



MODEL T32058 8" HELICAL CUTTERHEAD ASSEMBLY FOR G0857 INSTRUCTIONS

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

Introduction

The Model T32058 8" Helical Cutterhead is designed to replace the straight-knife cutterhead on the Model G0857 8" x 76" Jointer.

!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.

Due to the nature of installation, an additional person **MUST** be available to assist with lifting the G0857 jointer table base. The total time for setup/ installation is 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.

Specifications

Maximum Width of Cut..... 8"
Cutterhead Diameter 3¹/₁₆"
Number of Indexable Carbide Inserts 36
Indexable Carbide Insert Size 15 x 15 x 2.5mm

Inventory (Figure 1)

| Description | Qty |
|--|-----|
| A. Helical Cutterhead Assembly | 1 |
| B. T-Handle Torx Drivers T25..... | 2 |
| C. Flat Hd Torx Screws T25 10-32 x 1/2"..... | 10 |
| D. Indexable Inserts 15 x 15 x 2.5mm | 5 |

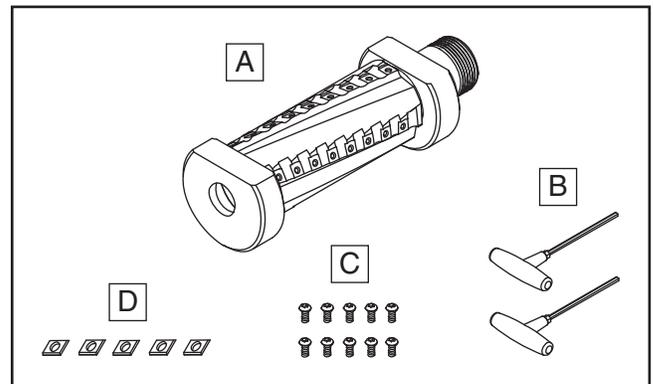


Figure 1. Model T32058 inventory.

Tools Needed

- Additional Person for Lifting 1
- Safety Glasses (per person)..... 1
- Pair of Heavy Leather Gloves 2
- Wood Blocks 24" 4x4 2
- Phillips Head Screwdriver #2 1
- Flat Head Screwdriver..... 1
- Hex Wrenches 5, 6, 9mm..... 1 Ea.
- Adjustable Wrench 1
- Precision Straightedge 36" 1
- Feeler Gauge Set..... 1
- Shop Rag As Needed
- Degreaser..... As Needed

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Removing Existing Cutterhead

1. DISCONNECT MACHINE FROM POWER!
2. Remove jointer fence and cutterhead guard.
3. Remove rabbeting table, cutterhead front cover, rear access panel, and belt cover, then remove V-belt from pulleys.
4. Loosen infeed and outfeed table locks, then loosen jam nuts and positive stop bolts.
5. Lower both tables to make enough room for cutterhead to come out (see **Figure 2**).

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



Figure 2. Jointer disassembly Steps 1–5.

6. Remove (3) hex bolts, lock washers, and flat washers from jointer table base and set aside for later installation.

Note: One hex bolt is located on the left side of the table base below the outfeed table, and two hex bolts are located on the right side of the table base below the infeed table.



7. With help from an assistant, lift one side of the table base and place (1) 24" 4x4 wood block underneath, as shown in **Figure 3**. Repeat for the opposite side.

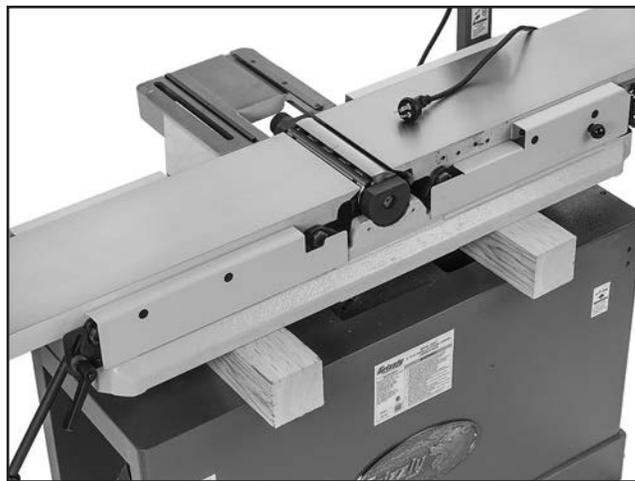


Figure 3. Table base supported by wood blocks.

!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 during the following steps.

8. Remove knives or reverse their mounting direction so blades face toward cutterhead.



- Remove cap screws and lock washers that secure both bearing blocks (see **Figure 4**).

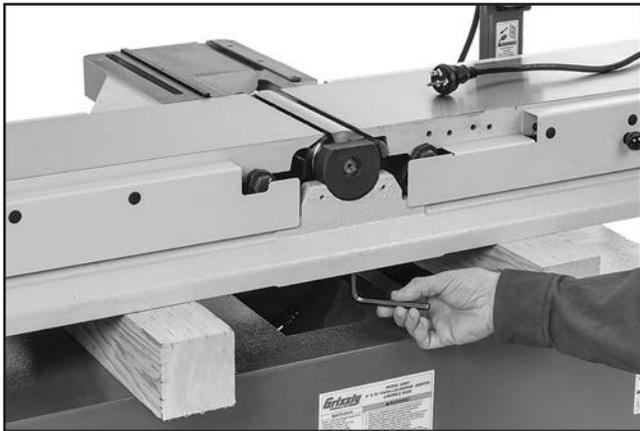


Figure 4. Removing cap screw and lock washer on bearing block.

- Carefully remove bearing blocks and cutterhead from casting (see **Figure 5**).

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

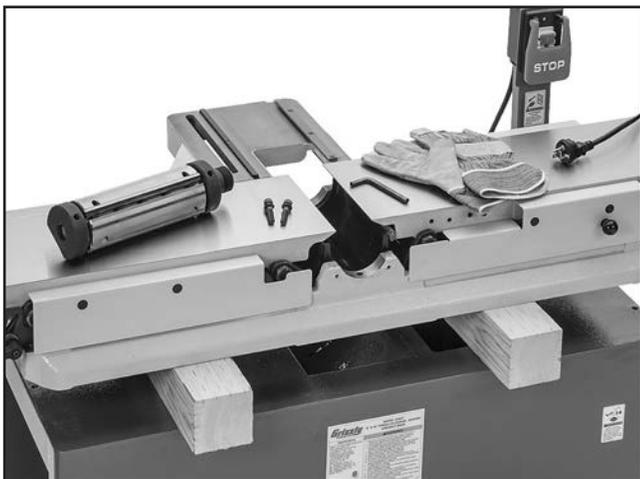


Figure 5. Cutterhead removed.

Installing Helical Cutterhead

⚠ WARNING

Jointer carbide inserts are extremely sharp. Wear leather gloves to avoid the risk of serious personal injury during the following steps.

- With a rag and degreaser, clean area of casting where bearing blocks will rest.
- Install cutterhead with cap screws and lock washers previously removed (see **Figure 6**).

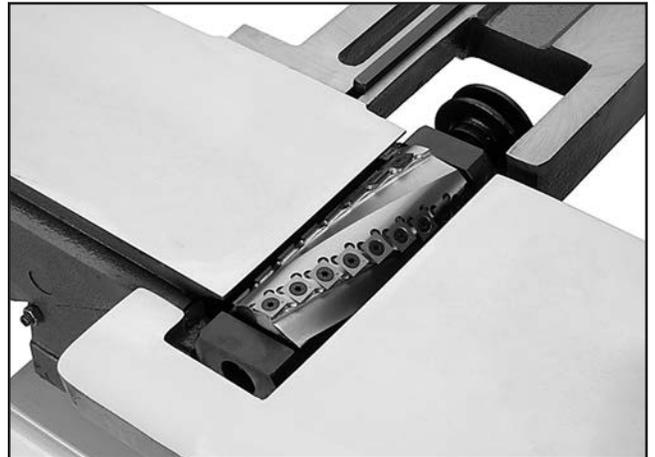


Figure 6. Example of helical cutterhead installed.

- Tighten helical cutterhead in place, and ensure pulley set screw is tight.
- Using straightedge and feeler gauge set, inspect cutterhead parallelism with outfeed table, as shown in **Figure 7**. With straightedge in position, raise or lower outfeed table until cutterhead body (not the carbide insert) just touches straightedge.

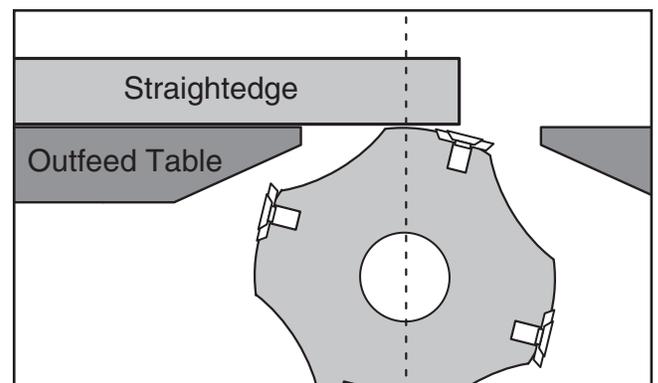


Figure 7. Checking cutterhead parallelism.



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 8**.

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

6. Loosen cap screws securing both bearing blocks, lift 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 4–6** and adjust as necessary, then tighten cap screws on bearing blocks.

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

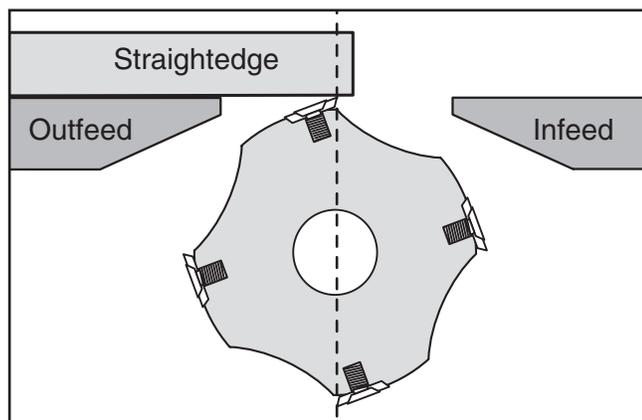


Figure 8. Cutterhead insert at top-dead-center.

When correctly set, carbide insert will just touch straightedge when insert is at its highest point of rotation (see **Figure 8**).

— 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 outfeed table adjustment lever until straightedge just touches an insert at its highest point of rotation.

9. Tighten helical cutterhead in place, and ensure pulley set screw is tight.



10. With help from an assistant, lift one side of the table base and carefully remove one wood block from underneath. Repeat for the opposite side.

11. Secure jointer table base to cabinet stand with (3) hex bolts, lock washers, and flat washers removed earlier.

12. Lock outfeed table, then re-install fence.

13. Re-install V-belt on pulleys. (Refer to instructions in your G0857 manual for details.)

14. Re-install rabbeting table, cutterhead front cover, rear access panel, and belt cover.

15. Reset positive stop bolts on infeed and outfeed tables.

16. 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.



Rotating Inserts

The cutterhead is equipped with 36 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it clockwise 90° to reveal a fresh cutting edge (see **Figure 9**).

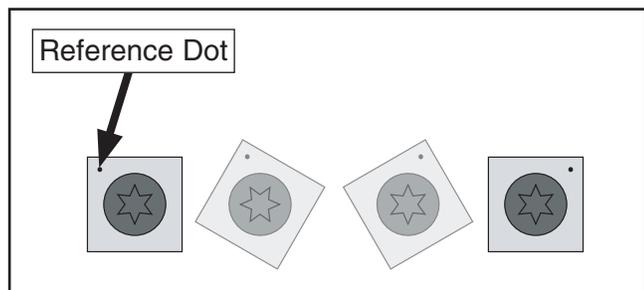


Figure 9. Rotating indexable carbide inserts.

In addition, each insert has a reference dot on one corner. As the insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. The insert must be replaced when all four edges are dull.

Recommended Tools

- Pair of Heavy Leather Gloves 1
- Safety Glasses (per person)..... 1
- T-Handle Torx Driver T25 1
- Torque Wrench 0–50 in.-lb..... 1
- Shop Rag As Needed
- Degreaser..... As Needed
- Light Machine Oil As Needed

Installing or adjusting a carbide insert:

1. DISCONNECT MACHINE FROM POWER!
2. Remove any sawdust from head of carbide insert Torx screw.
3. Remove Torx screw and carbide insert.
4. 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.
5. Lubricate Torx screw threads with a light machine oil, wipe excess oil off threads, and torque Torx screw to 48-50 INCH pounds.

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.*

Note: *Excess oil may squeeze between insert and cutterhead or in screw hole, thereby lifting insert or screw slightly and affecting work-piece finishes.*



Accessories

H9893—10 Pack of Indexable Carbide Inserts
Replacement 15 x 15 x 2.5mm carbide inserts for Model T32057 8" Helical Cutterhead.

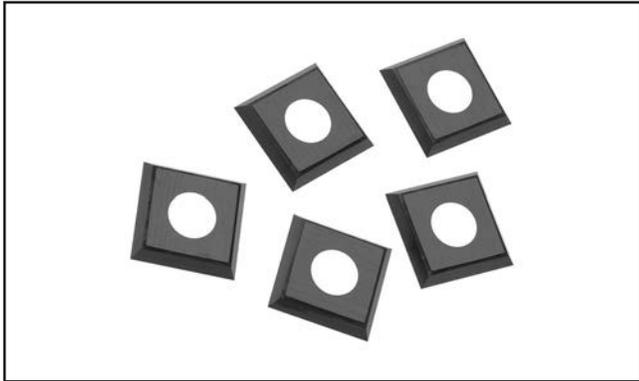


Figure 10. H9893 Indexable Carbide Inserts.

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 11. Assortment of basic eye protection.

G0860—1½ HP Portable Cyclone Dust Collector

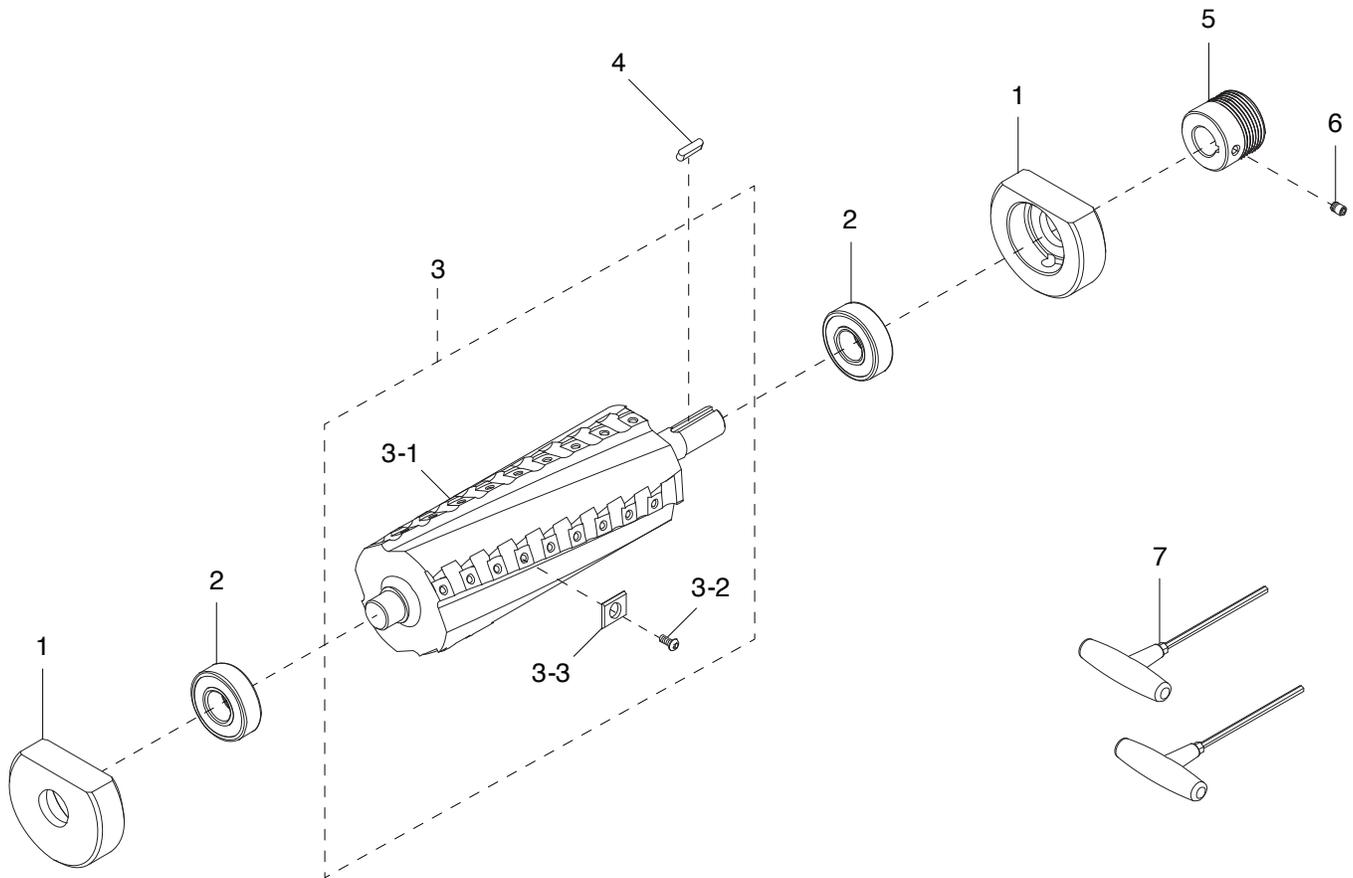
This compact unit features an impressive 868 CFM and up to 9.7" of static pressure—perfect for handling up to two large machines at once. The 20 gallon collection drum with quick release handle catches large particulate for quick and clean bag changes, and the pleated 1-micron filter captures remaining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



Figure 12. G0860 Portable Dust Collector.



T32058 Parts Breakdown & List



| REF PART # | DESCRIPTION |
|------------|--|
| 1 | PT32058001 BEARING BLOCK |
| 2 | PT32058002 BALL BEARING 6204-2NSE |
| 3 | PT32058003 HELICAL CUTTERHEAD ASSEMBLY |
| 3-1 | PT32058003-1 CUTTERHEAD 8" HELICAL |
| 3-2 | PT32058003-2 FLAT HD TORX SCR T-25 10-32 X 1/2 |

| REF PART # | DESCRIPTION |
|------------|--|
| 3-3 | PT32058003-3 INSERTS 15 X 15 X 2.5MM-10 PK |
| 4 | PT32058004 KEY 5 X 5 X 22 RE |
| 5 | PT32058005 CUTTERHEAD PULLEY |
| 6 | PT32058006 SET SCREW M6-1 X 8 |
| 7 | PT32058007 T-HANDLE TORX DRIVER T-25 |

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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