



# MODEL G0984

## 4-SIDED PLANER/MOULDER

### OWNER'S MANUAL

*(For models manufactured since 09/24)*



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

## **WARNING!**

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

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

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

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

## **WARNING!**

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

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

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

# Table of Contents

|                                                   |           |
|---------------------------------------------------|-----------|
| <b>INTRODUCTION.....</b>                          | <b>1</b>  |
| <b>SPECIFICATIONS &amp; SAFETY RULES .....</b>    | <b>2</b>  |
| Identification .....                              | 5         |
| Control Panel Controls .....                      | 6         |
| Table Elevation Digital Controller .....          | 9         |
| Safety Instructions for Machinery .....           | 10        |
| Additional Safety for Planer/Moulders.....        | 12        |
| Power Supply .....                                | 13        |
| <b>MACHINE INSTALLATION.....</b>                  | <b>15</b> |
| Site Considerations .....                         | 16        |
| Cleanup .....                                     | 17        |
| Loose Inventory .....                             | 18        |
| Hardware Recognition Chart.....                   | 20        |
| Machine Assembly .....                            | 21        |
| Connecting Dust Collection System.....            | 25        |
| Power Connection .....                            | 26        |
| <b>MACHINE OPERATION .....</b>                    | <b>28</b> |
| Operation Overview .....                          | 28        |
| Replacing Upper/Lower Cutterhead Knives.....      | 30        |
| Replacing Left/Right Cutterhead Knives .....      | 32        |
| Adjusting Lower Cutterhead Depth of Cut .....     | 33        |
| Adjusting Table Elevation .....                   | 34        |
| Adjusting Left/Right Cutterhead Height.....       | 38        |
| Adjusting Left Cutterhead Position.....           | 39        |
| Adjusting Infeed/Outfeed Fence.....               | 40        |
| Installing/Removing Workpiece Bridge .....        | 42        |
| Adjusting Feed Speed.....                         | 43        |
| <b>MACHINE ACCESSORIES.....</b>                   | <b>45</b> |
| <b>MACHINE MAINTENANCE .....</b>                  | <b>46</b> |
| Daily Maintenance.....                            | 46        |
| Biweekly Maintenance .....                        | 46        |
| Monthly Maintenance .....                         | 47        |
| Yearly Maintenance.....                           | 47        |
| Lubrication.....                                  | 48        |
| <b>MACHINE SERVICE.....</b>                       | <b>49</b> |
| Troubleshooting.....                              | 49        |
| Tensioning Upper Cutterhead V-Belt.....           | 50        |
| Tensioning Table Elevation Chain .....            | 51        |
| Constructing Gauge Block .....                    | 52        |
| Checking Table Parallelism .....                  | 53        |
| <b>WIRING .....</b>                               | <b>54</b> |
| Wiring Safety Instructions .....                  | 54        |
| Wiring Schematic .....                            | 55        |
| Electrical Cabinet Wiring Diagram .....           | 56        |
| Control Panel & Limit Switch Wiring Diagrams..... | 57        |

**PARTS..... 58**

    Main.....58

    Table.....61

    Feed System .....62

    Vertical Cutterheads .....64

    Frame .....66

    Extension Tables .....68

    Accessories .....69

    Electrical Cabinet & Table Limit Switches .....70

    Labels & Cosmetics (Front) .....72

    Labels & Cosmetics (Rear) .....73

**WARRANTY & RETURNS..... 75**

# INTRODUCTION

---

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery and equipment, there are certain hazards involved with the operation of the machine. Operate the machine with respect and caution, and always pay attention to all warnings and safety rules. Failure to do so can result in serious personal injury or machine damage.

Use proper safety equipment, such as push sticks, and wear the proper personal protective equipment for the operation. Wear safety glasses, a respirator, and hearing protection when operating the machine. Even the best guard will not make up for poor judgment, carelessness, or inattention.

Always use common sense and exercise caution in the workshop. If you have any questions regarding the machine operation, do not operate the machine. Figure out an alternative procedure that is safer. REMEMBER! Your personal safety is your responsibility.

Do not modify this machine or use it for any application other than that for which it was designed. Before operating the machine, the operator must thoroughly read and understand this operation manual.

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

## **WARNING**

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

## **CAUTION**

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



# SPECIFICATIONS & SAFETY RULES



## MACHINE DATA SHEET

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

### MODEL G0984 4-SIDED PLANER/MOULDER

#### Product Dimensions:

Weight ..... 1199 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height ..... 40-1/2 x 127-1/2 x 44-1/2 in.  
Footprint (Length x Width) ..... 43-1/2 x 25-1/2 in.

#### Shipping Dimensions:

Type ..... Wood Crate  
Content ..... Machine  
Weight ..... 1300 lbs.  
Length x Width x Height ..... 50 x 46 x 49 in.  
Must Ship Upright ..... Yes

#### Electrical:

Power Requirement ..... 230V, 3-Phase, 60 Hz  
Full-Load Current Rating ..... 47.4A  
Minimum Circuit Size ..... 60A  
Connection Type ..... Permanent (Hardwired to Shutoff Switch)  
Switch Type ..... ON/OFF Switch w/Emergency Stop

#### Motors:

##### Upper Cutterhead

Horsepower ..... 4 HP  
Phase ..... 3-Phase  
Amps ..... 11A  
Speed ..... 3360 RPM  
Type ..... Induction  
Power Transfer ..... Belt  
Bearings ..... Sealed & Permanently Lubricated

##### Lower Cutterhead

Horsepower ..... 4 HP  
Phase ..... 3-Phase  
Amps ..... 11A  
Speed ..... 3360 RPM  
Type ..... Induction  
Power Transfer ..... Belt  
Bearings ..... Sealed & Permanently Lubricated

##### Left Cutterhead

Horsepower ..... 4 HP  
Phase ..... 3-Phase  
Amps ..... 11A  
Speed ..... 3360 RPM  
Type ..... Induction  
Power Transfer ..... Belt  
Bearings ..... Sealed & Permanently Lubricated



### Right Cutterhead

|                      |                                 |
|----------------------|---------------------------------|
| Horsepower .....     | 4 HP                            |
| Phase .....          | 3-Phase                         |
| Amps .....           | 11A                             |
| Speed .....          | 3360 RPM                        |
| Type .....           | Induction                       |
| Power Transfer ..... | Belt                            |
| Bearings .....       | Sealed & Permanently Lubricated |

### Feed System

|                      |                                 |
|----------------------|---------------------------------|
| Horsepower .....     | 1 HP                            |
| Phase .....          | 3-Phase                         |
| Amps .....           | 3.4A                            |
| Speed .....          | 1740 RPM                        |
| Type .....           | Induction                       |
| Power Transfer ..... | Gear                            |
| Bearings .....       | Sealed & Permanently Lubricated |

### Table Elevation

|                      |                                 |
|----------------------|---------------------------------|
| Horsepower .....     | 1/8 HP                          |
| Phase .....          | 3-Phase                         |
| Amps .....           | 0.17A                           |
| Speed .....          | 1600 RPM                        |
| Type .....           | Induction                       |
| Power Transfer ..... | Gear                            |
| Bearings .....       | Sealed & Permanently Lubricated |

### Main Specifications:

#### Main Specifications

|                                                         |            |
|---------------------------------------------------------|------------|
| Planer Size .....                                       | 10-1/4 in. |
| Max. Cut Width .....                                    | 10-1/4 in. |
| Max. Cut Height .....                                   | 8-1/4 in.  |
| Min. Stock Length .....                                 | 12 in.     |
| Min. Stock Width .....                                  | 1 in.      |
| Min. Stock Thickness .....                              | 3/8 in.    |
| Number of Cuts Per Inch (Per Cutterhead) .....          | 158 - 24   |
| Number of Cuts Per Minute (Per Cutterhead) .....        | 13,300     |
| Cutterhead Speed .....                                  | 6650 RPM   |
| Planing Feed Rate .....                                 | 7 - 47 FPM |
| Moulding Feed Rate .....                                | 7 FPM      |
| Max. Cut Depth Upper Cutterhead Full Width .....        | 5/64 in.   |
| Max. Cut Depth Upper Cutterhead 6-Inch Wide Board ..... | 5/32 in.   |
| Max. Cut Depth Lower Cutterhead Full Width .....        | 5/64 in.   |
| Max. Cut Depth Lower Cutterhead 6-Inch Wide Board ..... | 5/32 in.   |

#### Cutterhead Information (Upper)

|                                    |                           |
|------------------------------------|---------------------------|
| Cutterhead Type .....              | Straight Knife            |
| Cutterhead Diameter .....          | 2-3/4 in.                 |
| Number of Knife Slots .....        | 4 (2 Planing, 2 Moulding) |
| Planing Knife Type .....           | HSS, Single-Sided, Solid  |
| Planing Knife Size Length .....    | 16-1/8 in.                |
| Planing Knife Size Width .....     | 13/16 in.                 |
| Planing Knife Size Thickness ..... | 1/8 in.                   |
| Knife Adjustment .....             | Jack Screws               |

#### Cutterhead Information (Lower)

|                                    |                           |
|------------------------------------|---------------------------|
| Cutterhead Type .....              | Straight Knife            |
| Cutterhead Diameter .....          | 2-3/4 in.                 |
| Number of Knife Slots .....        | 4 (2 Planing, 2 Moulding) |
| Planing Knife Type .....           | HSS, Single-Sided, Solid  |
| Planing Knife Size Length .....    | 11-13/16 in.              |
| Planing Knife Size Width .....     | 13/16 in.                 |
| Planing Knife Size Thickness ..... | 1/8 in.                   |
| Knife Adjustment .....             | Jack Screws               |



**Cutterhead Information (Left)**

|                                     |                          |
|-------------------------------------|--------------------------|
| Cutterhead Type.....                | Straight Knife           |
| Cutterhead Diameter.....            | 3-1/2 in.                |
| Spindle Size .....                  | 1-1/4 in.                |
| Exposed Spindle Length .....        | 6 in.                    |
| Spindle Capacity Under the Nut..... | 4-3/16 in.               |
| Number of Knife Slots.....          | 2                        |
| Maximum Knife Size Length .....     | 2-1/8 in.                |
| Maximum Knife Size Width .....      | 1-1/8 in.                |
| Maximum Knife Size Thickness .....  | 5/32 in.                 |
| Included Knife Type.....            | HSS, Single-Sided, Solid |
| Included Knife Size Length .....    | 2-1/8 in.                |
| Included Knife Size Width .....     | 1-1/8 in.                |
| Included Knife Size Thickness ..... | 1/8 in.                  |

**Cutterhead Information (Right)**

|                                     |                          |
|-------------------------------------|--------------------------|
| Cutterhead Type.....                | Straight Knife           |
| Cutterhead Diameter.....            | 3-1/2 in.                |
| Spindle Size .....                  | 1-1/4 in.                |
| Exposed Spindle Length .....        | 6 in.                    |
| Spindle Capacity Under the Nut..... | 4-3/16 in.               |
| Number of Knife Slots.....          | 2                        |
| Maximum Knife Size Length .....     | 2-1/8 in.                |
| Maximum Knife Size Width .....      | 1-1/8 in.                |
| Maximum Knife Size Thickness .....  | 5/32 in.                 |
| Included Knife Type.....            | HSS, Single-Sided, Solid |
| Included Knife Size Length .....    | 2-1/8 in.                |
| Included Knife Size Width .....     | 1-1/8 in.                |
| Included Knife Size Thickness ..... | 1/8 in.                  |

**Table Information**

|                                                    |                     |
|----------------------------------------------------|---------------------|
| Table Movement.....                                | 7-7/8 in.           |
| Table Bed Size Length .....                        | 40-9/16 in.         |
| Table Bed Size Width.....                          | 16-5/16 in.         |
| Table Bed Size Thickness.....                      | 2 in.               |
| Floor-to-Table Height.....                         | 24-3/8 - 32-1/4 in. |
| Infeed/Outfeed Extension Table Size Length.....    | 43-5/16 in.         |
| Infeed/Outfeed Extension Table Size Width.....     | 12-1/2 in.          |
| Infeed/Outfeed Extension Table Size Thickness..... | 1/8 in.             |

**Construction**

|                           |              |
|---------------------------|--------------|
| Table Bed .....           | Cast Iron    |
| Extension Tables .....    | Steel        |
| Body .....                | Steel        |
| Cutterhead Assembly ..... | Steel        |
| Infeed Roller.....        | Steel        |
| Outfeed Roller.....       | Rubber       |
| Paint Type/Finish.....    | Polyurethane |

**Other**

|                               |               |
|-------------------------------|---------------|
| Measurement Scale .....       | Inch & Metric |
| Number of Dust Ports .....    | 4             |
| Dust Port Size .....          | 4 in.         |
| Gearbox Oil Capacity .....    | 0.16L         |
| One-Shot Oiler Capacity ..... | 0.16L         |

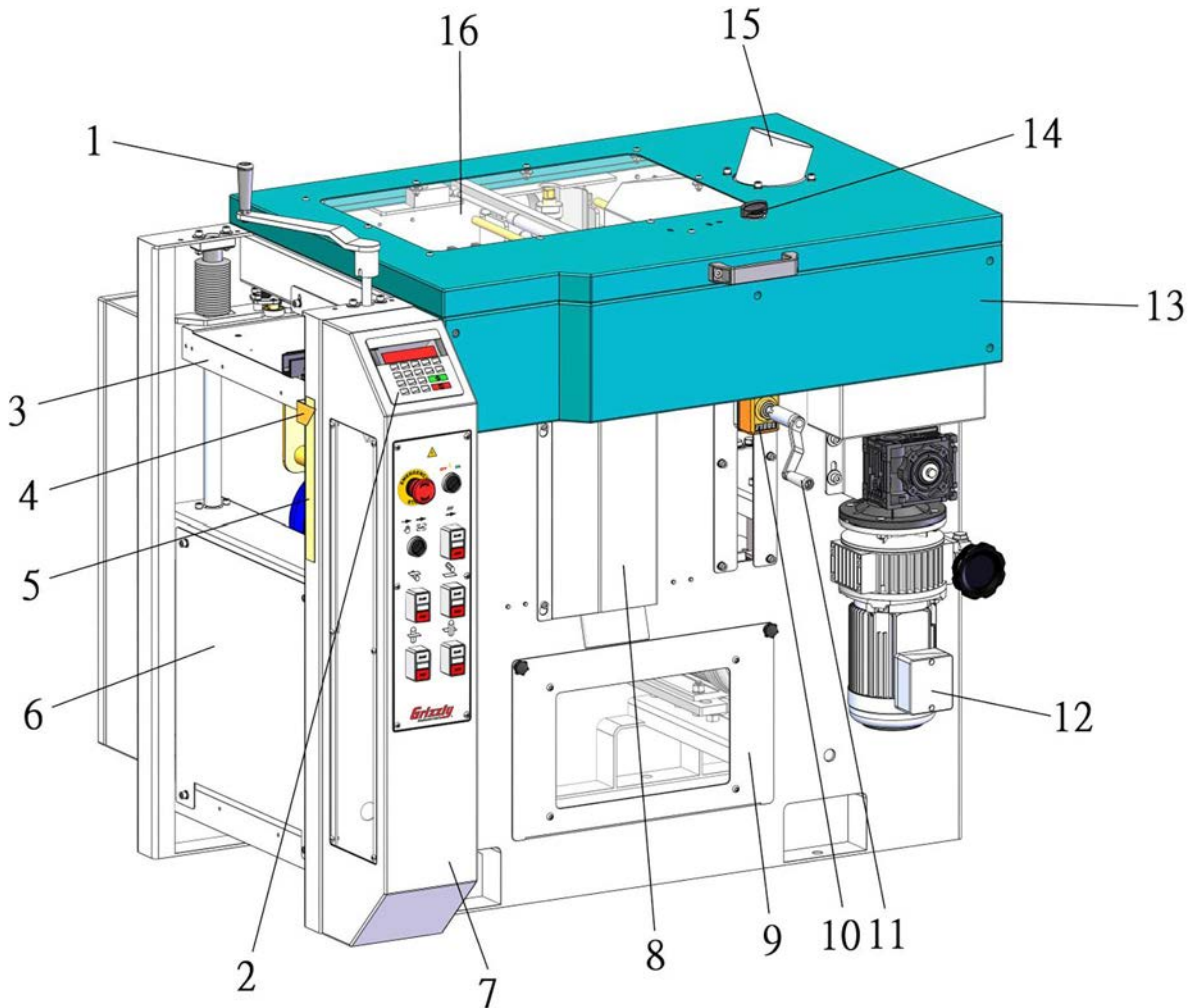
**Other Specifications:**

|                                        |          |
|----------------------------------------|----------|
| Country of Origin.....                 | Taiwan   |
| Warranty.....                          | 1 Year   |
| Approximate Assembly & Setup Time..... | 3 Hours  |
| Serial Number Location.....            | ID Label |
| Sound Rating .....                     | 89 dB    |



# Identification

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

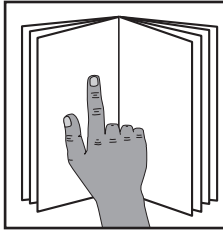


1. Table elevation adjustment handle
2. Table elevation digital display
3. Table
4. Table elevation indicator
5. Table elevation scale
6. Front cover
7. Control box
8. Right cutterhead guard
9. Right cover

10. Left cutterhead position indicator
11. Left cutterhead adjustment handle
12. Variable-speed control reducer and motor (1 HP)
13. Sprocket cover
14. Top door lock knob
15. Top dust hood outlet (4")
16. Top door



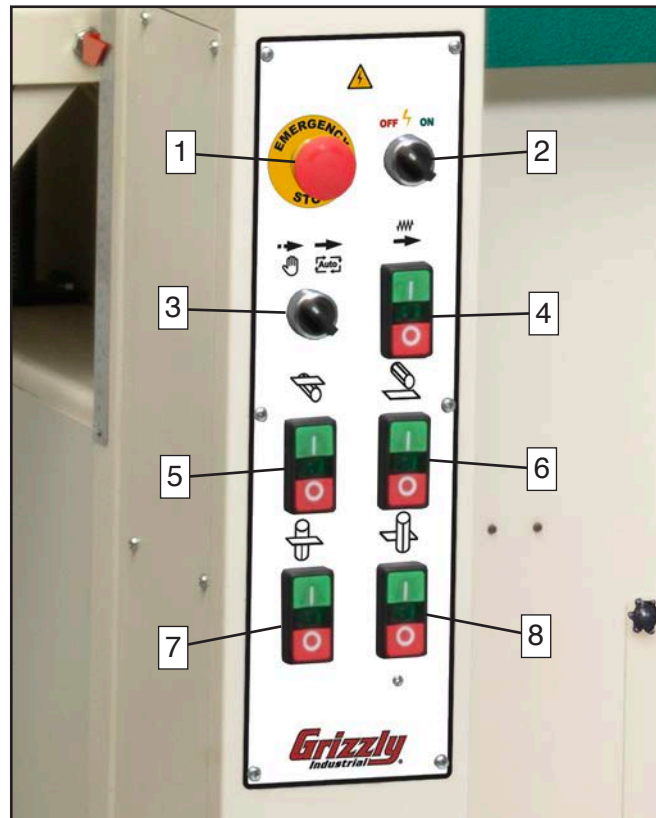
# Control Panel Controls



## **!WARNING**

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

Refer to the following figures and descriptions to become familiar with the basic controls of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.



1. EMERGENCY STOP button
2. Power ON/OFF switch
3. Manual/automatic feed switch
4. Feed system start/stop
5. Lower cutterhead start/stop
6. Upper cutterhead start/stop
7. Left cutterhead start/stop
8. Right cutterhead start/stop



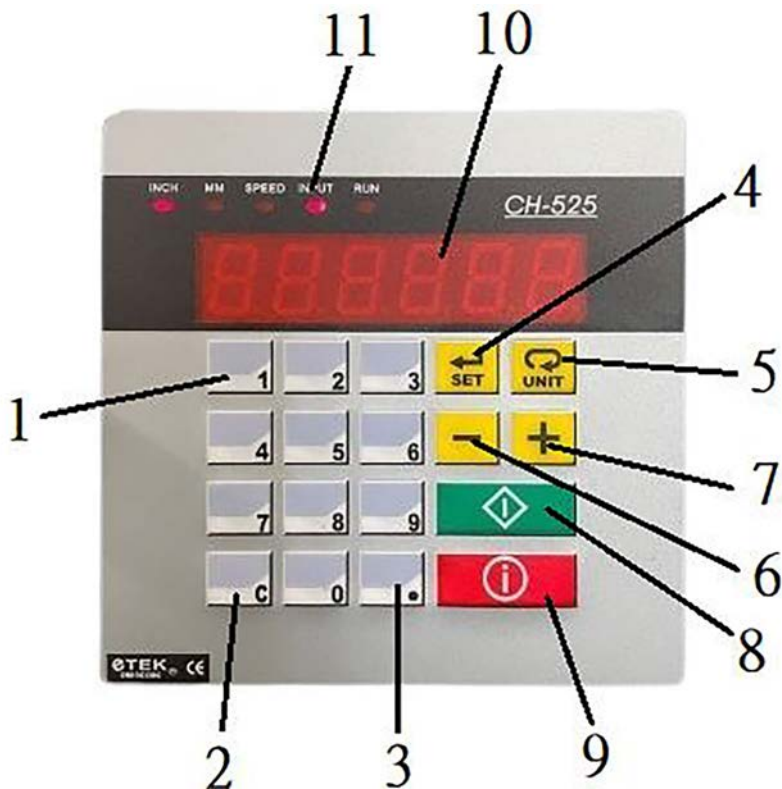
| DIAGRAM                                                                             | DESCRIPTION                 | FUNCTION                                                                                                                                                                                                                                               |
|-------------------------------------------------------------------------------------|-----------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|    | POWER ON/OFF                | <p>Turn switch to right "<b>ON</b>" position for power <b>ON</b>.</p> <p>Turn switch to left "<b>OFF</b>" position for power <b>OFF</b>.</p>                                                                                                           |
|    | EMERGENCY STOP BUTTON       | <p>Turns all machine functions <b>OFF</b> when pressed.</p> <p>During operation, if any abnormal situation occurs, press button to immediately shut down all machine functions. When starting machine, reset this button by twisting it clockwise.</p> |
|   | UPPER CUTTERHEAD START/STOP | <p>When power switch is in the ON position, press the green button to start the cutterhead.</p> <p>When the indicator light is <b>ON</b>, the motor is running.</p> <p>Press the red button to stop the cutterhead.</p>                                |
|  | LEFT CUTTERHEAD START/STOP  | <p>When power switch is in the ON position, press the green button to start the cutterhead.</p> <p>When the indicator light is <b>ON</b>, the motor is running.</p> <p>Press the red button to stop the cutterhead.</p>                                |



| DIAGRAM                                                                             | DESCRIPTION                                   | FUNCTION                                                                                                                                                                                                                        |
|-------------------------------------------------------------------------------------|-----------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|    | <b>RIGHT CUTTERHEAD<br/>START/STOP</b>        | <p>When power switch is in the ON position, press the green button to start the cutterhead.</p> <p>When the indicator light is <b>ON</b>, the motor is running.</p> <p>Press the red button to stop the cutterhead.</p>         |
|    | <b>LOWER CUTTERHEAD<br/>START/STOP</b>        | <p>When power switch is in the ON position, press the green button to start the cutterhead.</p> <p>When the indicator light is <b>ON</b>, the motor is running.</p> <p>Press the red button to stop the cutterhead.</p>         |
|   | <b>FEED SYSTEM<br/>START/STOP</b>             | <p>When power switch is in the ON position, press the green button to start the feed system.</p> <p>When the indicator light is <b>ON</b>, the feed system is running.</p> <p>Press the red button to stop the feed system.</p> |
|  | <b>MANUAL/AUTOMATIC<br/>FEED SWITCH</b>       | <p>Turn this switch to right position for automatic feeding.</p> <p>Turn this switch to left position to jog feed system manually.</p>                                                                                          |
|  | <b>TABLE ELEVATION<br/>DIGITAL CONTROLLER</b> | <p>When power switch is in the ON position, use buttons to raise or lower table. See <b>Page 9</b> for details.</p>                                                                                                             |



# Table Elevation Digital Controller



1. Numerical keypad to input desired table height.
2. Clear current display value.
3. Set the number to the right of the decimal point.
4. Enters input mode.
5. Toggles display between inches and millimeters.
6. Manually lowers display value for work table position.
7. Manually raises display value for work table position.
8. Enters current display value to move table.
9. Stops table movement.
10. Displays current table elevation setting.
11. Indicates current settings (Inch/MM/Input/Run).

## NOTICE :

1. Unit of measurement: INCH/MM.
2. Route distance: MM = 00000.1 ~ 99999.9, INCH = 0000.00 ~ 9999.99.



# 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 loose clothing, gloves, neckties, 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 Planer/Moulders

## WARNING

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

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

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

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

**BODY PLACEMENT.** Stand to one side of machine during entire operation to avoid getting hit if kickback occurs. DO NOT look inside machine during operation; wood chips fly around inside machine at a high rate of speed.

**CUTTING LIMITATIONS.** To reduce risk of kickback hazards and damage to machine, DO NOT exceed maximum depth of cut or minimum board size dimensions found in **Machine Data Sheet**. Only feed one board at a time.

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

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

**INFEED ROLLER CLEARANCE.** Infeed rollers are designed to pull material into spinning cutterheads. To reduce risk of entanglement, keep hands, clothing, jewelry, and long hair away from infeed rollers during operation.

**INSPECT KNIVES.** Loose or damaged knives can become dangerous projectiles or cause machine damage. Dull knives increase risk of kickback. Before starting machine, verify knives are clean, sharp, undamaged, secure, and properly adjusted and verify that moulding knives do not contact any part of table, rollers, fences, roller guides, or dust hoods to prevent severe injury and machine damage!

**WORKPIECE SUPPORT.** To reduce risk of kickback and jams, always make sure workpiece can move completely across tables without rocking or tipping. For long stock, use auxiliary support stands on infeed and outfeed ends of machine.

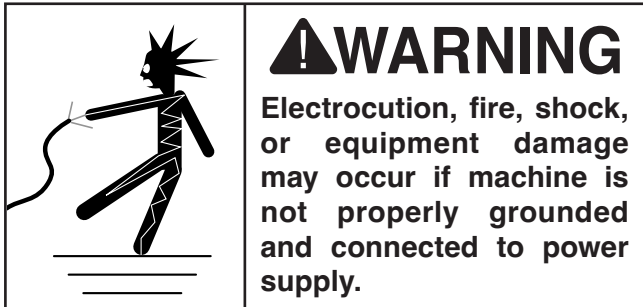
**GRAIN DIRECTION.** Planing/moulding across grain is hard on machine and may cause kickback. Plane/mould in same direction or at a slight angle with wood grain.



# 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 230V ..... 47.4A

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

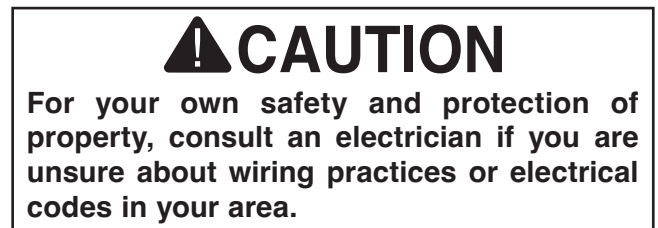
If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets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

## Circuit Requirements for 230V

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

**Nominal Voltage ..... 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... 3-Phase**  
**Power Supply Circuit ..... 60 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.)



**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.*



## Connection Type

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

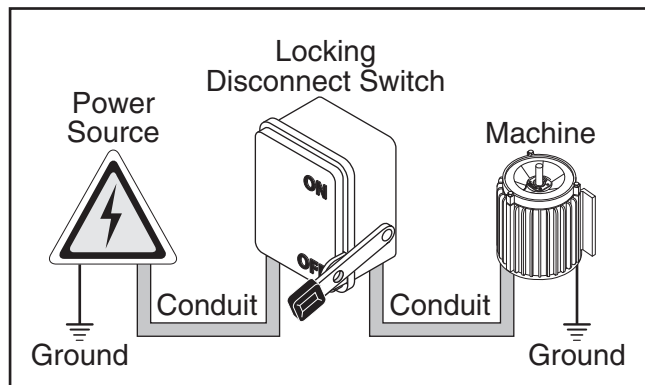


**Figure 1.** Typical setup of a permanently connected machine.

## Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

### **!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.**

## Extension Cords

Since this machine must be permanently connected to the power supply, an extension cord cannot be used.



# MACHINE INSTALLATION

---

Before operating your machine, the machine must be moved to a suitable location and assembled. Use the steps below to prepare your machine for operation.

1. Check the machine for transport damage. Inform the shipper and manufacturer immediately if any damage is found.
2. Prepare a suitable location for the machine. Leave proper space around the machine to allow maintenance and material handling. See **Page 16** for more details.
3. Prepare a dust collection system for the machine.
4. Open crate and remove loose items from pallet.
5. Move the machine to the prepared location with power lifting equipment that is rated for the weight of the machine. Machine weight must be balanced to prevent it from tipping, and we suggest having a lifting assistant to help guide the machine. If a forklift is used, it must be operated by a qualified driver and the forks must fully extend under the base of the machine. Failure to use the correct lifting equipment or techniques may result in serious personal injury or machine damage.
6. Clean the machine to remove the rust preventative that was applied for shipping. See **Page 17** for more details.
7. Inventory loose items shipped with machine. See **Page 18** for more details.
8. Fully assemble the machine. See **Page 21** for details.
9. Connect (4) Ø4" flexible dust hoses to the dust hood outlets on the machine, then attach hoses to the dust collection system. See **Page 25** for details.
10. Prepare the power supply circuit for the machine. See **Page 13** for more details. DO NOT connect machine to power until instructed later in this manual.



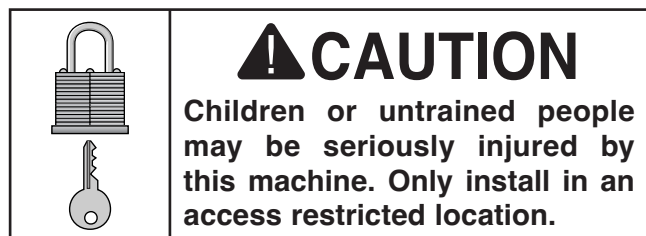
# Site Considerations

## Weight Load

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

## Space Allocation

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



## Physical Environment

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

## Electrical Installation

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

## Lighting

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

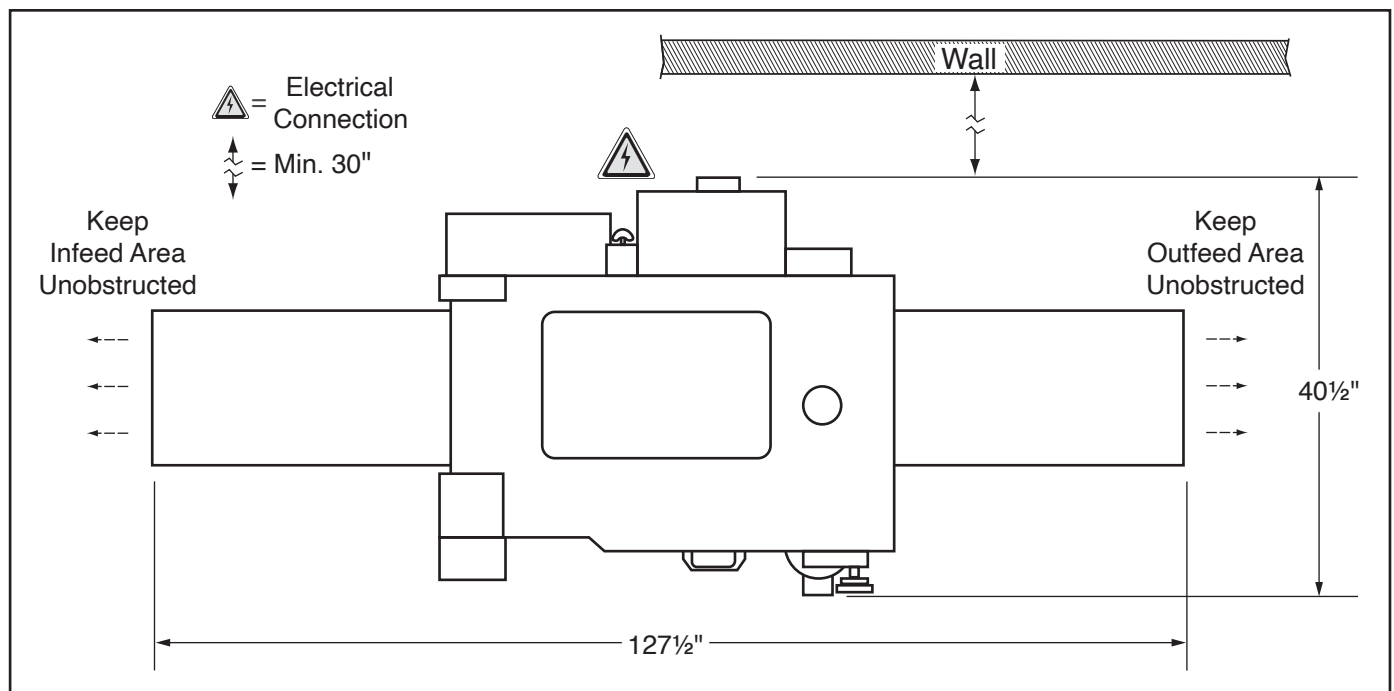


**Figure 2.** Minimum working clearances.



# 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.

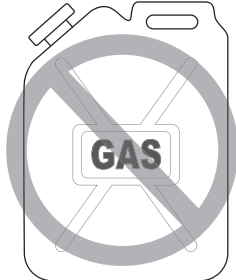
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

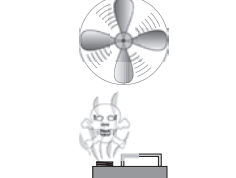
## Before cleaning, gather the following:

- 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.

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

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

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

## T23692—Orange Power Degreaser

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

|                                                                                                                                            |                                                                                       |
|--------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| <p><b>Order online at</b><br/><b><a href="http://www.grizzly.com">www.grizzly.com</a></b><br/><b>OR</b><br/><b>Call 1-800-523-4777</b></p> |  |
|--------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|

Figure 3. T23692 Orange Power Degreaser.



# Loose Inventory

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

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

## NOTICE

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

| Extension Table (Figure 4)      | Qty |
|---------------------------------|-----|
| A. Infeed Table.....            | 1   |
| B. Outfeed Table.....           | 1   |
| C. Infeed Extension Fence ..... | 1   |
| D. Pivot Brackets.....          | 4   |

|                                          |    |
|------------------------------------------|----|
| E. Fence Adjustment Rods.....            | 3  |
| F. Fence Rod Mounts.....                 | 3  |
| G. Table Braces .....                    | 4  |
| H. Fence Mounting Brackets.....          | 3  |
| I. Table Supports .....                  | 2  |
| J. Table Support Mounting Brackets ..... | 2  |
| K. Hardware (Not Shown)                  |    |
| —Spacers 11 x 25 x 3.5mm .....           | 8  |
| —Hex Bolts M10-1.5 x 60.....             | 8  |
| —Hex Bolts M10-1.5 x 25.....             | 4  |
| —Hex Bolts M8-1.25 x 16.....             | 3  |
| —Cap Screws M8-1.25 x 40.....            | 3  |
| —Cap Screws M8-1.25 x 20.....            | 7  |
| —Cap Screws M6-1 x 20 .....              | 10 |
| —Fender Washers 8mm .....                | 4  |
| —Fender Washers 6mm .....                | 6  |
| —Flat Washers 8mm.....                   | 7  |
| —Flat Washers 6mm.....                   | 4  |
| —Lock Washers 8mm .....                  | 17 |
| —Lock Washers 6mm.....                   | 10 |
| —Lock Nuts M10-1.5 .....                 | 12 |
| —Hex Nuts M8-1.25 .....                  | 4  |

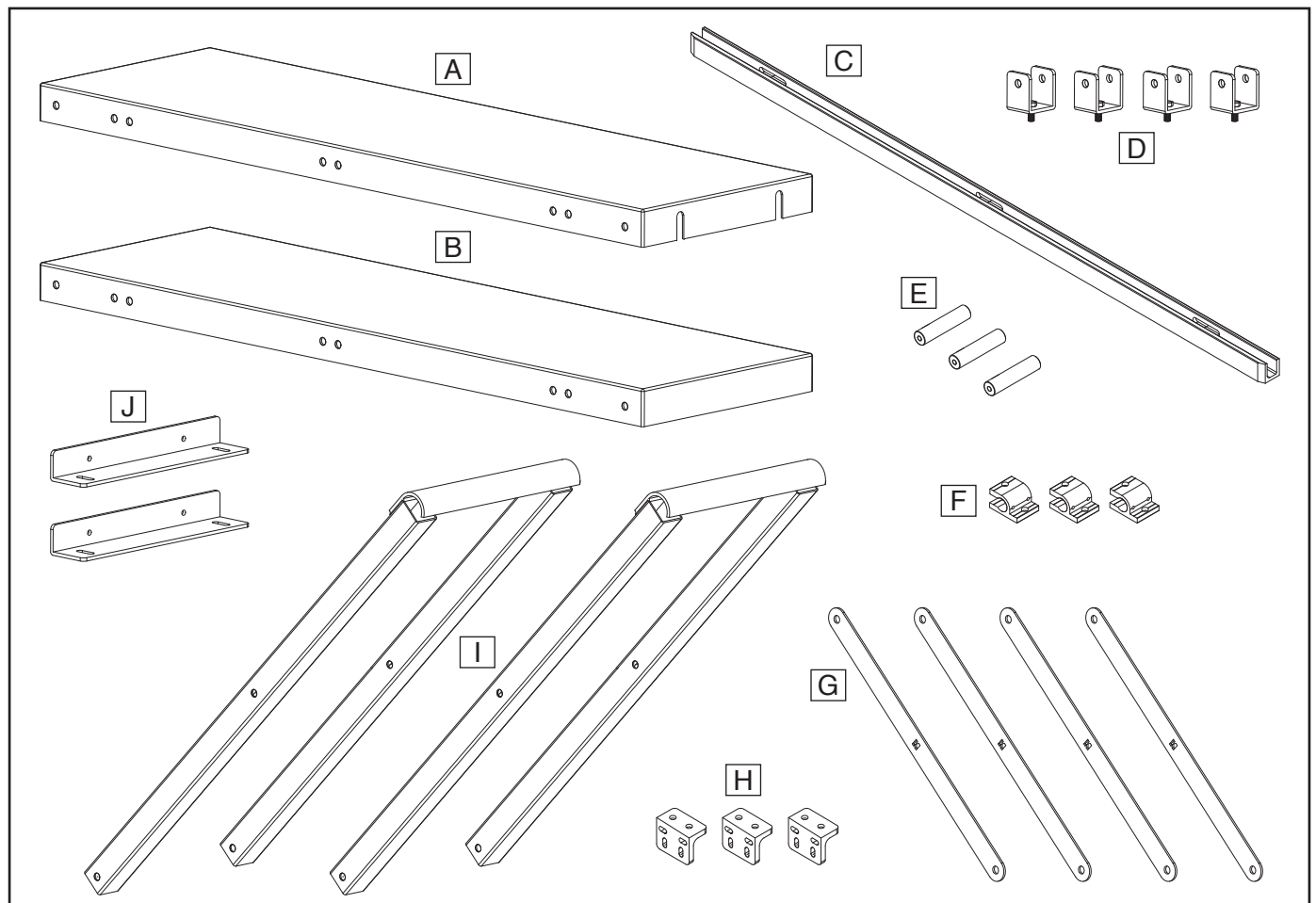


Figure 4. Extension table inventory.



| Cutterhead Adjustment (Figure 5) |                                                                      | Qty |
|----------------------------------|----------------------------------------------------------------------|-----|
| L.                               | Infeed Plates 1mm.....                                               | 2   |
| M.                               | Infeed Plate 2mm .....                                               | 1   |
| N.                               | Left/Right Cutterhead Spacers<br>(Some Pre-Installed on Cutterheads) |     |
|                                  | —40mm Thickness .....                                                | 4   |
|                                  | —20mm Thickness .....                                                | 2   |
|                                  | —10mm Thickness.....                                                 | 4   |
|                                  | —5mm Thickness .....                                                 | 2   |
|                                  | —2mm Thickness .....                                                 | 4   |
|                                  | —1.5mm Thickness.....                                                | 2   |
|                                  | —0.5mm Thickness.....                                                | 4   |
|                                  | —0.3mm Thickness.....                                                | 2   |
|                                  | —0.1mm Thickness .....                                               | 4   |
| O.                               | Upper/Lower Cutterhead<br>Knife Setting Jig .....                    | 1   |

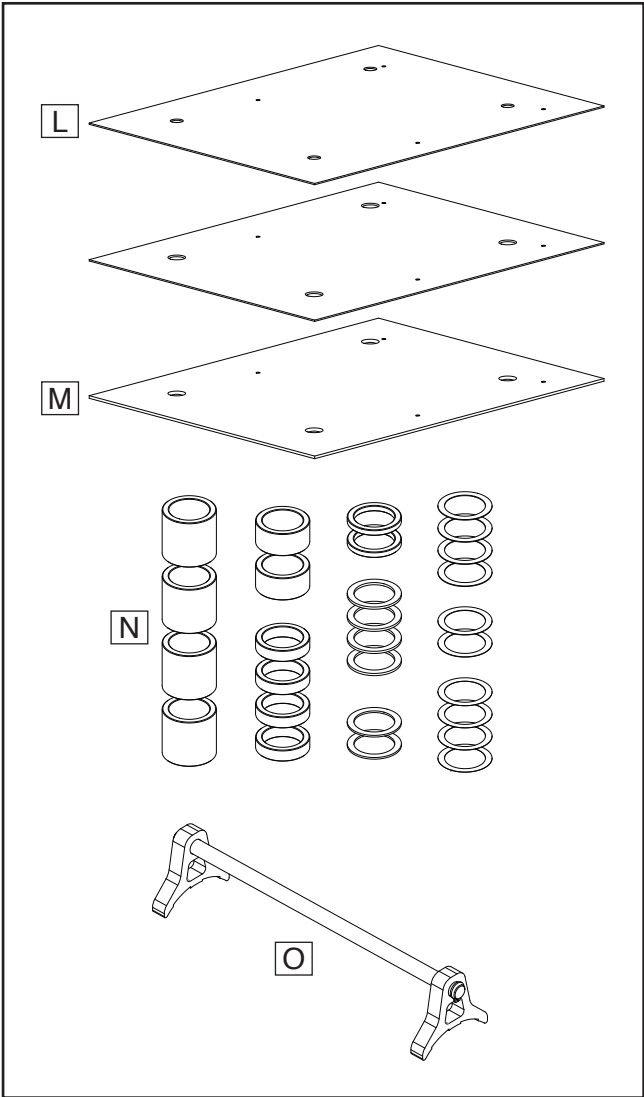


Figure 5. Cutterhead adjustment inventory.

| Tools & Handles (Figure 6) |                                                       | Qty   |
|----------------------------|-------------------------------------------------------|-------|
| P.                         | Toolbox .....                                         | 1     |
| Q.                         | Hex Wrenches 3, 4, 5, 6, 8mm.....                     | 1 Ea. |
| R.                         | T-Handle Hex Wrenches 4, 6mm .....                    | 1 Ea. |
| S.                         | Open-End Wrenches 10 x 12, 12 x 14,<br>17 x 19mm..... | 1 Ea. |
| T.                         | Combo Wrenches 13, 30mm.....                          | 1 Ea. |
| U.                         | Table Elevation Adjustment Handle.....                | 1     |
| V.                         | Left Cutterhead Adjustment Handle .....               | 1     |

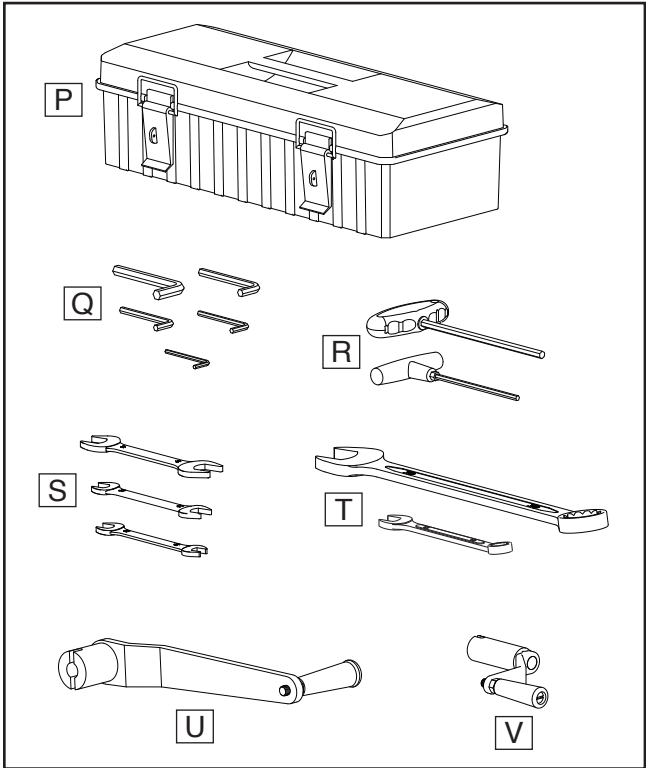


Figure 6. Tools and handles inventory.

| Other (Figure 7) |                        | Qty |
|------------------|------------------------|-----|
| W.               | Workpiece Bridge ..... | 1   |

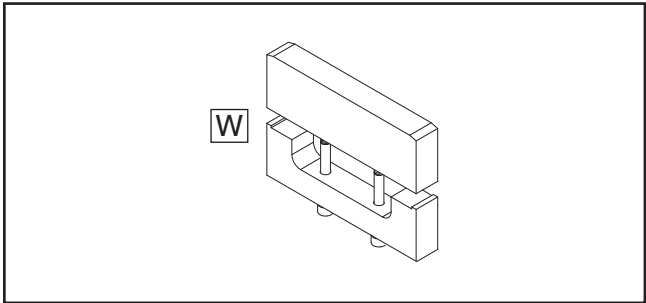


Figure 7. Other inventory.



# Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

#10

1/4"

5/16"

3/8"

7/16"

1/2"



Key

4mm

5mm

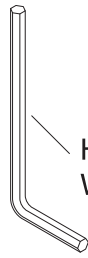
6mm

8mm

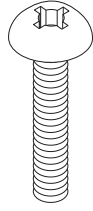
10mm

12mm

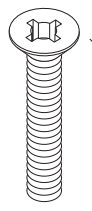
16mm



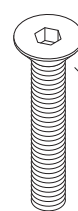
Hex  
Wrench



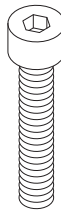
Phillips  
Head  
Screw



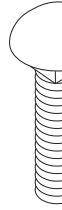
Flat  
Head  
Screw



Flat  
Head  
Cap  
Screw



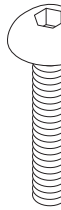
Cap  
Screw



Carriage  
Bolt



Flange  
Bolt



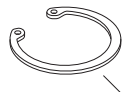
Button  
Head  
Screw



Tap  
Screw



External  
Retaining  
Ring



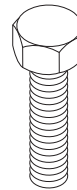
Internal  
Retaining  
Ring



E-Clip



Set  
Screw



Hex  
Bolt



Flat Washer

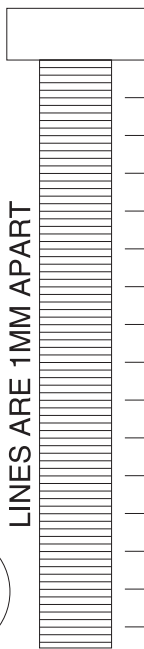


Lock  
Washer



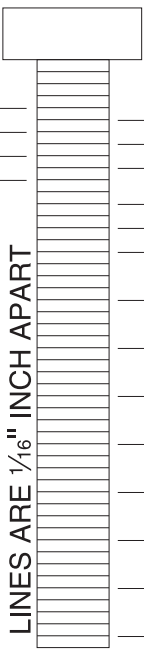
Hex  
Nut

LINES ARE 1MM APART



5mm  
10mm  
15mm  
20mm  
25mm  
30mm  
35mm  
40mm  
45mm  
50mm  
55mm  
60mm  
65mm  
70mm  
75mm

LINES ARE 1/16" INCH APART



1/4"  
3/8"  
1/2"  
5/8"  
5/16"  
7/16"  
9/16"  
3/4"  
7/8"  
1"  
1 1/4"  
1 1/2"  
1 3/4"  
2"  
2 1/4"  
2 1/2"  
2 3/4"  
3"

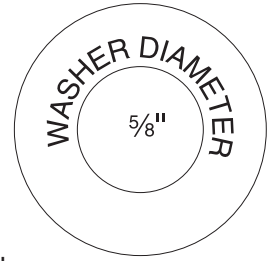
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Lock  
Nut



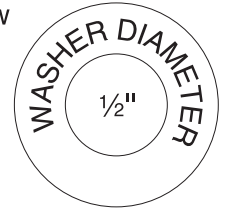
Wing  
Nut



WASHER DIAMETER  
5/8"



WASHER DIAMETER  
9/16"



WASHER DIAMETER  
1/2"



WASHER DIAMETER  
7/16"



WASHER DIAMETER  
3/8"



4mm



WASHER DIAMETER  
5/16"



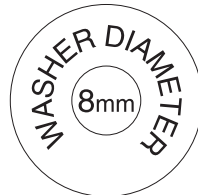
5mm



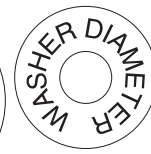
WASHER DIAMETER  
1/4"



WASHER DIAMETER  
10mm



WASHER DIAMETER  
8mm



6mm



#10



# Machine Assembly

The machine must be fully assembled before it can be operated.

1. Attach (2) table support mounting brackets to infeed and outfeed ends of machine with (4) M6-1 x 20 cap screws, (4) 6mm lock washers, and (4) 6mm flat washers (see **Figure 8**).
2. Attach (4) pivot brackets to table support mounting brackets with (4) M8-1.25 hex nuts, (4) 8mm lock washers, and (4) 8mm flat washers (see **Figure 8**).

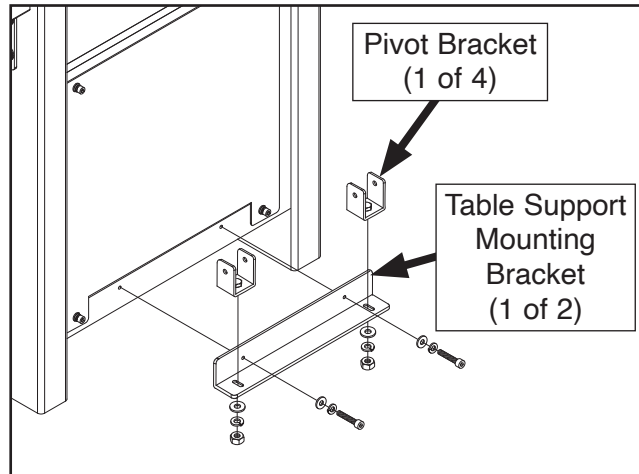


**Figure 8.** Attaching table support mounting brackets and pivot brackets to machine (outfeed end shown).

3. Attach (2) table supports to pivot brackets with (4) M10-1.5 x 60 hex bolts and (4) M10-1.5 lock nuts (see **Figure 9**).

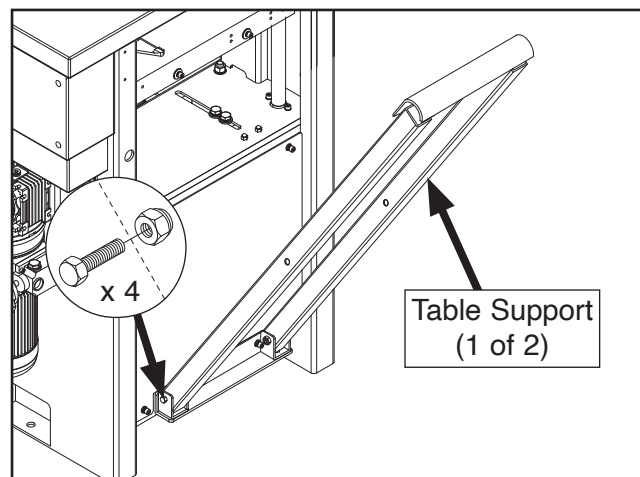


**Figure 9.** Table support attached to pivot brackets (outfeed end shown).



4. Loosely attach (4) table braces to table supports with (4) M10-1.5 x 60 hex bolts, (4) 11 x 25 x 3.5mm spacers, and (4) M10-1.5 lock nuts (see **Figure 10**).

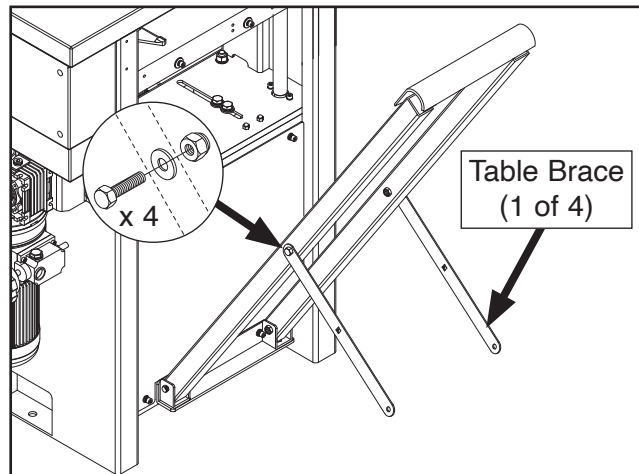


**Figure 10.** Table braces attached to table supports (outfeed end shown).

5. Set outfeed table on outfeed table support and have assistant hold it at end of table bed so you can secure outfeed table to table with (2) M8-1.25 x 20 cap screws, (2) 8mm lock washers, and (2) 8mm fender washers (see **Figure 11**).
6. With assistant still holding outfeed table in place, attach braces to outfeed table with (2) M10-1.5 x 25 hex bolts, (2) 11 x 25 x 3.5mm spacers, and (2) M10-1.5 lock nuts (see **Figure 11**).

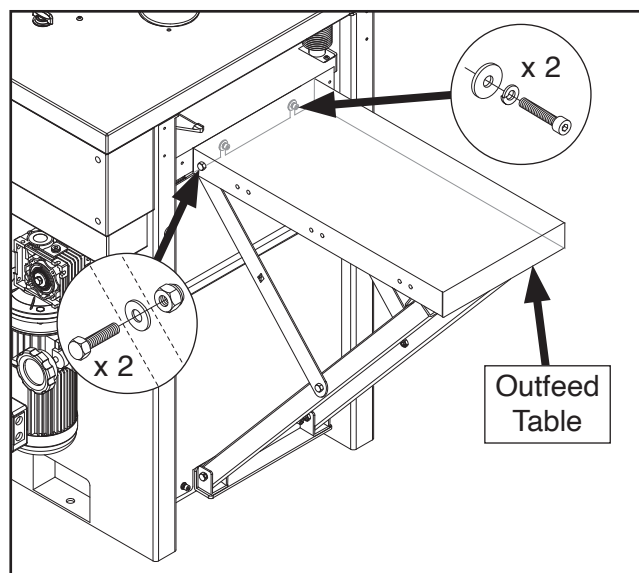


**Figure 11.** Outfeed table installed.

7. Repeat **Steps 5–6** for infeed table.



8. Attach (3) fence mounting brackets to infeed table with (6) M6-1 x 20 cap screws, (6) 6mm lock washers, and (6) 6mm fender washers (see **Figure 12**).

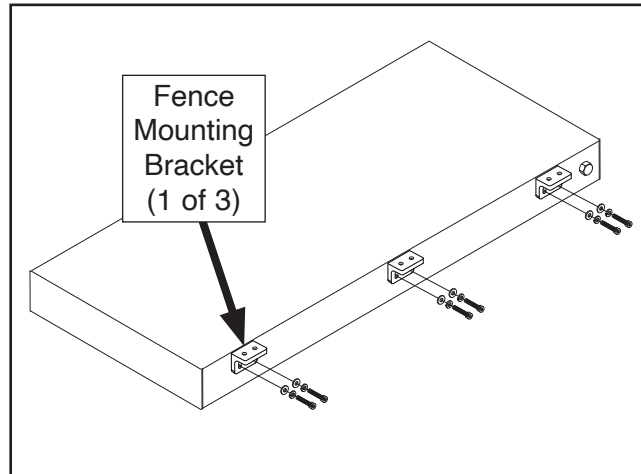


**Figure 12.** Attaching fence mounting brackets to infeed table (machine and table support removed for clarity).

9. Attach (3) fence rod mounts to fence mounting brackets with (3) M8-1.25 x 20 cap screws and (3) 8mm lock washers (see **Figure 13**).

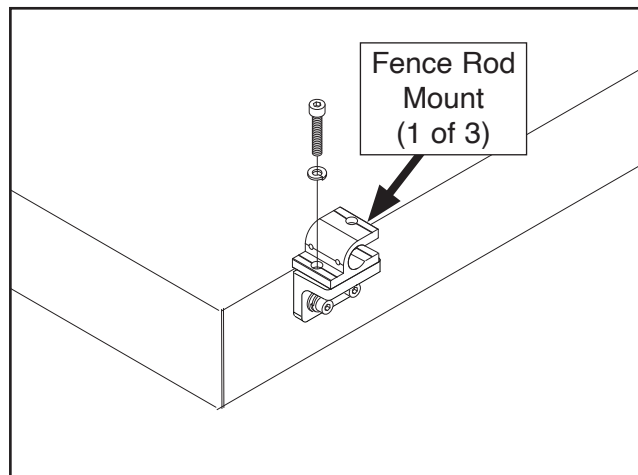


**Figure 13.** Attaching fence rod mount to fence mounting bracket.



10. Place (1) fence adjustment rod in each fence rod mount, as shown in **Figure 14**, then secure with (3) M8-1.25 x 40 cap screws and (3) 8mm lock washers.

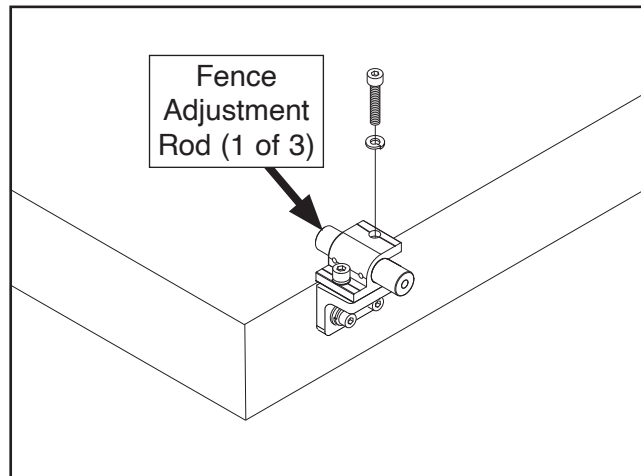


**Figure 14.** Securing fence adjustment rod in fence rod mount.

11. Attach infeed extension fence to fence adjustment rods with (3) M8-1.25 x 16 hex bolts, (3) 8mm lock washers, and (3) 8mm flat washers (see **Figure 15**).

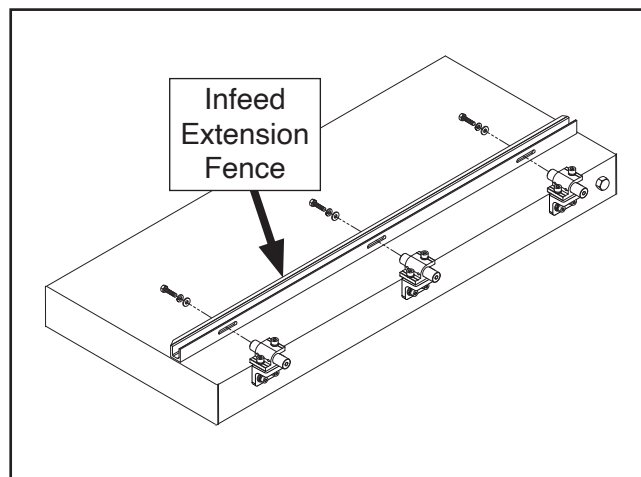


**Figure 15.** Attaching infeed extension fence to fence adjustment rods (machine and table support removed for clarity).



# Connecting Dust Collection System

## CAUTION

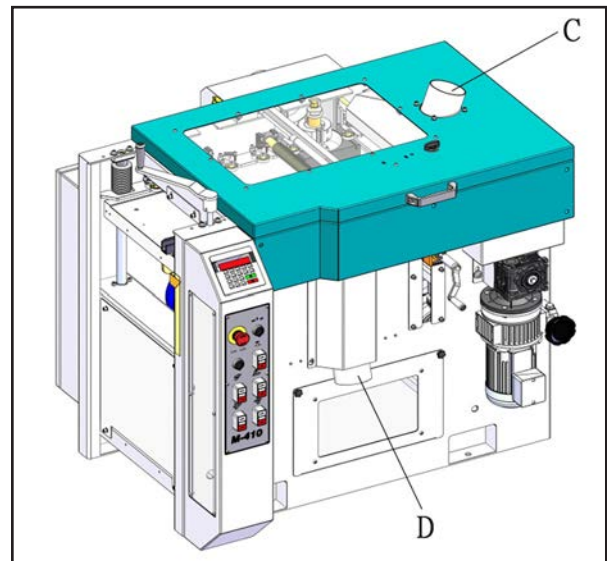
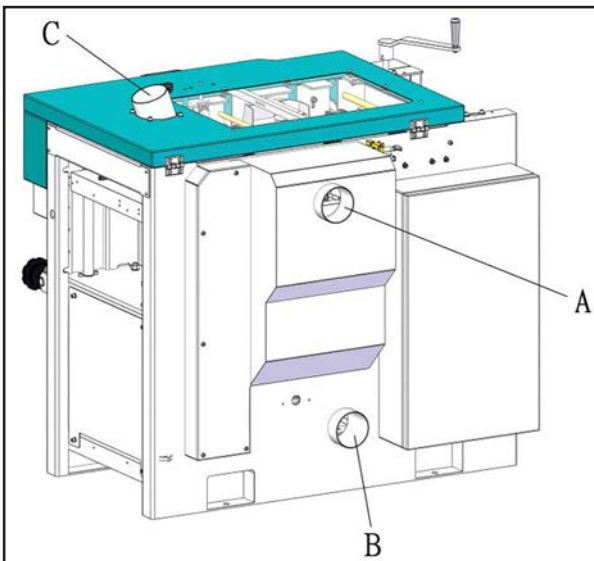
This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

### Minimum CFM at Each Dust Port: 400 CFM

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

1. Start dust collector before operating the machine.
2. Connect 4" hose connectors and 4" flexible hoses to the (4) dust hood outlets on the machine.

**Attach 4" dust hoses at the locations shown below:**



# Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the POWER SUPPLY section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.

To connect the prepared power supply wires to the machine, use the steps below.

1. Connect incoming power wires to the "R", "S", and "T" terminals shown in **Figure 16**. Connect ground wire to "E" terminal.



**Figure 16.** Location of ground and power terminals.

## WARNING

Make sure incoming ground wire is connected to correct terminal to ensure machine will be properly grounded. An ungrounded or improperly grounded machine can cause electrocution if live electrical wires make contact with frame or other parts touched by operator.

2. Press EMERGENCY STOP button on control panel, then twist it clockwise to reset it (see **Page 6** for details).
3. Connect machine to power, then turn power ON/OFF switch to ON position (see **Page 6** for details).



4. Press left and right cutterhead green start buttons to start cutterheads and observe cutterhead rotation from above (see **Figure 17**), then press red stop buttons to stop cutterheads.
  - a. If left cutterhead turns clockwise and right cutterhead turns counterclockwise, then power wires are connected correctly.
  - b. If left cutterhead turns counterclockwise and right cutterhead turns clockwise, DISCONNECT MACHINE FROM POWER. Swap position of any two of the incoming "R", "S", and "T" power wires.

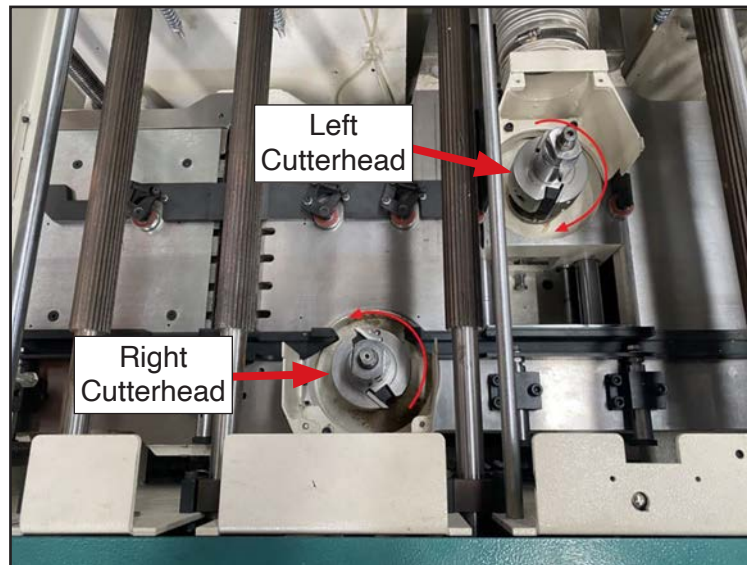


**Figure 17.** Correct cutterhead rotation (shown from right side of machine with top door opened for clarity).

**NOTICE :**

1. The prepared 3-phase power conduit should contain 3 power wires and one yellow/green ground wire. The conduit must be long enough to reach the machine junction box without putting stress on the wires.
2. Install a strain relief at the junction box hole to secure and protect the conduit at the power supply junction box on the machine.

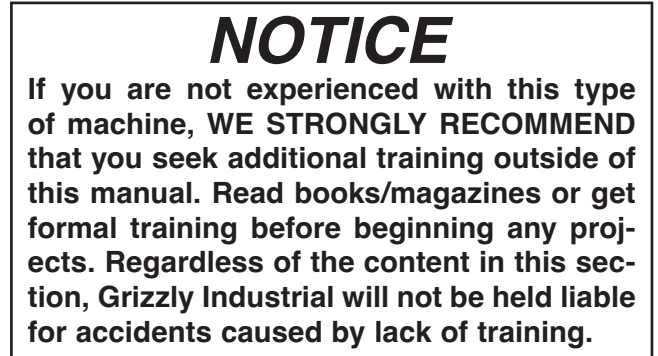
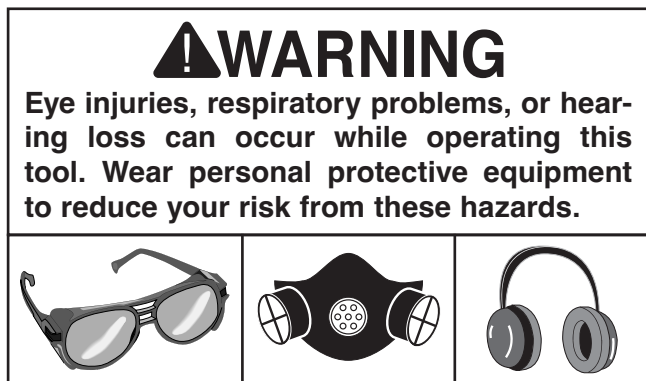


# MACHINE OPERATION

## Operation Overview

The purpose of this overview is to provide the operator with a basic understanding of how the machine is used during operation, so the 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.



### Typical Planing Operation

When planing on the Model G0984, the upper and right cutterheads size the material while the lower and left cutterheads surface plane the opposite sides of the workpiece. The steps below describe a typical operation using all four cutterheads, but the machine can also be configured to plane only the face of the workpiece like a typical planer.

**NOTICE :** Do not exceed maximum depth of cut for upper and lower cutterheads in a single pass.

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

1. Examines the workpiece to make sure it is suitable for planing.
2. DISCONNECTS MACHINE FROM POWER, then opens top door.
3. Installs planing knives.
4. Sets lower cutterhead depth to create a flat surface on bottom of workpiece.
5. Adjusts table elevation and left/right cutterhead height according to workpiece thickness.
6. Adjusts left cutterhead position and infeed fence according to workpiece width and installs or removes workpiece bridge, if necessary.
7. Closes top door. Machine will not start if top door is not in closed position.



8. Puts on safety glasses, respirator, and hearing protection.
9. Connects machine to power, then starts planer/moulder and dust collection system.
10. Adjusts feed rate as desired.
11. Stands to one side of machine to reduce risk of kickback injuries, then feeds workpiece into machine until feed system grabs it and feeds it through machine.
12. Once workpiece is clear of machine and stops moving, turns **OFF** machine and disconnects it from power.
13. Removes workpiece and measures thickness and width.
  - If further planing is required, operator "zeroes" infeed fence and lower cutterhead depth of cut, adjusts table elevation and left cutterhead position to slightly increase depth of cut as necessary, then repeats **Steps 9–13**.

### Typical Moulding Operation

When moulding on the Model G0984, the upper, right, and left cutterheads can be configured to cut a profile into the material while the lower cutterhead surface planes the bottom of the workpiece.

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

1. Examines the workpiece to make sure it is suitable for moulding.
2. DISCONNECTS MACHINE FROM POWER, then opens top door.
3. Installs desired planing/moulding knives in upper, right, and left cutterheads.
4. Sets lower cutterhead depth to create a flat surface on bottom of workpiece, if necessary.
5. Adjusts table elevation according to workpiece height.
6. Adjusts left/right cutterhead height according to workpiece thickness and desired profile.
7. Adjusts left cutterhead position and infeed fence according to workpiece width and installs or removes workpiece bridge, if necessary.
8. Closes top door. Machine will not start if top door is not in closed position.
9. Puts on safety glasses, respirator, and hearing protection.
10. Connects machine to power, then starts planer/moulder and dust collection system.
11. Adjusts feed rate to lowest setting.
12. Stands to one side of machine to reduce risk of kickback injuries, then feeds workpiece into machine until feed system grabs it and feeds it through machine.
13. Once workpiece is clear of machine and stops moving, turns **OFF** machine and disconnects it from power.
14. Removes workpiece and examines moulding results.
  - If further moulding is required, operator "zeroes" lower cutterhead depth of cut, adjusts table elevation, infeed fence, and left cutterhead position to slightly increase depth of cut, then repeats **Steps 10–14**.



# Replacing Upper/Lower Cutterhead Knives

The Model G0984 ships with four HSS, single-sided, solid planing knives installed in the upper and lower cutterheads. If you wish to install moulding knives in the upper cutterhead, refer to **MACHINE ACCESSORIES** on **Page 45** for the required gibs and the moulding knives that Grizzly offers.

When checking, resetting, and replacing the planer knives, follow these steps:

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Remove the button head screw and turn the door knob (A) clockwise to unlock the top door (see **Figure 18**).
3. Turn the knife gib bolts (F) (see **Figure 19**) clockwise to loosen the knife gibs (G).

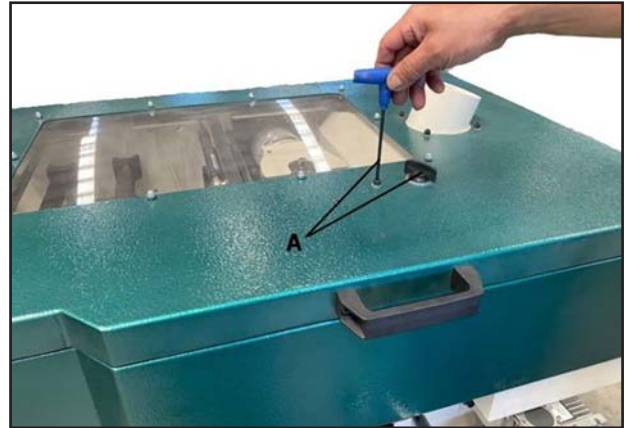


**Figure 18.** Location of top door components.

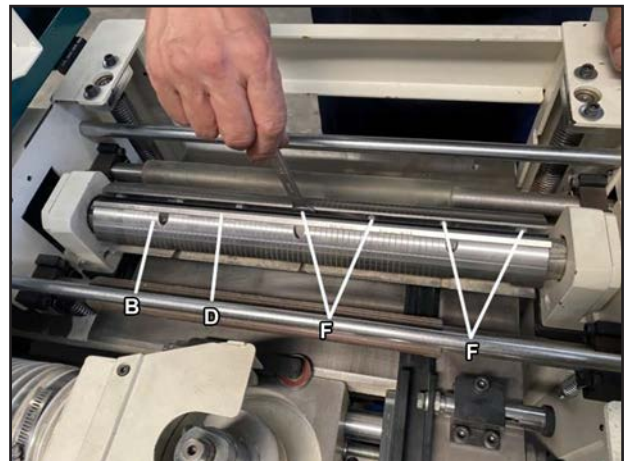


**Figure 19.** Location of gib, knife, and gib screws.

4. Put on protective gloves, then carefully remove the gib (G), knife (D), and jack screws (H) (see **Figure 20**). Remove the remaining knife in the same manner.
5. Thoroughly clean the cutterhead, knife (D), gibs (G), jack screws (H), and gib bolts (F). Check the screws and bolts; if the threads appear worn or stripped, or if the heads are damaged, replace them.
6. Install the new knife (D), jack screws (H), gib (G), and gib bolts (F).

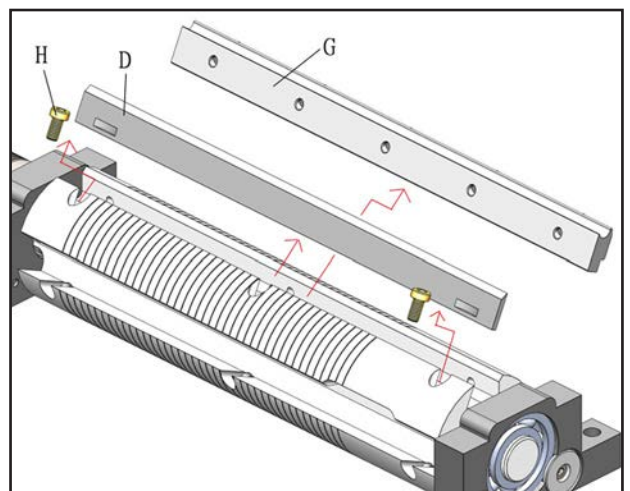


**Figure 20.** Removing gib, knife, and jack screws.



7. Carefully position the knife setting gauge (C) (see **Figure 21**), so the gauge is on the cutterhead radius.
8. Tighten the gib bolts (F) just enough so the gib exerts a little pressure on the cutterhead (see **Figure 21**).

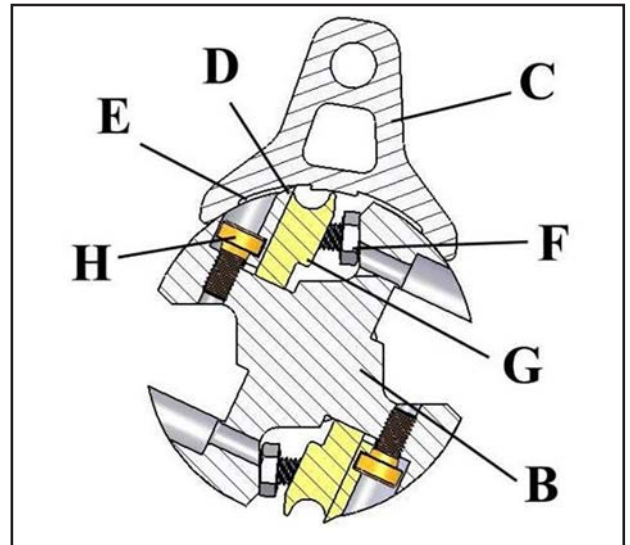


**Figure 21.** Knife installation components.

9. Turn the jack screws (H) (see **Figure 22**), located between the knife groove and the cutterhead slot (see **Figure 22**), to raise the knife until it just contacts the gauge's 0.787" depth groove (E) (see **Figure 21**). Secure the setting by turning the gib bolts (F) counterclockwise. Install the remaining knife in the same manner.

**NOTICE :**

When tightening the gib bolts (F), first tighten the side bolts, then tighten them inward toward the center of the cutterhead.

10. Close and secure top door.

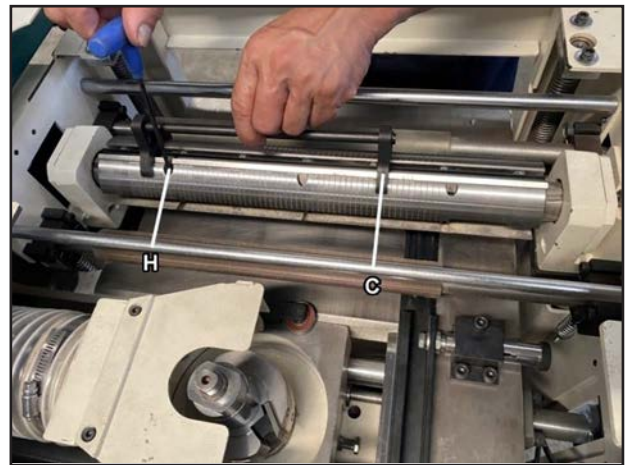


**Figure 22.** Knife installation components.



# Replacing Left/Right Cutterhead Knives

When checking, changing, or replacing the knives in the left and right vertical cutterheads, follow these steps:

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Remove the button head screw and turn the door knob (A) clockwise to unlock the top door (see **Figure 23**).
3. Put on protective gloves.

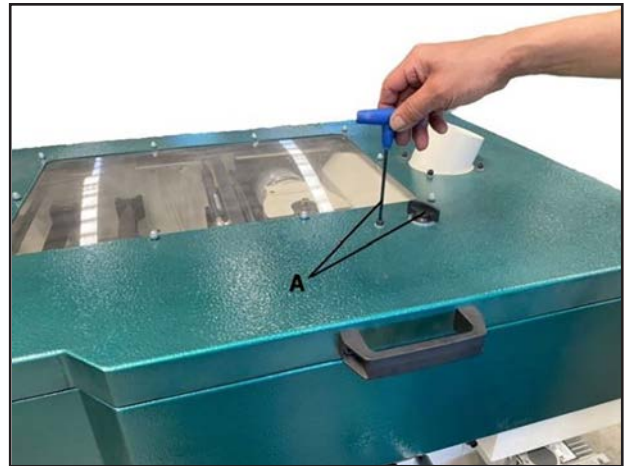


**Figure 23.** Location of top door components.

4. Loosen gib screw (B) until you can remove gib (C) (see **Figure 24**) from cutterhead.
5. Replace knife (D) (see **Figure 24**), install gib (C), and tighten gib screw (B) until knife is secure.
6. Replace the remaining knife in the same manner.
7. Close and secure top door.

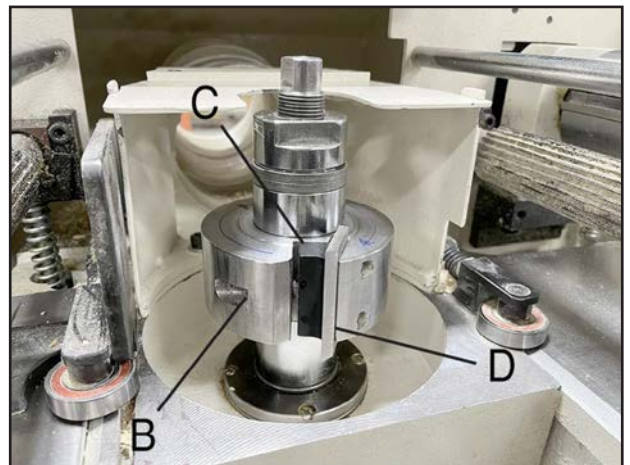


**Figure 24.** Location of gib, knife, and gib screw.

## **NOTICE :**

When changing the left and right cutterhead knives, the cutterhead height may need to be adjusted. Refer to **Adjusting Left/Right Cutterhead Height** on **Page 38** for more details.



# Adjusting Lower Cutterhead Depth of Cut

The Model G0984 comes with three metal sheets of varying thicknesses: 1mm (A), 1mm (B), and 2mm (C) (see **Figure 25**). These sheets can be installed on the infeed table bed and will determine the amount of material that is surface planed.

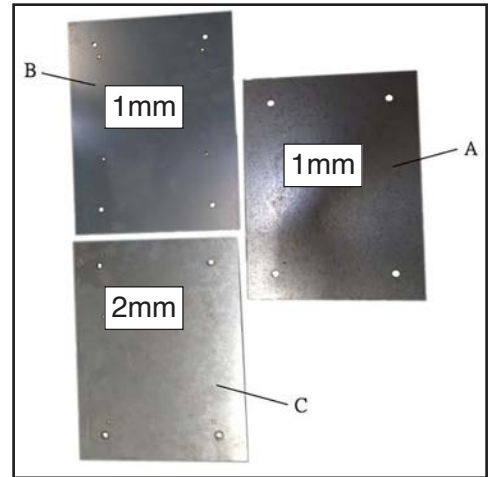


**Figure 25.** Included depth-of-cut sheets.

When no depth-of-cut sheets are installed on the infeed table bed (D), as shown in **Figure 26**, the lower cutterhead depth of cut is 4mm.

The 1mm sheet will produce a 3mm depth of cut while the 2mm sheet will produce a 2mm depth of cut. Stack more than one sheet together as necessary to produce your desired results.

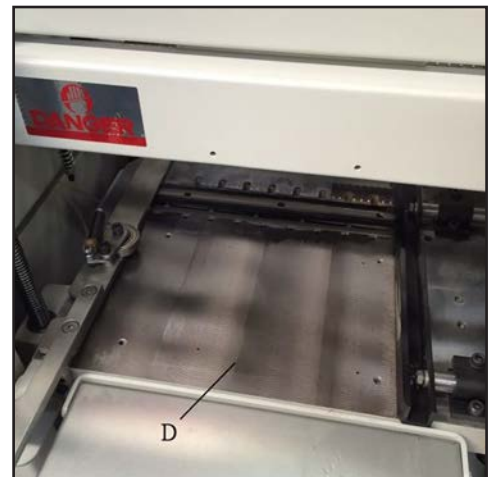


**Figure 26.** Infeed table bed without sheets installed.

Remove the (4) flat head screws (E) shown in **Figure 27**, then install the depth-of-cut sheets (A/B/C) as desired. Install the flat head screws to secure.

## NOTICE :

If all three depth-of-cut sheets are used together, the depth of cut is 0mm.

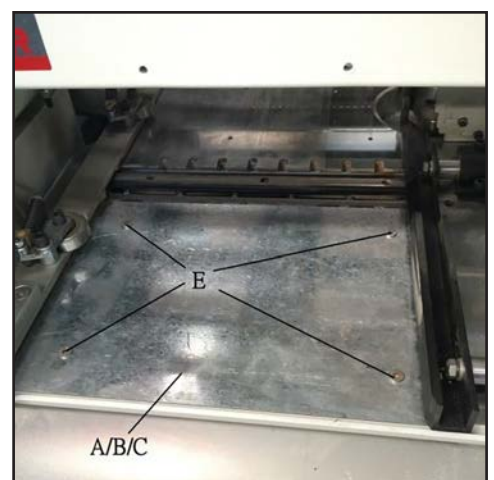


**Figure 27.** Location of depth-of-cut sheet screws.



# Adjusting Table Elevation

## Using Table Elevation Adjustment Handle

To manually move the work table up and down, use the crank (A) (see **Figure 28**) to turn the table elevation leadscrew (B).

- Turn crank clockwise to raise the table.
- Turn crank counterclockwise to lower the table.

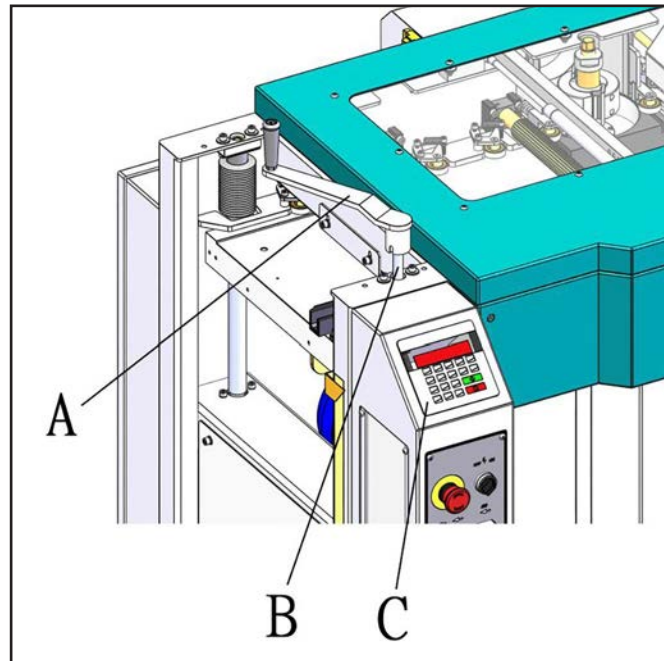


**Figure 28.** Table elevation controls.

## NOTICE :

After the work table is adjusted manually, the table elevation digital controller (C) needs to be calibrated to the table position.



### Using Table Elevation Digital Controller

Use the following example to see how to adjust the table elevation using the table elevation digital controller. In this example, the table elevation is at 100.0mm, as shown in **Figure 29**, but we want to raise the table to 200.0mm.

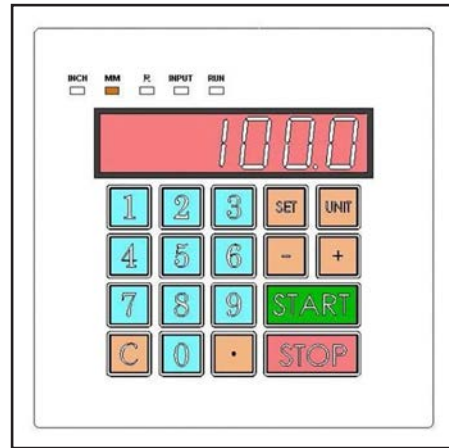


**Figure 29.** Table elevation set to 100.0mm.

1. Press SET button. Display will enter input mode and show the number 0 (see **Figure 30**).

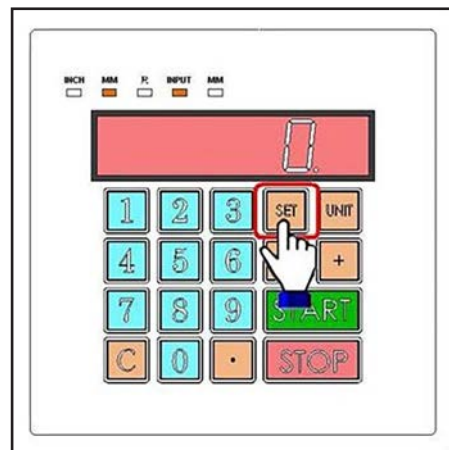


**Figure 30.** Pressing SET button.

2. Use numerical keypad to enter desired table position of 200mm (or 200.0mm) (see **Figure 31**).
  - a. You can also use the + and - buttons to manually raise or lower the display value (see **Figures 32–33**). Press and hold + button until display increases to 200.0mm.

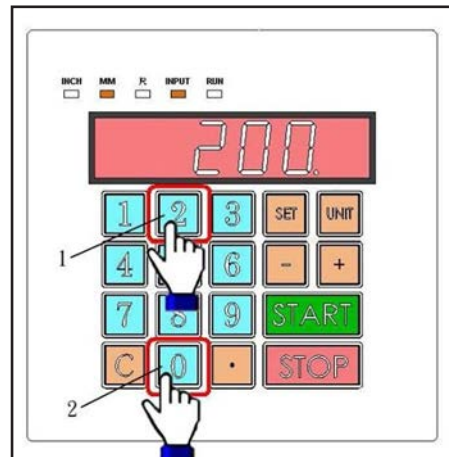


**Figure 31.** Entering 200.0mm value.



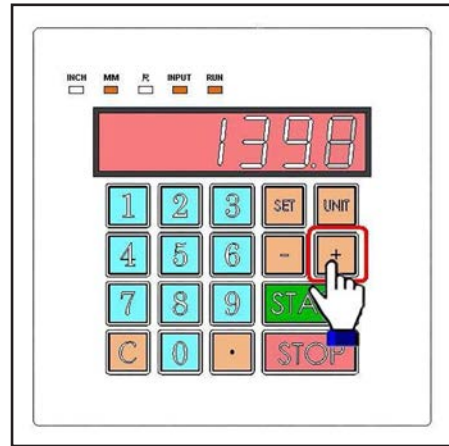


**Figure 32.** Manually increasing value.

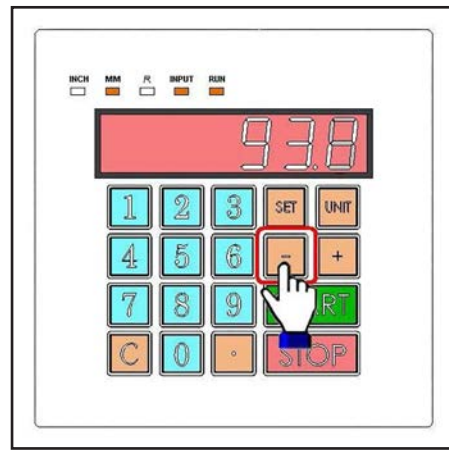


**Figure 33.** Manually decreasing value.

3. Press  button (see **Figure 34**) to input value. Display will revert back to 100mm to display table position as it approaches 200mm.

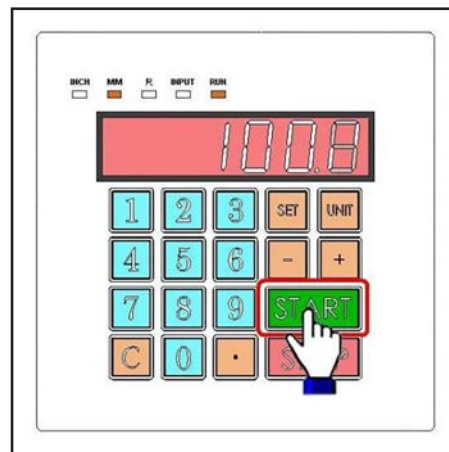


**Figure 34.** Inputting desired value.



### Calibrating Table Elevation Digital Controller

When the planed material thickness does not match the value displayed on the table elevation digital controller, calibrate the controller. For example, if the current number displayed on the controller is 85.6mm, as shown in **Figure 35**, and the planed material is 100mm thick, then calibrate the controller as follows:

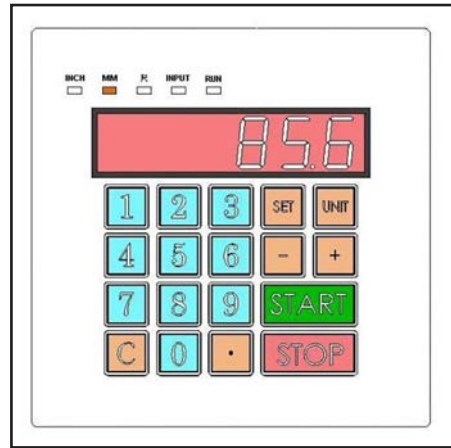


**Figure 35.** Example of displayed value that needs calibration.

1. Press SET button. Display will enter input mode and show the number 0 (see **Figure 36**).

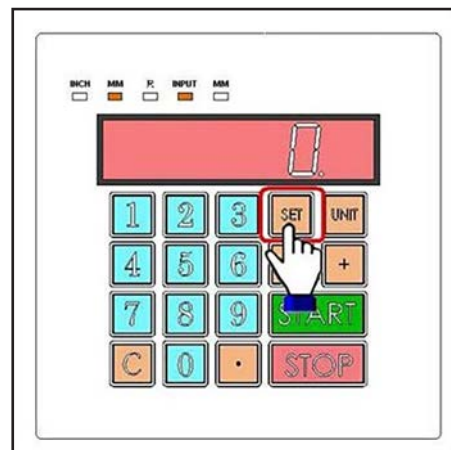


**Figure 36.** Pressing SET button.

2. Use numerical keypad to enter the correct table elevation value (100mm) (see **Figure 37**).
3. Press and hold SET button until display value stops flashing.

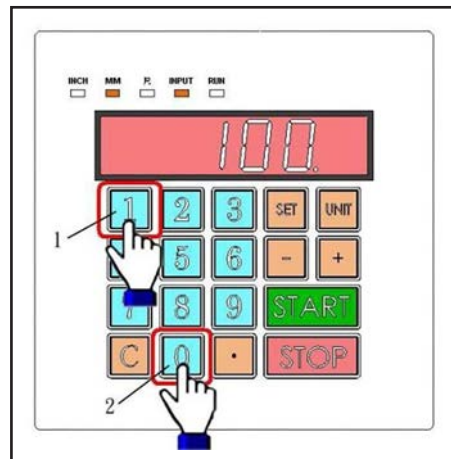


**Figure 37.** Entering correct value.

### NOTICE :

If pressing and holding the SET button does not work, or the number entered is incorrect, it means the last input was invalid. Please do it again.



# Adjusting Left/Right Cutterhead Height

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Remove the button head screw and turn door knob (A) clockwise to unlock the top door (see **Figure 38**).
3. Put on protective gloves.

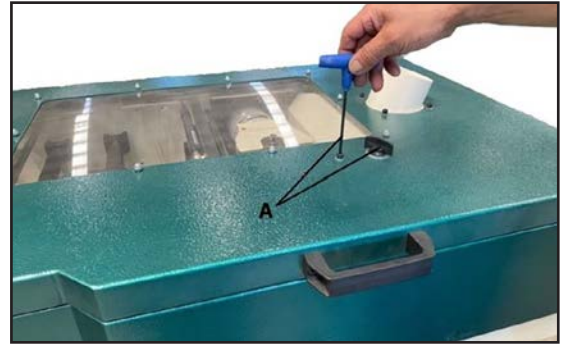


**Figure 38.** Location of top door components.

4. Remove the cutterhead nut (G) with a 30mm wrench (E) and 14mm wrench (F) (see **Figure 39**).
  - On the left cutterhead, nut loosens clockwise.
  - On the right cutterhead, nut loosens counterclockwise.



**Figure 39.** Removing cutterhead nut.

5. According to the thickness of the material, arrange the cutterhead (D) and spacers (C) as needed on the cutterhead spindle (B) (see **Figures 40–41**).
6. Install cutterhead nut, then adjust remaining vertical cutterhead in the same manner.
7. Close and secure top door.



**Figure 40.** Placing cutterhead on top of spacers.



**Figure 41.** Placing spacers on top of cutterhead.



# Adjusting Left Cutterhead Position

The left vertical cutterhead can be moved across the machine table to the desired position according to the workpiece width. This is accomplished via a crank handle located on the right side of the machine. Once the position is set, remove the handle so it is not moved accidentally.

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Before adjusting the left cutterhead, loosen the lock lever (C) (see **Figure 42**), under the outfeed table.
3. Turn the left cutterhead adjustment handle (see **Figure 43**).
  - a. Turn clockwise to reduce the working width.
  - b. Turn counterclockwise to increase the working width.
4. After the desired position is set, tighten the left cutterhead lock lever.

## NOTICE :

There is a position indicator readout above the adjustment handle that can provide you with a reference for resetting the machine.

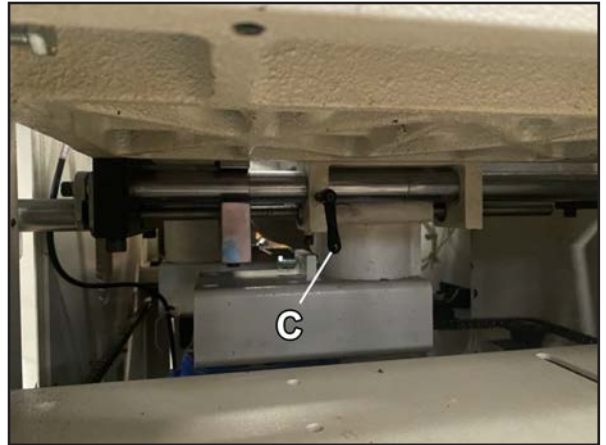


**Figure 42.** Location of left cutterhead lock lever.



**Figure 43.** Left cutterhead adjustment handle.



# Adjusting Infeed/Outfeed Fence

To adjust the fences, loosen the cap screws and turn the knobs (see **Figure 44**).

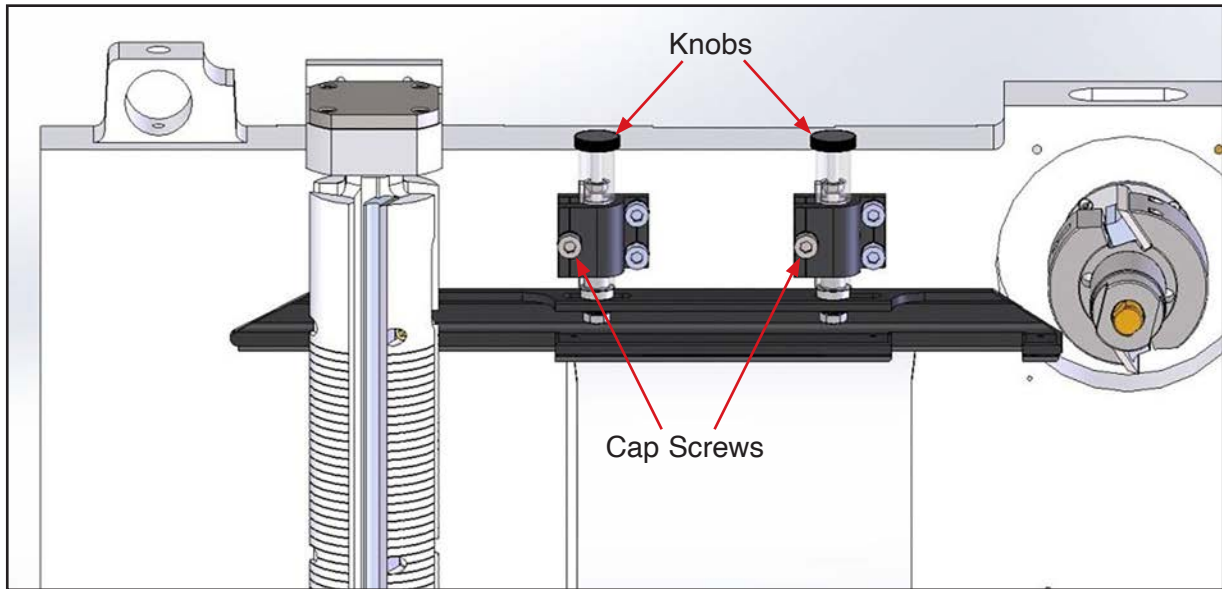


**Figure 44.** Location of fence cap screws and knobs (top view shown).

1. Adjust the outfeed fence so it is 90° to the upper cutterhead (see **Figure 45**).
2. Adjust the outfeed fence so it is aligned to the knives on the right cutterhead (see **Figure 45**).

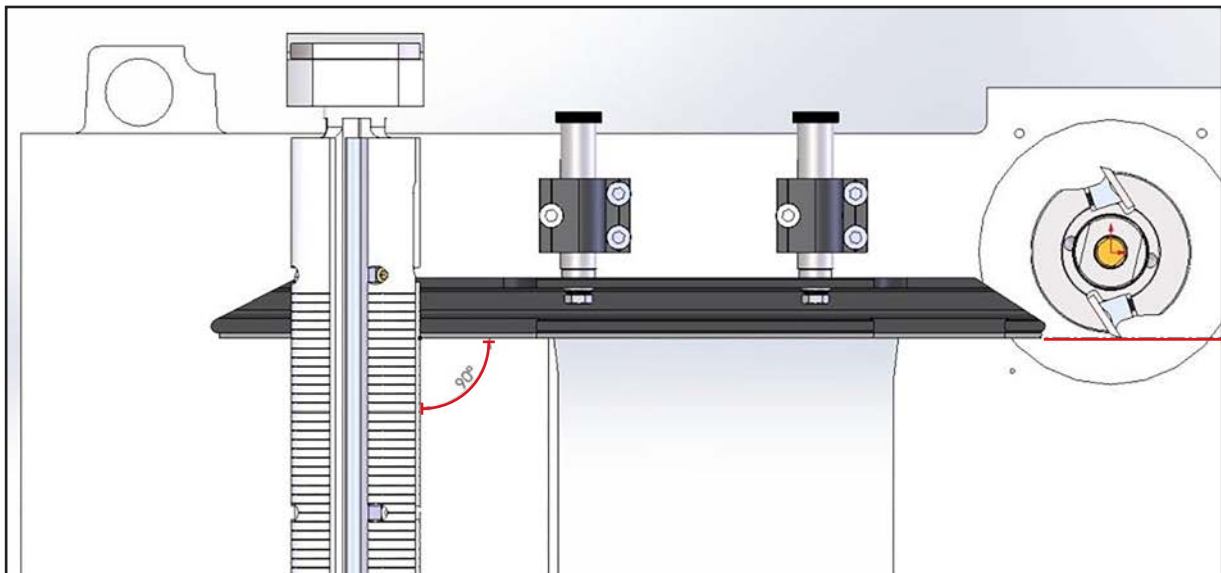


**Figure 45.** Outfeed fence 90° to upper cutterhead and aligned with right cutterhead knives (top view shown).



3. Align the infeed fence to the outfeed fence (see **Figure 46**).

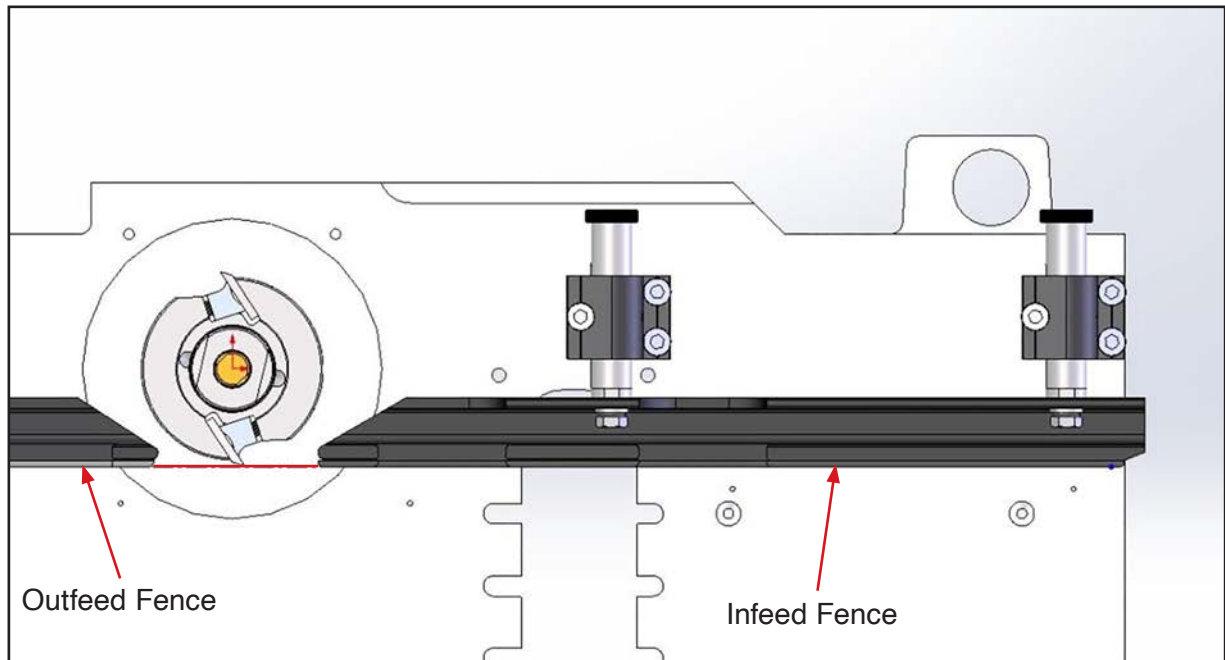


**Figure 46.** Infeed fence aligned with outfeed fence (top view shown).

4. Adjust the infeed fence to the desired depth of cut for the right cutterhead (see **Figure 47**).

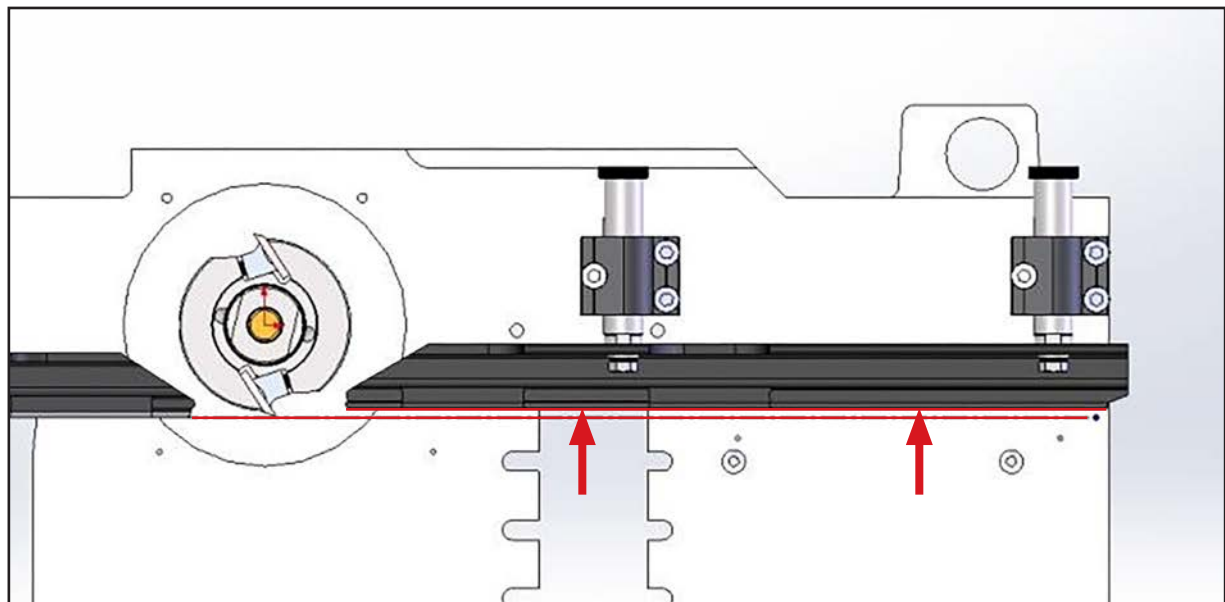


**Figure 47.** Infeed fence adjusted for desired depth of cut (top view shown).

5. Tighten fence cap screws to secure.



# Installing/Removing Workpiece Bridge

The workpiece bridge is installed to prevent the workpiece from falling into the table gap next to the left cutterhead. If the workpiece is less than 43mm wide, remove the workpiece bridge. If the workpiece is more than 43mm wide, install the workpiece bridge.

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Install/remove the workpiece bridge depending on the width of your workpiece.
  - a. To remove the bridge, remove the cap screws (C) shown in **Figure 48**, then remove the workpiece bridge (A) and the fixing base (B).
  - b. To install the bridge, remove the cap screws (C), install the workpiece bridge (A) and fixing base (B) as shown in **Figure 49**, then install the cap screws to secure.

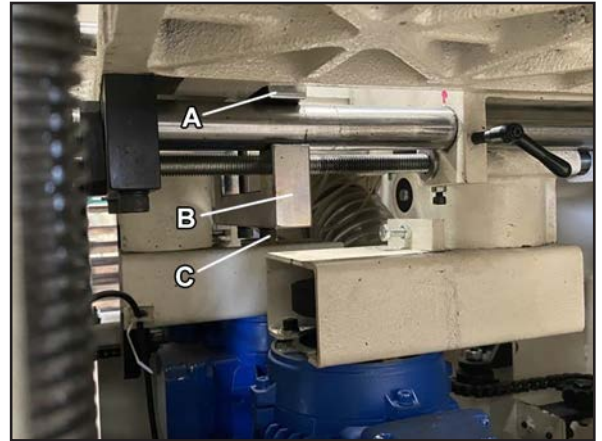


**Figure 48.** Workpiece bridge installed (shown from below).

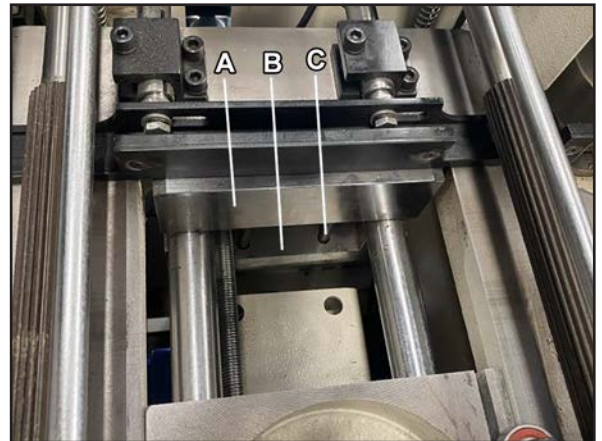


**Figure 49.** Workpiece bridge installed (shown from above).



# Adjusting Feed Speed

Adjust the feed speed according to the workpiece thickness, workpiece hardness, and depth of cut. Adjust the feed speed as follows:

1. The transmission is lubricated with liquid lubricant. The lubricating oil grade is ISO 320. Please check the oil level before using the feed system.

## NOTICE :

Lubricating oil has been added to the machine at the factory. Lubricating oil should be changed after **the first 2,000 hours of use and every 5,000 hours thereafter**. The lubricating oil in the gearbox should be maintained at two-thirds of the oil level gauge. Users should check the oil level frequently. Using the wrong lubricating oil or failure to change oil WILL result in machine damage.

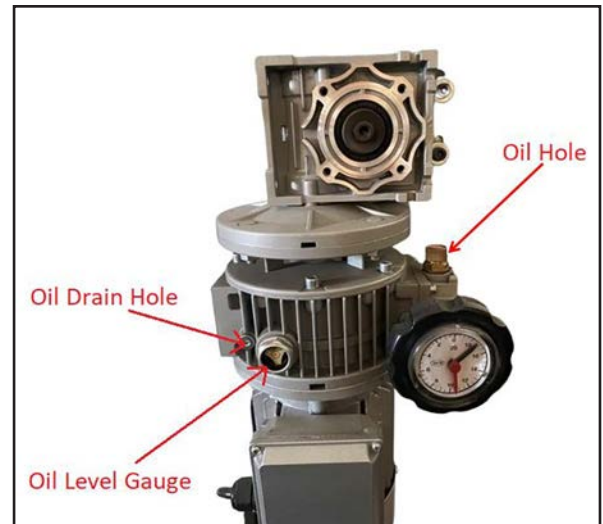


**Figure 50.** Feed system lubrication components.

2. Turn the adjustment knob, shown in **Figure 51**, to adjust the feed speed between 7–47 FPM. Turn knob clockwise to increase speed; turn knob counterclockwise to decrease speed.

## NOTICE :

Only adjust feed speed while feed system is moving to prevent machine damage.



**Figure 51.** Location of feed speed adjustment knob.



The red hand on the feed speed adjustment knob turns 360 degrees for each whole number the black hand moves (see **Figure 52**) on the reference scale. Refer to the chart below for the RPM and FPM equivalents.



**Figure 52.** Feed speed adjustment knob reference scale.

| Gear Ratio: 7.5 |                      | Frequency: 60HZ       |
|-----------------|----------------------|-----------------------|
| Scale           | Rotation Speed (RPM) | Linear Velocity (FPM) |
| 2               | 21.6                 | 7.12                  |
| 4               | 22.5                 | 7.41                  |
| 6               | 31.8                 | 10.4                  |
| 8               | 46.8                 | 15.42                 |
| 10              | 62.9                 | 20.73                 |
| 12              | 80.7                 | 26.61                 |
| 14              | 100                  | 32.97                 |
| 16              | 120.7                | 39.8                  |
| 18              | 144                  | 47.47                 |



# MACHINE 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.

### **Vertical Cutterhead Knives**

These HSS knives come in pairs and fit the Model G0984 vertical cutterheads. See our website for profiles and images.

- T34175—Side Planer Knives**
- T34176—Rounded Top Side Knives**
- T34177— $\frac{3}{4}$ " S4S Side Knives**
- T34178— $\frac{3}{4}$ " T&G Flooring Knives Female**
- T34179— $\frac{3}{4}$ " T&G Flooring Knives Male**
- T34180— $1\frac{1}{2}$ " T&G Knives Female**
- T34181— $1\frac{1}{2}$ " T&G Knives Male**
- T34182— $\frac{3}{4}$ " Shiplap Side Knives**
- T34183— $\frac{3}{4}$ " V-Shiplap Side Knives**
- T34184— $\frac{3}{4}$ " Paneling V-Groove Knives Male**
- T34185— $\frac{3}{4}$ " Paneling V-Groove Knives Female**
- T34186—Bottom Relief Knives**
- T34187—Baseboard Ogee Profile Knives**
- T34188—Baseboard Bottom Knives**
- T34189— $\frac{3}{4}$ " Crown Molding Top Knives**
- T34190— $2\frac{1}{4}$ " Crown Molding Top Knives**
- T34192—Crown Molding Side Knives**
- T34193—Straight Top Knives**
- T34194—Ogee Profile Knives**

### **T34390—Upper Cutterhead Moulding Gibs, 2-Pk**

These gibs allow you to install moulding gibs in the upper cutterhead to profile the face of your workpiece.



**Figure 53.** T34390 Upper Cutterhead Moulding Gibs.

### **Upper Cutterhead Knives**

These HSS knives come in pairs and fit the Model G0984 upper cutterhead when used with the Model T34390 gibs. See our website for profiles and images.

- T34175—Side Planer Knives**
- T34176—Rounded Top Side Knives**
- T34177— $\frac{3}{4}$ " S4S Side Knives**
- T34178— $\frac{3}{4}$ " T&G Flooring Knives Female**
- T34179— $\frac{3}{4}$ " T&G Flooring Knives Male**
- T34180— $1\frac{1}{2}$ " T&G Knives Female**
- T34181— $1\frac{1}{2}$ " T&G Knives Male**
- T34182— $\frac{3}{4}$ " Shiplap Side Knives**
- T34183— $\frac{3}{4}$ " V-Shiplap Side Knives**
- T34184— $\frac{3}{4}$ " Paneling V-Groove Knives Male**
- T34185— $\frac{3}{4}$ " Paneling V-Groove Knives Female**
- T34186—Bottom Relief Knives**
- T34187—Baseboard Ogee Profile Knives**
- T34188—Baseboard Bottom Knives**
- T34189— $\frac{3}{4}$ " Crown Molding Top Knives**
- T34190— $2\frac{1}{4}$ " Crown Molding Top Knives**
- T34191— $4\frac{3}{4}$ " Crown Molding Top Knives**
- T34192—Crown Molding Side Knives**
- T34193—Straight Top Knives**
- T34194—Ogee Profile Knives**
- T34197—Casing Undercutter Knives**

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



# MACHINE MAINTENANCE

---

The machine inspection and maintenance is the responsibility of the operator. Thoroughly performing daily or routine inspection and maintenance will enable you to prevent problems from occurring, which may reduce the possibility of machine damage. The correct cleaning and maintenance of the machine will not only keep the machine operating optimally, but also prevent injuries to the operator.

## Daily Maintenance

1. Make sure the machine has been disconnected from power before performing any inspection, cleaning, or maintenance.
2. After use, use an air gun and cleaning tool to remove the wood dust, chips, or glue accumulated on the machine. Do not blow compressed air directly into cutterhead bearings to prevent any objects or dust from entering the cutterhead bearing. Failure to comply may cause damage to these critical parts.
3. After use, clean all tables and pressure rollers. Coat them with a little wax or oil to prevent them from rusting.
4. After use, clean the cutterhead knives and check them for breakage or wear. Any worn or broken knives must be replaced. Coat knives with a little oil to prevent them from rusting.
5. Use proper tools to inspect safety guards, fasteners, and the machine parts. All parts must be in position and securely fastened. If any safety guards or covers are damaged, repair or replace them immediately.
6. The top door limit switch should be checked and kept clean. If it becomes damaged, replace it immediately.

## Biweekly Maintenance

1. **EMERGENCY STOP BUTTON**  
Inspect and test EMERGENCY STOP button every two weeks to ensure it is working correctly. When EMERGENCY STOP button is pressed, the machine **MUST** stop running immediately.
2. **INPUT POWER WIRES**  
Check the incoming power wires every two weeks to ensure they are not strained, damaged, broken, or have poor contacts.
3. **BRAKING DEVICES**  
Inspect and test all braking devices for motor transmission shafts every two weeks. Motor brakes should stop their motors within 7–10 seconds.
4. **HUMIDITY INSPECTION**  
Inspect and test humidity in working environment every two weeks. The humidity of the environment should be kept in the range of 10–90% RH. Too much humidity in the working environment may cause rusting on motor braking devices, which can reduce their braking function.



# Monthly Maintenance

1. Make sure the machine has been disconnected from power before performing any inspection, cleaning, or maintenance.
2. Inspect and test electric controls. If any button or switch is damaged, or if wires are broken or have poor contacts, repair or replace them immediately.
3. Check V-belts once a month. If necessary, adjust belt tension. If any belt is damaged or worn, replace it immediately.
4. Check transmission chain once a month. If necessary, adjust chain tension. If chain is damaged or worn, replace it immediately.
5. Clean dust off of motor surfaces and fans.
6. When motor or shaft is equipped with a braking device, check its brake disc. Adjust the gap if necessary. If brake disc is broken or failed, replace it with a new one.

# Yearly Maintenance

1. Make sure the machine has been disconnected from power before performing any inspection, cleaning, or maintenance.
2. Apply an ohmmeter to inspect the motor insulation condition. If the resistance is under 2 mega ohms, repair or replace motor immediately.
3. Check all machine parts to see if they are rusted or not. If parts are rusted, remove rust and spray or coat oil on the parts for protection.
4. When the machine is not in use for a long time, coat table, transmission shafts, cutters, chain sprockets, and chains with oil. This will prevent parts from rusting.



# Lubrication

1. **BEFORE LUBRICATING MACHINE, DISCONNECT MACHINE FROM POWER!**
2. Lubricate the locations as shown in **Figures 54–56** as described in the chart below.

| INDEX | POSITION              | INTERVAL | TYPE OF OIL |
|-------|-----------------------|----------|-------------|
| A.    | Feed Roller Bushings  | Daily    | SAE-30      |
| B.    | Table Lift Screws (2) | Monthly  | Grease      |
| C.    | Table Slide Ways (4)  | Monthly  | SAE-30      |

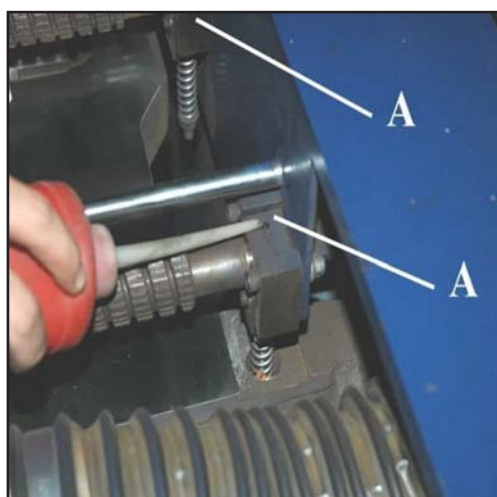


**Figure 54.** Lubricating feed roller bushings.



**Figure 56.** Lubricating table slide ways.

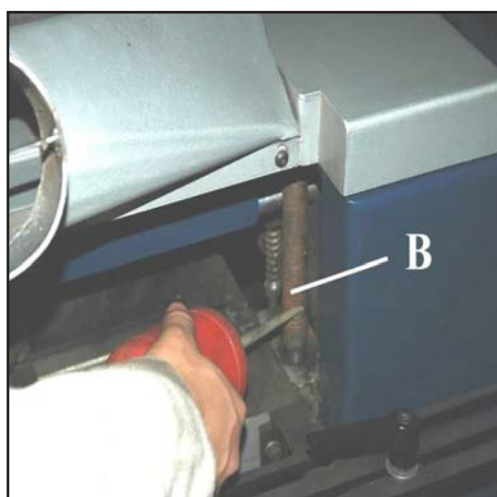


**Figure 55.** Lubricating table elevation leadscrews.



# MACHINE SERVICE

---

## Troubleshooting

Electronic parts should be replaced, inspected, or repaired only by a qualified electrical technician to avoid the danger of electrical shock.

1. If the machine does not start when a start button is pressed, check the following:
  - a. Ensure power is connected and has been turned **ON**.
  - b. Check if a fuse has blown or a breaker has tripped.
  - c. Check if wiring is broken, disconnected, or corroded.
  - d. Check top door limit switch for fault.
2. If the machine stalls, check the following:
  - a. Check overload relays in electrical box to see if they have tripped.
3. If the machine has noisy operation, check the following:
  - a. Check V-belt for correct belt tension.
  - b. Turn cutterheads, transmission chains, and motors by hand. Rotational grinding requires bearing replacement.



# Tensioning Upper Cutterhead V-Belt

After the machine has been operated a long time, the V-belt tension may gradually loosen, affecting the power transmission efficiency. When this happens, the V-belt tension needs to be adjusted. The upper cutterhead motor is located under the work table and will need to be accessed. The steps for adjusting the V-belt tension are as follows:

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Remove the (4) cap screws (A) on the rear cover (B) of the machine, and remove the rear cover (see **Figure 57**).
3. Remove (5) cap screws (C) on the belt cover (D) of the machine, and remove the belt cover (see **Figure 58**).
4. Adjust the (2) adjusting nuts (E)(F) (see **Figure 59**) to move the motor up or down as needed to increase or decrease the belt tension. After the adjustment is made, tighten the two adjusting nuts (E)(F) to secure.
5. Install rear cover (B) and belt cover (D).



**Figure 57.** Location of rear cover and screws.

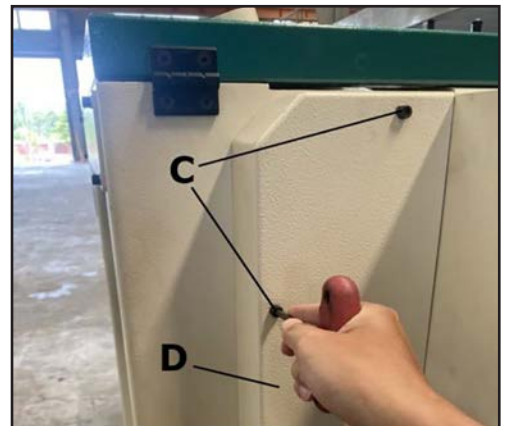


**Figure 58.** Location of belt cover and screws.



**Figure 59.** Location of adjusting nuts.



# Tensioning Table Elevation Chain

The tension of the table elevation chain will gradually relax over time, affecting the power transmission efficiency. At this time, the chain tension needs to be adjusted to ensure normal transmission efficiency. Follow the procedure below to adjust chain tension:

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Remove the (4) cap screws (A) on the rear cover (B) of the machine, and remove the rear cover (see **Figure 60**).
3. Loosen the (2) hex bolts (C)(D) (see **Figure 61**) that secures the idler sprocket (E) (see **Figure 62**).
4. Turn the adjustment screw (F) according to the chain tension (G) condition (see **Figure 62**).
5. Proper chain tension (G) can be determined by pressing in its center position, which should have approximately 1/8" of deflection.
6. After the chain tension is adjusted, tighten the hex bolts (C)(D) to secure.
7. Install rear cover (B).



**Figure 60.** Location of rear cover screws.

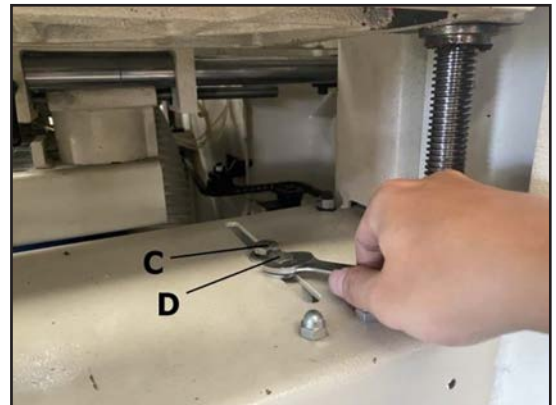


**Figure 61.** Location of idler sprocket hex bolts.

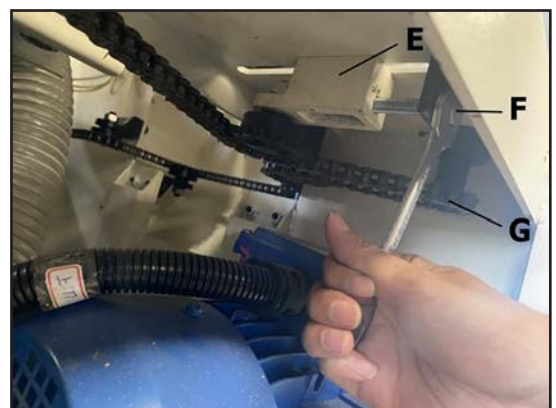


**Figure 62.** Location of idler sprocket and adjustment screw.



# Constructing Gauge Block

In order to check and adjust the height of the chip breaker and adjust the table parallel to the cutterhead, you will need a gauge block made of hardwood. Make the gauge block to the dimensions shown in **Figure 63**.

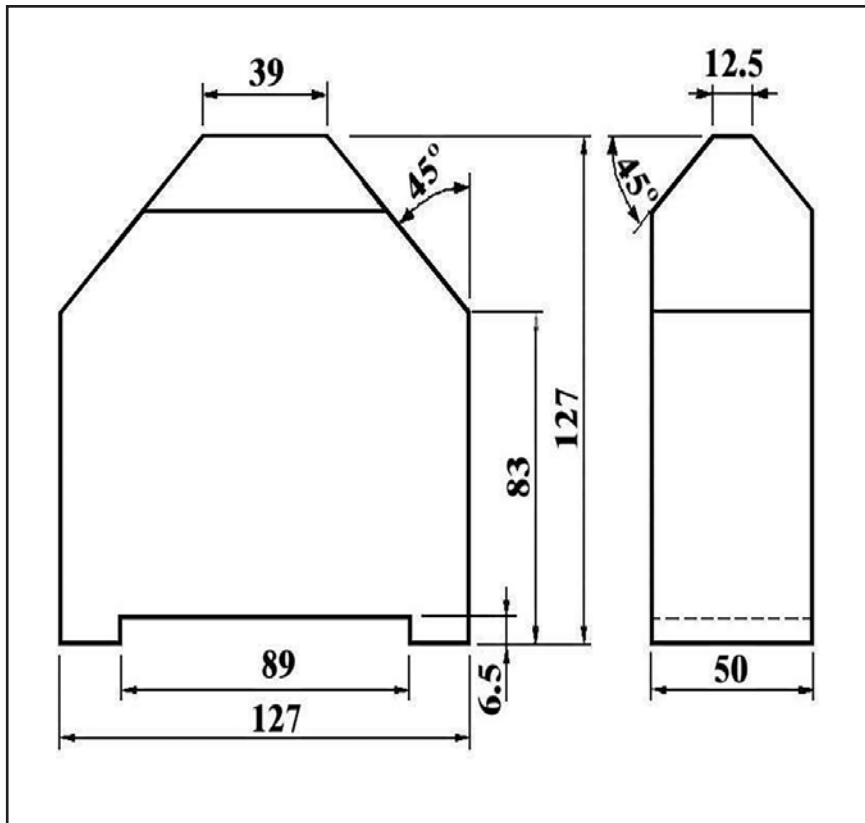


**Figure 63.** Gauge block dimensions (shown in millimeters).



# Checking Table Parallelism

The table is set parallel to the upper cutterhead at the factory and should not require further adjustment. To check that the table is parallel to the upper cutterhead, refer to **Constructing Gauge Block** section on **Page 52**, then follow the steps below:

1. **DISCONNECT THE MACHINE FROM POWER!**
2. Check whether the cutterhead knives are correctly set according to the instructions in the **Replacing Upper/Lower Cutterhead Knives** section on **Page 30**.
3. Place the gauge block (C) (see **Figure 64**) just below the cutterhead on the left side of the work table. Raise the table until the top of the gauge block (C) just touches the cutterhead knife.
4. Carefully move gauge block to the right side of the table under the cutterhead. The clearance from the table to cutterhead should be the same.
5. If the work table is not parallel to the cutterhead, remove the (8) cap screws (A) on the front/rear covers (B) of the machine, and remove the front and rear covers (see **Figure 65**).
6. On corner of table that requires adjustment, loosen the hex bolt (D) and hex nut (E) shown in **Figure 66**, then turn the adjusting nut (F) until the table is parallel to the cutterhead. After the adjustment is completed, tighten the hex bolt (D) and hex nut (E) to secure, then install the front and rear covers.



**Figure 64.** Gauge block placed below cutterhead.



**Figure 65.** Location of front/rear cover and screws.

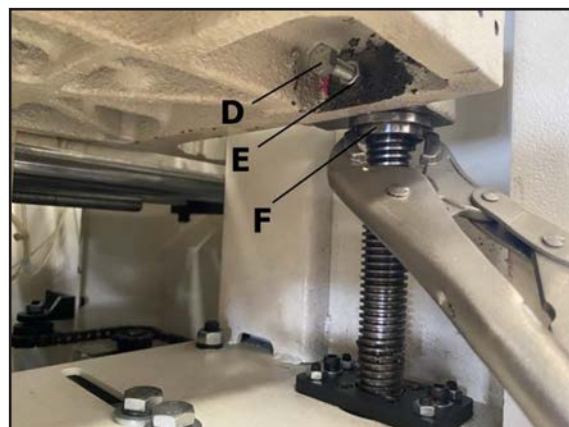


**Figure 66.** Table parallelism adjustment components.



# 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.

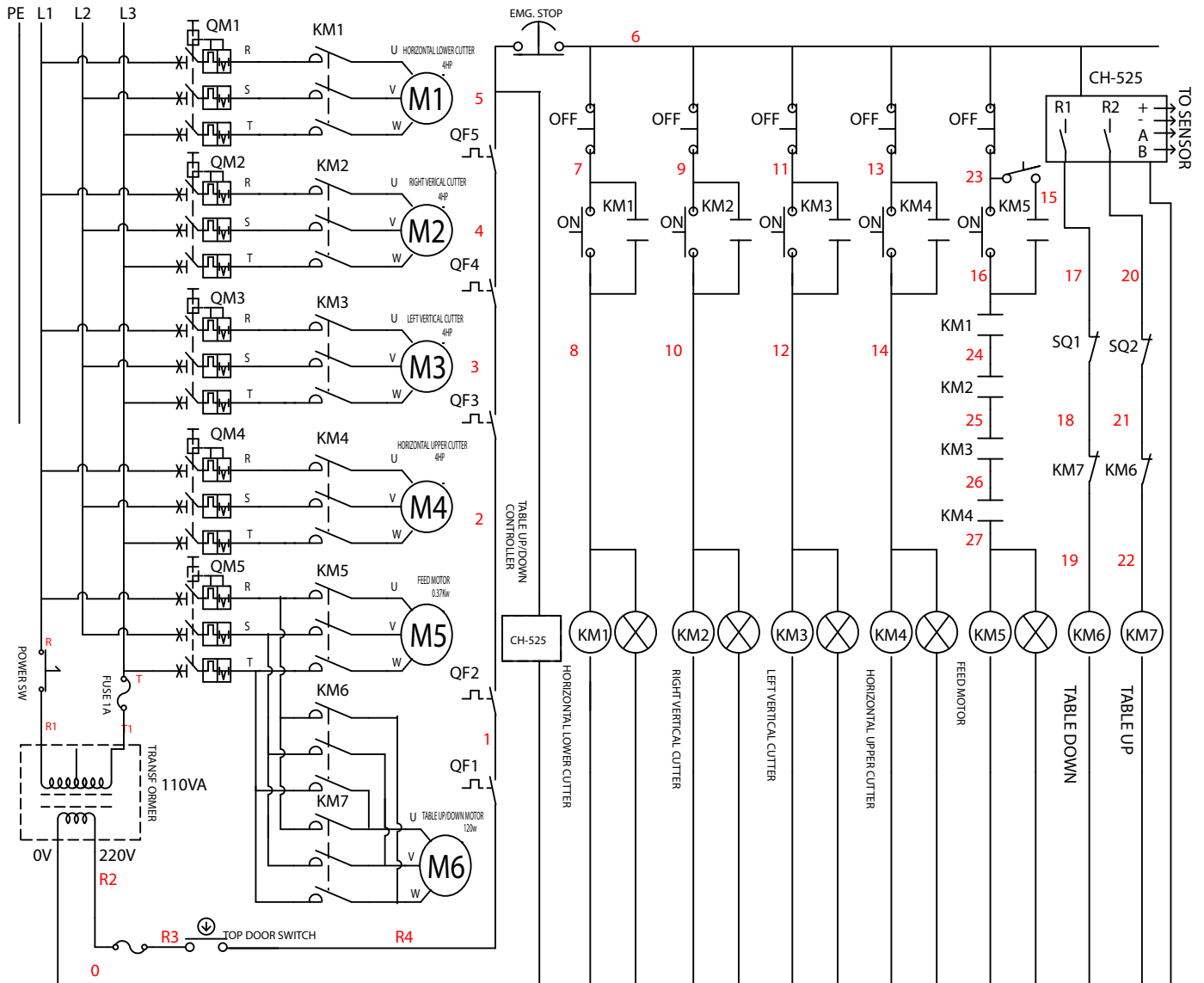
**MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

**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.

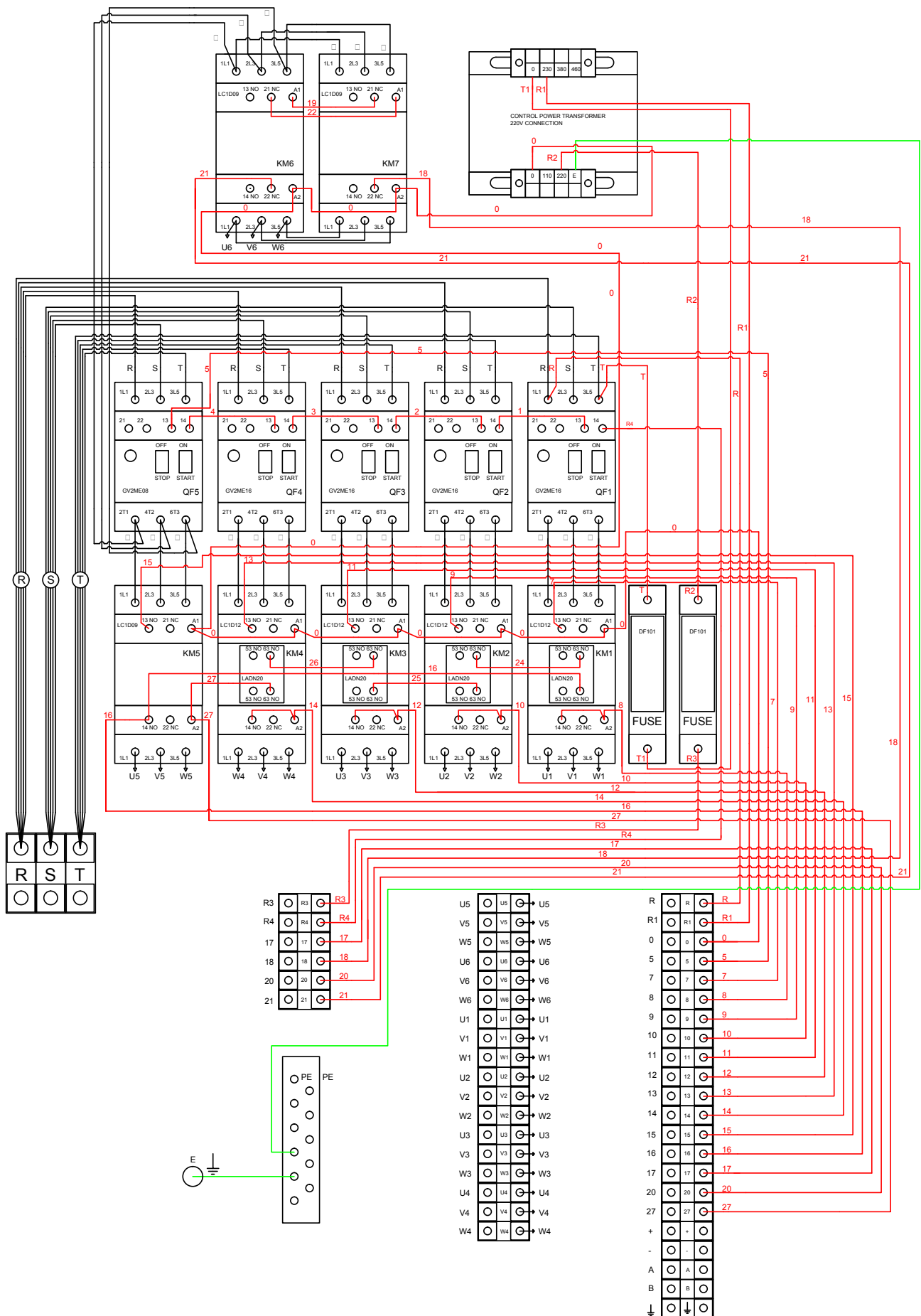
**EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.



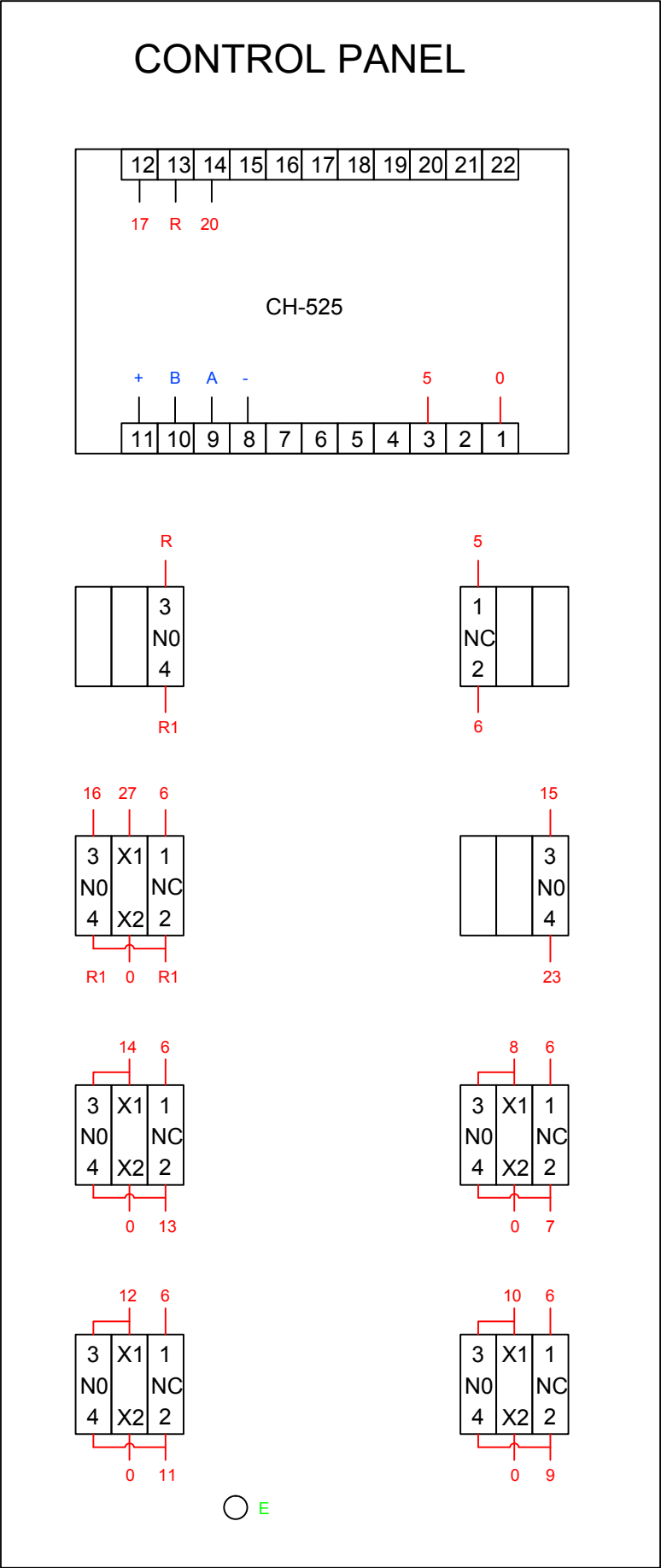
# Wiring Schematic



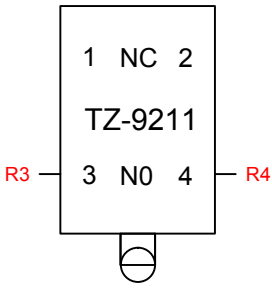
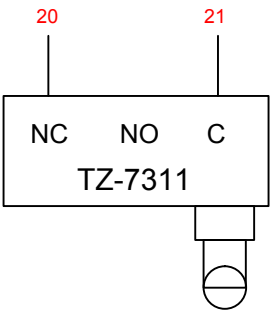
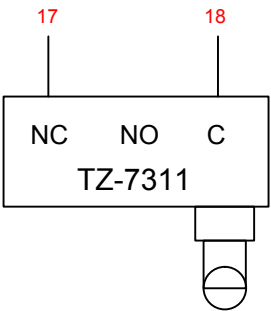
# Electrical Cabinet Wiring Diagram



# Control Panel & Limit Switch Wiring Diagrams



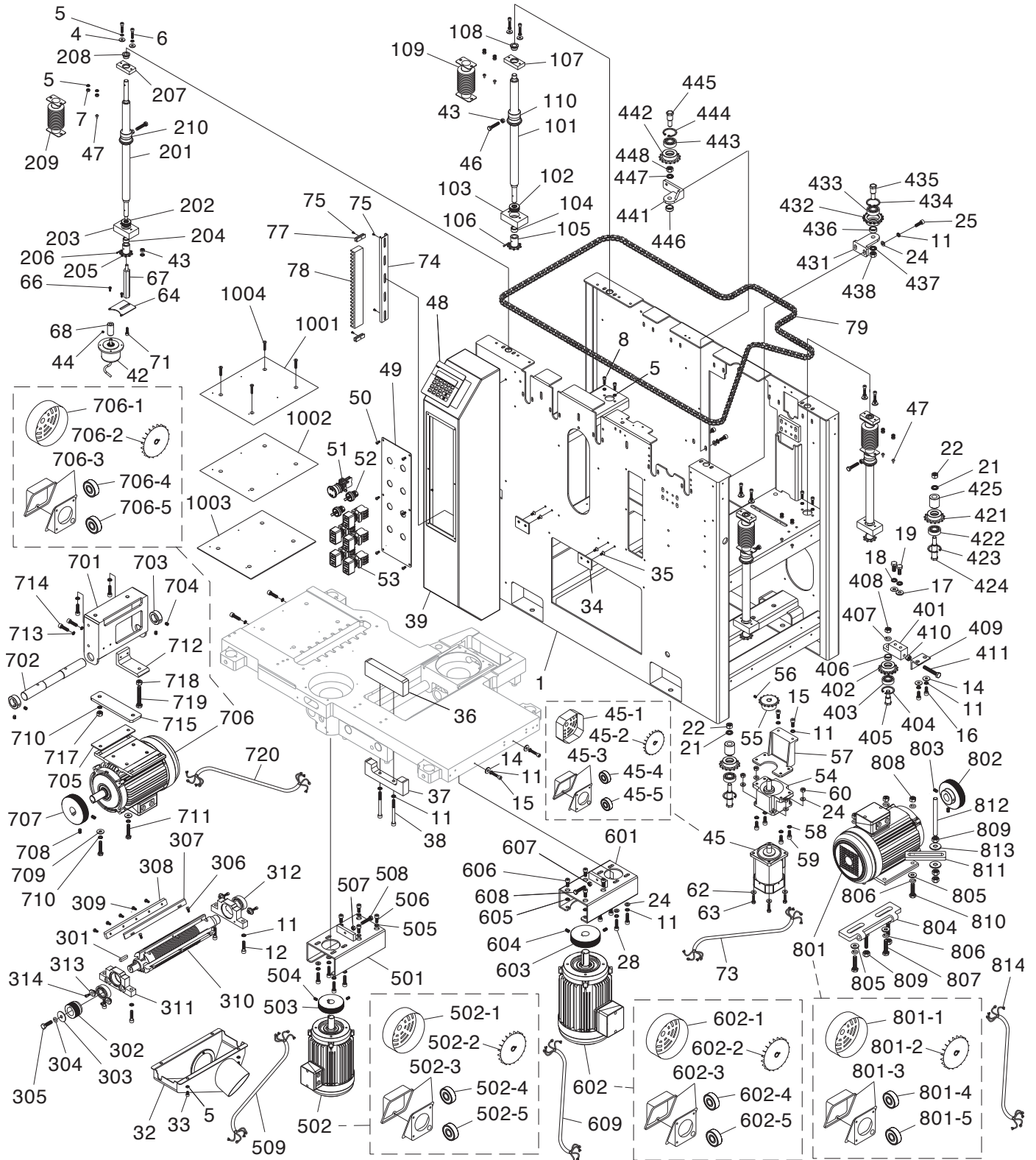
## SAFETY/LIMIT SWITCHES



# PARTS

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

## Main



# Main Parts List

| REF  | PART #      | DESCRIPTION                         |
|------|-------------|-------------------------------------|
| 1    | P09840001   | MACHINE FRAME                       |
| 4    | P09840004   | FENDER WASHER 6MM                   |
| 5    | P09840005   | LOCK WASHER 6MM                     |
| 6    | P09840006   | CAP SCREW M6-1 X 30                 |
| 7    | P09840007   | HEX NUT M6-1                        |
| 8    | P09840008   | CAP SCREW M6-1 X 30                 |
| 11   | P09840011   | LOCK WASHER 8MM                     |
| 12   | P09840012   | CAP SCREW M8-1.25 X 35              |
| 14   | P09840014   | FENDER WASHER 8MM                   |
| 15   | P09840015   | CAP SCREW M8-1.25 X 25              |
| 16   | P09840016   | CAP SCREW M8-1.25 X 20              |
| 17   | P09840017   | FLAT WASHER 10MM                    |
| 18   | P09840018   | LOCK WASHER 10MM                    |
| 19   | P09840019   | HEX BOLT M10-1.5 X 25               |
| 21   | P09840021   | LOCK WASHER 12MM                    |
| 22   | P09840022   | HEX NUT M12-1.75                    |
| 24   | P09840024   | FLAT WASHER 8MM                     |
| 25   | P09840025   | CAP SCREW M8-1.25 X 25              |
| 28   | P09840028   | CAP SCREW M8-1.25 X 25              |
| 32   | P09840032   | DUST HOOD LOWER CUTTERHEAD          |
| 33   | P09840033   | CAP SCREW M6-1 X 10                 |
| 34   | P09840034   | CHAIN PAD                           |
| 35   | P09840035   | FLAT HD CAP SCR M6-1 X 10           |
| 36   | P09840036   | WORKPIECE BRIDGE                    |
| 37   | P09840037   | BRIDGE FIXING BASE                  |
| 38   | P09840038   | CAP SCREW M8-1.25 X 95              |
| 39   | P09840039   | CONTROL BOX                         |
| 42   | P09840042   | ENCODER W/CORD ETEK ES80-200-2      |
| 43   | P09840043   | HEX NUT M8-1.25                     |
| 44   | P09840044   | SET SCREW M5-.8 X 8                 |
| 45   | P09840045   | MOTOR 1/8HP 230V 3-PH               |
| 45-1 | P09840045-1 | MOTOR FAN COVER                     |
| 45-2 | P09840045-2 | MOTOR FAN                           |
| 45-3 | P09840045-3 | MOTOR JUNCTION BOX                  |
| 45-4 | P09840045-4 | BALL BEARING 6201ZZ (FRONT)         |
| 45-5 | P09840045-5 | BALL BEARING 6000ZZ (REAR)          |
| 46   | P09840046   | HEX BOLT M8-1.25 X 40               |
| 47   | P09840047   | PHLP HD SCR M4-.7 X 10              |
| 48   | P09840048   | DIGITAL CONTROLLER ETEK CH-525      |
| 49   | P09840049   | CONTROL PANEL                       |
| 50   | P09840050   | PHLP HD SCR M5-.8 X 10              |
| 51   | P09840051   | EMERGENCY STOP BUTTON RENY R2PNM4   |
| 52   | P09840052   | 2-POSITION SWITCH RENY R2PND        |
| 53   | P09840053   | START/STOP BUTTON SWITCH RENY R2SNS |
| 54   | P09840054   | GEARBOX REDUCER VGS-5GU-50K 1:50    |
| 55   | P09840055   | SPROCKET 15T                        |
| 56   | P09840056   | SET SCREW M6-1 X 16                 |
| 57   | P09840057   | MOTOR MOUNT                         |
| 58   | P09840058   | LOCK WASHER 8MM                     |
| 59   | P09840059   | CAP SCREW M8-1.25 X 20              |
| 60   | P09840060   | FLANGE NUT M6-1                     |
| 62   | P09840062   | FLAT WASHER 6.3 X 9.8 X 1MM         |
| 63   | P09840063   | HEX BOLT M6-1 X 25                  |
| 64   | P09840064   | ADJUSTMENT BRACKET                  |
| 66   | P09840066   | CAP SCREW M4-.7 X 8                 |
| 67   | P09840067   | ENCODER MOUNT                       |
| 68   | P09840068   | COUPLER                             |

| REF | PART #    | DESCRIPTION                            |
|-----|-----------|----------------------------------------|
| 71  | P09840071 | CAP SCREW M6-1 X 30                    |
| 73  | P09840073 | MOTOR CORD 18G 4W 59" TABLE ELEVATION  |
| 74  | P09840074 | DIN RAIL 25 X 9.8 X 245MM              |
| 75  | P09840075 | PHLP HD SCR 8-32 X 1/4                 |
| 77  | P09840077 | END BLOCK DIN25                        |
| 78  | P09840078 | TERMINAL BAR 22P DIN25                 |
| 79  | P09840079 | CHAIN #41 X 270P                       |
| 101 | P09840101 | LEADSCREW IDLER                        |
| 102 | P09840102 | THRUST BEARING 2902                    |
| 103 | P09840103 | BEARING HOUSING                        |
| 104 | P09840104 | BEARING 14.1 X 20 X 10 COPPER          |
| 105 | P09840105 | SPROCKET 9T                            |
| 106 | P09840106 | ROLL PIN 3 X 22                        |
| 107 | P09840107 | MOUNTING PLATE                         |
| 108 | P09840108 | BALL SCREW BEARING 14.1 X 24.5 X 11.8  |
| 109 | P09840109 | DUST BOOT                              |
| 110 | P09840110 | LEADSCREW NUT                          |
| 201 | P09840201 | LEADSCREW DRIVE                        |
| 202 | P09840202 | THRUST BEARING 2902                    |
| 203 | P09840203 | BEARING HOUSING                        |
| 204 | P09840204 | BEARING 14.1 X 20 X 10 COPPER          |
| 205 | P09840205 | SPROCKET 9T                            |
| 206 | P09840206 | ROLL PIN 3 X 22                        |
| 207 | P09840207 | MOUNTING PLATE                         |
| 208 | P09840208 | BALL SCREW BEARING 14.1 X 24.5 X 11.8  |
| 209 | P09840209 | DUST BOOT                              |
| 210 | P09840210 | LEADSCREW NUT                          |
| 301 | P09840301 | KEY 8 X 8 X 30                         |
| 302 | P09840302 | PULLEY                                 |
| 303 | P09840303 | FLAT WASHER 10.5 X 38 X 4MM            |
| 304 | P09840304 | LOCK WASHER 10MM                       |
| 305 | P09840305 | HEX BOLT M10-1.5 X 20                  |
| 306 | P09840306 | JACK SCREW M6-1 X 12                   |
| 307 | P09840307 | PLANER KNIFE 11-13/16" X 13/16" X 1/8" |
| 308 | P09840308 | PLANER KNIFE GIB                       |
| 309 | P09840309 | HEX BOLT M6-1 X 10                     |
| 310 | P09840310 | CUTTERHEAD 11-13/16" LOWER             |
| 311 | P09840311 | BEARING HOUSING                        |
| 312 | P09840312 | BALL BEARING 6205-2RS                  |
| 313 | P09840313 | RETAINING WASHER 14 X 25 X 9.5MM       |
| 314 | P09840314 | CAP SCREW M5-.8 X 12                   |
| 401 | P09840401 | CHAIN TENSION BLOCK                    |
| 402 | P09840402 | SPROCKET 15T                           |
| 403 | P09840403 | BALL BEARING 6203ZZ                    |
| 404 | P09840404 | INT RETAINING RING 40MM                |
| 405 | P09840405 | SPROCKET SHAFT 17 X 46MM               |
| 406 | P09840406 | SPACER 17 X 23.5 X 9MM                 |
| 407 | P09840407 | LOCK WASHER 12MM                       |
| 408 | P09840408 | HEX NUT M12-1.75                       |
| 409 | P09840409 | CHAIN TENSION BRACKET                  |
| 410 | P09840410 | HEX NUT M10-1.5                        |
| 411 | P09840411 | HEX BOLT M10-1.5 X 60                  |
| 421 | P09840421 | SPROCKET 15T                           |
| 422 | P09840422 | BALL BEARING 6203ZZ                    |
| 423 | P09840423 | INT RETAINING RING 40MM                |
| 424 | P09840424 | SPROCKET SHAFT 17 X 80MM               |
| 425 | P09840425 | SPACER 17 X 32 X 39MM                  |



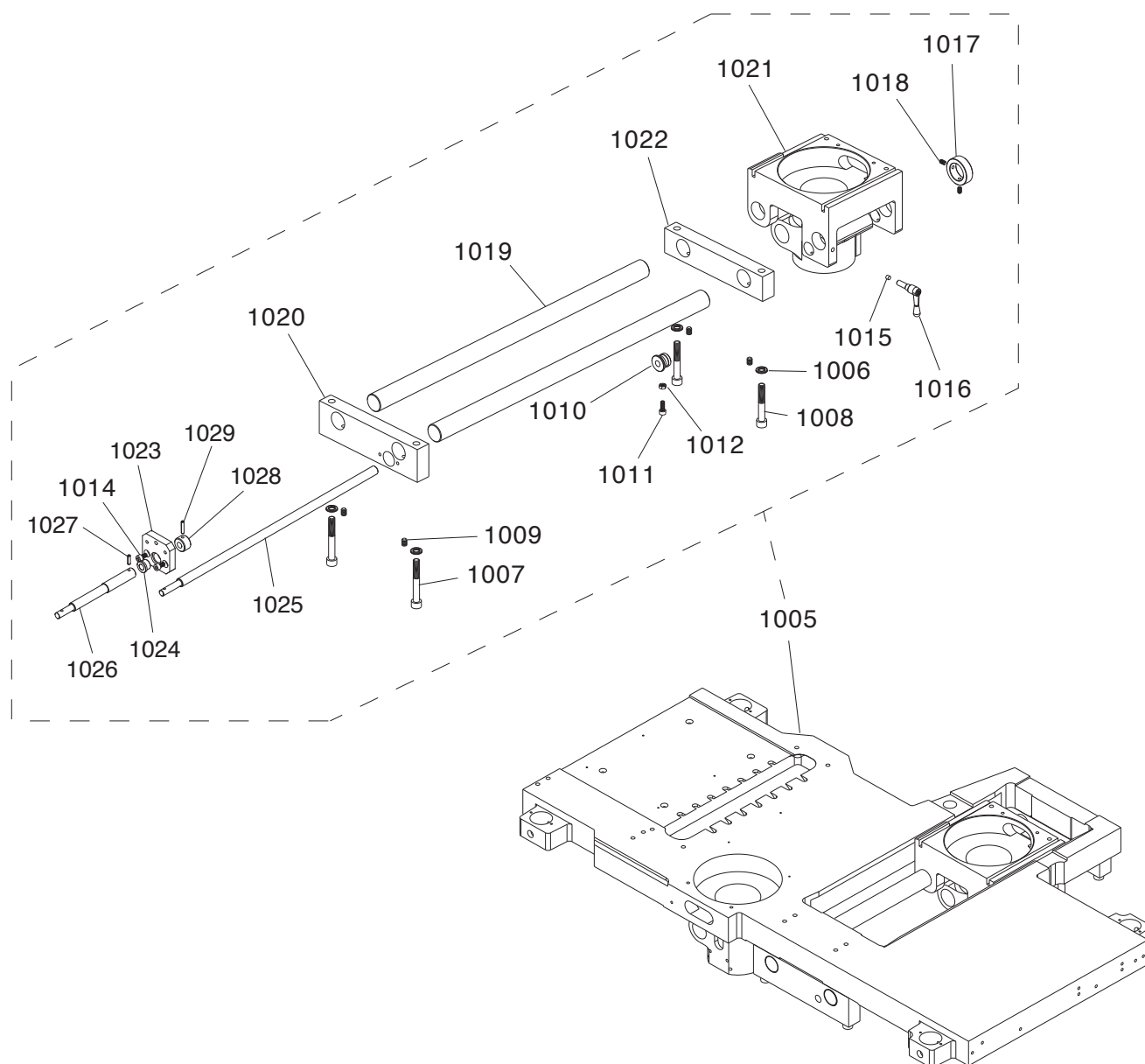
# Main Parts List (Cont.)

| REF   | PART #      | DESCRIPTION                    |
|-------|-------------|--------------------------------|
| 431   | P09840431   | SPROCKET MOUNTING BRACKET      |
| 432   | P09840432   | SPROCKET 15T                   |
| 433   | P09840433   | BALL BEARING 6203ZZ            |
| 434   | P09840434   | INT RETAINING RING 40MM        |
| 435   | P09840435   | SPROCKET SHAFT 17 X 46MM       |
| 436   | P09840436   | SPACER 17 X 23.5 X 9MM         |
| 437   | P09840437   | LOCK WASHER 12MM               |
| 438   | P09840438   | HEX NUT M12-1.75               |
| 441   | P09840441   | SPROCKET MOUNTING BRACKET      |
| 442   | P09840442   | SPROCKET 15T                   |
| 443   | P09840443   | BALL BEARING 6203ZZ            |
| 444   | P09840444   | INT RETAINING RING 40MM        |
| 445   | P09840445   | SPROCKET SHAFT 17 X 46MM       |
| 446   | P09840446   | SPACER 17 X 23.5 X 9MM         |
| 447   | P09840447   | LOCK WASHER 12MM               |
| 448   | P09840448   | HEX NUT M12-1.75               |
| 501   | P09840501   | MOTOR MOUNT                    |
| 502   | P09840502   | MOTOR 4HP 230V 3-PH            |
| 502-1 | P09840502-1 | MOTOR FAN COVER                |
| 502-2 | P09840502-2 | MOTOR FAN                      |
| 502-3 | P09840502-3 | MOTOR JUNCTION BOX             |
| 502-4 | P09840502-4 | BALL BEARING 6205ZZ (FRONT)    |
| 502-5 | P09840502-5 | BALL BEARING 6204ZZ (REAR)     |
| 503   | P09840503   | MOTOR PULLEY                   |
| 504   | P09840504   | SET SCREW M8-1.25 X 12         |
| 505   | P09840505   | LOCK WASHER 8MM                |
| 506   | P09840506   | CAP SCREW M8-1.25 X 20         |
| 507   | P09840507   | HEX NUT M8-1.25                |
| 508   | P09840508   | HEX BOLT M8-1.25 X 40          |
| 509   | P09840509   | MOTOR CORD 14G 4W 51" LEFT CH  |
| 601   | P09840601   | MOTOR MOUNT                    |
| 602   | P09840602   | MOTOR 4HP 230V 3-PH            |
| 602-1 | P09840602-1 | MOTOR FAN COVER                |
| 602-2 | P09840602-2 | MOTOR FAN                      |
| 602-3 | P09840602-3 | MOTOR JUNCTION BOX             |
| 602-4 | P09840602-4 | BALL BEARING 6205ZZ (FRONT)    |
| 602-5 | P09840602-5 | BALL BEARING 6204ZZ (REAR)     |
| 603   | P09840603   | MOTOR PULLEY                   |
| 604   | P09840604   | SET SCREW M8-1.25 X 12         |
| 605   | P09840605   | LOCK WASHER 8MM                |
| 606   | P09840606   | CAP SCREW M8-1.25 X 20         |
| 607   | P09840607   | HEX NUT M8-1.25                |
| 608   | P09840608   | HEX BOLT M8-1.25 X 40          |
| 609   | P09840609   | MOTOR CORD 14G 4W 39" RIGHT CH |
| 701   | P09840701   | MOTOR MOUNT                    |
| 702   | P09840702   | CONNECTION SHAFT               |

| REF   | PART #      | DESCRIPTION                    |
|-------|-------------|--------------------------------|
| 703   | P09840703   | LOCK COLLAR 28 X 42.5 X 15MM   |
| 704   | P09840704   | SET SCREW M8-1.25 X 12         |
| 705   | P09840705   | MOTOR BASE PLATE               |
| 706   | P09840706   | MOTOR 4HP 230V 3-PH            |
| 706-1 | P09840706-1 | MOTOR FAN COVER                |
| 706-2 | P09840706-2 | MOTOR FAN                      |
| 706-3 | P09840706-3 | MOTOR JUNCTION BOX             |
| 706-4 | P09840706-4 | BALL BEARING 6205ZZ (FRONT)    |
| 706-5 | P09840706-5 | BALL BEARING 6204ZZ (REAR)     |
| 707   | P09840707   | MOTOR PULLEY                   |
| 708   | P09840708   | SET SCREW M8-1.25 X 12         |
| 709   | P09840709   | FENDER WASHER 8MM              |
| 710   | P09840710   | LOCK WASHER 8MM                |
| 711   | P09840711   | HEX BOLT M8-1.25 X 40          |
| 712   | P09840712   | MOTOR ADJUSTMENT PLATE         |
| 713   | P09840713   | LOCK WASHER 6MM                |
| 714   | P09840714   | CAP SCREW M6-1 X 20            |
| 715   | P09840715   | MOTOR PLATE                    |
| 717   | P09840717   | HEX NUT M8-1.25                |
| 718   | P09840718   | HEX NUT M10-1.5                |
| 719   | P09840719   | HEX BOLT M10-1.5 X 50          |
| 720   | P09840720   | MOTOR CORD 14G 4W 35" LOWER CH |
| 801   | P09840801   | MOTOR 4HP 230V 3-PH            |
| 801-1 | P09840801-1 | MOTOR FAN COVER                |
| 801-2 | P09840801-2 | MOTOR FAN                      |
| 801-3 | P09840801-3 | MOTOR JUNCTION BOX             |
| 801-4 | P09840801-4 | BALL BEARING 6205ZZ (FRONT)    |
| 801-5 | P09840801-5 | BALL BEARING 6204ZZ (REAR)     |
| 802   | P09840802   | MOTOR PULLEY                   |
| 803   | P09840803   | SET SCREW M8-1.25 X 12         |
| 804   | P09840804   | MOTOR BRACKET                  |
| 805   | P09840805   | FLAT WASHER 10 X 25 X 3MM      |
| 806   | P09840806   | LOCK WASHER 10MM               |
| 807   | P09840807   | HEX BOLT M10-1.5 X 45          |
| 808   | P09840808   | HEX NUT M10-1.5                |
| 809   | P09840809   | HEX NUT M12-1.75               |
| 810   | P09840810   | HEX BOLT M10-1.5 X 45          |
| 811   | P09840811   | TENSION BRACKET                |
| 812   | P09840812   | STUD-FT M12-1.75 X 135         |
| 813   | P09840813   | FLAT WASHER 12.7 X 34 X 3MM    |
| 814   | P09840814   | MOTOR CORD 14G 4W 55" UPPER CH |
| 1001  | P09841001   | INFEED PLATE 1MM               |
| 1002  | P09841002   | INFEED PLATE 1MM               |
| 1003  | P09841003   | INFEED PLATE 2MM               |
| 1004  | P09841004   | FLAT HD CAP SCR M6-1 X 16      |



# Table

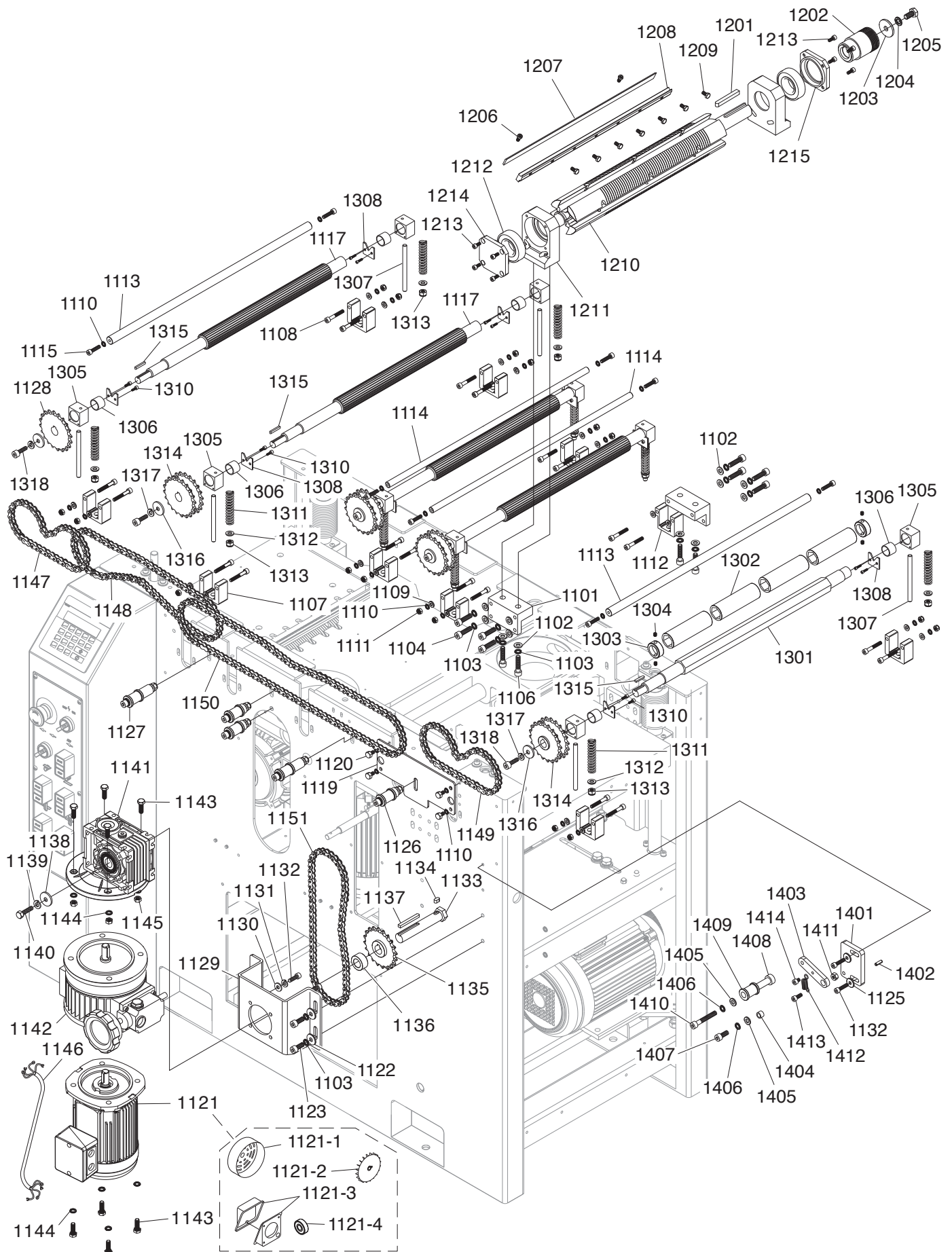


| REF  | PART #    | DESCRIPTION                    |
|------|-----------|--------------------------------|
| 1005 | P09841005 | TABLE ASSEMBLY                 |
| 1006 | P09841006 | LOCK WASHER 10MM               |
| 1007 | P09841007 | CAP SCREW M10-1.5 X 75         |
| 1008 | P09841008 | CAP SCREW M10-1.5 X 65         |
| 1009 | P09841009 | SET SCREW M8-1.25 X 10         |
| 1010 | P09841010 | LEADSCREW NUT                  |
| 1011 | P09841011 | CAP SCREW M6-1 X 16            |
| 1012 | P09841012 | HEX NUT M6-1                   |
| 1014 | P09841014 | CAP SCREW M6-1 X 12            |
| 1015 | P09841015 | DOWEL PIN 6.8 X 5MM COPPER     |
| 1016 | P09841016 | ADJUSTABLE HANDLE M8-1.25 X 20 |
| 1017 | P09841017 | LOCK COLLAR 30 X 45 X 14MM     |

| REF  | PART #    | DESCRIPTION                         |
|------|-----------|-------------------------------------|
| 1018 | P09841018 | SET SCREW M6-1 X 10                 |
| 1019 | P09841019 | ROD                                 |
| 1020 | P09841020 | ROD BRACKET RIGHT                   |
| 1021 | P09841021 | LEFT CUTTERHEAD MOUNT               |
| 1022 | P09841022 | ROD BRACKET LEFT                    |
| 1023 | P09841023 | LEADSCREW MOUNTING PLATE            |
| 1024 | P09841024 | FLANGED BEARING 10 X 19 X 12 COPPER |
| 1025 | P09841025 | LEADSCREW LEFT CUTTERHEAD           |
| 1026 | P09841026 | EXTENSION SHAFT                     |
| 1027 | P09841027 | ROLL PIN 4 X 16                     |
| 1028 | P09841028 | LOCK COLLAR 10 X 23 X 14MM          |
| 1029 | P09841029 | ROLL PIN 4 X 22                     |



# Feed System



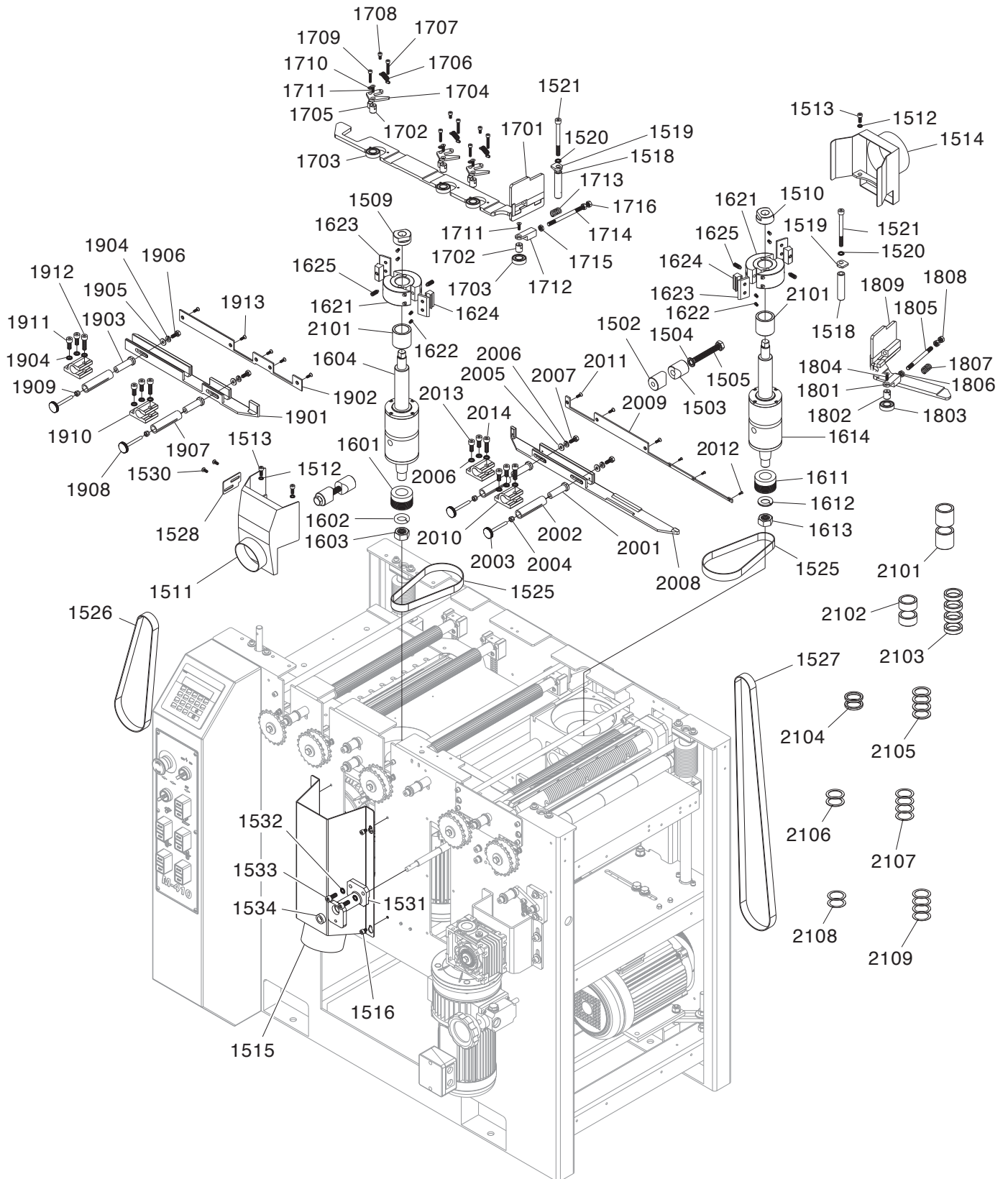
# Feed System Parts List

| REF    | PART #      | DESCRIPTION                       |
|--------|-------------|-----------------------------------|
| 1101   | P09841101   | CUTTERHEAD MOUNTING BRACKET       |
| 1102   | P09841102   | FLAT WASHER 8MM                   |
| 1103   | P09841103   | LOCK WASHER 8MM                   |
| 1104   | P09841104   | CAP SCREW M8-1.25 X 25            |
| 1106   | P09841106   | CAP SCREW M8-1.25 X 40            |
| 1107   | P09841107   | ROLLER SUPPORT                    |
| 1108   | P09841108   | CAP SCREW M6-1 X 40               |
| 1109   | P09841109   | FLAT WASHER 6MM                   |
| 1110   | P09841110   | LOCK WASHER 6MM                   |
| 1111   | P09841111   | LOCK NUT M6-1                     |
| 1112   | P09841112   | CLEARANCE ROLLER SUPPORT          |
| 1113   | P09841113   | SUPPORT SHAFT 16 X 545            |
| 1114   | P09841114   | SUPPORT SHAFT 12 X 545            |
| 1115   | P09841115   | CAP SCREW M6-1 X 20               |
| 1117   | P09841117   | INFEED ROLLER                     |
| 1119   | P09841119   | PLATE UPPER CUTTERHEAD            |
| 1120   | P09841120   | HEX BOLT M6-1 X 10                |
| 1121   | P09841121   | MOTOR 1HP 230V 3-PH               |
| 1121-1 | P09841121-1 | MOTOR FAN COVER                   |
| 1121-2 | P09841121-2 | MOTOR FAN                         |
| 1121-3 | P09841121-3 | MOTOR JUNCTION BOX                |
| 1121-4 | P09841121-4 | BALL BEARING 6202ZZ               |
| 1122   | P09841122   | FENDER WASHER 8MM                 |
| 1123   | P09841123   | CAP SCREW M8-1.25 X 20            |
| 1125   | P09841125   | FLAT WASHER 6MM                   |
| 1126   | P09841126   | CHAIN ROLLER ASSEMBLY INNER       |
| 1127   | P09841127   | CHAIN ROLLER ASSEMBLY OUTER       |
| 1128   | P09841128   | SPROCKET 20T                      |
| 1129   | P09841129   | MOTOR MOUNT                       |
| 1130   | P09841130   | FLAT WASHER 6MM                   |
| 1131   | P09841131   | LOCK WASHER 6MM                   |
| 1132   | P09841132   | CAP SCREW M6-1 X 20               |
| 1133   | P09841133   | REDUCER SHAFT                     |
| 1134   | P09841134   | KEY 6 X 6 X 12                    |
| 1135   | P09841135   | SPROCKET 20T                      |
| 1136   | P09841136   | SPACER 18 X 30 X 14.3MM           |
| 1137   | P09841137   | KEY 6 X 6 X 50                    |
| 1138   | P09841138   | FENDER WASHER 8MM                 |
| 1139   | P09841139   | LOCK WASHER 8MM                   |
| 1140   | P09841140   | HEX BOLT M8-1.25 X 20             |
| 1141   | P09841141   | GEARBOX REDUCER HHM-40#1/7.5      |
| 1142   | P09841142   | STEPLESS VS REDUCER TKF-005-1/2HP |
| 1143   | P09841143   | HEX BOLT M8-1.25 X 25             |
| 1144   | P09841144   | LOCK WASHER 8MM                   |
| 1145   | P09841145   | HEX NUT M8-1.25                   |
| 1146   | P09841146   | MOTOR CORD 18G 4W 67" FEED        |
| 1147   | P09841147   | CHAIN #41 X 40P                   |
| 1148   | P09841148   | CHAIN #41 X 58P                   |
| 1149   | P09841149   | CHAIN #41 X 44P                   |

| REF  | PART #    | DESCRIPTION                          |
|------|-----------|--------------------------------------|
| 1150 | P09841150 | CHAIN #41 X 60P                      |
| 1151 | P09841151 | CHAIN #41 X 51P                      |
| 1201 | P09841201 | KEY 8 X 8 X 60                       |
| 1202 | P09841202 | PULLEY                               |
| 1203 | P09841203 | FLAT WASHER 11 X 38 X 2MM            |
| 1204 | P09841204 | LOCK WASHER 10MM                     |
| 1205 | P09841205 | HEX BOLT M10-1.5 X 35                |
| 1206 | P09841206 | JACK SCREW M6-1 X 12                 |
| 1207 | P09841207 | PLANER KNIFE 16-1/8" X 13/16" X 1/8" |
| 1208 | P09841208 | PLANER KNIFE GIB                     |
| 1209 | P09841209 | HEX BOLT M6-1 X 10                   |
| 1210 | P09841210 | CUTTERHEAD 16-1/8" UPPER             |
| 1211 | P09841211 | BEARING HOUSING                      |
| 1212 | P09841212 | BALL BEARING 6206ZZ                  |
| 1213 | P09841213 | CAP SCREW M5-.8 X 12                 |
| 1214 | P09841214 | BEARING COVER RIGHT                  |
| 1215 | P09841215 | BEARING COVER LEFT                   |
| 1301 | P09841301 | OUTFEED ROLLER                       |
| 1302 | P09841302 | SLEEVE 32 X 105 RUBBER               |
| 1303 | P09841303 | LOCK COLLAR 22 X 32 X 12MM           |
| 1304 | P09841304 | SET SCREW M6-1 X 6                   |
| 1305 | P09841305 | BEARING BLOCK                        |
| 1306 | P09841306 | BEARING 19 X 22.2 X 18 COPPER        |
| 1307 | P09841307 | STUD-FT M8-1.25 X 103                |
| 1308 | P09841308 | BEARING GUARD RUBBER                 |
| 1310 | P09841310 | CAP SCREW M4-.7 X 8                  |
| 1311 | P09841311 | COMPRESSION SPRING 2.5 X 15 X 70     |
| 1312 | P09841312 | FLAT WASHER 8MM                      |
| 1313 | P09841313 | LOCK NUT M8-1.25                     |
| 1314 | P09841314 | SPROCKET 20T/20T                     |
| 1315 | P09841315 | KEY 6 X 6 X 30                       |
| 1316 | P09841316 | FENDER WASHER 8MM                    |
| 1317 | P09841317 | LOCK WASHER 8MM                      |
| 1318 | P09841318 | CAP SCREW M8-1.25 X 20               |
| 1401 | P09841401 | SPRING ROLLER MOUNTING BLOCK         |
| 1402 | P09841402 | ROLL PIN 5 X 16                      |
| 1403 | P09841403 | SPRING PLATE                         |
| 1404 | P09841404 | BUSHING 8 X 12 X 2.2                 |
| 1405 | P09841405 | FLAT WASHER 8MM                      |
| 1406 | P09841406 | LOCK WASHER 8MM                      |
| 1407 | P09841407 | CAP SCREW M8-1.25 X 20               |
| 1408 | P09841408 | BUSHING                              |
| 1409 | P09841409 | ROLLER                               |
| 1410 | P09841410 | CAP SCREW M8-1.25 X 55               |
| 1411 | P09841411 | HEX NUT M6-1                         |
| 1412 | P09841412 | EXTENSION SPRING 1.5 X 10 X 32       |
| 1413 | P09841413 | CAP SCREW M6-1 X 16                  |
| 1414 | P09841414 | CAP SCREW M6-1 X 8                   |



# Vertical Cutterheads



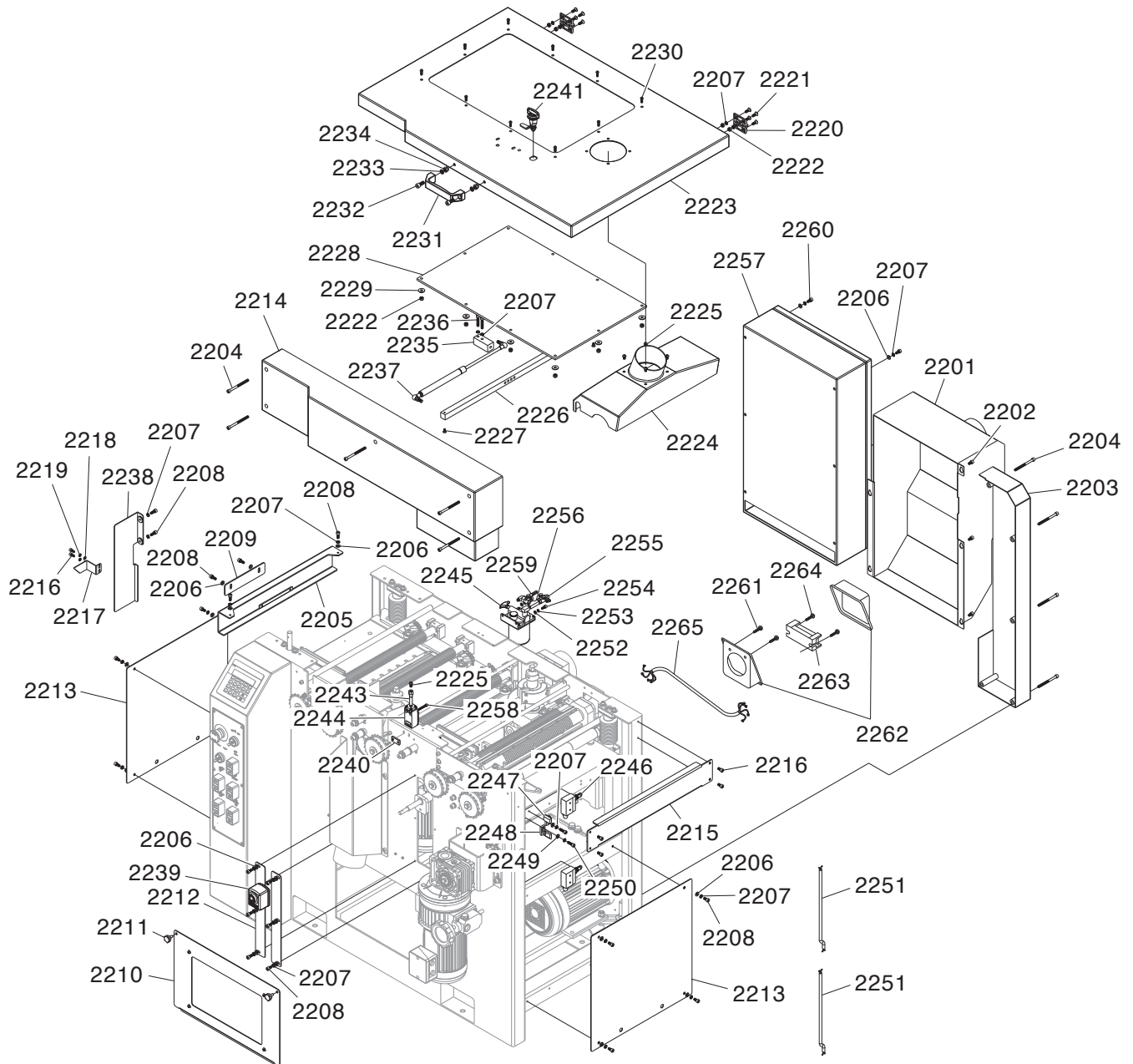
# Vertical Cutterheads Parts List

| REF  | PART #    | DESCRIPTION                         |
|------|-----------|-------------------------------------|
| 1502 | P09841502 | CLAMP BLOCK M12-1.75                |
| 1503 | P09841503 | CLAMP BLOCK                         |
| 1504 | P09841504 | LOCK WASHER 12MM                    |
| 1505 | P09841505 | HEX BOLT M12-1.75 X 100             |
| 1509 | P09841509 | SPINDLE NUT M20-1.5                 |
| 1510 | P09841510 | SPINDLE NUT M10-1.5 LH              |
| 1511 | P09841511 | DUST HOOD RIGHT CUTTERHEAD          |
| 1512 | P09841512 | LOCK WASHER 6MM                     |
| 1513 | P09841513 | CAP SCREW M6-1 X 16                 |
| 1514 | P09841514 | DUST HOOD LEFT CUTTERHEAD           |
| 1515 | P09841515 | COVER RIGHT CUTTERHEAD              |
| 1516 | P09841516 | CAP SCREW M6-1 X 10                 |
| 1518 | P09841518 | SPACER 9 X 15.9 X 69                |
| 1519 | P09841519 | PRESSURE PLATE                      |
| 1520 | P09841520 | LOCK WASHER 8MM                     |
| 1521 | P09841521 | CAP SCREW M8-1.25 X 95              |
| 1525 | P09841525 | V-BELT 190J8                        |
| 1526 | P09841526 | V-BELT 300J8                        |
| 1527 | P09841527 | V-BELT 562J8                        |
| 1528 | P09841528 | PLATE                               |
| 1530 | P09841530 | PHLP HD SCR M5-.8 X 10              |
| 1531 | P09841531 | POSITION METER PLATE                |
| 1532 | P09841532 | LOCK WASHER 6MM                     |
| 1533 | P09841533 | CAP SCREW M6-1 X 25                 |
| 1534 | P09841534 | SPACER 14 X 22 X 8MM                |
| 1601 | P09841601 | PULLEY VERTICAL CUTTERHEAD          |
| 1602 | P09841602 | LOCK WASHER 20MM                    |
| 1603 | P09841603 | HEX NUT M20-2.5                     |
| 1604 | P09841604 | SPINDLE ASSEMBLY RIGHT              |
| 1611 | P09841611 | PULLEY VERTICAL CUTTERHEAD          |
| 1612 | P09841612 | LOCK WASHER 20MM                    |
| 1613 | P09841613 | PULLEY VERTICAL CUTTERHEAD          |
| 1614 | P09841614 | SPINDLE ASSEMBLY LEFT               |
| 1621 | P09841621 | CUTTERHEAD VERTICAL                 |
| 1622 | P09841622 | LOCK SCREW M5-.8 X 6.5              |
| 1623 | P09841623 | PLANER KNIFE 2-1/8" X 1-1/8" X 1/8" |
| 1624 | P09841624 | KNIFE GIB                           |
| 1625 | P09841625 | GIB SCREW M8-1.25 X 20 DOG-PT       |
| 1701 | P09841701 | ROLLER GUIDE BRACKET INFEED         |
| 1702 | P09841702 | BEARING SHAFT                       |
| 1703 | P09841703 | BALL BEARING 6002-2RS               |
| 1704 | P09841704 | PIVOT PLATE                         |
| 1705 | P09841705 | ROLLER BUSHING                      |
| 1706 | P09841706 | EXTENSION SPRING 1 X 10 X 32        |
| 1707 | P09841707 | CAP SCREW M5-.8 X 30                |
| 1708 | P09841708 | CAP SCREW M5-.8 X 8                 |
| 1709 | P09841709 | CAP SCREW M5-.8 X 25                |
| 1710 | P09841710 | FLAT WASHER 5MM                     |
| 1711 | P09841711 | FLAT HD CAP SCR M5-.8 X 16          |
| 1712 | P09841712 | PRESSURE ROLLER BRACKET             |

| REF  | PART #    | DESCRIPTION                     |
|------|-----------|---------------------------------|
| 1713 | P09841713 | COMPRESSION SPRING 2 X 14 X 25  |
| 1714 | P09841714 | STUD-DE M8-1.25 X 105, 20       |
| 1715 | P09841715 | HEX NUT M8-1.25 THIN            |
| 1716 | P09841716 | HEX NUT M8-1.25                 |
| 1801 | P09841801 | PRESSURE ROLLER BRACKET         |
| 1802 | P09841802 | BEARING SHAFT                   |
| 1803 | P09841803 | BALL BEARING 6002-2RS           |
| 1804 | P09841804 | FLAT HD CAP SCR M5-.8 X 16      |
| 1805 | P09841805 | STUD-DE M8-1.25 X 105, 20       |
| 1806 | P09841806 | HEX NUT M8-1.25 THIN            |
| 1807 | P09841807 | COMPRESSION SPRING 2 X 14 X 25  |
| 1808 | P09841808 | HEX NUT M8-1.25                 |
| 1809 | P09841809 | ROLLER GUIDE BRACKET OUTFEED    |
| 1901 | P09841901 | INFEED FENCE                    |
| 1902 | P09841902 | FENCE FACE                      |
| 1903 | P09841903 | STANDOFF-ROUND FF M8-1.25, M6-1 |
| 1904 | P09841904 | LOCK WASHER 8MM                 |
| 1905 | P09841905 | FLAT WASHER 8MM                 |
| 1906 | P09841906 | HEX BOLT M8-1.25 X 20           |
| 1907 | P09841907 | CLAMP COLLAR                    |
| 1908 | P09841908 | THUMB SCREW M6-1 X 55           |
| 1909 | P09841909 | LOCK NUT M6-1                   |
| 1910 | P09841910 | FENCE MOUNT                     |
| 1911 | P09841911 | CAP SCREW M8-1.25 X 20          |
| 1912 | P09841912 | CAP SCREW M8-1.25 X 30          |
| 1913 | P09841913 | FLAT HD CAP SCR M4-.7 X 10      |
| 2001 | P09842001 | STANDOFF-ROUND FF M8-1.25, M6-1 |
| 2002 | P09842002 | CLAMP COLLAR                    |
| 2003 | P09842003 | THUMB SCREW M6-1 X 55           |
| 2004 | P09842004 | LOCK NUT M6-1                   |
| 2005 | P09842005 | FLAT WASHER 8MM                 |
| 2006 | P09842006 | LOCK WASHER 8MM                 |
| 2007 | P09842007 | HEX BOLT M8-1.25 X 20           |
| 2008 | P09842008 | OUTFEED FENCE                   |
| 2009 | P09842009 | FENCE FACE                      |
| 2010 | P09842010 | FENCE MOUNT                     |
| 2011 | P09842011 | FLAT HD CAP SCR M4-.7 X 10      |
| 2012 | P09842012 | FLAT HD CAP SCR M3-.5 X 10      |
| 2013 | P09842013 | CAP SCREW M8-1.25 X 20          |
| 2014 | P09842014 | CAP SCREW M8-1.25 X 30          |
| 2101 | P09842101 | SPACER 31.75 X 42 X 40          |
| 2102 | P09842102 | SPACER 31.75 X 42 X 20          |
| 2103 | P09842103 | SPACER 31.75 X 42 X 10          |
| 2104 | P09842104 | SPACER 31.75 X 42 X 5           |
| 2105 | P09842105 | SPACER 31.75 X 42 X 2           |
| 2106 | P09842106 | SPACER 31.75 X 42 X 1.5         |
| 2107 | P09842107 | SPACER 31.75 X 42 X 0.5         |
| 2108 | P09842108 | SPACER 31.75 X 42 X 0.3         |
| 2109 | P09842109 | SPACER 31.75 X 42 X 0.1         |



# Frame



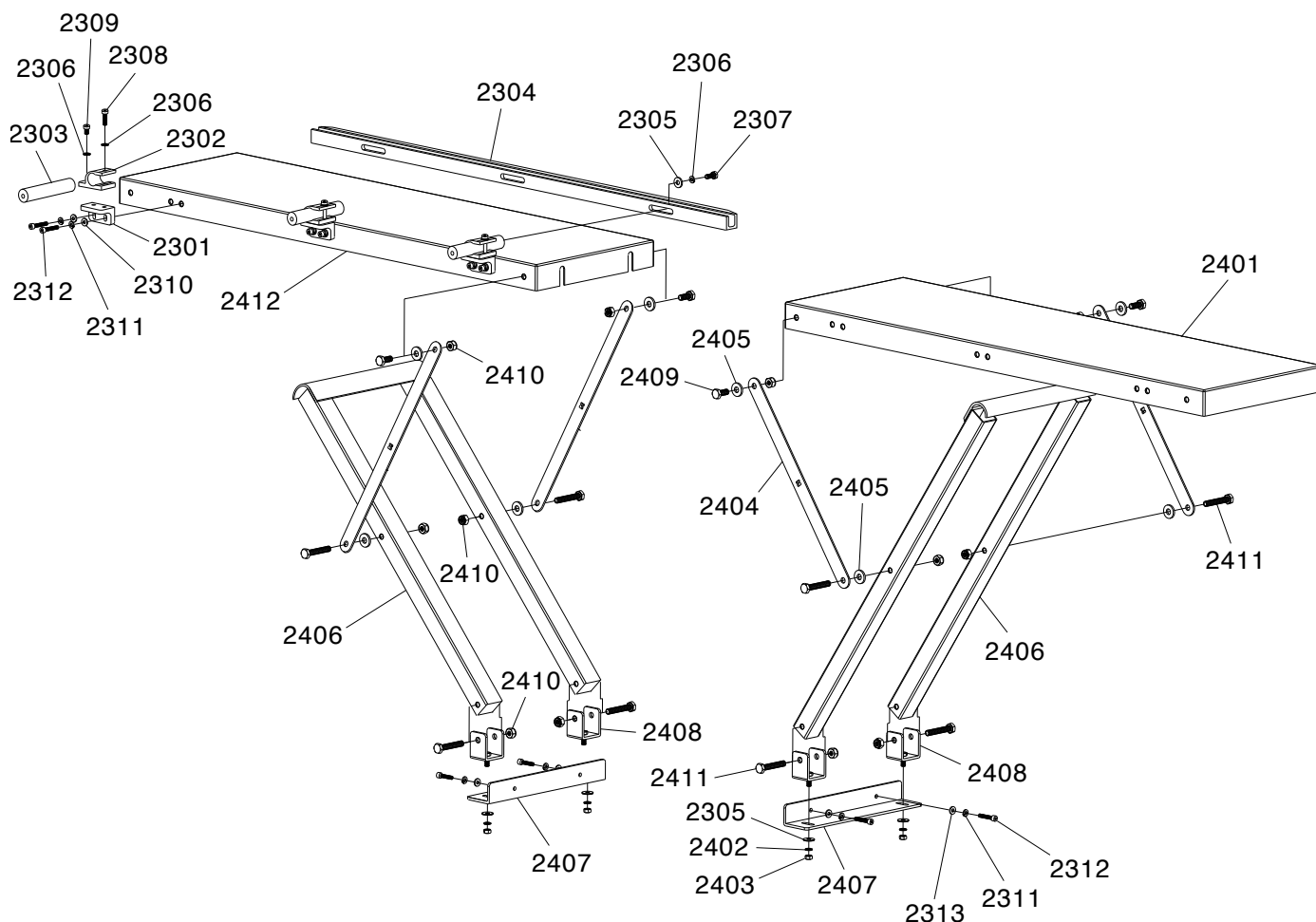
# Frame Parts List

| REF  | PART #    | DESCRIPTION                 |
|------|-----------|-----------------------------|
| 2201 | P09842201 | DUST HOOD LEFT              |
| 2202 | P09842202 | CAP SCREW M6-1 X 10         |
| 2203 | P09842203 | BELT COVER                  |
| 2204 | P09842204 | CAP SCREW M6-1 X 80         |
| 2205 | P09842205 | INFEED GUARD                |
| 2206 | P09842206 | FLAT WASHER 6MM             |
| 2207 | P09842207 | LOCK WASHER 6MM             |
| 2208 | P09842208 | CAP SCREW M6-1 X 16         |
| 2209 | P09842209 | WORKPIECE HEIGHT LIMITER    |
| 2210 | P09842210 | COVER RIGHT                 |
| 2211 | P09842211 | KNOB BOLT 1/4-20 X 1/2      |
| 2212 | P09842212 | SHAFT CHANNEL COVER         |
| 2213 | P09842213 | COVER FRONT/REAR            |
| 2214 | P09842214 | SPROCKET COVER              |
| 2215 | P09842215 | OUTFEED GUARD               |
| 2216 | P09842216 | CAP SCREW M5-.8 X 12        |
| 2217 | P09842217 | TABLE ELEVATION INDICATOR   |
| 2218 | P09842218 | FLAT WASHER 5MM             |
| 2219 | P09842219 | LOCK WASHER 5MM             |
| 2220 | P09842220 | HINGE                       |
| 2221 | P09842221 | FLAT HD CAP SCR M6-1 X 16   |
| 2222 | P09842222 | LOCK NUT M6-1               |
| 2223 | P09842223 | TOP DOOR                    |
| 2224 | P09842224 | DUST HOOD TOP               |
| 2225 | P09842225 | BUTTON HD CAP SCR M6-1 X 10 |
| 2226 | P09842226 | SUPPORT ROD                 |
| 2227 | P09842227 | FLAT HD CAP SCR M5-.8 X 10  |
| 2228 | P09842228 | DOOR WINDOW                 |
| 2229 | P09842229 | FENDER WASHER 6MM           |
| 2230 | P09842230 | BUTTON HD CAP SCR M6-1 X 20 |
| 2231 | P09842231 | DOOR HANDLE                 |
| 2232 | P09842232 | CAP SCREW M8-1.25 X 20      |

| REF  | PART #    | DESCRIPTION                                |
|------|-----------|--------------------------------------------|
| 2233 | P09842233 | LOCK WASHER 8MM                            |
| 2234 | P09842234 | HEX NUT M8-1.25                            |
| 2235 | P09842235 | GAS SPRING MOUNT                           |
| 2236 | P09842236 | CAP SCREW M6-1 X 35                        |
| 2237 | P09842237 | GAS SPRING W/BALL STUDS M8-1.25 X 14       |
| 2238 | P09842238 | PULLEY GUARD                               |
| 2239 | P09842239 | POSITION INDICATOR SIKO DA0917-7/875-2-E-O |
| 2240 | P09842240 | SWITCH MOUNT                               |
| 2241 | P09842241 | DOOR LOCK                                  |
| 2243 | P09842243 | SWITCH EXTENSION ROD                       |
| 2244 | P09842244 | LIMIT SWITCH W/CORD TEND TZ-9211           |
| 2245 | P09842245 | ONE-SHOT OILER CHEN YING CTA-3             |
| 2246 | P09842246 | LIMIT SWITCH TEND TZ-7311                  |
| 2247 | P09842247 | LIMIT ACTUATOR UPPER                       |
| 2248 | P09842248 | LIMIT ACTUATOR LOWER                       |
| 2249 | P09842249 | FLAT WASHER 6MM                            |
| 2250 | P09842250 | CAP SCREW M6-1 X 20                        |
| 2251 | P09842251 | LIMIT SWITCH CORD 20G 2W 79"               |
| 2252 | P09842252 | FLAT WASHER 5MM                            |
| 2253 | P09842253 | LOCK WASHER 5MM                            |
| 2254 | P09842254 | CAP SCREW M5-.8 X 12                       |
| 2255 | P09842255 | ELBOW ADAPTER 90-DEG M8-1 X 18, 1/8" PT    |
| 2256 | P09842256 | TEE-FITTING M1/8" PT                       |
| 2257 | P09842257 | ELECTRICAL CABINET                         |
| 2258 | P09842258 | CAP SCREW M4-.7 X 40                       |
| 2259 | P09842259 | BALL VALVE 1/8" X 1/8" PT                  |
| 2260 | P09842260 | CAP SCREW M6-1 X 12                        |
| 2261 | P09842261 | PHLP HD SCR M5-.8 X 10                     |
| 2262 | P09842262 | POWER JUNCTION BOX                         |
| 2263 | P09842263 | TERMINAL BAR 4P M5 X 84 TM6                |
| 2264 | P09842264 | PHLP HD SCR M5-.8 X 30                     |
| 2265 | P09842265 | POWER CORD 10G 4W 33" INCOMING             |



# Extension Tables

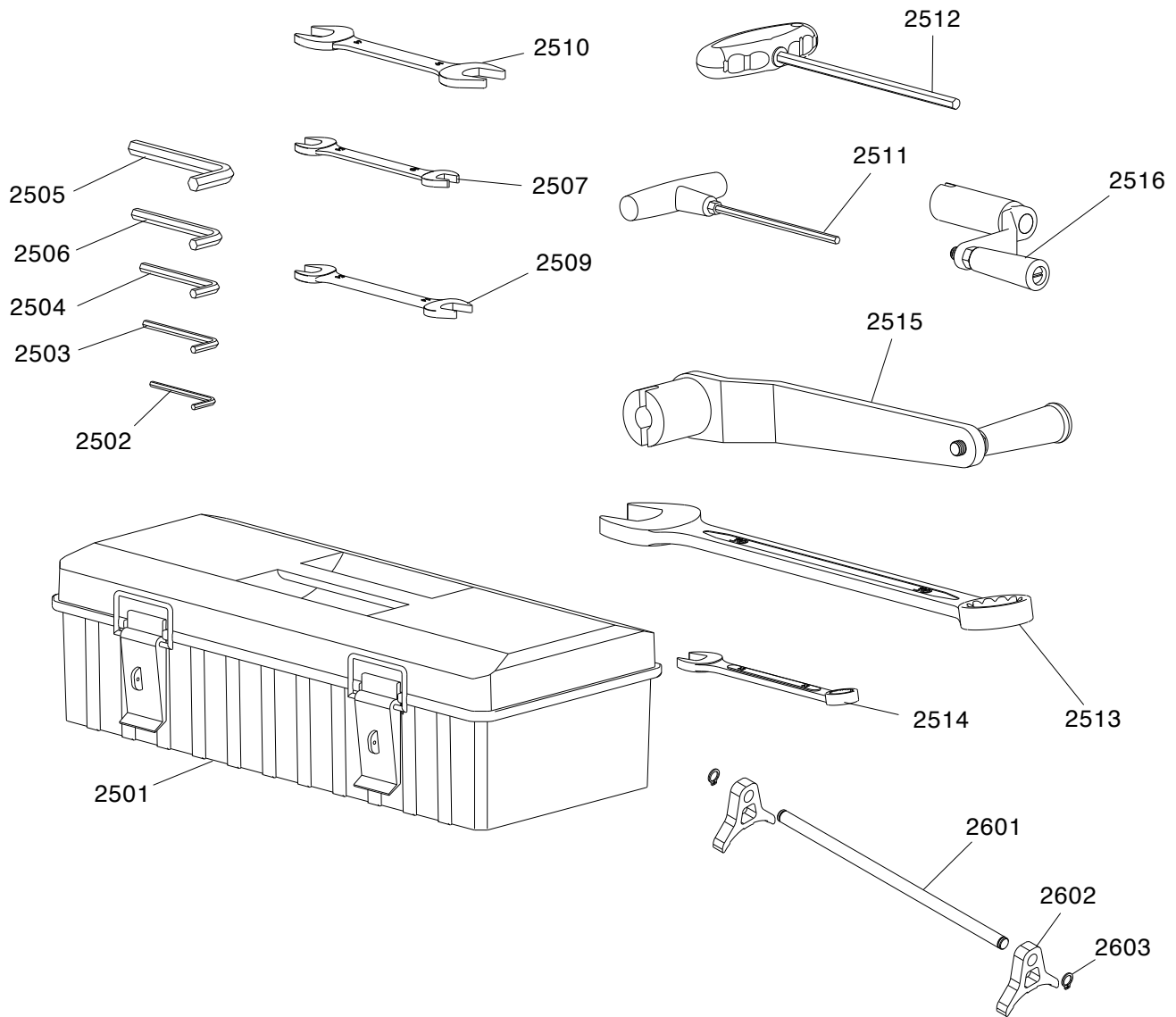


| REF  | PART #    | DESCRIPTION            |
|------|-----------|------------------------|
| 2301 | P09842301 | FENCE MOUNTING BRACKET |
| 2302 | P09842302 | ROD MOUNT              |
| 2303 | P09842303 | FENCE ADJUSTMENT ROD   |
| 2304 | P09842304 | INFEED FENCE           |
| 2305 | P09842305 | FLAT WASHER 8MM        |
| 2306 | P09842306 | LOCK WASHER 8MM        |
| 2307 | P09842307 | HEX BOLT M8-1.25 X 16  |
| 2308 | P09842308 | CAP SCREW M8-1.25 X 40 |
| 2309 | P09842309 | CAP SCREW M8-1.25 X 20 |
| 2310 | P09842310 | FENDER WASHER 6MM      |
| 2311 | P09842311 | LOCK WASHER 6MM        |
| 2312 | P09842312 | CAP SCREW M6-1 X 20    |
| 2313 | P09842313 | FLAT WASHER 6MM        |

| REF  | PART #    | DESCRIPTION                    |
|------|-----------|--------------------------------|
| 2401 | P09842401 | OUTFEED TABLE                  |
| 2402 | P09842402 | LOCK WASHER 8MM                |
| 2403 | P09842403 | HEX NUT M8-1.25                |
| 2404 | P09842404 | TABLE BRACE                    |
| 2405 | P09842405 | SPACER 11 X 25 X 3.5MM         |
| 2406 | P09842406 | TABLE SUPPORT                  |
| 2407 | P09842407 | TABLE SUPPORT MOUNTING BRACKET |
| 2408 | P09842408 | PIVOT BRACKET                  |
| 2409 | P09842409 | HEX BOLT M10-1.5 X 25          |
| 2410 | P09842410 | LOCK NUT M10-1.5               |
| 2411 | P09842411 | HEX BOLT M10-1.5 X 60          |
| 2412 | P09842412 | INFEED TABLE                   |



# Accessories

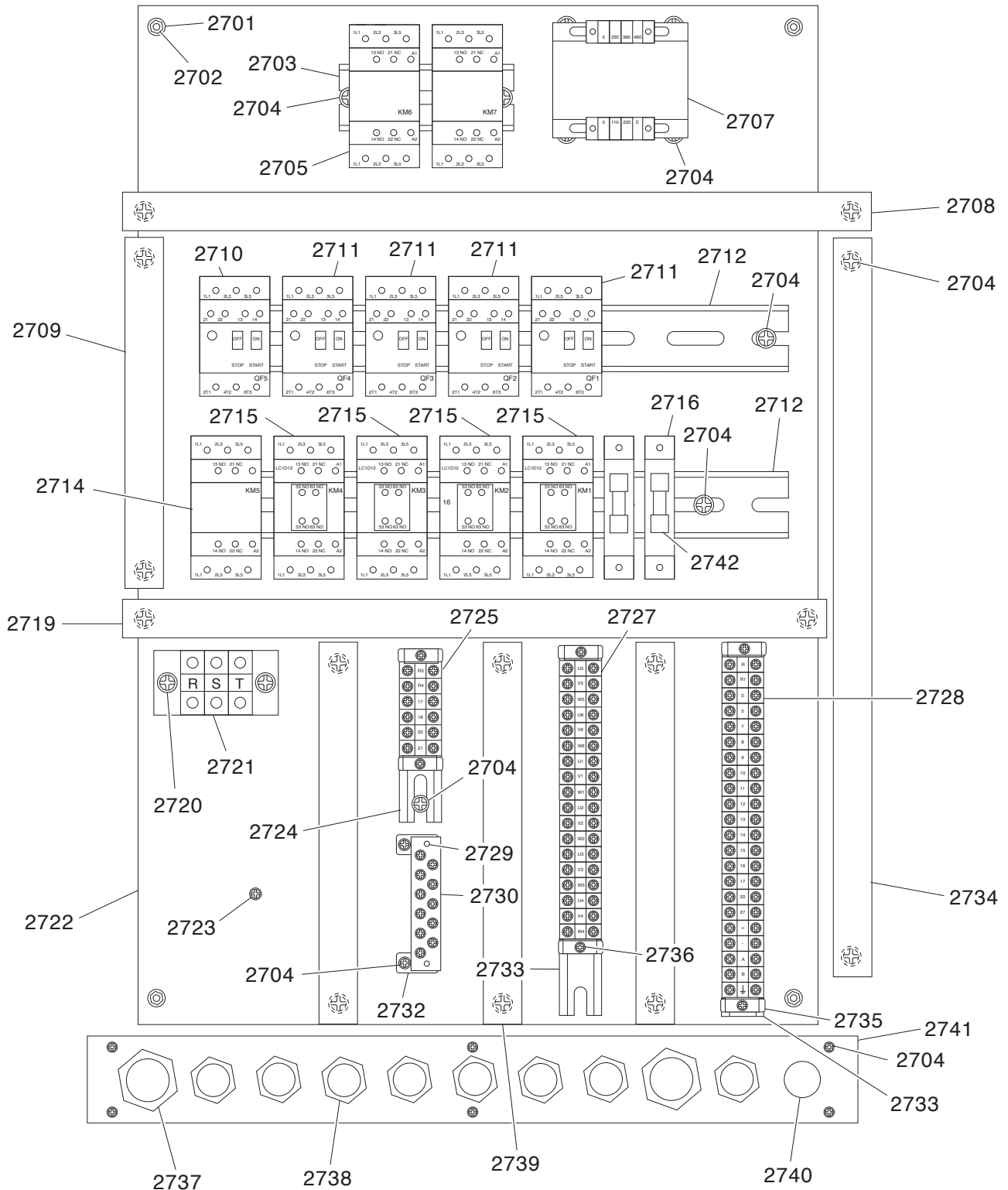


| REF  | PART #    | DESCRIPTION                |
|------|-----------|----------------------------|
| 2501 | P09842501 | TOOLBOX                    |
| 2502 | P09842502 | HEX WRENCH 3MM             |
| 2503 | P09842503 | HEX WRENCH 4MM             |
| 2504 | P09842504 | HEX WRENCH 5MM             |
| 2505 | P09842505 | HEX WRENCH 8MM             |
| 2506 | P09842506 | HEX WRENCH 6MM             |
| 2507 | P09842507 | WRENCH 10 X 12MM OPEN-ENDS |
| 2509 | P09842509 | WRENCH 12 X 14MM OPEN-ENDS |
| 2510 | P09842510 | WRENCH 17 X 19MM OPEN-ENDS |

| REF  | PART #    | DESCRIPTION                            |
|------|-----------|----------------------------------------|
| 2511 | P09842511 | T-HANDLE HEX WRENCH 4MM                |
| 2512 | P09842512 | T-HANDLE HEX WRENCH 6MM                |
| 2513 | P09842513 | WRENCH 30MM COMBO                      |
| 2514 | P09842514 | WRENCH 13MM COMBO                      |
| 2515 | P09842515 | TABLE ELEVATION ADJUSTMENT HANDLE ASSY |
| 2516 | P09842516 | LEFT CUTTERHEAD ADJUSTMENT HANDLE ASSY |
| 2601 | P09842601 | KNIFE SETTING JIG ROD                  |
| 2602 | P09842602 | KNIFE SETTING JIG FOOT                 |
| 2603 | P09842603 | EXT RETAINING RING 9MM                 |



# Electrical Cabinet & Table Limit Switches



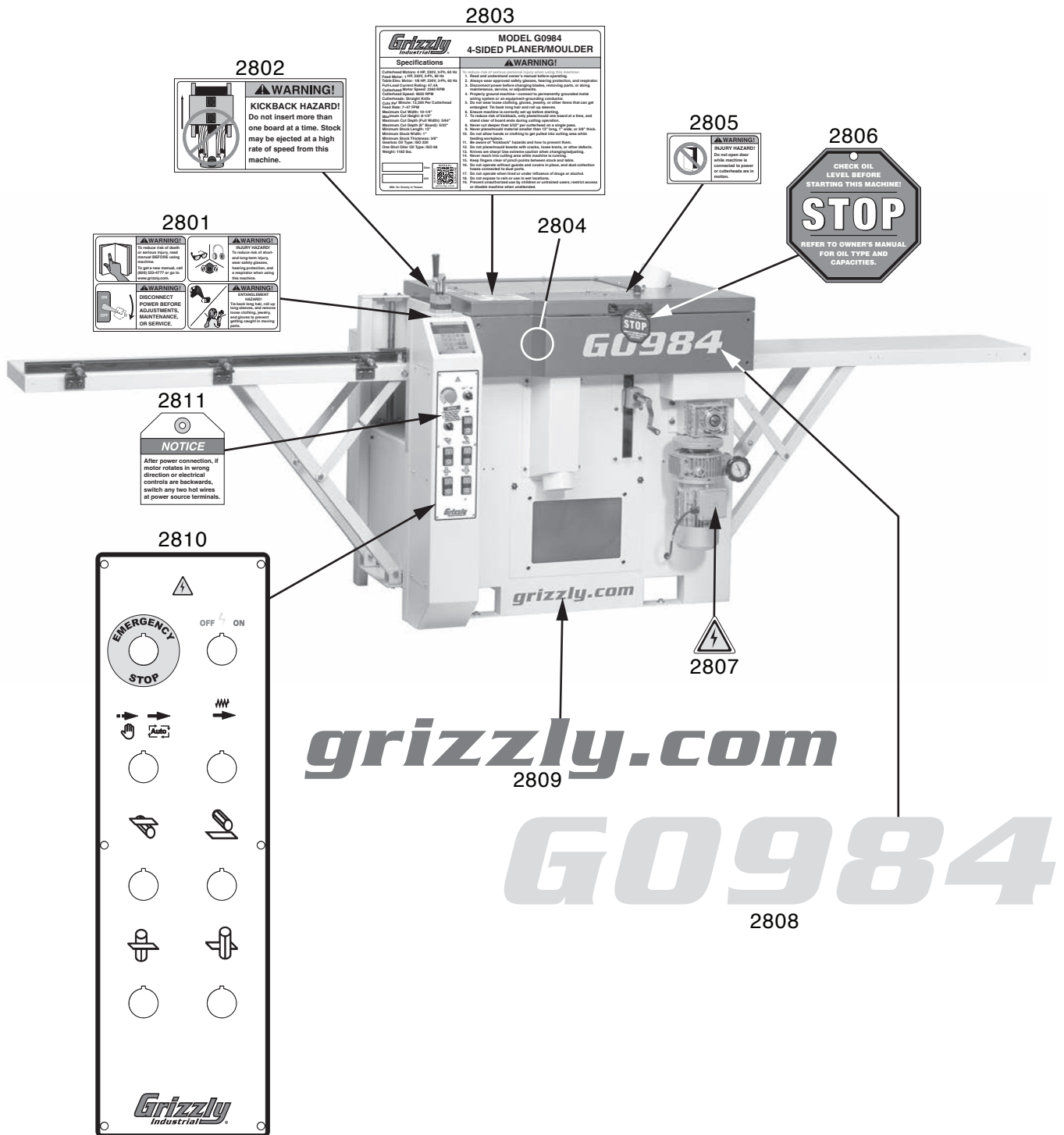
# Electrical Cabinet & Table Limit Switches Parts List

| REF  | PART #    | DESCRIPTION                         |
|------|-----------|-------------------------------------|
| 2701 | P09842701 | FLAT WASHER 1/4                     |
| 2702 | P09842702 | HEX NUT 1/4-20                      |
| 2703 | P09842703 | DIN RAIL 35 X 94                    |
| 2704 | P09842704 | PHLP HD SCR 8-32 X 1/4              |
| 2705 | P09842705 | CONTACTOR SCHNEIDER LC1D09 220V     |
| 2707 | P09842707 | TRANSFORMER LUNGCH LCPIC-TBS-100110 |
| 2708 | P09842708 | WIRE DUCT 25 X 45 X 365MM           |
| 2709 | P09842709 | WIRE DUCT 25 X 45 X 240MM           |
| 2710 | P09842710 | CONTACTOR SCHNEIDER GV2ME08         |
| 2711 | P09842711 | CONTACTOR SCHNEIDER GV2ME16         |
| 2712 | P09842712 | DIN RAIL 35 X 305MM                 |
| 2714 | P09842714 | CONTACTOR SCHNEIDER LC1D09 220V     |
| 2715 | P09842715 | CONTACTOR SCHNEIDER LC1D12 220V     |
| 2716 | P09842716 | FUSE HOLDER SCHNEIDER DF101         |
| 2719 | P09842719 | WIRE DUCT 25 X 45 X 338MM           |
| 2720 | P09842720 | PHLP HD SCR 8-32 X 1                |
| 2721 | P09842721 | TERMINAL BAR 3P 8-32 X 15 TM6       |
| 2722 | P09842722 | MOUNTING PLATE                      |

| REF  | PART #    | DESCRIPTION                  |
|------|-----------|------------------------------|
| 2723 | P09842723 | PHLP HD SCR 8-32 X 3/8       |
| 2724 | P09842724 | DIN RAIL 25 X 100MM          |
| 2725 | P09842725 | TERMINAL BAR 6P DIN25 TM3    |
| 2727 | P09842727 | TERMINAL BAR 18P DIN25 TM3   |
| 2728 | P09842728 | TERMINAL BAR 22P DIN25 TM3   |
| 2729 | P09842729 | PHLP HD SCR 10-24 X 3/8      |
| 2730 | P09842730 | GROUND TERMINAL PLATE T10    |
| 2732 | P09842732 | TERMINAL PLATE MOUNT         |
| 2733 | P09842733 | DIN RAIL 25 X 220MM          |
| 2734 | P09842734 | WIRE DUCT 25 X 45 X 455MM    |
| 2735 | P09842735 | END BLOCK DIN25              |
| 2736 | P09842736 | PHLP HD SCR M4-.7 X 6        |
| 2737 | P09842737 | STRAIN RELIEF 1"             |
| 2738 | P09842738 | STRAIN RELIEF 13/16"         |
| 2739 | P09842739 | WIRE DUCT 25 X 45 X 225MM    |
| 2740 | P09842740 | PLUG 22MM                    |
| 2741 | P09842741 | STRAIN RELIEF MOUNTING PLATE |
| 2742 | P09842742 | FUSE 2A 500V 10MM CARTRIDGE  |



# Labels & Cosmetics (Front)

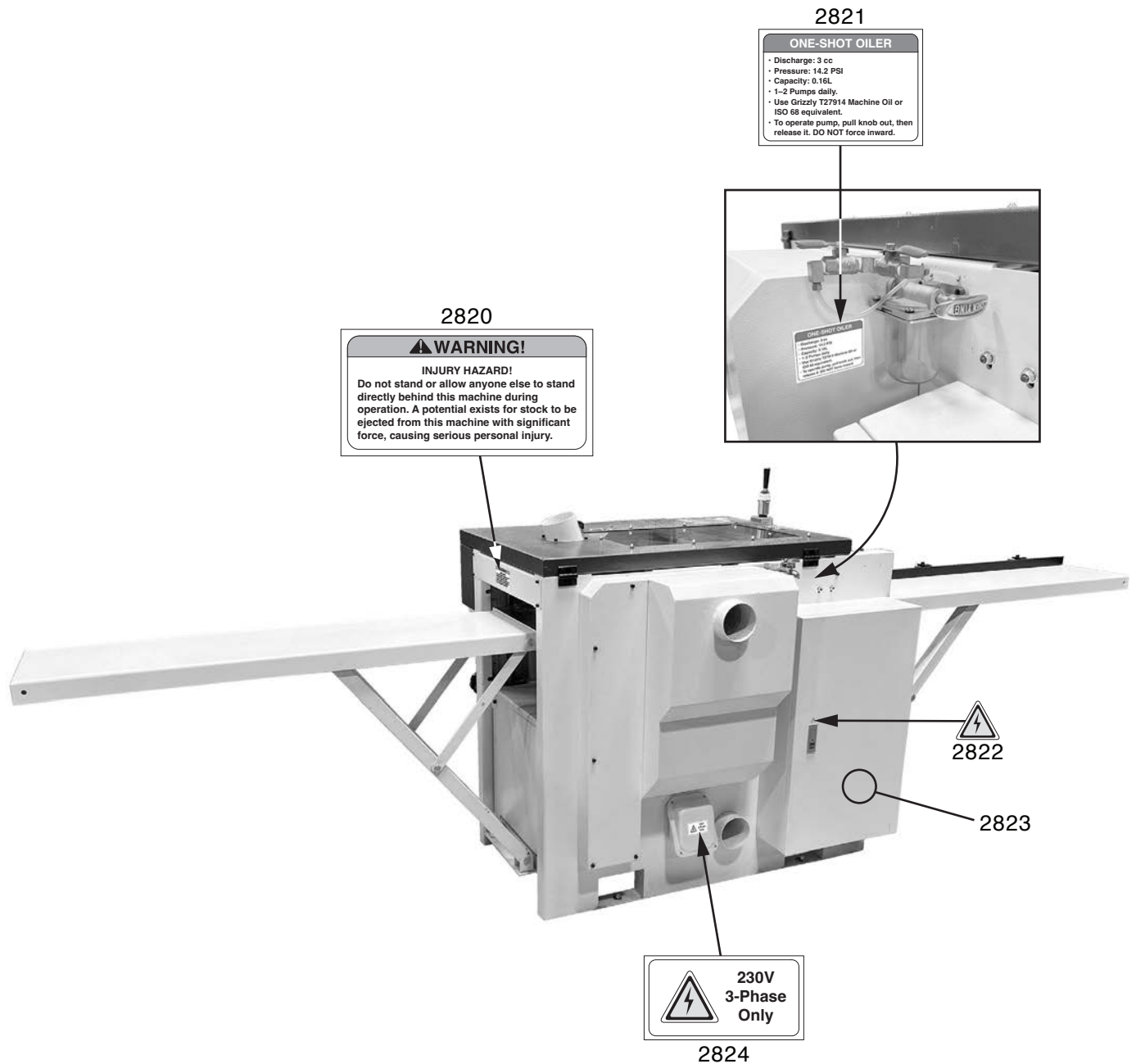


| REF  | PART #    | DESCRIPTION                   |
|------|-----------|-------------------------------|
| 2801 | P09842801 | COMBO WARNING LABEL           |
| 2802 | P09842802 | KICKBACK HAZARD LABEL         |
| 2803 | P09842803 | MACHINE ID LABEL              |
| 2804 | P09842804 | TOUCH-UP PAINT, GRIZZLY GREEN |
| 2805 | P09842805 | DO NOT OPEN DOOR LABEL        |
| 2806 | P09842806 | CHECK OIL HANG TAG            |

| REF  | PART #    | DESCRIPTION               |
|------|-----------|---------------------------|
| 2807 | P09842807 | ELECTRICITY LABEL         |
| 2808 | P09842808 | MODEL NUMBER LABEL        |
| 2809 | P09842809 | GRIZZLY.COM LABEL         |
| 2810 | P09842810 | CONTROL PANEL LABEL       |
| 2811 | P09842811 | POWER CONNECTION HANG TAG |



# Labels & Cosmetics (Rear)



| REF  | PART #    | DESCRIPTION          |
|------|-----------|----------------------|
| 2820 | P09842820 | DO NOT STAND LABEL   |
| 2821 | P09842821 | ONE-SHOT OILER LABEL |
| 2822 | P09842822 | ELECTRICITY LABEL    |

| REF  | PART #    | DESCRIPTION                   |
|------|-----------|-------------------------------|
| 2823 | P09842823 | TOUCH-UP PAINT, GRIZZLY BEIGE |
| 2824 | P09842824 | 230V 3-PHASE LABEL            |

## ⚠ WARNING

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





# WARRANTY & RETURNS

---

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

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

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

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

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

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

For further information about the warranty, visit <https://www.grizzly.com/forms/warranty> or scan the QR code below to be automatically directed to our warranty page.





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

*Visit Our Website Today For  
Current Specials!*

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

