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# MODEL T32018

## 8" V-HELICAL

## CUTTERHEAD

## INSTRUCTIONS

### Introduction

The Model T32018 8" V-Helical Cutterhead is designed to replace the straight-knife cutterheads in the following Grizzly and Shop Fox jointers:

- Grizzly G0500, G0586
- Grizzly G1018 Series  
—Dual-Belt Models ONLY (Mfd. Since 1992)
- Shop Fox W1684

The Model T32018 will also replace straight-knife cutterheads in the following non-Grizzly machines, but are outside the scope of these instructions:

- Bridgewood BW8J
- Geetech CT-200, CT-204L
- Sunhill SM-204

### WARNING

**DO NOT** modify or alter this cutterhead to make it fit other makes or models of jointers for which it is not designed. Doing so could result in property damage or serious personal injury.

The total installation/setup procedure takes approximately one hour. Read these instructions thoroughly before beginning.

**Note:** Not all pictures in these instructions will exactly reflect your machine. Some photos are provided for representation purposes only to help you better understand the instructions given.

### Inventory (Figure 1)

Description	Qty
A. V-Helical Cutterhead Assembly .....	1
B. Flat Hd Torx Screws T20 M6-1 x 15 .....	10
C. Indexable Inserts 15 x 15 x 2.5mm .....	5
D. Torx Bits T-20 .....	5
E. Flat Washers 3/8" .....	2
F. Lock Washers 3/8" .....	2
G. Bearing Block Studs 3/8"-24 x 4" .....	2
H. Hex Nuts 3/8"-24 .....	2
I. T-Handle Bit Driver 1/4" .....	1

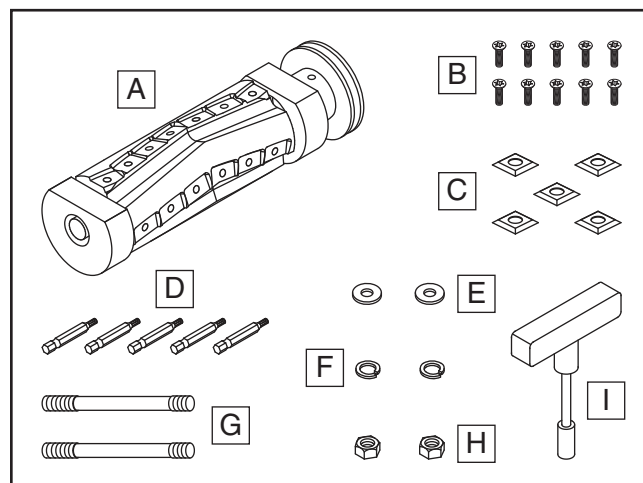


Figure 1. Model T32018 inventory.

### Specifications

Maximum Width of Cut .....	8"
Cutterhead Diameter .....	3 1/16"
Number of Indexable Inserts .....	32
Indexable Insert Size .....	15 x 15 x 2.5mm

## Removing Existing Cutterhead

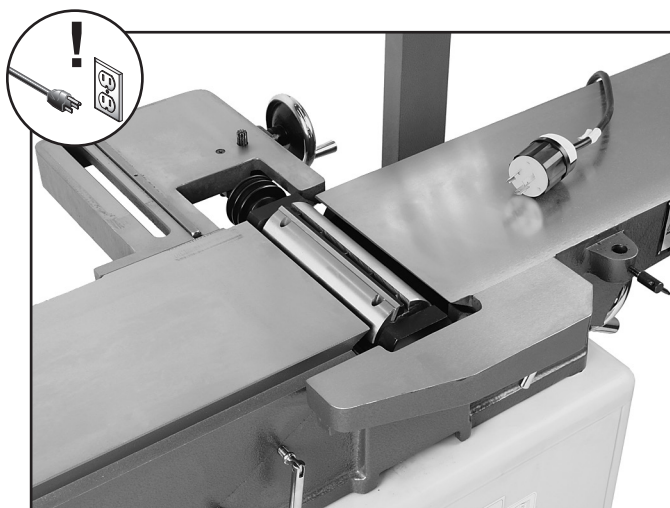
### Items Needed

- Heavy Leather Gloves..... 1 Pair
- Safety Glasses (per person)..... 1
- Open-End Wrench  $\frac{9}{16}$ " ..... 1
- Clean Shop Rags ..... As Needed
- Degreaser..... As Needed

### To remove existing cutterhead:

1. DISCONNECT MACHINE FROM POWER!
2. Remove jointer fence and cutterhead guard.
3. Remove rear panel and belt guard, then remove V-belt from pulleys.
4. Lower both tables to make enough room for the cutterhead to come out (see **Figure 2**).

**Note:** When lowering, make sure that the fence support does not come in contact with the cutterhead pulley.



**Figure 2.** Example of jointer disassembly **Steps 1-4.**

5. Remove hex nut and lock/flat washer on bearing block stud, as shown in **Figure 3**, and repeat on the other side.



**Figure 3.** Example of removing hex nut and lock/flat washer on bearing block stud.

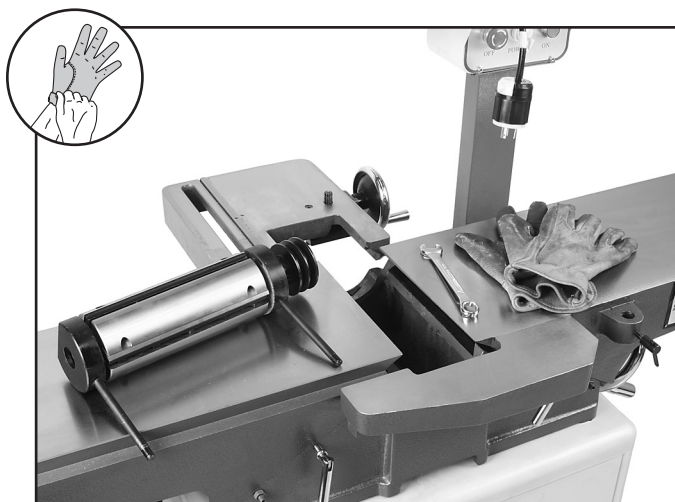


## ⚠ WARNING

Jointer knives are extremely sharp. You must remove the jointer knives, or mount the knives blade side down to avoid the risk of serious personal injury.

6. Wearing heavy leather gloves, carefully remove cutterhead from the casting (see **Figure 4**).

**Note:** Your cutterhead may have paper shims on the bearing block or where the bearing block rests. These were included at the factory when they calibrated your cutterhead to be even with the outfeed table. Your new cutterhead may or may not need these. If you see any shims, carefully pull them off and set them aside for later use—or keep them with your cutterhead in the event that you re-install it later. Also, mark the side of the cutterhead where they were used, so the future install will go smoothly.



**Figure 4.** Example of cutterhead removed.

## Installing V-Helical Cutterhead

### Items Needed

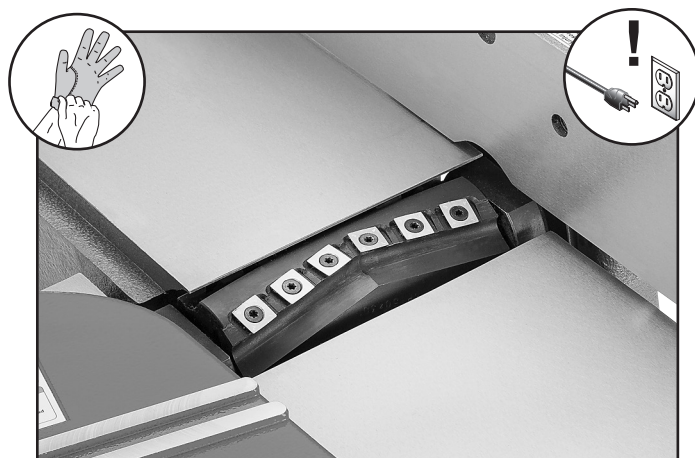
- Heavy Leather Gloves ..... 1 Pair
- Safety Glasses (per person)..... 1
- Open-End Wrench  $\frac{9}{16}$ " ..... 1
- Hex Wrench  $\frac{5}{32}$ " ..... 1
- Precision Straightedge 12" ..... 1
- Feeler Gauge Set..... 1
- Clean Shop Rags ..... As Needed
- Degreaser..... As Needed

## ⚠ WARNING

Cutterhead inserts are extremely sharp. Wear heavy leather gloves to avoid the risk of serious personal injury.

### To install V-helical cutterhead:

1. DISCONNECT MACHINE FROM POWER!
2. Install V-helical cutterhead (see **Figure 5**) with bearing block studs, lock washers (G0586 uses flat washers), and hex nuts included with the Model T32018.

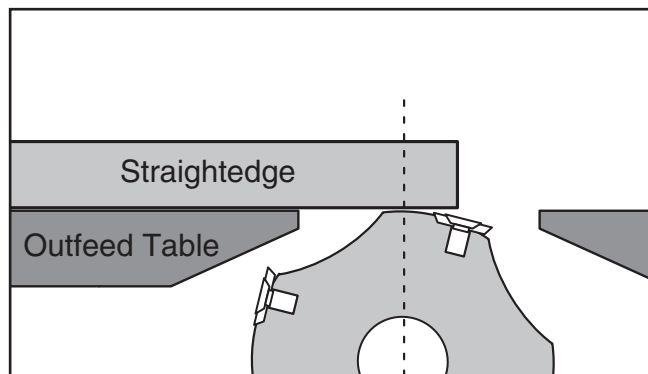


**Figure 5.** Example of V-helical cutterhead installed.

3. Tighten cutterhead in place, and ensure pulley set screws are tight.



4. Using straightedge and feeler gauge set, inspect cutterhead parallelism with outfeed table as shown in **Figure 6**. With straightedge in position, raise or lower outfeed table until cutterhead body (not the indexable insert) just touches straightedge.



**Figure 6.** Checking cutterhead parallelism.

5. Move straightedge to the other side to determine if one end of cutterhead body is higher/lower than the other. (Place feeler gauge between cutterhead body and straightedge to determine the height difference.)

- If cutterhead is even or within 0.003" with outfeed table from one side to other, skip to **Step 7**.

- If cutterhead is over 0.003" from one side to other, go to **Step 6**.

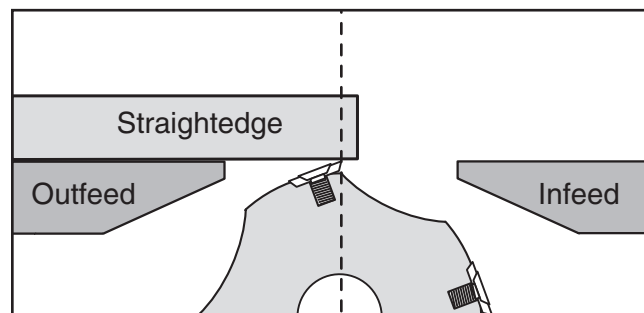
6. Loosen hex nuts securing both bearing block studs, lift V-helical cutterhead slightly, then place a shim beneath bearing block that needs to be adjusted.

**Note:** Use shims from your old cutterhead if available. If not available, newspaper is approximately 0.003" thick and will work for shimming (we don't recommend shimming more than 0.003" on either side, as this may affect how the bearing block seats in the casting).

7. Repeat **Steps 3–5** and adjust as necessary, then tighten hex nuts on bearing block studs.

8. Place a straightedge on outfeed table so it extends over cutterhead, and rotate cutterhead pulley until one of the indexable inserts is at top-dead-center (TDC), as shown in **Figure 7**.

**IMPORTANT:** When correctly set, indexable insert will just touch straightedge when insert is at its highest point of rotation.



**Figure 7.** Cutterhead insert at top-dead-center.

- If your outfeed table is correctly set, no adjustments are necessary.

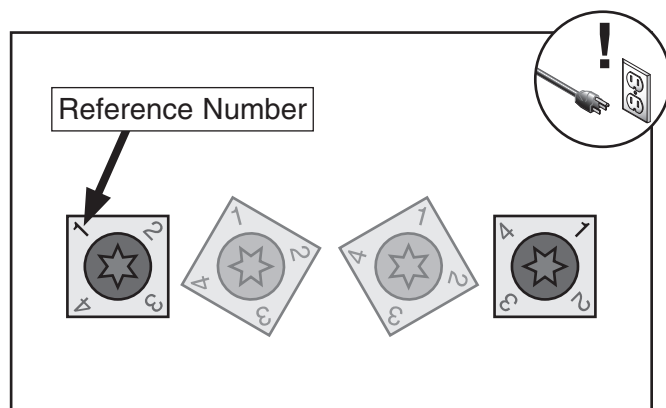
- If insert lifts straightedge off table or if table is below straightedge, adjust outfeed table height with handwheel until straightedge just touches an insert at its highest point of rotation.

9. Lock outfeed table, then re-install fence.
10. Re-install V-belt on pulleys (refer to instructions in your jointer manual for details).
11. Re-install rear panel and belt guard.
12. Install cutterhead guard back over cutterhead, making sure that spring tension in guard is properly set so guard springs back over cutterhead when it is pulled back and released.



## Replacing/Rotating Indexable Inserts

The Model T32018 V-Helical Cutterhead is equipped with 4-sided indexable inserts. Each insert can be removed, rotated, and re-installed to use any of its four cutting edges. If one cutting edge becomes dull or damaged, simply rotate it 90° (see **Figure 8**) to use a sharp cutting edge.



**Figure 8.** Rotating indexable inserts.

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

### Items Needed

- Heavy Leather Gloves ..... 1 Pair
- Safety Glasses (per person)..... 1
- Flat Hd Torx Screws M6-1 x 15 .... As Needed
- Indexable Inserts (T32014) ..... As Needed
- Torx Bit T-20 ..... 1
- T-Handle Bit Driver 1/4" ..... 1
- Torque Wrench 0–50 in.-lb. .... 1
- Clean Shop Rags ..... As Needed
- Degreaser ..... As Needed
- Light Machine Oil..... As Needed

### To replace or rotate an indexable insert:

1. DISCONNECT MACHINE FROM POWER!
  2. Set fence to 90° and move it all the way back.
  3. Remove cutterhead guard and lower infeed table as far down as it will go.
  4. Remove belt guard to access V-helical cutterhead pulley.
  5. Rotate pulley as needed to make inserts accessible for removal or rotation.
  6. Remove any sawdust from head of indexable insert Torx screw.
  7. Put on heavy leather gloves to protect fingers and hands.
  8. Remove Torx screw and indexable insert.
  9. Clean all dust and dirt off insert and cutterhead pocket from which insert was removed, and replace insert so a fresh, sharp edge is facing outward.
- Note:** Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between insert and cutterhead will slightly raise insert, and make noticeable marks on your workpieces the next time you cut.
10. Lubricate Torx screw threads with a light machine oil, wipe excess oil off threads, and torque Torx screw to 48-50 inch pounds.
- Note:** Excess oil may squeeze between insert and cutterhead or in screw hole, thereby lifting insert or screw slightly and affecting work-piece finishes.
11. Re-install belt guard and raise infeed table.
  12. Install cutterhead guard back over cutterhead, making sure that spring tension in guard is properly set so guard springs back over cutterhead when it is pulled back and released.

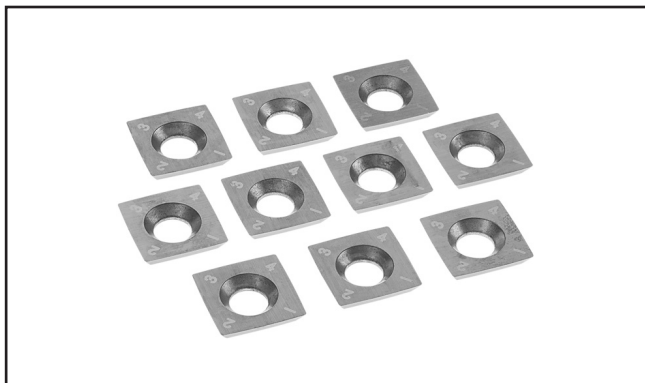




## Accessories

### **T32014—10 Pack of Indexable Carbide Inserts**

Replacement 15 x 15 x 2.5mm indexable carbide inserts for Model T32018 8" V-Helical Cutterhead.



**Figure 9.** T32014 Indexable Carbide Inserts.

## Basic Eye Protection

**T20501—Face Shield Crown Protector 4"**

**T20502—Face Shield Crown Protector 7"**

**T20503—Face Shield Window**

**T20451—"Kirova" Clear Safety Glasses**

**T20452—"Kirova" Anti-Reflective S. Glasses**

**T20456—DAKURA Safety Glasses, Black/Clear**



**Figure 10.** Assortment of basic eye protection.

### **G0860—1½ HP Portable Cyclone Dust Collector**

This compact unit features an impressive 868 CFM and up to 9.7" of static pressure—perfect for handling up to two large machines at once. The 20-gallon collection drum with quick-release handle catches large particulate for quick and clean bag changes, and the pleated 1-micron filter captures remaining dust as part of this super efficient two-stage separation system. All this, and it features a wireless remote!



**Figure 11.** G0860 Portable Dust Collector.

**T24029—Economy Leather Gloves, Medium**

**T24030—Economy Leather Gloves, Large**

**T24031—Economy Leather Gloves, Ex. Large**

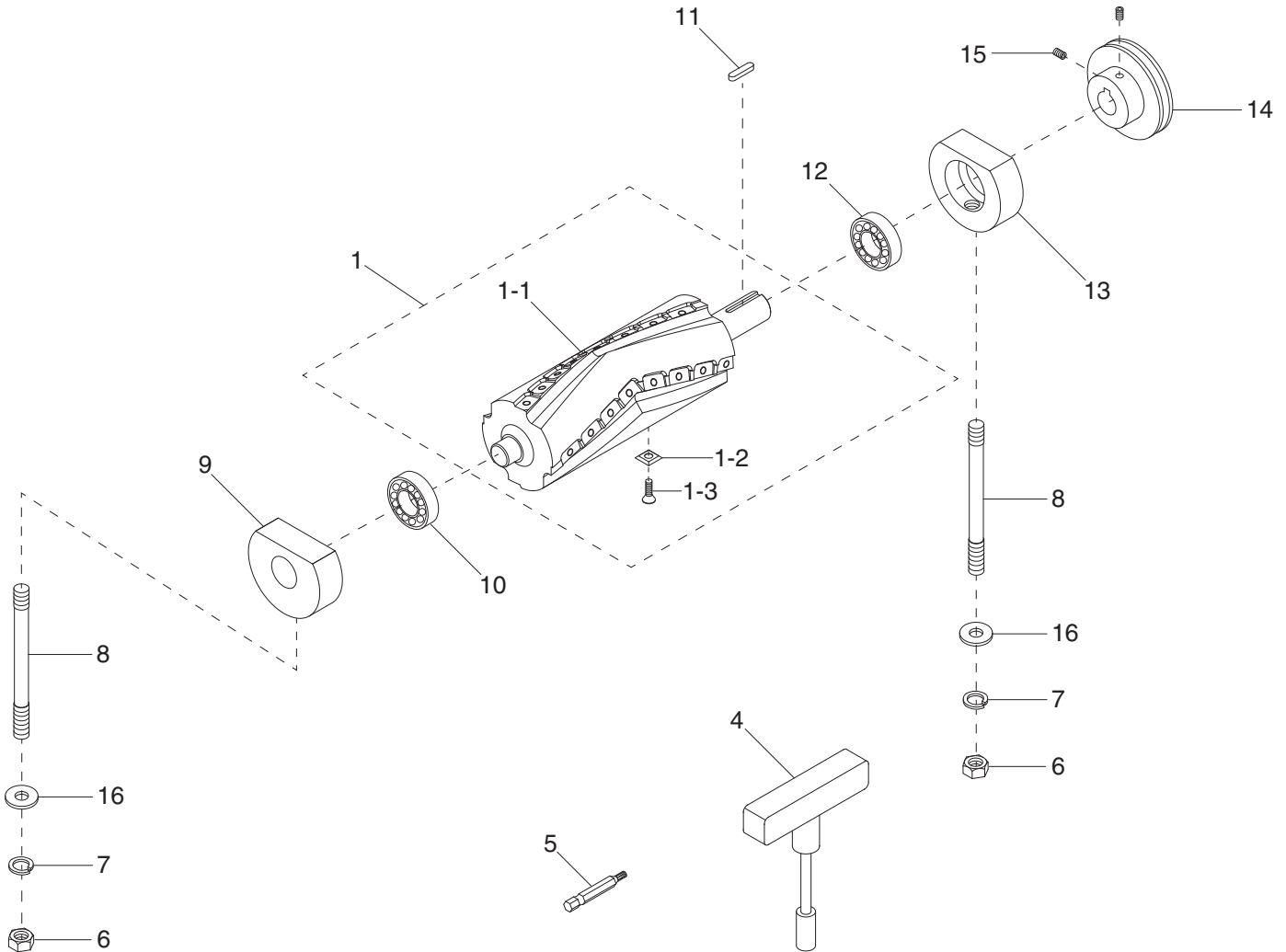
Ideal for tough jobs, these unlined leather gloves feature striped cotton-blend canvas back and cuff that extends to the wrist, and a gray economy suede palm.



**Figure 12.** Heavy leather gloves.



# Parts Breakdown & List



REF PART #	DESCRIPTION
1	PT32018001 V-HELICAL CUTTERHEAD ASSEMBLY 8"
1-1	PT32018001-1 V-HELICAL CUTTERHEAD 8"
1-2	PT32018001-2 CARBIDE INSERTS 15 X 15 X 2.5MM 10-PK
1-3	PT32018001-3 FLAT HD TORX SCR T20 M6-1 X 16
4	PT32018004 T-HANDLE BIT DRIVER 1/4"
5	PT32018005 TORX BIT T-20
6	PT32018006 HEX NUT 3/8-24
7	PT32018007 LOCK WASHER 3/8
8	PT32018008 STUD-UDE 3/8-24 X 4, 3/8, 1

REF PART #	DESCRIPTION
9	PT32018009 BEARING BLOCK (FRONT)
10	PT32018010 BALL BEARING 6204-2RS
11	PT32018011 KEY 5 X 5 X 35 RE
12	PT32018012 BALL BEARING 6205-2RS
13	PT32018013 BEARING BLOCK (REAR)
14	PT32018014 CUTTERHEAD PULLEY
15	PT32018015 SET SCREW 5/16-18 X 3/8
16	PT32018016 FLAT WASHER 3/8

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** to check for availability.





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