bracket assembly (see **Figure 13**).

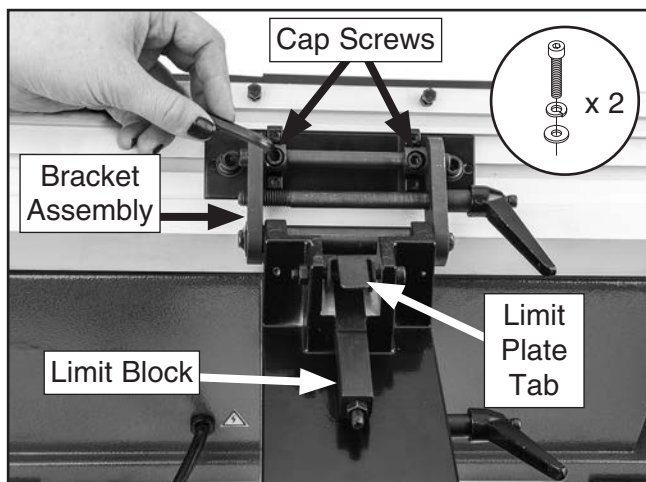


Figure 13. Attaching fence to fence bracket assembly.

6. Slide fence bracket assembly onto support dovetails and locking plate assembly, as shown in **Figure 14**.

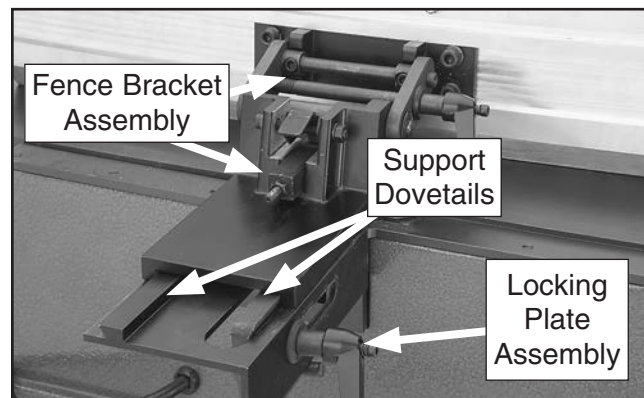


Figure 14. Fence assembly on support dovetails.

7. Install fence tilt lock by threading handle shaft into bracket assembly (see **Figure 15**).

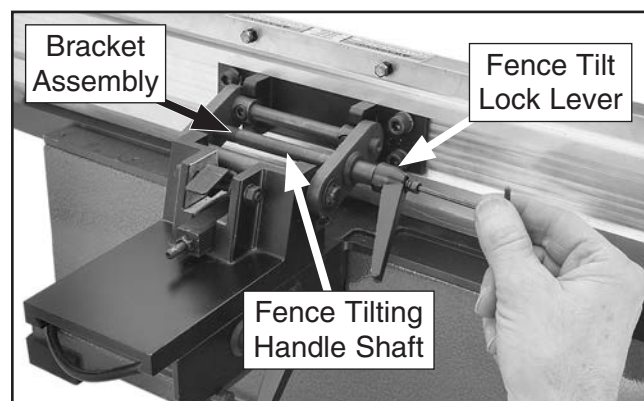


Figure 15. Installing fence tilt lock.

8. Slide fence forward until it contacts cutterhead guard. Cutterhead guard should completely cover cutterhead, as shown in **Figure 16**.

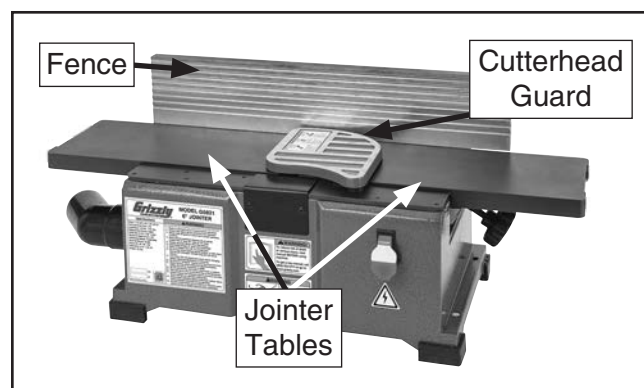


Figure 16. Fence positioned over jointer tables.

9. Tighten fence carriage lock lever to lock fence in place.



10. Use (2) M8-1/25 x 30 cap screws, (2) 6mm lock washers and (2) 6mm flat washers to attach *each* handle to each end of the jointer tables (see **Figure 17**).

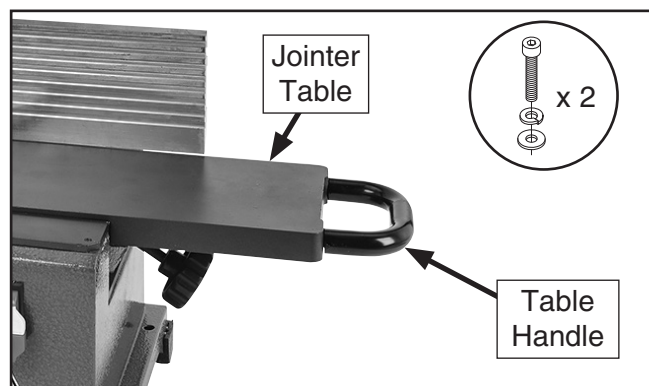


Figure 17. Handle attached to end of table.

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.

Recommended CFM at Dust Port: 250 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 bag:

1. Fit dust collection bag over dust port, as shown in **Figure 18**, and secure with bag clamp.

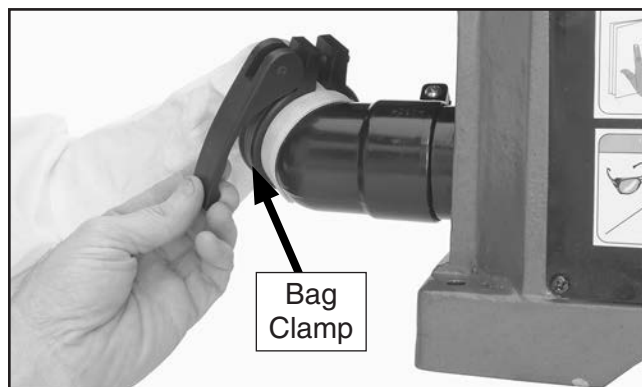


Figure 18. Securing dust collection bag with bag clamp.

2. Tug bag to make sure it does not come off. A tight fit is necessary for proper performance.

Note: *Dust collection bag may be substituted with an appropriately-sized dust collector with 2½" dust collection hose (see above).*



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 verifies safety features stop machine when needed, and that machine operates properly prior to regular operation.

WARNING

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

WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Verify that the machine is operating correctly by turning the machine **ON**.
 - When operating correctly, machine runs smoothly with little or no vibration or rubbing noises.
 - Investigate and correct strange or unusual noises or vibrations before operating machine further. Always disconnect machine from power when investigating or correcting potential problems.

4. Turn machine **OFF**.
5. Remove switch-disabling key, as shown in **Figure 19**.

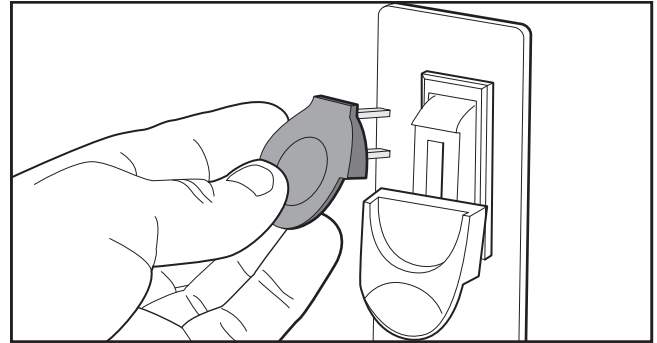


Figure 19. Removing key from paddle switch.

6. Try to start machine with ON/OFF paddle switch.
 - If machine *does not* start, switch disabling feature is working as designed.
 - If machine *does* start, immediately stop machine and disconnect from power. Switch disabling feature is not working correctly. This safety feature *must* work properly before proceeding with regular operations. Call Tech Support for help.

Tightening Drive Belt

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belt will stretch and seat into the pulley grooves. After this time, you must re-tension the belt to avoid slippage and burn-out. Refer to **Page 38** when you are ready to perform this important adjustment.

It's normal for the pulleys and belt to get hot. Allow them to cool before making adjustments.

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

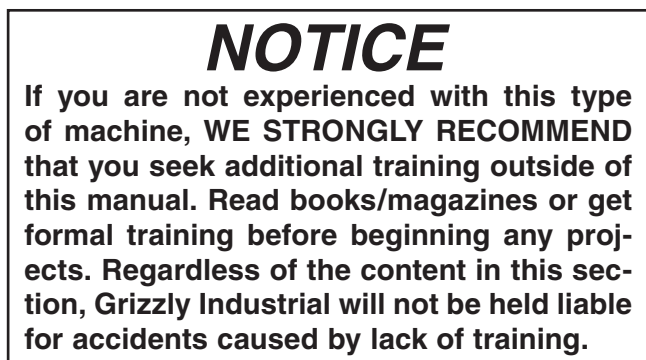
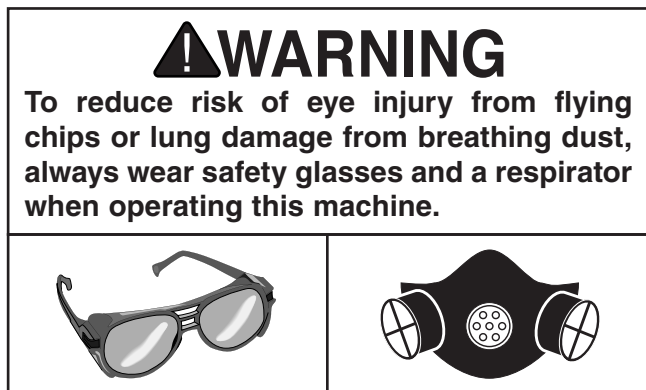


SECTION 4: OPERATIONS

Operation Overview

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

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



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

1. Examines workpiece to verify it is safe and suitable for cutting.
2. Adjusts fence for width of workpiece and locks it in place.
3. Adjusts fence tilt, if necessary.
4. Adjusts infeed table height to set depth of cut per pass.
5. Puts on safety glasses, respirator, and any other required protective equipment.
6. Starts jointer.
7. Using push blocks as needed, holds workpiece firmly against infeed table and fence, and feeds workpiece into cutterhead at a steady and controlled rate until entire length of workpiece has been cut and it clears the cutterhead on the outfeed table side.
8. Repeats cutting process described above until desired results are achieved.
9. Stops jointer.



Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

- **DO NOT joint or surface plane stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.
- **Jointing and surface planing with the grain is safer for the operator and produces a better finish.** Cutting against the grain increases the likelihood of kickback and workpiece tear-out. DO NOT cut against the grain! Cutting with the grain is feeding the stock across the cutterhead so the grain points down and back, as viewed from the front edge of the stock (see **Figure 20**).

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

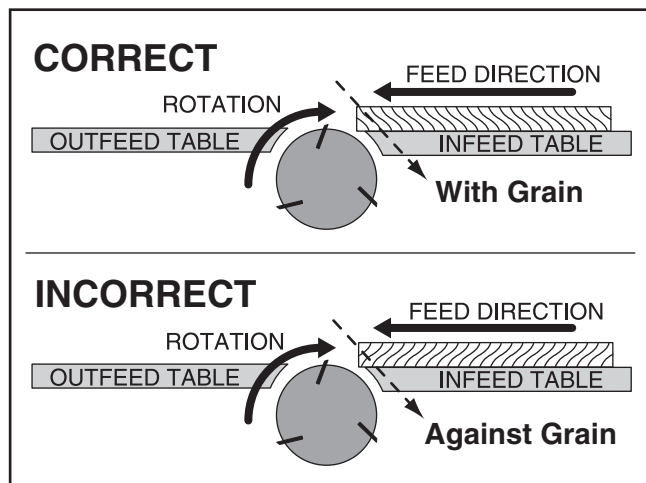


Figure 20. Proper grain alignment with the cutterhead.

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

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

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

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.
- **Make sure your workpiece exceeds the minimum dimension requirements, as shown in Figure 21, before processing it through the jointer, or the workpiece may break or kickback during the operation.**

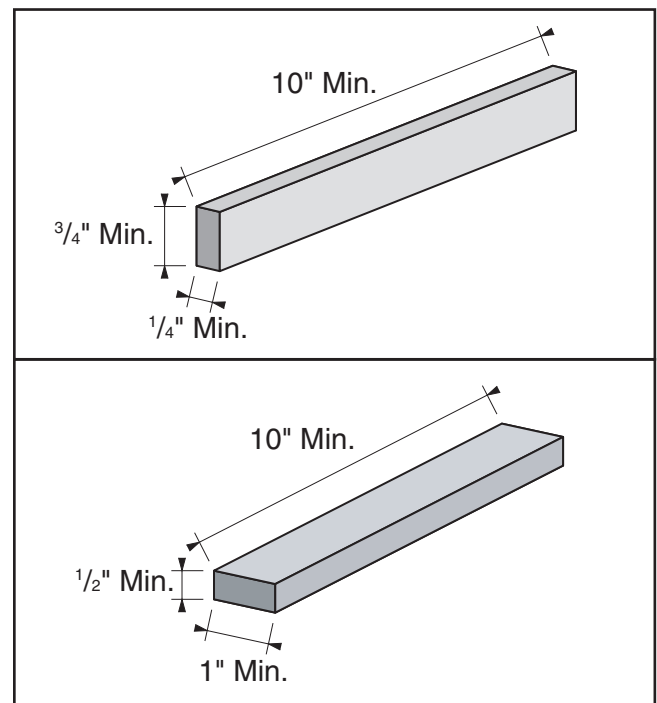


Figure 21. Minimum stock dimensions for jointer.



Setting Depth of Cut

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

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

| Tools Needed | Qty |
|----------------------------------|-----|
| Precision Straightedge 24" | 1 |
| Hex Wrench 3mm..... | 1 |
| Open-End Wrench 10mm..... | 1 |

Adjusting Infeed Table Height

To adjust infeed table height, rotate the infeed table adjustment knob to raise or lower the table (see **Figure 22**).

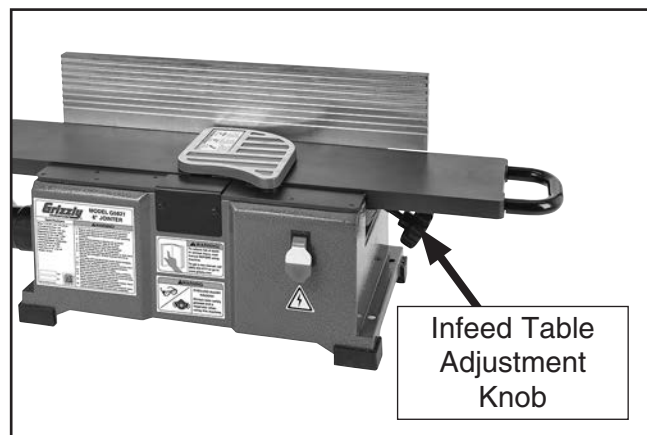


Figure 22. Location of infeed table adjustment knob.

Adjusting Zero Stop

The zero stop (see **Figure 23**) allows the operator to consistently bring the infeed table even with the outfeed table height.

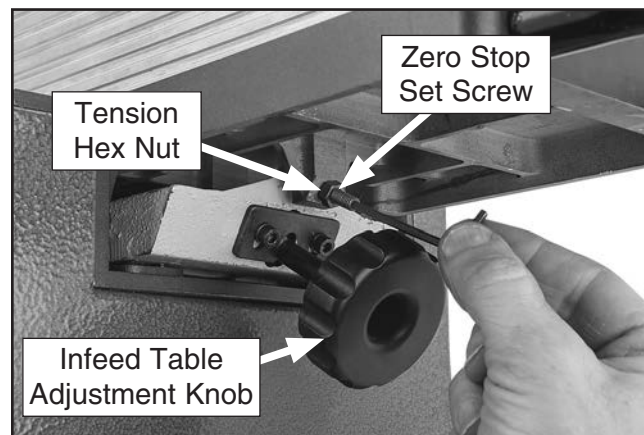


Figure 23. Zero stop components.

To set zero stop:

1. Place a straightedge on top of outfeed table and use infeed table adjustment knob to raise or lower table until table contact is even along straightedge.

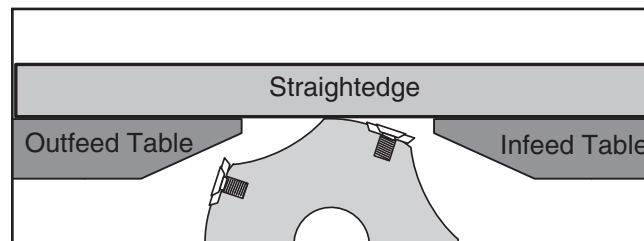


Figure 24. Checking table parallelism.

2. Loosen tension hex nut, and adjust zero stop set screw until it contacts table base (see **Figure 23**).
3. Tighten tension hex nut to secure height setting.



Setting Fence Stops

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

| Tools Needed | Qty |
|---------------------------|-----|
| 45° Square | 1 |
| 90° Square | 1 |
| Sliding Bevel..... | 1 |
| Open-End Wrench 10mm..... | 1 |
| Hex Wrench 6mm..... | 1 |

Setting 90° Fence Stop

1. DISCONNECT MACHINE FROM POWER!
2. Loosen fence tilt lock (see **Figure 25**), and press limit plate tab forward into limit block rear slot.

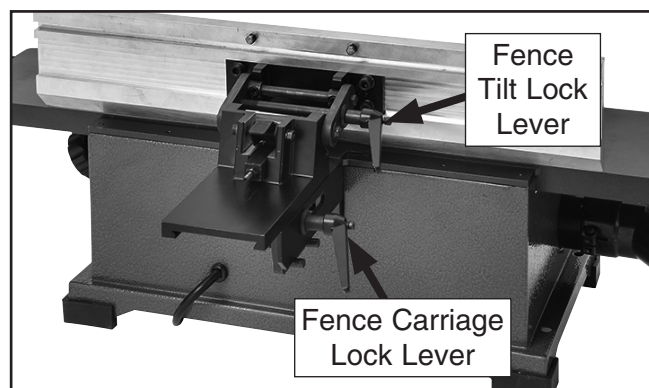


Figure 25. Fence carriage overview.

3. Use a 90° square to adjust fence to 90° (see **Figure 26**), then tighten fence tilt lock.

Note: Fence should stop at 90° when it contacts limit block shaft.

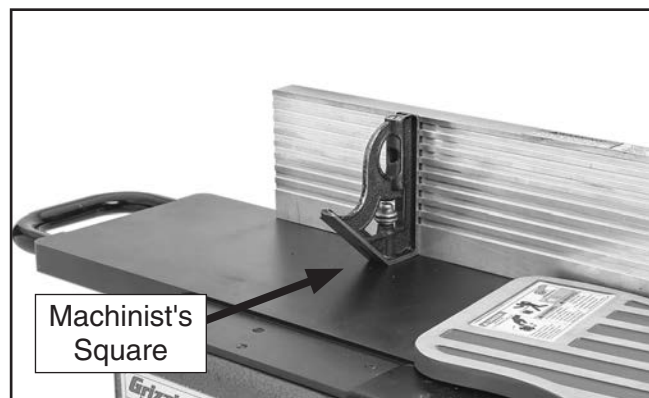


Figure 26. Checking the 90° stop.

— If fence *does not* stop at 90° when it contacts limit block shaft, 90° stop is not adjusted correctly. Proceed to **Steps 6–9**.

4. Bring fence to 90°, then loosen jam nut located on rear of limit block shaft (see **Figure 27**)

Note: Keep limit plate in limit block rear slot while making adjustments (see **Figure 27**).

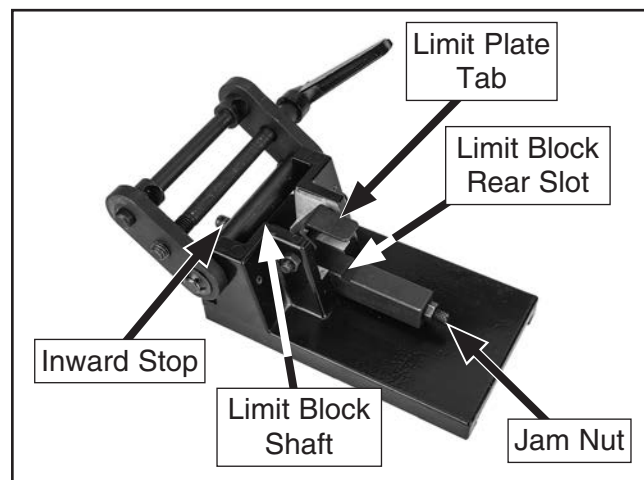


Figure 27. Fence stop parts identification.

5. Turn limit block shaft by hand until it contacts fence.
6. Re-tighten jam nut. The 90° stop is now set precisely.

Setting 45° Fence Stop

1. DISCONNECT MACHINE FROM POWER!
2. Use a 45° square to adjust fence to 45° position, as shown in **Figure 28**.



Figure 28. Checking 45° fence stop.



- Loosen fence tilt lock, and release fence from 90° limit block stop.
- Tip fence towards table as far as it will go, ensuring limit plate stays in limit block rear slot, then tighten fence tilt lock.

Note: When fence tilts towards table, it will stop when it contacts inward stop (see **Figure 27**).

- Remove limit block from fence bracket assembly and set it aside (see **Figure 29**).

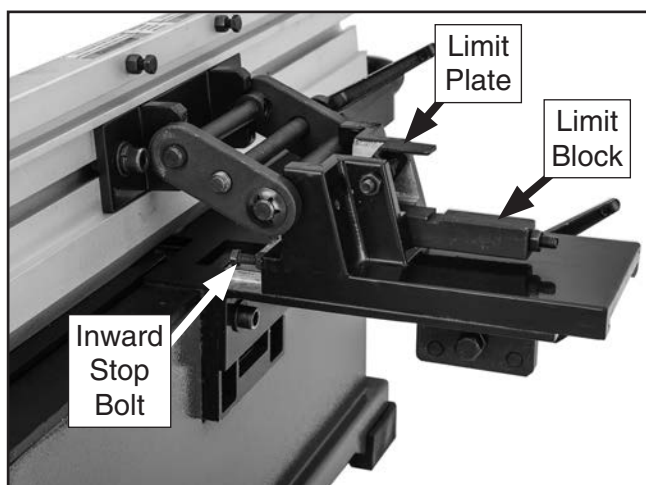


Figure 29. Adjusting the inward stop.

- Adjust inward stop bolt (see **Figure 29**) until it contacts fence face at precisely 45° inward, then tighten jam nut (where bolt meets bracket assembly) while holding stop bolt in place. Replace limit block and set limit plate.

Setting 135° Fence Stop

- DISCONNECT MACHINE FROM POWER!
- Loosen fence tilt lock, remove limit block and set it aside.

Note: You may need to move fence carriage toward front of machine slightly to avoid bottom of fence catching on edge of table.

- Tip fence back (away from table) until it stops.

Note: Fence will stop when outward stop bolt contacts fence bracket.

- Use a machinist's combination square to check fence angle, as shown in **Figure 30**.

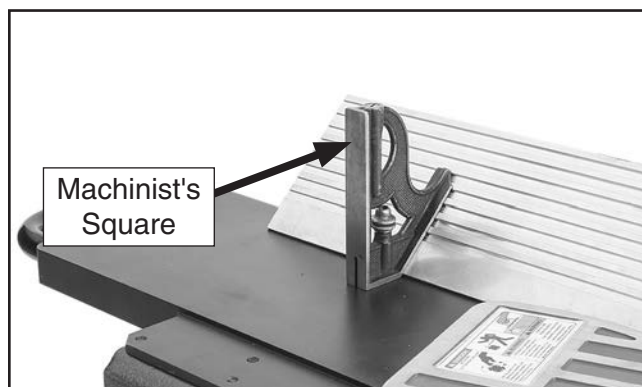


Figure 30. Checking 45° outward (135°) stop.

— If fence tilts away from table at 135°, outward stop is set correctly. Put limit block back, bring fence to 90° and tighten fence tilt lock.

— If fence is *not* tilting away from table at 135°, do **Steps 5–6** to set outward stop correctly.

- With outward stop bolt resting against fence bracket, adjust length of stop bolt until fence is at 45°, then tighten jam nut (see **Figure 31**).

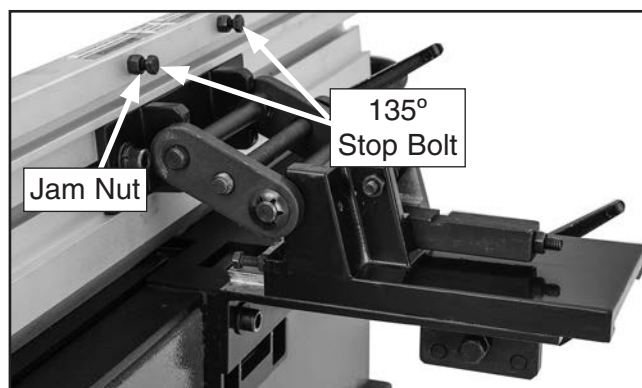


Figure 31. 135° fence stop detail.

- Put limit block back, position fence at 90°, and tighten fence tilt lock.

NOTICE

Check accuracy of each setting frequently with a machinist's combination square and re-adjust as necessary.



Rotating/Changing Cutterhead Inserts

The spiral cutterhead is equipped with 4-sided indexable carbide inserts. Each insert can be removed, rotated, and re-installed to use any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° (as shown below) to use a sharp cutting edge.

The inserts have a reference dot on one corner. The position of the reference dot on installed inserts can be used to track which edges are sharp/unused and which edges are dull or damaged. Replace inserts once the reference dot has been rotated back to its original position.

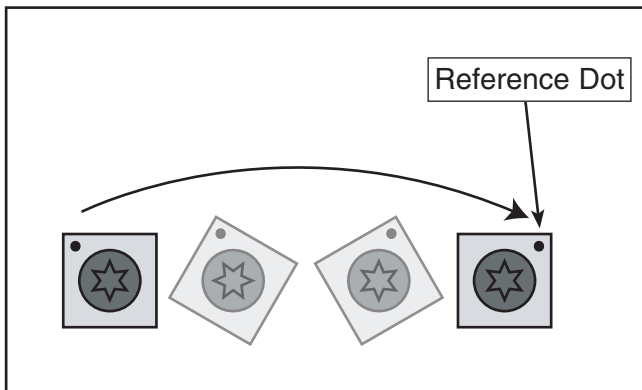


Figure 32. Insert rotating sequence.

| Tools Needed | Qty |
|-------------------------------|-----|
| Phillips Screwdriver #2 | 1 |
| Torque Wrench | 1 |
| Torx Bit T-25 | 1 |
| Precision Straightedge | 1 |

To rotate or replace spiral cutterhead insert:

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

5. Put on heavy leather gloves to protect fingers and hands.
6. Remove any sawdust or debris from head of insert, Torx screw, and surrounding area (see **Figure 33**).

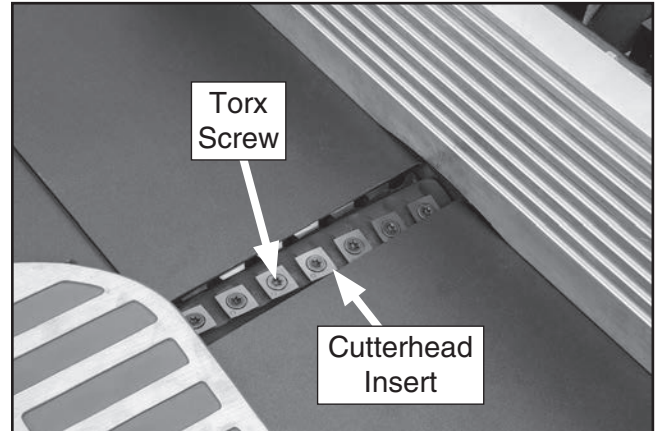


Figure 33. Location of cutterhead inserts and Torx screws.

7. Remove Torx screw and insert, then carefully clean away all dust and debris from insert and insert pocket in cutterhead.

IMPORTANT: This step is critical for achieving a smooth finish with cutting operations. Dirt or dust trapped under insert during installation will slightly raise insert in cutterhead, which will leave marks on workpiece after jointing.

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

8. Re-install insert with a sharp cutting edge facing outward. Make sure insert is properly seated in cutterhead pocket before securing.

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

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

IMPORTANT: If too much oil is applied to the threads, excess will attempt to squeeze out of threaded hole as you install insert and force it



Squaring Stock

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

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

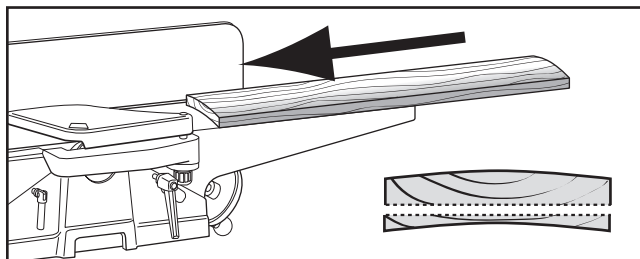
A properly "squared up" workpiece is essential for tasks such as accurate tablesaw cuts, glue-ups/laminations, cutting accurate bevels on a bandsaw, and many other applications where one surface of a workpiece is used to reference another.

Tools Needed

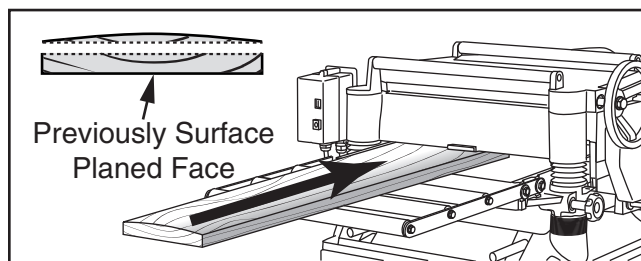
| | Qty |
|----------------|-----|
| Jointer | 1 |
| Planer | 1 |
| Tablesaw | 1 |

Squaring stock involves four steps performed in the order below:

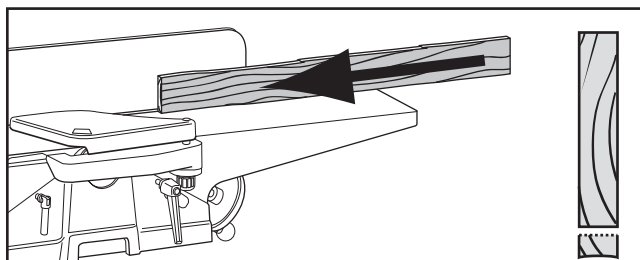
1. Surface Plane on the Jointer—The concave face of the workpiece is surface planed flat with the jointer.



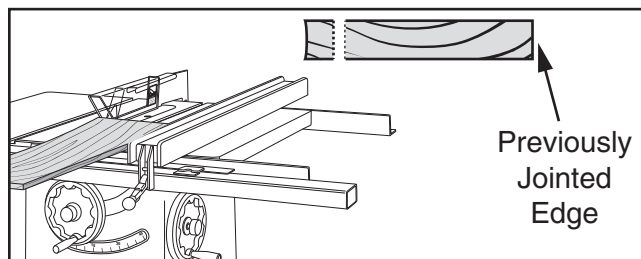
2. Surface Plane on a Thickness Planer—The opposite face of the workpiece is surface planed flat with a thickness planer.



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



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



Surface Planing

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

NOTICE

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



Figure 34. Example of surface planing operations.

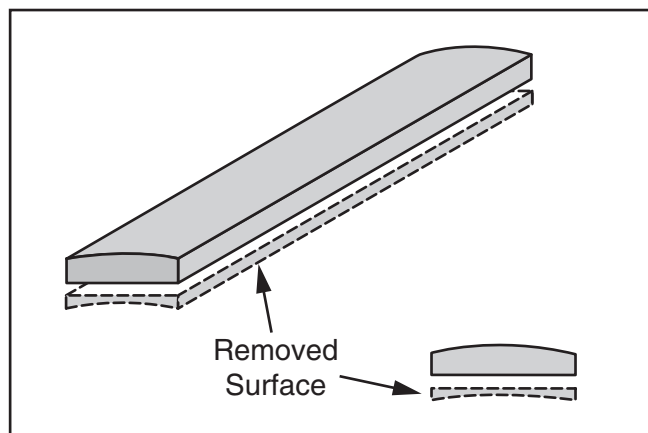


Figure 35. Illustration of surface planing results.

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Set infeed table height to desired cutting depth for each pass.

⚠ CAUTION: To minimize risk of kickback, do not exceed a cutting depth of $\frac{1}{16}$ " per pass when surface planing.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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

⚠ WARNING

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



Edge Jointing

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

NOTICE

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

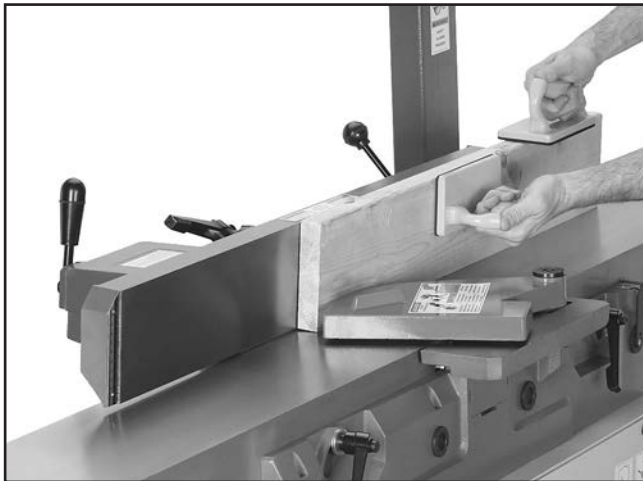


Figure 36. Example of edge jointing operation.

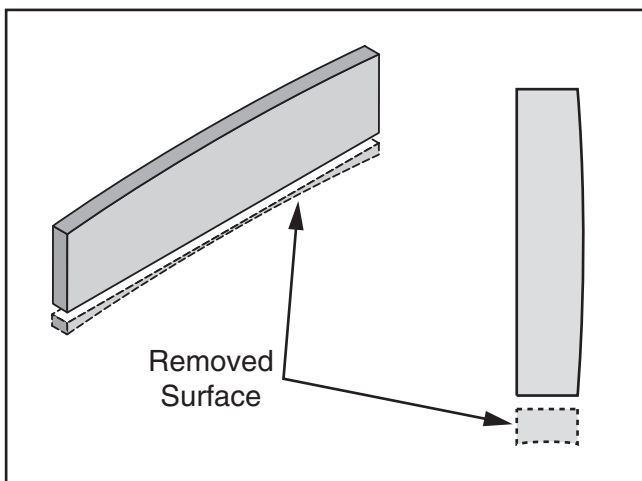


Figure 37. Illustration of edge jointing results.

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Set infeed table height to desired cutting depth for each pass.

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

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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



Bevel Cutting

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

NOTICE

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

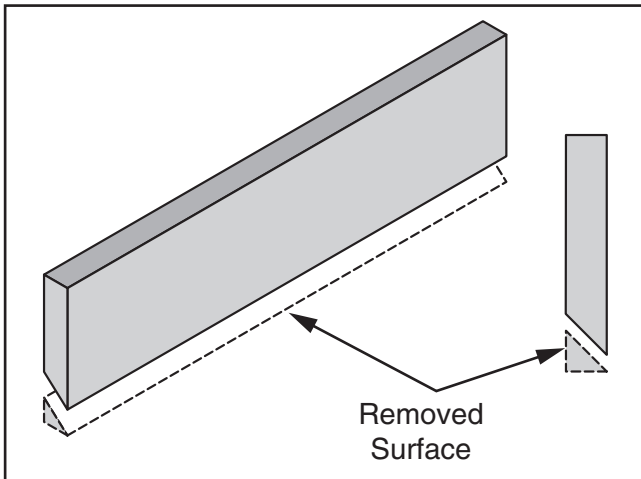


Figure 38. Illustration of bevel cutting results.



Figure 39. Example of fence setup for a bevel cut of 45°.

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Set infeed table height to cutting depth desired for each pass.

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

3. Set fence tilt to desired angle of cut.

4. Place workpiece against fence and infeed table with concave side face down.

5. Start jointer.

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

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

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



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.

T24736—Carbide Replacement Inserts

Solid Carbide Indexable Inserts for G0821.
Size: 15 x 15 x 2.5mm (10 pack).

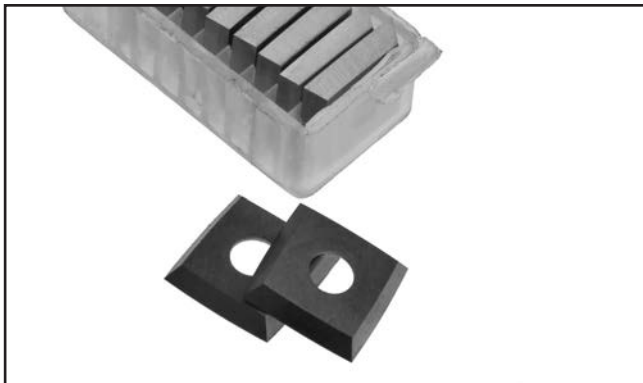


Figure 40. Replacement inserts for G0821.

G5725—3-Pc. Combination Bevel/Square

This cast-iron Combination Bevel/Square features center heads, and a 12" blade with graduations down to $\frac{1}{64}$ ". Square head features spirit level and hardened scribe. Comes with a protective plastic case.

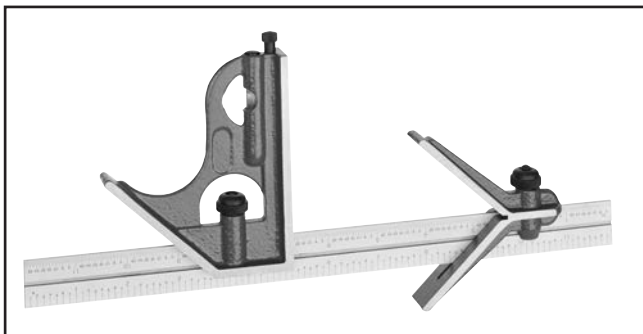


Figure 41. G5725 Combination Bevel/Square.

G9643—8" Precision Straightedge G9644—12" Precision Straightedge H2675—16" Precision Straightedge

These Grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.



Figure 42. Precision straightedges.

H7828—Shop Fox Tool Table Plus

The Tool Table Plus was designed to answer customer requests for a slightly wider and taller table than our G7313 to accommodate a variety of benchtop machines.



Figure 43. H7828 Shop Fox Tool Table Plus.



Basic Eye Protection

T20501—Face Shield Crown Protector 4"

T20502—Face Shield Crown Protector 7"

T20503—Face Shield Window

T20451—"Kirova" Clear Safety Glasses

T20452—"Kirova" Anti-Reflective S. Glasses

H7194—Bifocal Safety Glasses 1.5

H7195—Bifocal Safety Glasses 2.0

H7196—Bifocal Safety Glasses 2.5



Figure 44. Assortment of basic eye protection.

G1163P—1 HP Light-Duty Dust Collector

Effective dust collection not only keeps your shop cleaner and more pleasant to work in, but it can also protect your health by reducing your overall exposure to dust. Its small size and low profile make this a perfect point-of-use, dedicated dust collector.



Figure 45. G1163P 1 HP Dust Collector.

T23246—The Missing Shop Manual: Jointer

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

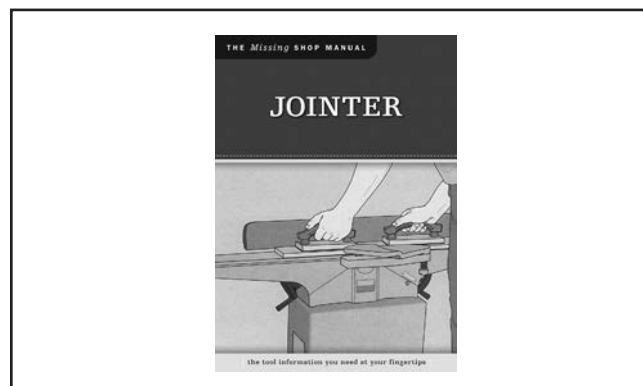


Figure 46. Instructional reference book.

W1314—Wire Hose Clamp 2½"

W1317—Wire Hose Clamp 4"

W1044—Dust Collection Adapter 2½" x 4"

W1053—Anti-Static Grounding Kit

W2046—Shop Vacuum Adapter 2½" x 2½"

We've hand picked a selection of dust collection components commonly needed to connect the Model G0821 to basic machinery.



Figure 47. Dust collection accessories.



G0832—13" Benchtop Planer w/Built-In Dust Collection

This 13" Benchtop Series Planer comes equipped with a cut depth indicator that instantly measures the depth of cut for each pass up to 1/8", an adjustable cutterhead depth stop for repeat planing operations, and a built-in, see-through chip blower. Add to that the convenient grab handles on the sides of the machine and you've got the ultimate in both precision and portability for your home shop or jobsite.



Figure 48. G0832 13" Benchtop Planer.

T10456—Heavy-Duty Anti-Fatigue Mat 3' x 5'

This Heavy-Duty Anti-Fatigue Mat features beveled edges and no-slip tread for safety and comfort. Open-hole design allows liquid to drain through, so it's perfect for wet or oily conditions. Measures 3' wide x 5' long x 3/8" thick.

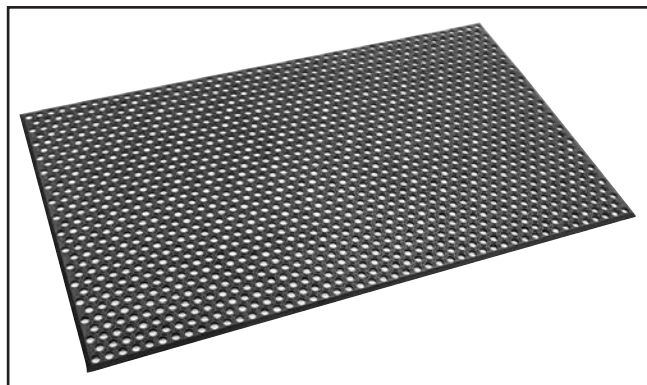


Figure 49. Model T10456 Anti-Fatigue Mat.

T24354—6" Digital Caliper with 6" Digital Micrometer Set

This high-precision electronic Outside Micrometer features a crisp, clear, easy-to-read LCD display, and is accurate to 0.001". Hardened and ground spindle with carbide anvil ensures durability and accuracy.



Figure 50. Model T24354 6" Digital Caliper with 1" Digital Micrometer Set.

G8983—Tilting Roller Stand

Adjusts from 26" to 44", 0°-45°. 150 lb. capacity.

G8984—Single Roller Stand

Adjusts from 26 5/8" to 45". 250 lb. capacity.

G8985—5 Roller Stand

Adjusts from 26" to 44 5/8". 250 lb. capacity.

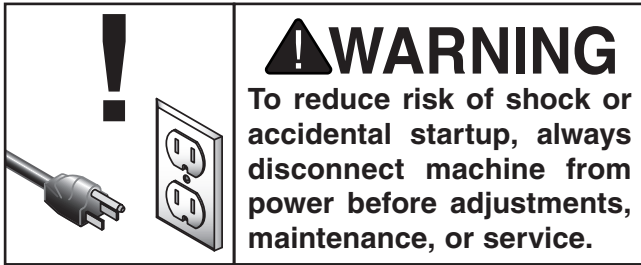
These super heavy-duty roller stands feature convenient hand knobs for fast height adjustment.



Figure 51. Shop Fox® Roller Stands.



SECTION 6: MAINTENANCE



Schedule

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

Daily

- Vacuum all dust on and around the machine.
- Empty debris from the dust collection bag. DO NOT use the jointer if debris obstructs the flow of material into the bag. Using the jointer when the chute is obstructed can lead to jointer malfunction and, possibly, fire. Failure to heed this warning can result in serious personal injury.
- Wipe down the tables and all other unpainted cast iron with a metal protectant.
- Check/repair for worn or damaged wires (**Page 43**).
- Check/replace damaged cutterhead or inserts (**Page 26**).
- Check/retighten loose mounting bolts.
- Check/resolve any other unsafe condition.

Monthly

- Check belt for proper tension, damage, or wear (**Page 38**).
- Clean/vacuum dust buildup from inside stand and off of motor.

Cleaning & Protecting

Cleaning the Model G0821 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast-iron 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 (see below for more details).

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 52. Recommended products for protecting unpainted cast iron/steel.



Lubrication

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

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move.

Clean the components below with mineral spirits and shop rags.

Leadscrew

Lubricate with light machine oil as needed (see **Figure 53**). Wipe off excess oil and sawdust with a cloth.

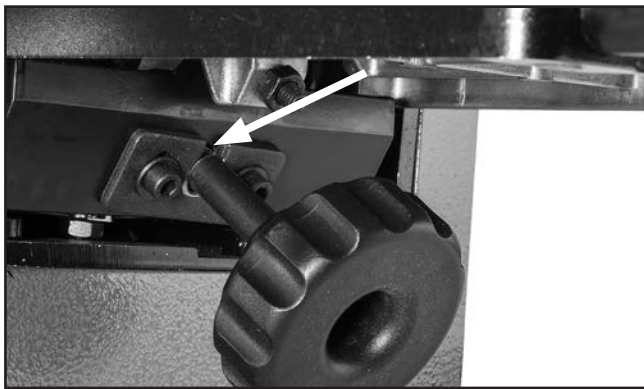


Figure 53. Leadscrew lubrication location.

Fence

Place one or two drops of light machine oil on fence pivot points (see **Figure 54**) as needed.

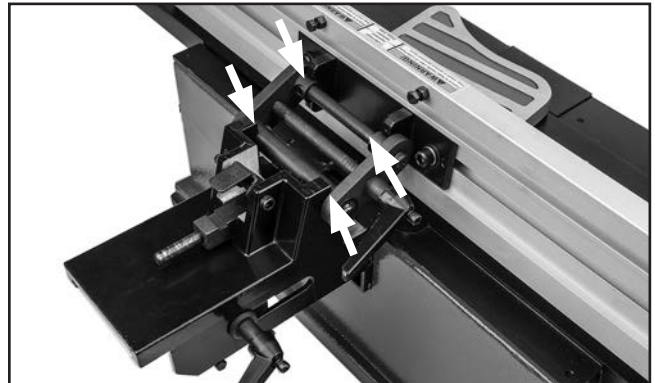


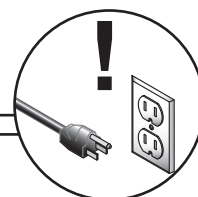
Figure 54. Fence lubrication locations.



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 immediately after startup. | <ol style="list-style-type: none"> 1. Switch disabling key removed from ON/OFF switch. 2. Power supply circuit breaker tripped/fuse blown. 3. Loose, broken, or disconnected wires. 4. Motor brushes worn or at fault. 5. Motor ON/OFF switch at fault. 6. Motor at fault. | <ol style="list-style-type: none"> 1. Replace switch disabling key. 2. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 3. Check/fix broken, disconnected, or corroded wires. 4. Remove/replace brushes. 5. Replace ON/OFF switch. 6. Test/repair/replace. |
| Machine stalls or is underpowered. | <ol style="list-style-type: none"> 1. Improper workpiece material. 2. Excessive feed rate. 3. Excessive depth of cut. 4. Dull inserts. 5. Dust collection problem. 6. Motor brushes are at fault. 7. Belt slipping; oil/grease on belt. 8. Pulley loose or not properly aligned. 9. Motor overheated. 10. Motor is at fault. | <ol style="list-style-type: none"> 1. Ensure workpiece is okay for jointing (Page 22). 2. Reduce feed rate. 3. Reduce depth of cut. 4. Rotate/replace inserts (Page 26). 5. Clear blockages; move machine closer to dust collector; upgrade dust collector. 6. Remove/replace brushes (Page 41). 7. Tension/replace belt (Page 38); clean belt. 8. Re-align pulleys; replace shaft key; tighten pulley set screw. 9. Clean motor, let cool, and reduce workload. 10. Test/repair/replace. |
| Machine has vibration or noisy operation. | <ol style="list-style-type: none"> 1. Motor or component is loose. 2. Belts worn or loose. 3. Pulley loose or not properly aligned. 4. Motor fan is rubbing on fan cover. 5. Loose mounting bolts. 6. Cutterhead bearings at fault. | <ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread-locking fluid. 2. Inspect/replace belts with new ones. 3. Re-align pulleys; replace shaft key; tighten pulley set screw. 4. Replace dented fan cover; replace loose/damaged fan. 5. Tighten/replace as required. 6. Replace bearing(s)/re-align cutterhead. |



Operations

| Symptom | Possible Cause | Possible Solution |
|--|--|---|
| Infeed table is hard to adjust. | 1. Sawdust, wood chips, or pitch/resin built up on table leadscrew or moving parts. | 1. Clean and lubricate infeed table leadscrew (Page 35). |
| Excessive snipe (gouge in end of board that is uneven with rest of cut). | 1. Outfeed table is out of alignment with cutterhead. 2. Operator is pushing down on trailing edge of the workpiece. | 1. Align cutterhead with outfeed table. 2. Reduce/eliminate downward pressure on that end of the workpiece. |
| Workpiece stops in middle of cut. | 1. Outfeed table is set lower than cutterhead. | 1. Align cutterhead inserts with outfeed table at top dead center. |
| Workpiece chipping, tear-out, indentations, or overall rough cuts. | 1. Not feeding workpiece to cut "with" the grain. 2. Dull inserts. 3. Workpiece not okay for jointing. 4. Nicked or chipped inserts. 5. Feeding workpiece too fast. 6. Excessive depth of cut. 7. Lack of proper dust collection or clogged dust port. | 1. Rotate workpiece 180° before feeding again. 2. Rotate/replace insert(s) (Page 26). 3. Ensure workpiece is okay for jointing (Page 22). 4. Rotate/replace insert(s) (Page 26). 5. Reduce feed rate. 6. Reduce depth of cut. 7. Clear blockages, ensure dust collection is operating efficiently; upgrade dust collector. |
| Fuzzy grain left in workpiece. | 1. Wood has high moisture content. 2. Dull inserts. | 1. Ensure wood moisture content is less than 20%. Allow to dry if necessary. 2. Replace/rotate inserts (Page 26). |
| Long lines or ridges that run along the length of the board. | 1. Nicked or chipped inserts. 2. Loose or incorrectly installed insert(s). 3. Dirt or debris under carbide inserts. | 1. Replace/rotate inserts (Page 26). 2. Remove/replace insert(s) and install properly (Page 26). 3. Remove inserts, properly clean mounting pockets and re-install. |
| Uneven cutter marks, wavy surface, or chatter marks across face of workpiece. | 1. Feeding workpiece too fast. 2. Inserts not adjusted at even heights in the cutterhead. 3. Dirt or debris under carbide inserts. | 1. Reduce feed rate. 2. Remove, clean, and re-install any inserts that are "raised" in the cutterhead (Page 26). 3. Remove inserts, properly clean mounting pockets, and re-install. |
| Glossy surface; scorching or burn marks on workpiece. | 1. Dull inserts. 2. Feed rate too slow. | 1. Rotate/replace insert(s) (Page 26). 2. Increase feed rate. |
| Workpiece is concave or convex along its length after jointing. | 1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes. | 1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take extra passes to achieve a correct edge, depending on starting condition of board and depth of cut. |
| Overall, cut quality is poor; inconsistent snipe problems; or consistent difficulty feeding workpiece. | 1. Debris under inserts. 2. Outfeed table height is not even with cutterhead. 3. Fence stops are set incorrectly. 4. Fence bracket parts are loose or parts are misaligned. | 1. Remove inserts, properly clean mounting pockets, and re-install. 2. Reset inserts to correct height and alignment with cutterhead assembly. 3. Recalibrate fence stops (Page 24). 4. Check/tighten fence bracket fasteners. |



Tensioning/ Replacing Belts

The G0821 uses belts to drive the cutterhead and the dust collection fan. When these belts are mis-aligned, damaged, or not tensioned correctly, the jointer will not function properly.

This sub-section describes how to service these belts. You can order replacement belts from Grizzly. The part number for the drive belt is **P0821072**; the part number for the fan belt is **P0821091**.

| Tools Needed | Qty |
|------------------------------------|-----|
| Phillips Head Screwdriver #2 | 1 |
| Hex Wrench 6mm..... | 1 |

To re-align or replace cutterhead belt:

1. DISCONNECT MACHINE FROM POWER!
2. While facing front of jointer, tip machine body away from you until fence stop bolts gently rest on fence carriage assembly.
3. Remove Phillips head screws securing motor cover to jointer base. Lift cover off and set it aside.
4. Remove all dust and debris from inside motor and belt areas.
5. Inspect cutterhead belt for proper tension, alignment, and condition.

Note: Belt is properly tensioned if it deflects no more than 1/4" when you press down on middle of belt with moderate pressure from your thumb or forefinger.

6. To release belt tension, loosen the four motor mounting cap screws (see **Figure 55**), but do not remove them.

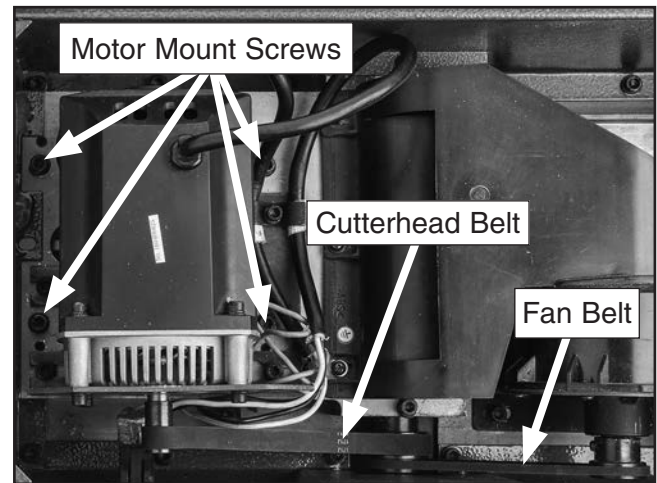


Figure 55. Motor mounting screws and belt locations (cover removed).

7. Replace a damaged belt with a new one.
8. Re-align and re-tension belt (see **Figure 56**) by tightening four motor mounting cap screws (see **Figure 55**). Adjust belt tension to allow approximately 1/4" deflection between pulleys.

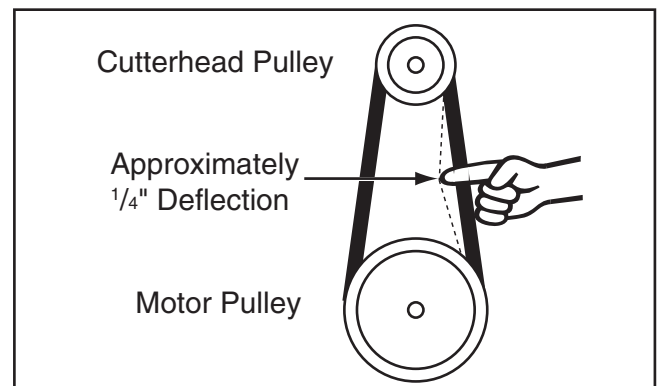


Figure 56. Correct belt deflection when properly tensioned.

9. Replace motor cover and set jointer upright.
10. Test run jointer. Repeat belt installation procedure if necessary.



To replace fan belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove motor cover and check belt for damage.
— If belt shows no wear or damage, proceed to **Step 4**.
3. Loosen (2) cap screws from fan mount. DO NOT remove screws!
4. Shift fan assembly to remove fan belt. Put one end of new belt on fan pulley, then fit other end onto the drive pulley.

Note: If belt is misaligned, the jointer needs to be serviced by a qualified technician. Call our Tech Support.

5. Re-install motor cover.

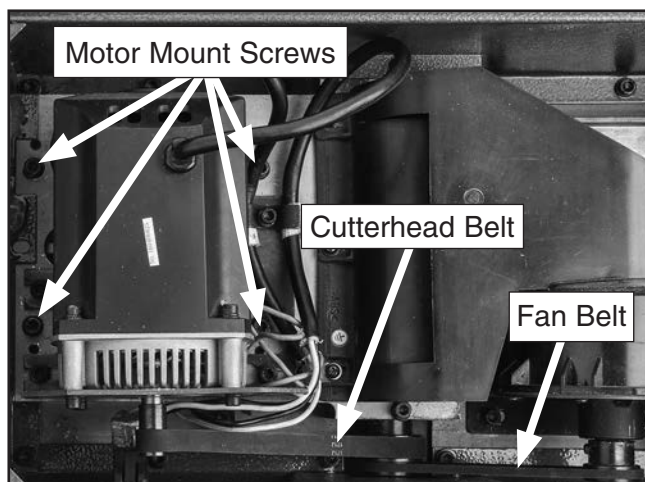


Figure 57. Motor fan belt location (cover removed).

Adjusting Infeed Table Parallelism

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

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

The G0821 uses set screws to adjust infeed table height. The outfeed table and cutterhead assembly have been properly aligned at the factory and do not require adjustment.

Tools Needed

| | Qty |
|------------------------------------|-----|
| Phillips Head Screwdriver #2 | 1 |
| Precision Straightedge 36" | 1 |
| Hex Wrench 3mm..... | 1 |
| Hex Wrench 5mm..... | 1 |
| Hex Wrench 6mm..... | 1 |

To adjust infeed table parallelism:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard and fence assembly.



3. Place straightedge lengthwise on outfeed table, and rotate infeed table adjustment knob until front of infeed table just touches straightedge.
4. Place straightedge in (4) positions shown in **Figure 58**. Use your hand to keep the straightedge flat on the outfeed table. This will show any areas on the infeed table that are too high or too low.

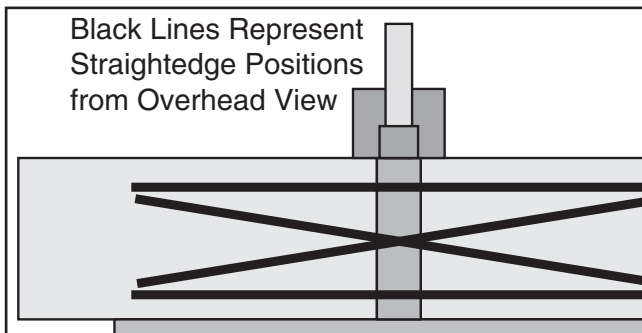


Figure 58. Straightedge positions for checking infeed/outfeed table parallelism.

- If straightedge sits flat against both infeed and outfeed tables in all positions above, then tables are parallel. Replace cutterhead guard and fence assembly.
 - If straightedge *does not* sit flat against both infeed and outfeed tables in any of the positions above, continue with adjustment steps.
5. Identify the highest or lowest corner of infeed table and remove straightedge.
 6. Turn machine upside-down to access motor cover, and remove (4) Phillips head screws securing motor cover to jointer base. Lift cover off and set it aside.

7. Loosen (4) cap screws (see **Figure 59**) securing corners of infeed table. Do not remove.
8. Locate set screw (see **Figure 59**) beneath each corner of table that is not parallel (consult notes from **Step 5**). Rotate set screw clockwise to raise infeed table; rotate counterclockwise to lower table.

Note: *Only rotate set screw in small increments.*

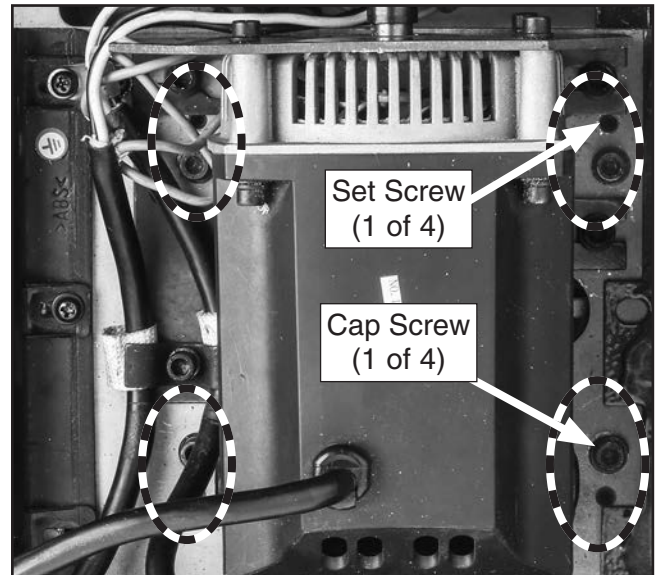


Figure 59. Infeed table adjustment set screw and cap screw locations.

9. Retighten cap screws to secure settings before turning jointer over to check table parallelism.
10. Repeat **Steps 4–8** until infeed table is parallel side-to-side and corner-to-corner.
11. Replace motor cover, and re-install cutterhead guard and fence assembly.



Replacing Motor Brushes

The G0821 has a universal motor that uses carbon brushes that normally wear out over time. If you are having trouble with the performance of the motor, refer to **Troubleshooting (Page 36)** to determine if the motor brushes must be replaced.

You can order a new brush kit (two brush assemblies) from Grizzly. The part number for the brush kit is **P0821108**.

| Tools Needed | Qty |
|------------------------------------|-----|
| Phillips Head Screwdriver #2 | 1 |
| Dime | 1 |
| Precision Ruler | 1 |

To replace motor brushes:

1. DISCONNECT MACHINE FROM POWER.
2. Tip jointer body until it gently rests on fence assembly.
3. Remove (4) Phillips head screws securing motor cover to jointer base. Remove cover and set it aside.
4. Take this opportunity to clear dust and debris from inside jointer.

5. Use a dime to unscrew motor brush caps (see **Figure 60**).

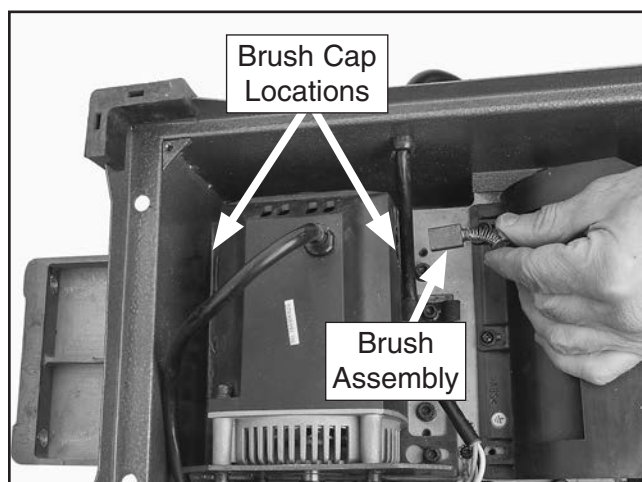


Figure 60. Removing a motor brush.

Note: When brush caps are being removed, a spring will pop out of the motor socket; a spring is firmly attached to each carbon brush. Do not separate brush from spring.

6. Use a ruler to measure wear of each carbon brush. If either brush is worn to less than $\frac{3}{32}$ " in length, replace *both* brushes.
7. Insert new brush assemblies, positioning them to slide into slots in motor sockets. Individually, press each brush cap against its spring, pushing it into motor socket and turning each brush cap to lock it into motor housing.
8. Re-install motor cover.
9. Test run jointer.

— If jointer runs properly, you are done.

— If motor does not start, either new brushes are not correctly aligned in each socket, or there is another problem with motor or wiring. Double-check all wire connections first, then refer to **Troubleshooting** on **Page 36** for assistance.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.















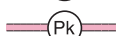
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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



Wiring Diagram

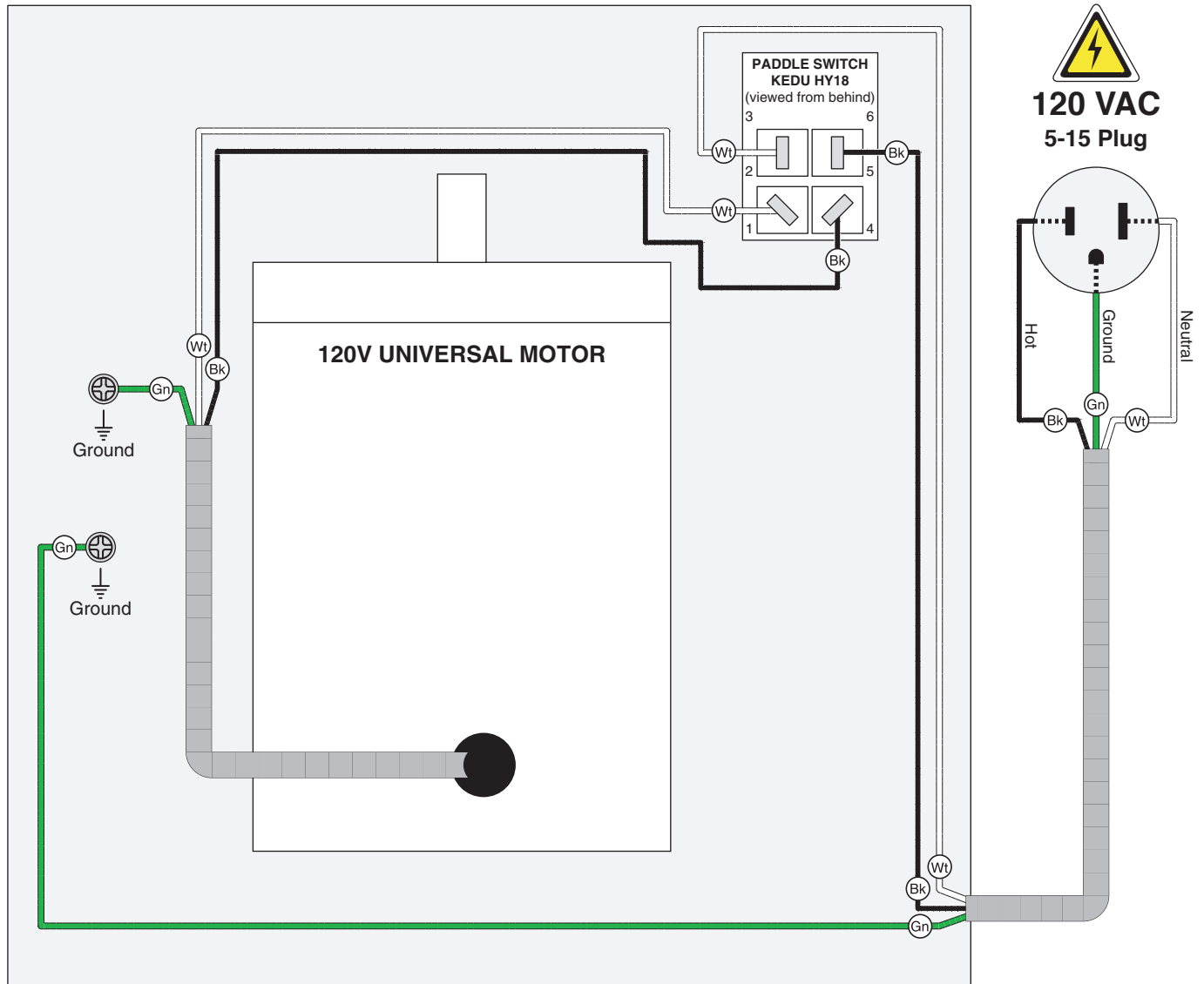


Figure 61. G0821 wiring diagram.



Figure 62. G0821 switch wiring.

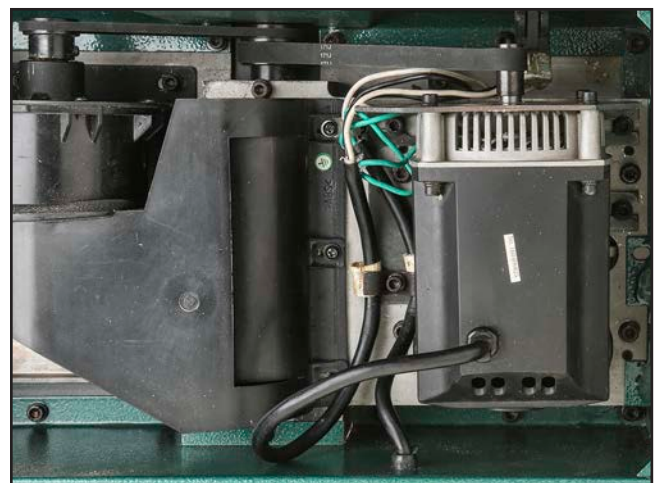
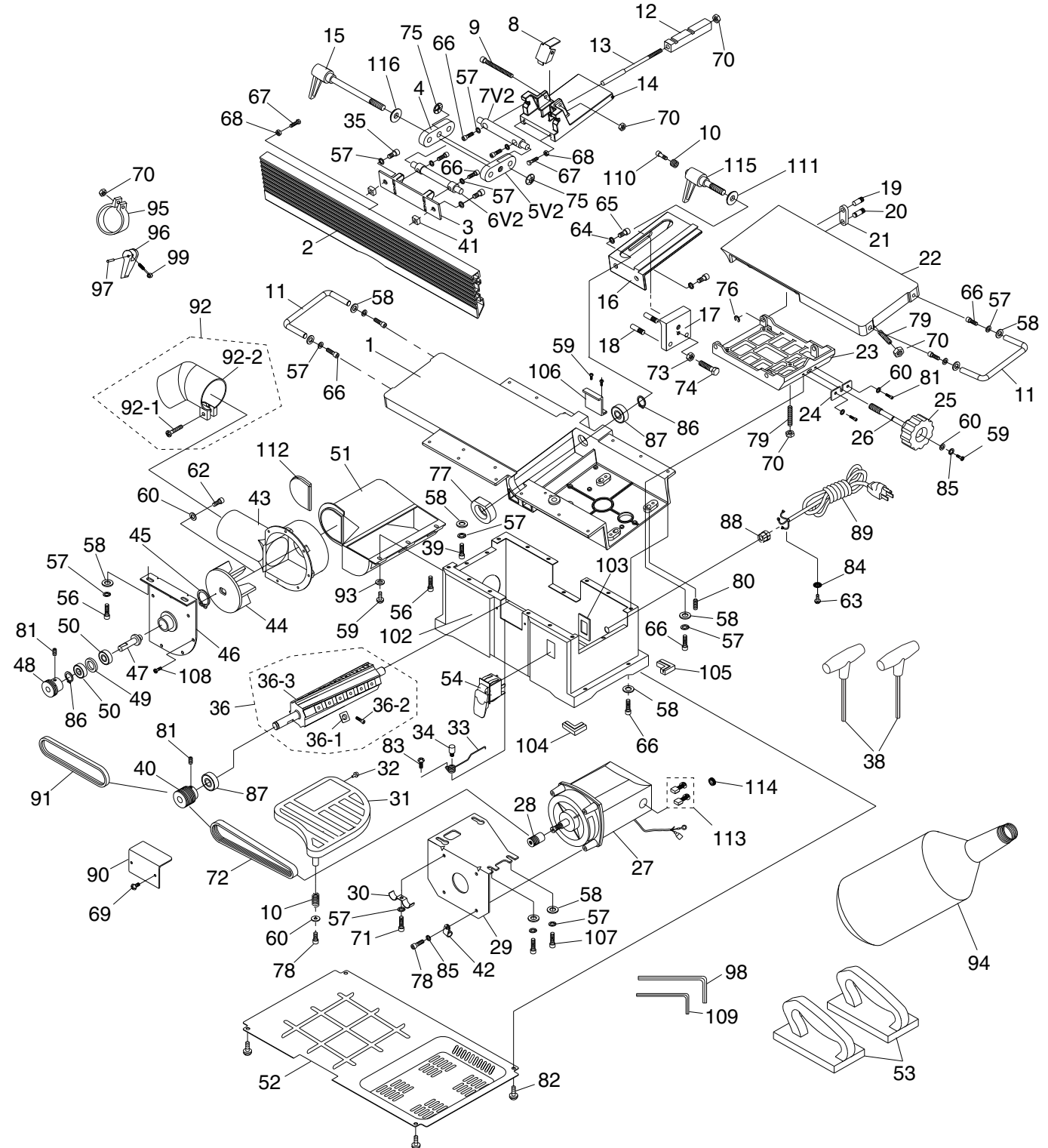


Figure 63. G0821 motor wiring.

Main



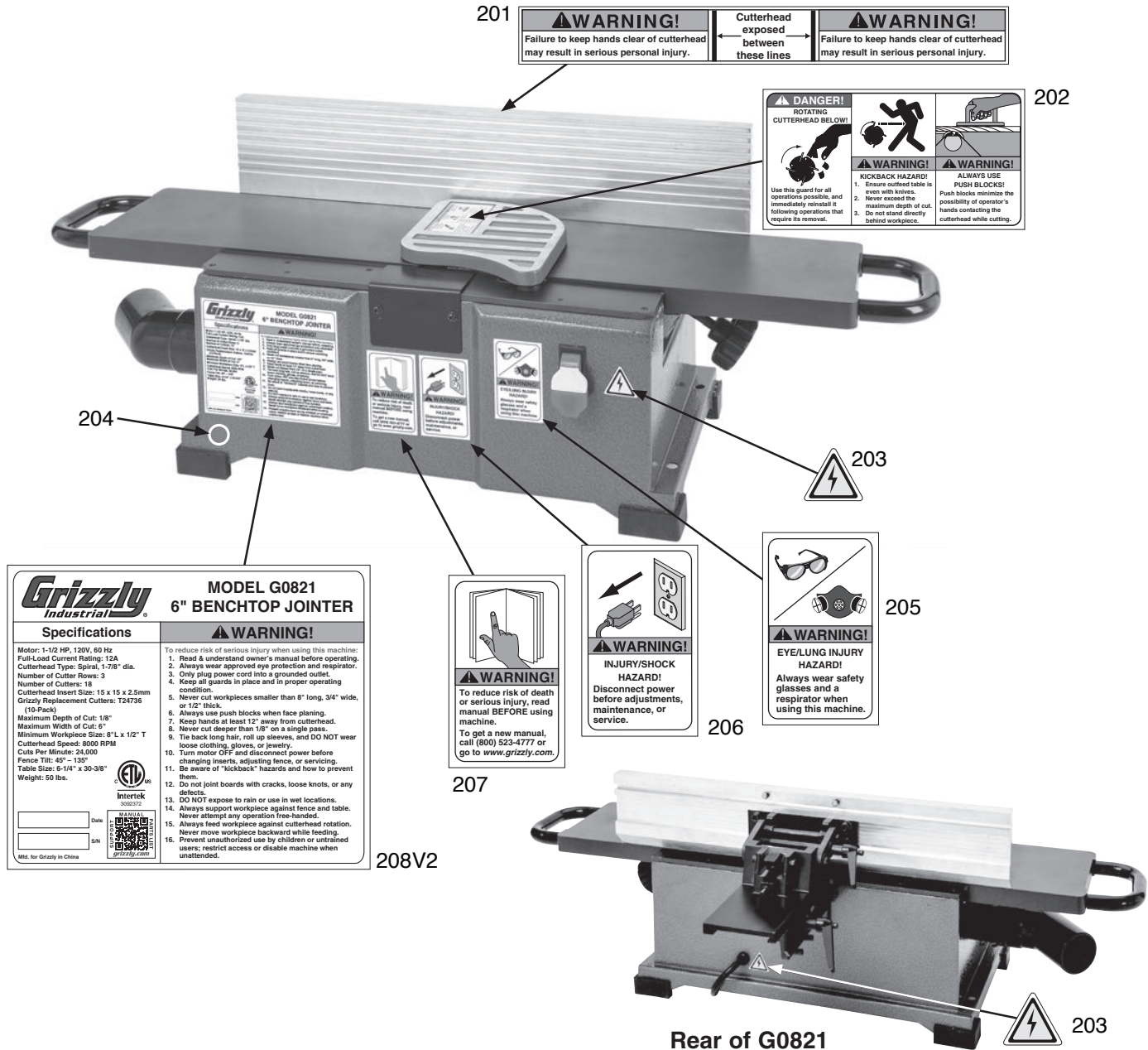
Main Parts List

| REF | PART # | DESCRIPTION |
|------|------------|----------------------------------|
| 1 | P0821001 | OUTFEED TABLE |
| 2 | P0821002 | FENCE |
| 3 | P0821003 | FENCE MOUNTING BRACKET |
| 4 | P0821004 | RIGHT PIVOT BAR |
| 5V2 | P0821005V2 | TAPERED LEFT PIVOT BAR V2.03.18 |
| 6V2 | P0821006V2 | TAPERED PIVOT SHAFT V2.03.18 |
| 7V2 | P0821007V2 | TAPERED CARRIAGE SHAFT V2.03.18 |
| 8 | P0821008 | LIMIT PLATE |
| 9 | P0821009 | CAP SCREW M6-1 X 55 |
| 10 | P0821010 | COMPRESSION SPRING 1 X 12.5 X 18 |
| 11 | P0821011 | CARRY HANDLE |
| 12 | P0821012 | LIMIT BLOCK |
| 13 | P0821013 | LIMIT BLOCK ADJ SHAFT |
| 14 | P0821014 | CARRIAGE |
| 15 | P0821015 | ADJ HANDLE M10-1.5 X 40, 65L |
| 16 | P0821016 | CARRIAGE SUPPORT BRACKET |
| 17 | P0821017 | CARRIAGE LOCKING PLATE |
| 18 | P0821018 | THREADED ALIGNMENT PIN |
| 19 | P0821019 | TABLE PIN |
| 20 | P0821020 | FRAME PIN |
| 21 | P0821021 | PIN BRACKET |
| 22 | P0821022 | INFEED TABLE |
| 23 | P0821023 | INFEED TABLE SUPPORT |
| 24 | P0821024 | DIAL SUPPORT PLATE |
| 25 | P0821025 | KNOB 12-LOBE 60MM |
| 26 | P0821026 | KNOB STUD M10-1.5 X 25 |
| 27 | P0821027 | MOTOR 1-1/2 HP 110V 1-PH |
| 28 | P0821028 | MOTOR PULLEY |
| 29 | P0821029 | MOTOR MOUNTING PLATE |
| 30 | P0821030 | CORD CLAMP |
| 31 | P0821031 | CUTTERHEAD GUARD |
| 32 | P0821032 | PHLP HD SCR M5-.8 X 8 |
| 33 | P0821033 | TORSION SPRING |
| 34 | P0821034 | ROLL PIN 9 X 23 |
| 35 | P0821035 | CAP SCREW M8-1.25 X 20 |
| 36 | P0821036 | HELICAL CUTTERHEAD ASSY 6" |
| 36-1 | P0821036-1 | CARBIDE INSERT 15 X 15 X 2.5 |
| 36-2 | P0821036-2 | FLAT HD TORX T-25 M5-.8 X 12 |
| 36-3 | P0821036-3 | HELICAL CUTTERHEAD 6" |
| 38 | P0821038 | T-HANDLE TORX DRIVER T-25 |
| 39 | P0821039 | CAP SCREW M6-1 X 20 |
| 40 | P0821040 | CUTTERHEAD PULLEY |
| 41 | P0821041 | SQUARE NUT M8-1.25 |
| 42 | P0821042 | CABLE CLAMP, PLASTIC |
| 43 | P0821043 | BLOWER PORT |
| 44 | P0821044 | BLOWER IMPELLER |
| 45 | P0821045 | EXT RETAINING RING 26MM |
| 46 | P0821046 | BLOWER MOUNTING PLATE |
| 47 | P0821047 | IMPELLER SHAFT |
| 48 | P0821048 | BLOWER PULLEY |
| 49 | P0821049 | SPACER 17ID X 26OD X 3L |
| 50 | P0821050 | BALL BEARING 6000-2Z |
| 51 | P0821051 | CHIP CHUTE |
| 52 | P0821052 | BASE COVER |
| 53 | P0821053 | PUSH BLOCKS |
| 54 | P0821054 | PADDLE SWITCH KEDU HY18 |
| 56 | P0821056 | CAP SCREW M6-1 X 12 |
| 57 | P0821057 | LOCK WASHER 6MM |

| REF | PART # | DESCRIPTION |
|------|------------|-------------------------------|
| 58 | P0821058 | FLAT WASHER 6MM |
| 59 | P0821059 | PHLP HD SCR M5-.8 X 10 |
| 60 | P0821060 | FLAT WASHER 5MM |
| 62 | P0821062 | CAP SCREW M5-.8 X 12 |
| 63 | P0821063 | TAP SCREW M5 X 10 |
| 64 | P0821064 | LOCK WASHER 8MM |
| 65 | P0821065 | CAP SCREW M8-1.25 X 30 |
| 66 | P0821066 | CAP SCREW M6-1 X 20 |
| 67 | P0821067 | HEX BOLT M5-.8 X 25 |
| 68 | P0821068 | HEX NUT M5-.8 |
| 69 | P0821069 | BUTTON HD CAP SCR M5-.8 X 6 |
| 70 | P0821070 | HEX NUT M6-1 |
| 71 | P0821071 | CAP SCREW M6-1 X 16 |
| 72 | P0821072 | V-BELT 171J5 RIBBED |
| 73 | P0821073 | HEX NUT M8-1.25 |
| 74 | P0821074 | HEX BOLT M8-1.25 X 25 |
| 75 | P0821075 | PUSH NUT 10MM |
| 76 | P0821076 | E-CLIP 6MM |
| 77 | P0821077 | BEARING BLOCK |
| 78 | P0821078 | CAP SCREW M5-.8 X 10 |
| 79 | P0821079 | SET SCREW M6-1 X 35 |
| 80 | P0821080 | SET SCREW M6-1 X 16 |
| 81 | P0821081 | CAP SCREW M5-.8 X 12 |
| 82 | P0821082 | PHLP HD SCR M5-.8 X 8 |
| 83 | P0821083 | TAP SCREW M4 X 10 |
| 84 | P0821084 | EXT TOOTH WASHER 6MM |
| 85 | P0821085 | LOCK WASHER 5MM |
| 86 | P0821086 | INT RETAINING RING 12MM |
| 87 | P0821087 | BALL BEARING 6201-2Z |
| 88 | P0821088 | STRAIN RELIEF TYPE-1 M12 |
| 89 | P0821089 | POWER CORD 16G 3W 72" 5-15P |
| 90 | P0821090 | BELT PULLEY COVER |
| 91 | P0821091 | V-BELT 139J2 RIBBED |
| 92 | P0821092 | DUST PORT ASSEMBLY |
| 92-1 | P0821092-1 | PHLP HD SCR M6-1 X 20 |
| 92-2 | P0821092-2 | DUST PORT 2-1/2" |
| 93 | P0821093 | FLAT WASHER 5MM |
| 94 | P0821094 | DUST BAG |
| 95 | P0821095 | DUST BAG CLAMP |
| 96 | P0821096 | BAG CLAMP HANDLE |
| 97 | P0821097 | ROLL PIN 6 X 20 |
| 98 | P0821098 | HEX WRENCH 6MM |
| 99 | P0821099 | CLAMP BOLT |
| 102 | P0821102 | BASE |
| 103 | P0821103 | SWITCH MOUNTING PLATE |
| 104 | P0821104 | RUBBER FOOT (RIGHT) |
| 105 | P0821105 | RUBBER FOOT (LEFT) |
| 106 | P0821106 | GUARD PLATE |
| 107 | P0821107 | CAP SCREW M6-1 X 16 |
| 108 | P0821108 | PHLP HD SCR M4-.7 X 10 |
| 109 | P0821109 | HEX WRENCH 5MM |
| 110 | P0821110 | CAP SCREW M5-.8 X 20 |
| 111 | P0821111 | BELLEVILLE WASHER 10MM |
| 112 | P0821112 | FOAM SEAL 10 X 8 X 320 |
| 113 | P0821113 | MOTOR BRUSH (2-PC) |
| 114 | P0821114 | MOTOR BRUSH CAP |
| 115 | P0821115 | ADJ HANDLE M10-1.5 X 115, 65L |
| 116 | P0821116 | BELLEVILLE WASHER 10MM |



Labels & Cosmetics



| REF | PART # | DESCRIPTION |
|-----|----------|-------------------------------|
| 201 | P0821201 | FENCE WARNING LABEL |
| 202 | P0821202 | CUTTERHEAD GUARD LABEL |
| 203 | P0821203 | ELECTRICITY LABEL |
| 204 | P0821204 | TOUCH-UP PAINT, GRIZZLY GREEN |

| REF | PART # | DESCRIPTION |
|-------|------------|-------------------------------|
| 205 | P0821205 | GLASSES/RESPIRATOR LABEL |
| 206 | P0821206 | DISCONNECT 110V LABEL |
| 207 | P0821207 | READ MANUAL LABEL |
| 208V2 | P0821208V2 | MACHINE ID LABEL ETL V2.03.17 |

! WARNING

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





WARRANTY CARD

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Street _____
City _____ State _____ Zip _____
Phone # _____ Email _____
Model # _____ Order # _____ Serial # _____

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1. How did you learn about us?

_____ Advertisement _____ Friend _____ Catalog
_____ Card Deck _____ Website _____ Other: _____

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

_____ 0-2 Years _____ 2-8 Years _____ 8-20 Years _____ 20+ Years

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

_____ 0-2 _____ 3-5 _____ 6-9 _____ 10+

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

_____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend?

_____ Yes _____ No

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

Note: We never use names more than 3 times.

_____ Yes _____ No

10. Comments: _____

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Street_____

City_____State_____Zip_____

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

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

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

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

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



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