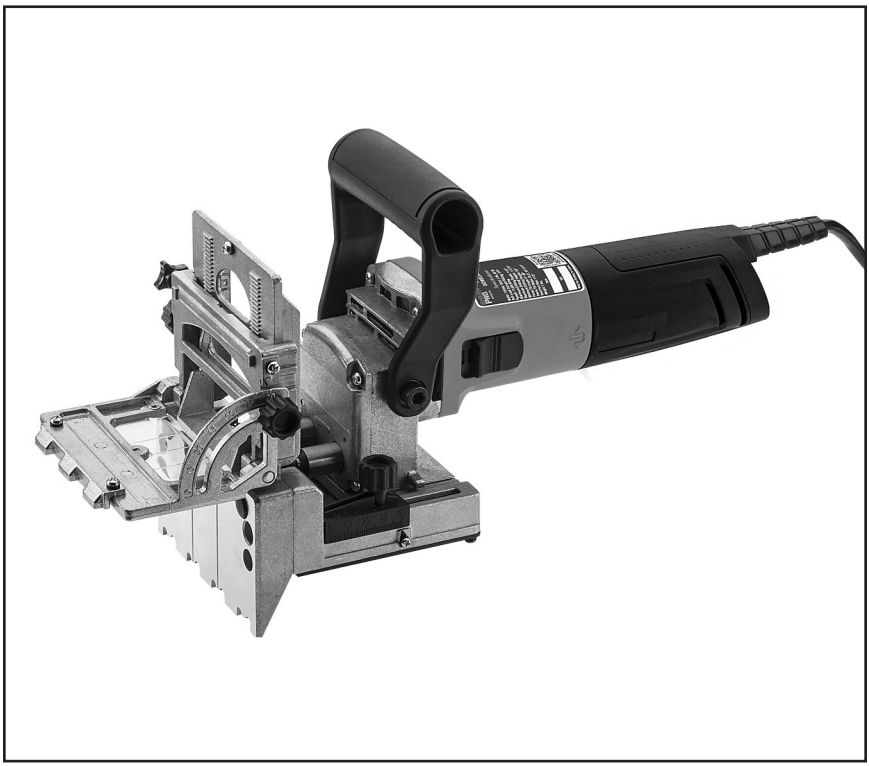
MODEL T32540
DUAL-SPINDLE DOWELING JOINTER
OWNER'S MANUAL
(For models manufactured since 10/20)



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WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.
#KS21481 PRINTED IN CHINA

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

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SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are 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.

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

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

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

NOTICE **This symbol is used to alert the user to useful information about proper operation of the equipment.**

⚠WARNING

Safety Instructions for Power Tools

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 power tool. When tool is not being used, disconnect power, and store in out-of-reach location to prevent unauthorized use—especially around children. Make workshop kid proof!

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

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

DISCONNECT POWER FIRST. Always disconnect tool 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

ELECTRICAL SAFETY. Tool plug must match outlet. Double-insulated tools have a polarized plug (one blade is wider than the other), which must be plugged into a polarized outlet. Never modify plug. Do not use adapter for grounded tools. Use a ground fault circuit interrupter if operation is unavoidable in damp locations. Avoid touching grounded surfaces when operating tool.

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control. Wear hard hat as needed.

HAZARDOUS DUST. Dust created while using tools 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, and connect tool to an appropriate dust collection device 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. Never leave adjustment tools, chuck keys, wrenches, etc. in or on tool—especially near moving parts. Verify removal before starting!

INTENDED USAGE. Only use tool for its intended purpose. Never modify or alter tool for a purpose not intended by the manufacturer or serious injury or death may result!

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

SAFE HANDLING. Firmly grip tool. To avoid accidental firing, do not keep finger on switch or trigger while carrying.

FORCING TOOLS.. Use right tool for job, and do not force it. It will do job safer and better at rate for which it was designed.

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. This protects hands and frees both of them to operate tool.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Ensure they are properly installed, undamaged, and working correctly.

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

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

MAINTAIN WITH CARE. Keep cutting tool edges sharp and clean. Follow all maintenance instructions and lubrication schedules to keep tool in good working condition. A tool that is improperly maintained could malfunction, leading to serious personal injury or death. Only have tool serviced by qualified service-personnel using matching replacement parts.

CHECK DAMAGED PARTS. Regularly inspect tool for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating tool.

MAINTAIN POWER CORDS. When disconnecting cord-connected tools from power, grab and pull the plug—NOT the cord. Carrying or pulling the cord may damage 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, sharp edges, moving parts, and wet/damp locations. Damaged cords increase risk of electrocution.

UNATTENDED OPERATION. Never leave tool running while unattended. Turn tool ***OFF*** and ensure all moving parts completely stop before walking away.

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 Doweling Jointers

⚠WARNING

Serious cuts, punctures, or death can occur from contact with rotating drill bits during operation. Workpieces, broken drill bits, or flying particles thrown by drill bits can blind or strike operators or bystanders with great force. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

PROPERLY MAINTAIN DRILL BITS. Always ensure doweling jointer drill bits are sharp, undamaged, and tightly attached before each use.

AVOIDING ENTANGLEMENT. DO NOT wear loose clothing, gloves, or jewelry. Tie back long hair. Keep all guards in place and secure. Always allow spindle to stop on its own. DO NOT stop spindle using your hand or any other object.

AVOID TOUCHING DRILL BITS. Never place hands or fingers between workpiece and drill bits, and DO NOT perform operations while supporting workpiece with one hand or balancing it on a leg or any other body part.

PROPERLY SUPPORT WORKPIECE. Properly support all workpieces to reduce risk of workpiece and tool slipping during drilling operations. Place workpiece on supports or workbench and clamp in place.

USE TOOL FOR INTENDED PURPOSE. Only use jointer on wood and wood-based products. DO NOT attempt to use this tool for any other operation.

USE RECOMMENDED DRILL BITS. Only use drill bits rated for speeds greater than 17,000 RPM. Bits not rated for this speed may fly apart. Only use drill bits that meet the specifications listed in the manual. DO NOT use drill bits with different diameters or irregular shank shapes/sizes. They will rotate irregularly, causing ejection of drill bit fragments and tool damage.

INSPECTING BIT/CUTTING TOOL. Always inspect bits/cutting tools for sharpness, chips, or cracks before each use. Replace dull, chipped, or cracked bits/cutting tools immediately.

PROPERLY INSTALL COMPONENTS. Ensure sliding base, tool face, and fence are in place and operating correctly before each operation.

STARTING AND STOPPING TOOL. Allow drill bits to reach full speed before drilling. Always allow drill bits to come to a complete stop before setting tool down.

MAINTAIN CONTROL OF TOOL. Hold tool with both hands and DO NOT allow the doweling jointer base to shift while performing operations.

⚠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.

⚠CAUTION

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

SECTION 2: INTRODUCTION

Manual Accuracy

We are proud to offer this document with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, immediately call our technical support for updates or clarification.

For your convenience, we post all available documentation on our website at **www.grizzly.com**. Any updates to this document will be reflected on our website as soon as complete.

Contact Info

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

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

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

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

Grizzly Industrial, Inc.®

MACHINE DATA SHEET

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

MODEL T32540
DUAL-SPINDLE DOWELING JOINTER

Product Dimensions:

Weight	7 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	13-1/2 x 6-1/2 x 9 in.

Shipping Dimensions:

Type	Cardboard Box
Content	Machine
Weight	9 lbs.
Length/Width/Height	27 x 17 x 11 in.

Electrical:

Power Requirement	120V, Single-Phase, 60 Hz
Full-Load Current Rating	5.9A
Minimum Circuit Size	15A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	79 in.
Power Cord Gauge	18 AWG
Plug Included	Yes
Included Plug Type	1-15
Switch Type	ON/OFF Toggle Switch

Motor:

Horsepower	1 HP
Phase	Single-Phase
Amps	5.9A
Speed	17,000 RPM
Type	Universal
Power Transfer	Direct
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Operation Info

Supported Drill Bit Sizes	6 - 12mm
Maximum Drilling Depth	1-1/2 in.
Maximum Drilling Height	1-11/16 in.
Minimum Drilling Height	3/8 in.
Drill Bit Spacing	1-1/4 in.
Fence Tilt Angle	0 - 90 deg.
Fence Tilt Stops	22.5, 45, 67.5 deg.

Other

Number of Dust Ports	1
Dust Port Size	1-1/4 in.

Other Specifications:

Country Of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Minutes
Serial Number Location	ID Label
Sound Rating	88 - 90 dB

Features:

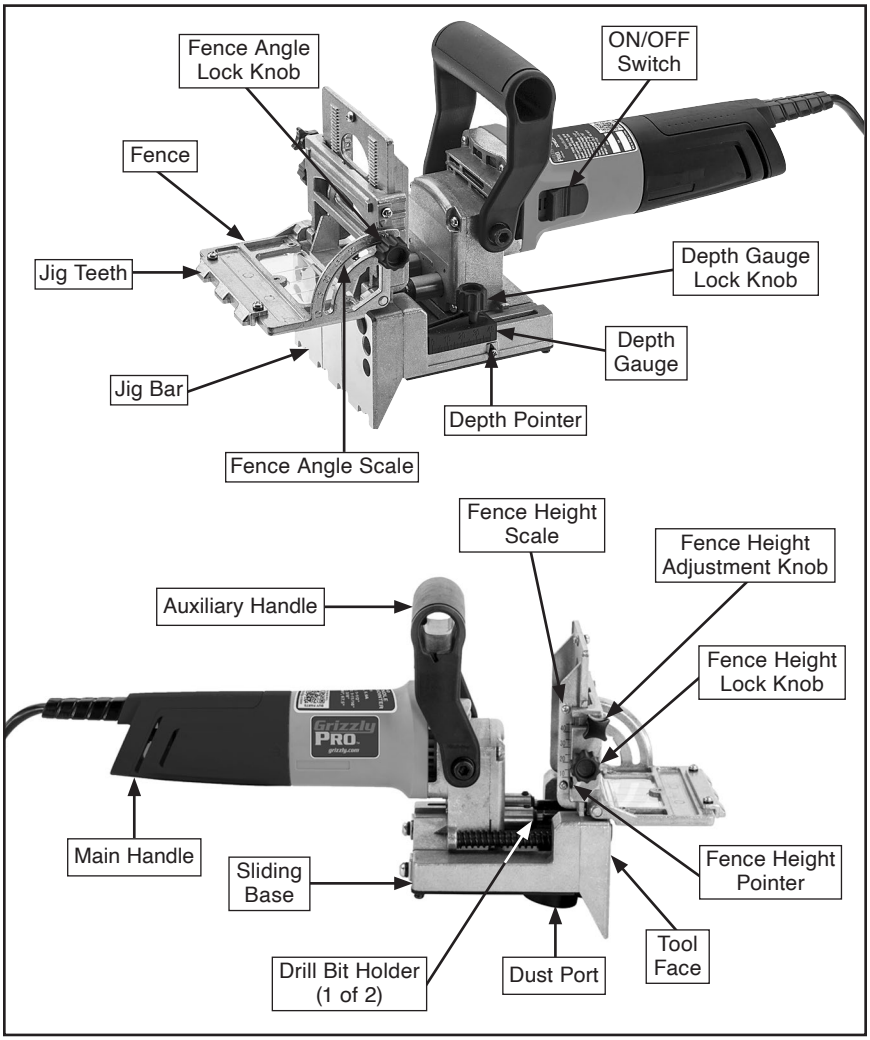
Adjustable Drilling Depth up to 1-1/2"
Clear Fence Viewing-Window for Accurate Drill Bit Placement
Removable Fence with Drilling-Height Adjustment of 3/8" – 1-11/16"
Drilling Angle of 0° – 90° with Stops at 22.5°, 45°, and 67.5°
Dust Extraction Below Drill Bits

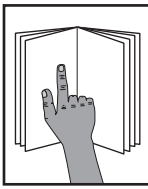
Accessories:

(2) 8mm Drill Bits
Hex Wrench 2.5mm

Identification

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

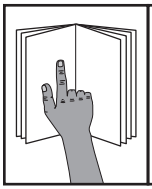




⚠WARNING

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

Controls & Components



⚠WARNING

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

Refer to **Figures 1–2** and the following descriptions to become familiar with the basic controls of this tool.

A. Fence Angle Lock Knob: Locks fence to desired angle of operation.

B. Fence: Orients tool to workpiece at specified angle.

C. Fence Angle Scale: Indicates approximate angle of fence. Detents allow setting angle at 22.5°, 45°, and 67.5°.

D. Depth Pointer: Indicates current depth setting.

E. Depth Gauge: Sets drilling depth between 0"–1½".

F. ON/OFF Switch: Starts and stops motor. Tool will remain running while switch is in ON position.

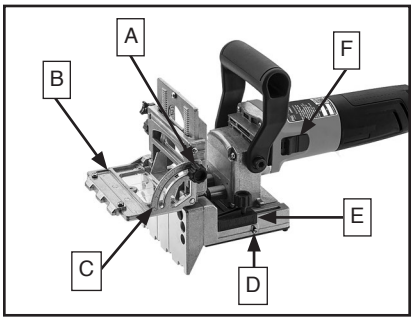


Figure 1. Fence angle, drilling depth, and power controls.

G. Sliding Base: Houses drill bits. Spring action retracts bits after drilling.

H. Dust Port: Connects to a dust collection system (not included) with a dust adapter (not included) to help prevent dust build up during drilling operations.

I. Jig Bar: Enables quick and accurate alignment with doweling jigs (not included).

J. Jig Teeth: Enables quick and accurate alignment with doweling jigs (not included).

K. Fence Height Pointer: Indicates current height setting.

L. Fence Height Lock Knob: Locks fence at desired height of drilling.

M. Fence Height Adjustment Knob: Adjusts fence to desired height.

N. Fence Height Scale: Indicates height of drill bits between $\frac{3}{8}$"–$1\frac{11}{16}$".

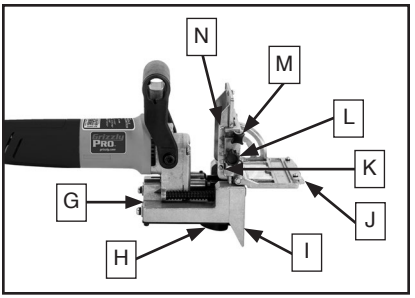


Figure 2. Fence height, jig teeth, and jig bar components.

SECTION 3: 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.



⚠WARNING

Electrocution, shock, fire or damage to equipment may occur if machine is not properly grounded and connected to power supply.

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.....5.9A

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 requirements in the following section.

⚠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.

120V Circuit Requirements

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

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

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*

Polarized Plug

To reduce the risk of electric shock, this equipment has a polarized plug (one blade is wider than the other). This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install the proper outlet. Do not change the plug in any way.

When servicing use only identical replacement parts.

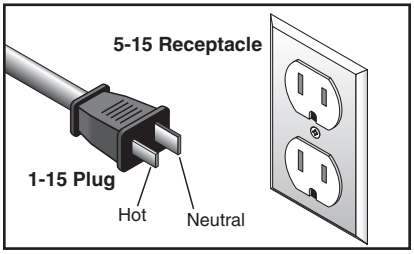


Figure 3. Typical 1-15 plug and receptacle.

Extension Cords

When using extension cords, make sure the cords are rated for outdoor use. Outdoor use cords are marked with a "W-A" or a "W" to signify their rating. Always check to make sure that the extension cords are in good working order and free of any type of damage, such as exposed wires, cuts, creased bends, or missing prongs.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes. When using extension cords, always choose the shortest cord possible, with the greatest-sized gauge.

Below is a list of minimum gauge sizes needed for running this tool at different lengths:

25 Feet 16AWG
50 Feet 14AWG
100 Feet 12AWG
Over 100 Feet..... Not Recommended

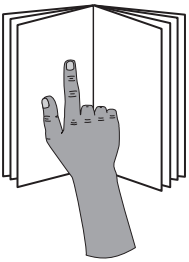
SECTION 4: SETUP

Unpacking

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

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

⚠WARNING



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

Inventory

The following is a list of items shipped with your tool. 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 tool and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Box 1 (Figures 4 & 5)	**Qty**
A. Dual-Spindle Doweling Jointer	1
B. Drill Bits 8mm	2
C. Hex Wrench 2.5mm	1

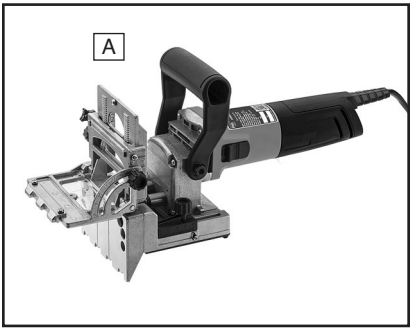


Figure 4. Model T32540 Doweling Jointer.

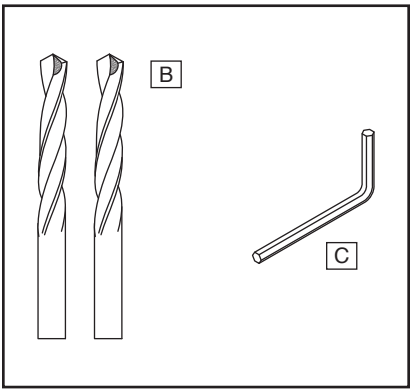


Figure 5. Loose inventory.

Dust Collection

The Model T32540 is equipped with a 1¼" dust port that can attach to a dust collection system or shop vacuum.

Refer to **ACCESSORIES** on **Page 22** for a 1"–1⅝" dust collection adaptor available at ***www.grizzly.com***.

⚠CAUTION

This tool 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 dust with a dust-collection system.

To connect to dust collection system:

1. Attach hose from dust collection system to dust port (see **Figure 6**) and secure with a hose clamp.

   — *If dust collection hose is larger than 1¼", attach 1"–1⅝" dust collection adaptor (not included) to dust port, then attach hose to adaptor.*

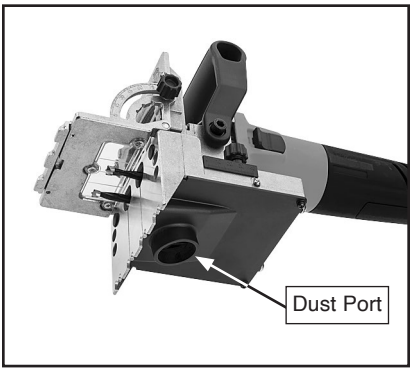


Figure 6. Model T32540 dust port.

2. Tug hose to make sure it does not come off.

   Note: *A tight fit is necessary and ensures proper performance during operation.*

Test Run

Before installing attachments and using your Model T32540, test run the tool to make sure it runs properly.

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

The test run consists of verifying the following: 1) The motor powers up and runs correctly.

⚠WARNING

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

⚠WARNING

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

To test run tool:

1. Clear away all setup/adjustment tools.

2. Connect tool to power supply.

3. While firmly holding auxiliary handle (see **Figure 7**) in one hand, move switch to ON position with opposite hand. Motor should run smoothly and without unusual problems or noises.

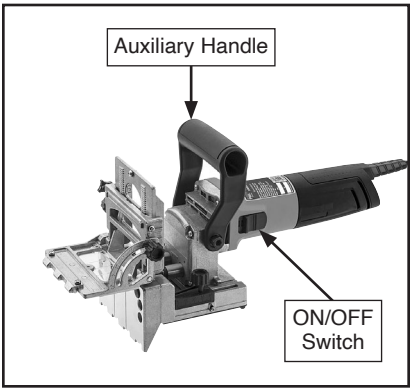
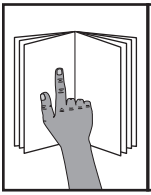


Figure 7. Location of auxiliary handle and ON/OFF switch.

4. Move switch to OFF position. Motor should immediately stop running.

Congratulations! Test run is complete.

SECTION 5: OPERATIONS

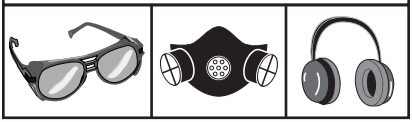


⚠WARNING

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

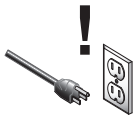
⚠WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



⚠CAUTION

To reduce risk of injury, always disconnect power from jointer before changing drill bits. Since bits are sharp, use extra care and wear gloves when installing them.





NOTICE

If you are not experienced with this type of tool, We strongly recommend that you seek additional training outside of this manual. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Installing Drill Bits

The Model T32540 will support 6–12mm (¼"–7⁄16") drill bits.

To install drill bits:

1. DISCONNECT TOOL FROM POWER!

2. Rotate drill bit holder until set screw is visible (see **Figure 8**).

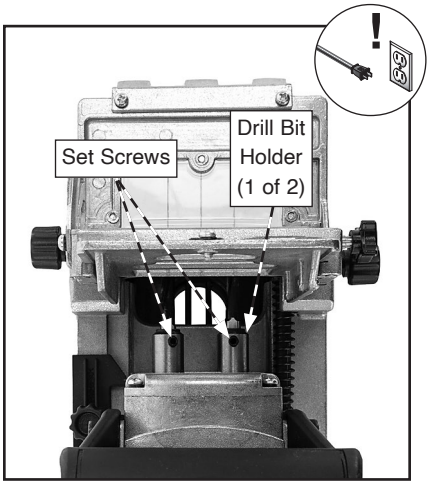


Figure 8. Drill bit holder set screws.

3. Loosen set screw, remove dull bit (if installed), and insert sharp drill bit into bit holder.

4. Rotate bit so flat section of shank aligns with set screw, then tighten set screw.

5. Verify drill bit is secure by attempting to pull it out by hand.

6. Repeat **Steps 2–5** for second drill bit.

Calibrating Depth

The depth gauge must be calibrated every time new drill bits are installed. Aligning the depth gauge to the pointer keeps the drilling depth consistent during operations.

To calibrate drilling depth:

1. DISCONNECT TOOL FROM POWER!

2. Loosen depth gauge lock knob (see **Figure 9**) until depth gauge moves freely.

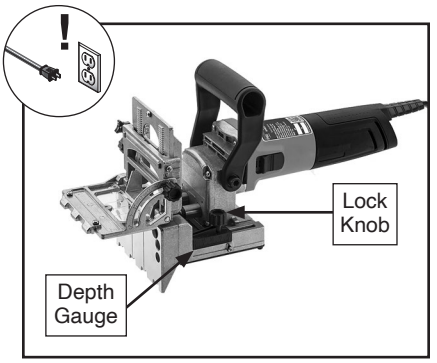


Figure 9. Depth gauge and lock knob.

3. Position tool against a flat piece of scrap wood (see **Figure 10**), and push tool body forward until cutting point of drill bits stop against wood. Hold this position.

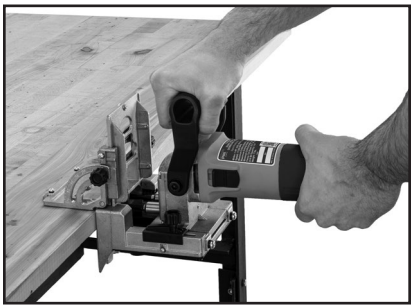


Figure 10. Positioning tool against flat wood surface.

4. Slide depth gauge as far back as possible, and tighten lock knob while still holding position from **Step 3**.

5. Loosen screw holding pointer, rotate pointer until it aligns with "0" on depth gauge, and tighten screw to secure pointer in position (see **Figure 11**).

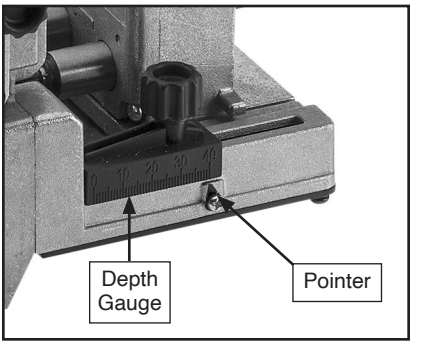


Figure 11. Adjusting pointer alignment with depth gauge.

6. Release holding position.

7. Position tool face against a flat piece of scrap wood, and push tool body forward until cutting point of drill bits stop against wood. Verify pointer is aligned with "0" on depth gauge.

Adjusting Fence Angle

The fence adjusts between 0°–90° to drill dowel holes into beveled edges.

Note: *Ball and groove detents on the fence are provided to easily set angles at 22.5°, 45°, or 67.5°.*

To adjust fence angle:

1. DISCONNECT TOOL FROM POWER!
2. Loosen fence angle lock knob (see **Figure 12**).

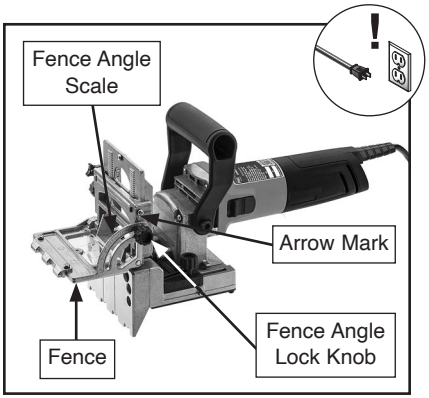


Figure 12. Location of fence angle adjustment components.

3. Tilt fence to match angle of workpiece beveled edge.
4. Tighten fence angle lock knob and verify fence is secure.

   Note: *ALWAYS verify fence is secure before operating.*

   Note: *Fence angle scale is an approximate value. Use additional measuring tools for precision measurements.*

Adjusting Drilling Depth

Drilling depth can be adjusted between 0–1½" using the depth gauge. When replacing drill bits, *always* calibrate the depth gauge according to **Calibrating Depth** on **Page 16**.

To adjust drilling depth:

1. DISCONNECT TOOL FROM POWER!
2. Loosen depth gauge lock knob (see **Figure 13**) until depth gauge moves freely.

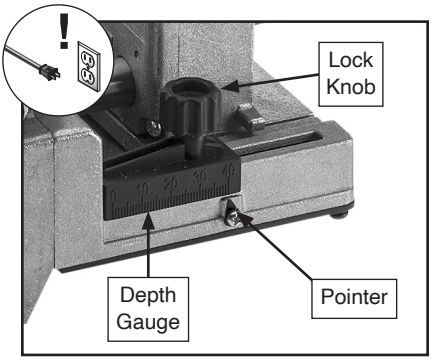


Figure 13. Depth gauge adjustment components.

3. Align desired value on depth gauge with pointer.
4. Tighten depth gauge lock knob and verify depth gauge is secure.

Adjusting Drilling Height

The fence uses a rack-and-pinion adjustment mechanism that allows for drilling at a height of $\frac{3}{8}$"–$1\frac{11}{16}$". Drilling height depends on your workpiece thickness.

To adjust drilling height:

1. DISCONNECT TOOL FROM POWER!

2. Loosen fence height lock knob and rotate fence height adjustment knob to move fence (see **Figure 14**).

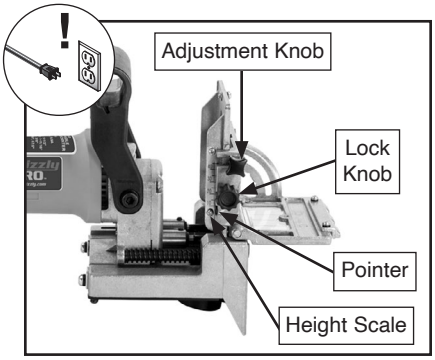


Figure 14. Drilling height adjustment components.

3. Align fence height pointer with desired value on fence height scale.

4. Tighten lock knob and verify fence is securely set to desired height.

Aligning Viewer

The Model T32540 features a clear plastic viewing screen over the drilling area to support accurate alignment during drilling operations and help protect the operator from flying debris.

To align viewer with workpiece:

1. Mark workpiece at desired doweling location.

2. Position tool face against workpiece and align viewer lines with mark on workpiece (see **Figure 15**).

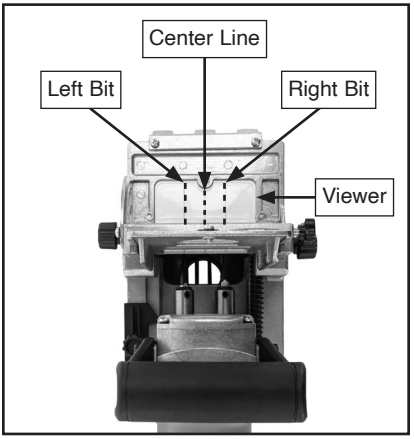


Figure 15. Alignment lines on viewer.

Note: *The Model T32540 drills doweling holes spaced 1¼" (32mm) apart.*

Workpiece Preparation

Properly mark your workpieces to avoid incorrect doweling placement and wasted material. The following example illustrates a typical doweling layout.

Laying Out Dowels

1. Place edges of (2) workpieces flush against each other on a smooth, flat surface. Verify board ends line up.

2. Place marks 2½"–3" from each end of one board.

   Note: *If distance between marks is greater than 6", place additional marks at 4"–6" intervals (see **Figure 16**).*

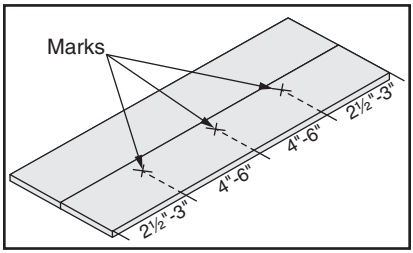


Figure 16. Doweling location marks.

3. Use a square to draw layout lines across both boards, then make registration marks on edge of each board to ensure correct edge will be drilled (see **Figure 17**).

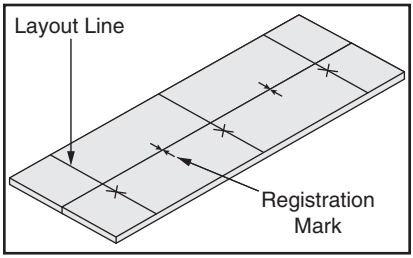


Figure 17. Layout lines and registration marks on pair of boards to be joined.

Securing Workpiece

Your workpiece must be properly secured before drilling. The drilling operation pushes the edge of the workpiece, which can cause an improperly secured workpiece to shift on the workbench, resulting in personal injury or damage to the tool or workpiece.

Use clamps to secure both ends of the workpiece to the workbench. The edge of the workpiece should slightly hang over the edge of the workbench (see **Figure 18**).

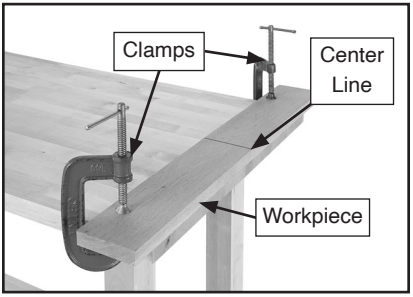


Figure 18. Example of workpiece clamped to workbench.

Note: *Clamps should be placed at least 3" from any cut marks to prevent interference with doweling jointer.*

Positioning Tool

The doweling jointer should always be positioned perpendicular to the workpiece in order to accurately drill joining surfaces (see **Figure 19**).

We recommend using the weight of the machine to assist with alignment and guide the direction of operation.



Figure 19. Tool positioned perpendicular to workpiece.

If holes need to be drilled too far from an edge to use the fence, set the fence angle to 0° so that the fence and tool face are flush (see **Figure 20**). The doweling jointer can then be positioned freely.

ALWAYS ensure tool is secure before starting drilling operations.



Figure 20. Tool positioned freely on workpiece.

Drilling Doweling Holes

The Model T32540 is capable of drilling holes for ¼"–7⁄16" dowels.

To drill doweling holes:

1. Place fence on workpiece so viewer center line is aligned with layout line, as shown in **Figure 21**. Make sure tool face contacts edge of workpiece.

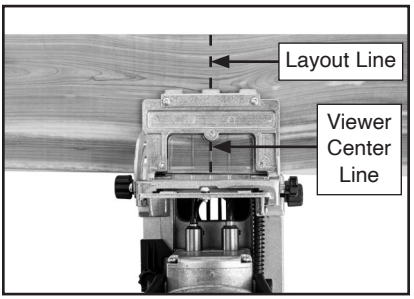


Figure 21. Doweling jointer aligned with workpiece.

2. Turn doweling jointer ***ON*** and allow motor to reach full speed.

3. With both hands holding tool, slowly push drill bits into workpiece, as shown in **Figure 22**, making sure viewer lines are aligned with layout line on workpiece, as described in **Step 1**.

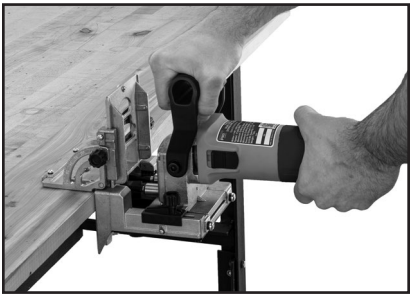


Figure 22. Doweling jointer operation.

4. Once drill bits reach full depth, slide jointer body backward, allowing bits to retract into base.

5. Turn doweling jointer ***OFF*** and wait for motor to come to a complete stop before setting tool down.

Gluing Dowels

Once all doweling holes have been drilled, test-fit dowels with a "dry fit" prior to the glue-up. Place a dowel in each groove, and fit the pieces together to check for proper alignment.

Once a proper fit is verified, apply glue to workpiece edges and holes, insert dowels into holes, then clamp according to the needs of the material and the glue manufacturer's instructions.

Using Tool Jigs

The Model T32540 is equipped with jig teeth and a jig bar to enable fast and accurate drilling with various doweling jigs (not included) for high volume, repetitious use. The operator can also construct shop-made doweling jigs for this tool, but building such a jig is beyond the scope of this manual.

Note: *Properly measure and mark your workpieces to avoid incorrect doweling placement and wasted material.*

To operate tool with doweling jigs:

1. Secure jig(s) to workpiece in required position after measuring.

2. Verify alignment of jig teeth or jig bar with jig(s) (see **Figure 23**).

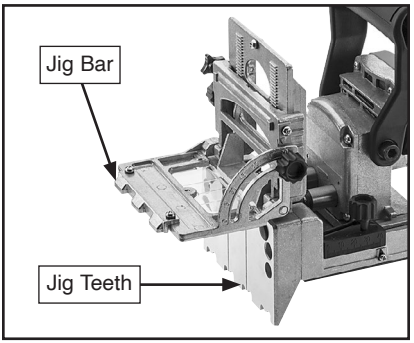


Figure 23. Doweling jointer jig teeth and jig bar.

3. Adjust drilling depth, fence angle, and fence height according to the task being performed.

4. Insert jig teeth or jig bar into teeth slots of jig, and operate doweling jointer according to **Drilling Doweling Holes** on **Page 20**.

SECTION 6: ACCESSORIES

⚠WARNING

Installing unapproved accessories may cause tool to malfunction, resulting in serious personal injury or tool damage. To reduce this risk, only install accessories recommended for this tool by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

T32642—8mm Dowel Pins (100-pk)
T32643—10mm Dowel Pins (100-pk)
T32644—12mm Dowel Pins (100-pk)
These computer-inspected dowel pins meet the demanding standards of high-speed drilling and dowel-driving equipment. Pins are chamfered for easy insertion, and grooved for even glue distribution. Made in the U.S.A.

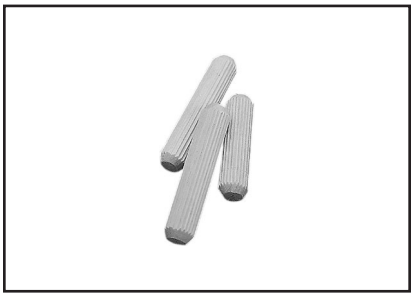


Figure 24. Assorted dowel pins.

H6839—Titebond III Wood Glue® (1 Qt.)
Ideal for both interior and exterior applications, this ultimate wood glue is the first one-part, water clean-up wood glue ever offered that is proven waterproof. It features superior bond strength, longer open assembly time and lower application temperature. This wood glue provides strong initial tack, sands easily without softening and is FDA approved for indirect food contact. Non-toxic and solvent-free, it cleans up with water.

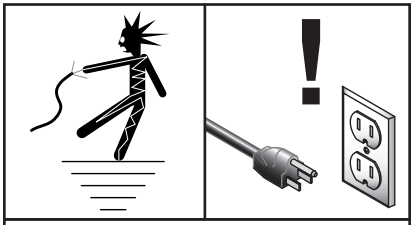


Figure 25. Model H6839 Titebond III Ultimate Wood Glue®.

T32541—8mm Dowel Jointer Bits (2-pk)
T32542—10mm Dowel Jointer Bits (2-pk)
T32543—12mm Dowel Jointer Bits (2-pk)
Replacement drill bit sets for the Model T32540 Dual-Spindle Doweling Jointer.

T32544—Dust Collection Adaptor
Compatible 1"–1⅝" dust collection adaptor for connecting the Model T32540 to a dust collection system or shop vacuum.

SECTION 7: MAINTENANCE



⚠WARNING

Always DISCONNECT POWER before servicing, adjusting, or doing maintenance to reduce risk of accidental injury or electrocution.

For optimum performance from this tool, routinely check the condition of the following items and repair or replace as necessary.

- Loose bolts
- Damaged bits
- Worn or damaged wires
- Any other unsafe condition

Cleaning

Use a brush and a shop vacuum to remove wood chips and other debris from the tool, particularly from around the drill bit holders. Never blow off the tool with compressed air, as this could force wood chips deeper into the motor vents. Use a clean cloth to wipe away any dust remaining after each operation.

Note: *DO NOT use caustic cleaners on plastic parts. If dry cleaning is insufficient, a mild detergent on a damp cloth is recommended. Keep dripping or running water away from tool at all times.*

Lubrication

Periodically lubricate all moving parts with a light machine oil, such as Model T33964 Quest Micro-Dry PTFE Dry Lubricant® (see **Figure 26**), as required.



Figure 26. Model T33964 PTFE Dry Lubricant.

Place a drop of oil on the return spring on the right side of the sliding base (see **Figure 27**), then slide the base back and forth, working the oil across the return spring. Use a clean rag to wipe off any excess oil, which can collect dust or stain the workpiece.

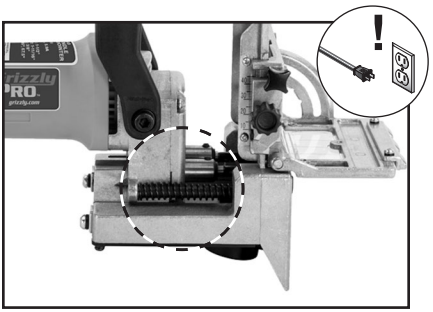


Figure 27. Location of return spring on sliding base.

Replacing Brushes

This tool is equipped with a universal motor that uses two carbon brushes to transmit electrical current inside the motor.

These brushes are considered to be regular "wear items" or "consumables" that will need to be replaced during the life of the motor. The frequency of required replacement is related to how much the motor is used and how hard it is pushed.

Always replace both carbon brushes at the same time. Replacement is necessary if motor no longer reaches full power, operation or starting becomes intermittent, or when the brushes measure less than ¼" long (new brushes are ⅝" long).

To replace motor brushes:

1. DISCONNECT TOOL FROM POWER!

2. Remove screw from main jointer handle (see **Figure 28**), and gently pull handle away from tool.

Note: *Make sure not to pull on or damage the wires located in main handle during disassembly.*

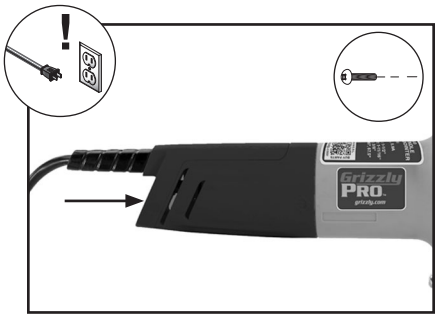


Figure 28. Location of main handle screw.

3. Locate and remove both motor brushes (see **Figure 29**). Brushes are typically on opposite sides of motor from each other.

Note: *If removing the brushes by hand is too difficult, use a small screwdriver to carefully push down on the brush holder tabs to release them.*

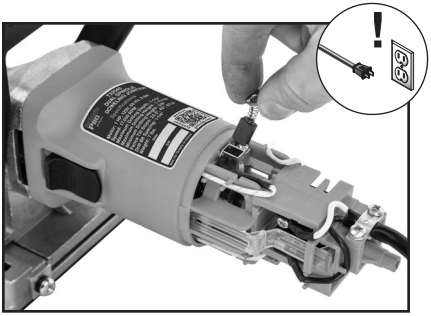


Figure 29. Replacing motor brush (1 of 2).

4. Install new motor brushes and reinstall and secure main handle.

SECTION 8: SERVICE

Troubleshooting

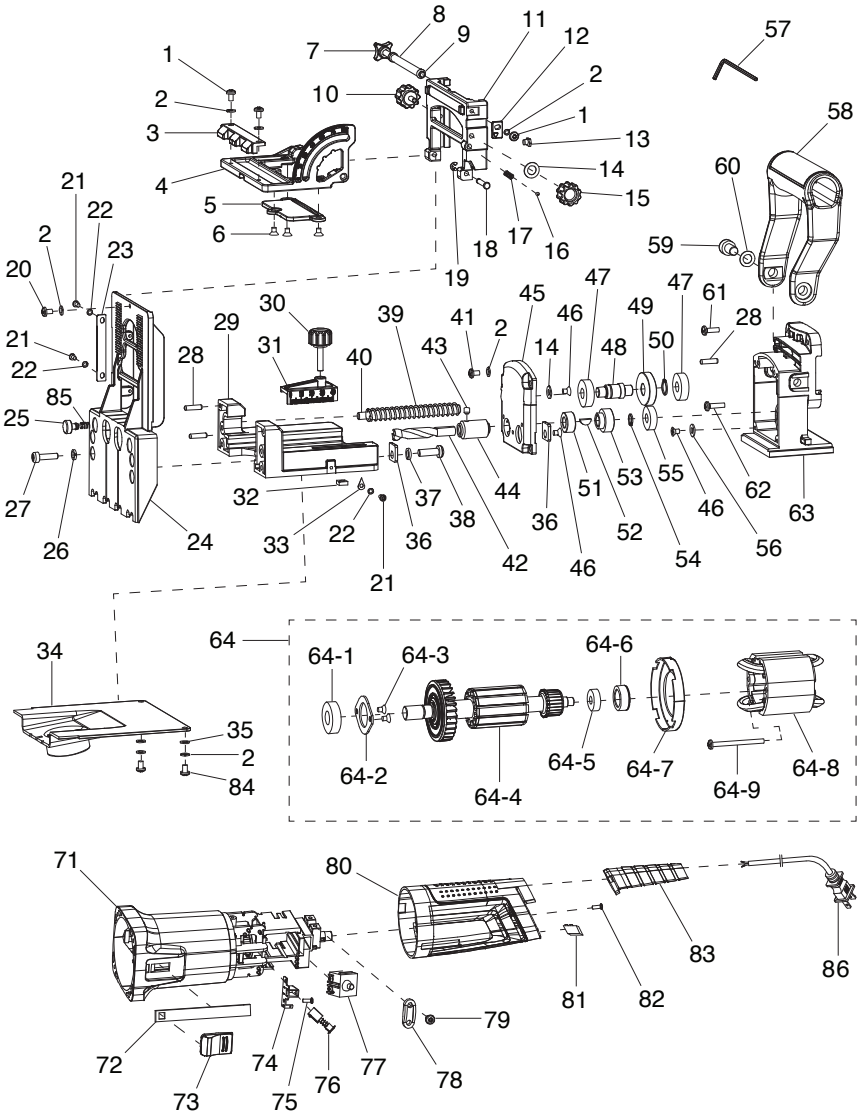


Symptom	Possible Cause	Possible Solution
Tool does not start, or power-supply fuse/ breaker trips immediately after startup.	1. Incorrect power supply voltage. 2. Power supply circuit breaker tripped or fuse blown. 3. Wiring broken, disconnected, or corroded. 4. Motor brushes worn out. 5. ON/OFF switch at fault. 6. Motor or motor bearings at fault.	1. Ensure correct power supply voltage and circuit size. 2. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 3. Check/fix broken, disconnected, or corroded wires. 4. Remove/replace (**Page 24**). 5. Replace switch. 6. Replace motor.
Tool stalls or is underpowered.	1. Workpiece material not suitable for tool. 2. Tool undersized for task. 3. Dust port clogged. 4. Drill bits dull or at fault. 5. Motor brushes worn out. 6. Extension cord gauge too small or cord too long. 7. Motor overheated. 8. Motor or motor bearings at fault.	1. Only drill into wood/ensure moisture is below 20%. 2. Reduce feed rate/depth of drilling; use sharp drill bit. 3. Clear dust port. 4. Remove/replace (**Page 15**). 5. Remove/replace (**Page 24**). 6. Use shorter extension cord of proper gauge (**Page 10**). 7. Clean motor, let cool, and reduce workload. 8. Replace motor.
Tool has vibration or noisy operation.	1. Motor, bits, or component loose. 2. Drill bits at fault/loose. 3. Workpiece loose. 4. Motor fan rubbing on fan cover. 5. Motor bearings at fault.	1. Tighten if loose. Replace damaged or missing bolts/ nuts. 2. Remove/replace (**Page 15**). 3. Use the correct holding fixture/re-clamp workpiece. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Drill bits are burning workpiece.	1. Drill bits dull or at fault/ loose.	1. Remove/replace (**Page 15**).

SECTION 9: PARTS

Please Note: *We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call* ***(800) 523-4777*** *or visit our online parts store at* ***www.grizzly.com*** *to check for availability.*

Main



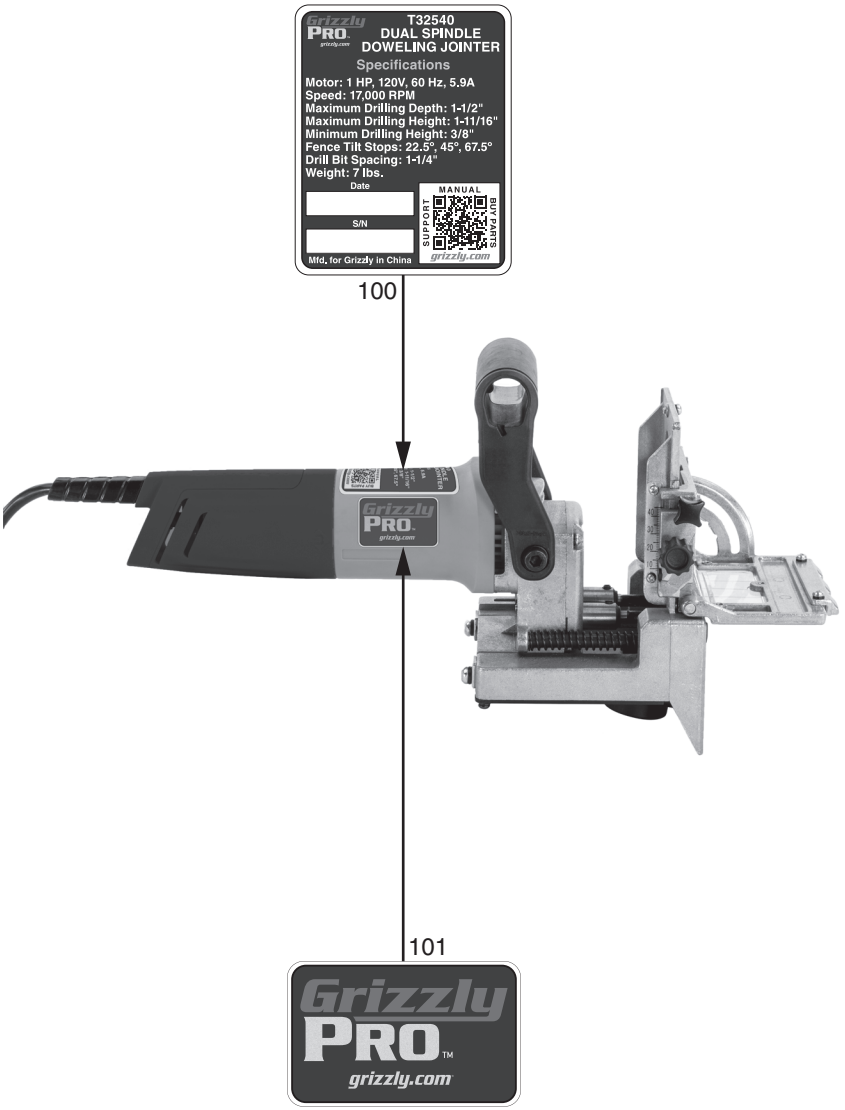
BUY PARTS ONLINE AT GRIZZLY.COM!
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Main Parts List

1	PT32540001	PHLP HD SCR M4-.7 X 10
2	PT32540002	LOCK WASHER 4MM
3	PT32540003	JIG TEETH BRACKET
4	PT32540004	FENCE
5	PT32540005	VIEWING SCREEN
6	PT32540006	FLAT HD CAP SCR M4-.7 X 8
7	PT32540007	KNOB M6-1, 4-LOBE, D20
8	PT32540008	HEIGHT ADJUSTMENT GEAR
9	PT32540009	O-RING 4 X 2MM
10	PT32540010	KNOB BOLT M4-.7 X 13, 10-LOBE, D19
11	PT32540011	HEIGHT BRACKET
12	PT32540012	ANGLE POINTER
13	PT32540013	HEIGHT POINTER
14	PT32540014	FLAT WASHER 6MM
15	PT32540015	KNOB BOLT M5-.8 X 14, 10-LOBE, D19
16	PT32540016	STEEL BALL 4MM
17	PT32540017	COMPRESSION SPRING 0.6 X 4 X 6
18	PT32540018	CLEVIS PIN 4 X 24
19	PT32540019	E-CLIP 3MM
20	PT32540020	PHLP HD SCR M4-.7 X 8
21	PT32540021	PHLP HD SCR M3-.5 X 6
22	PT32540022	LOCK WASHER 3MM
23	PT32540023	HEIGHT SCALE
24	PT32540024	FACEPLATE
25	PT32540025	RUBBER BUMPER
26	PT32540026	LOCK WASHER 5MM
27	PT32540027	PHLP HD SCR M5-.8 X 22
28	PT32540028	DOWEL PIN 4 X 8
29	PT32540029	SLIDING BASE
30	PT32540030	KNOB BOLT M5-.8 X 22, 10-LOBE, D19
31	PT32540031	DEPTH SCALE
32	PT32540032	SQUARE NUT M5-.8
33	PT32540033	DEPTH POINTER
34	PT32540034	DUST PORT 1-1/2"
35	PT32540035	FLAT WASHER 4MM
36	PT32540036	SQUARE CUSHION
37	PT32540037	LOCK WASHER 6MM
38	PT32540038	PHLP HD SCR M6-1 x 12
39	PT32540039	COMPRESSION SPRING 1.2 X 11 X 95
40	PT32540040	GUIDE ROD
41	PT32540041	PHLP HD SCR M4-.7 x 16
42	PT32540042	DOWEL JOINTER BIT 8MM (2-PK)
43	PT32540043	SET SCREW M5-.8 X 6
44	PT32540044	DRILL BIT HOLDER
45	PT32540045	GEARBOX COVER
46	PT32540046	FLAT HD SCR M4-.7 X 12
47	PT32540047	BALL BEARING 6012-OPEN
48	PT32540048	CENTER SPINDLE
49	PT32540049	TRANSFER GEAR 34T
50	PT32540050	EXT RETAINING RING 12MM
51	PT32540051	BALL BEARING 607ZZ
52	PT32540052	WOODRUFF KEY 3 X 10MM
53	PT32540053	OUTPUT GEAR 13T
54	PT32540054	EXT RETAINING RING 9MM
55	PT32540055	BALL BEARING 609ZZ
56	PT32540056	FENDER WASHER 6MM
57	PT32540057	HEX WRENCH 2.5MM
58	PT32540058	AUXILIARY HANDLE
59	PT32540059	CAP SCREW M8-1.25 X 18
60	PT32540060	FLAT WASHER 8MM
61	PT32540061	TAP SCREW M4.2 X 20
62	PT32540062	TAP SCREW M4.2 X 30
63	PT32540063	GEARBOX
64	PT32540064	MOTOR 1HP 120V 1-PH
64-1	PT32540064-1	BALL BEARING 6001ZZ
64-2	PT32540064-2	MOTOR BEARING CAP
64-3	PT32540064-3	FLAT HD SCR M4-.7 X 12
64-4	PT32540064-4	MOTOR ARMATURE
64-5	PT32540064-5	BALL BEARING 607ZZ
64-6	PT32540064-6	MOTOR BEARING SLEEVE
64-7	PT32540064-7	MOTOR FAN COVER
64-8	PT32540064-8	MOTOR STATOR
64-9	PT32540064-9	TAP SCREW M4 X 55
71	PT32540071	MOTOR HOUSING
72	PT32540072	TRANSFER BRACKET
73	PT32540073	ON/OFF SWITCH PLATE
74	PT32540074	MOTOR BRUSH HOLDER
75	PT32540075	TAP SCREW M3 X 8
76	PT32540076	MOTOR BRUSH (2-PC SET)
77	PT32540077	ON/OFF SWITCH 8A
78	PT32540078	CABLE CLAMP
79	PT32540079	TAP SCREW M4.2 X 12
80	PT32540080	PRIMARY HANDLE
81	PT32540081	HANDLE ACCESS COVER
82	PT32540082	TAP SCREW M4.2 X 20
83	PT32540083	STRAIN RELIEF BOOT 3/8
84	PT32540084	PHLP HD SCR M4-.7 X 12
85	PT32540085	COMPRESSION SPRING 0.5 X 10 X 6
86	PT32540086	POWER CORD 18G 3W 79" 1-15P

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Labels & Cosmetics



REF	PART #	DESCRIPTION
100	PT32540100	MACHINE ID LABEL
101	PT32540101	GRIZZLY PRO 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.

BUY PARTS ONLINE AT GRIZZLY.COM!
Scan QR code to visit our Parts Store.

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.



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