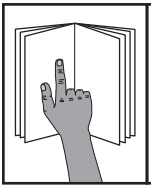
MODEL T34390
UPPER/LOWER CUTTERHEAD MOULDING GIBS FOR G0984
INSTRUCTIONS

For questions/help, contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

Introduction

These gibs allow you to install moulding knives in the upper or lower cutterheads to profile the faces of your workpiece.



⚠WARNING

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

Inventory

Box (Figure 1)	Qty
A. Gibs	2
B. Hex Bolts M6-1 x 10	2

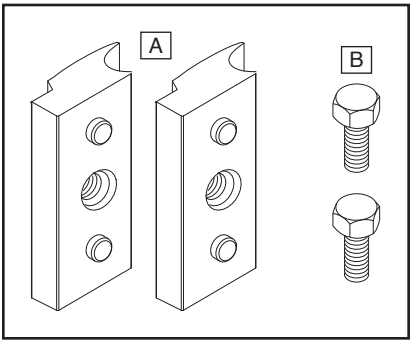


Figure 1. Box inventory.

Installation

Use the included moulding gibs to install any face moulding knives compatible with the Model G0984.



⚠WARNING

Wear safety glasses during entire setup process!



⚠WARNING

Knives are sharp! Put on protective gloves before handling.

Items Needed	Qty
Safety Glasses	1 Pr.
Protective Gloves	1 Pr.
Moulding Knife Pair	1
Thin Open-End Wrench 10mm	1

Note: *The 10mm open-end wrench included with the Model G0984 is machined to the correct thickness.*

To install moulding gibs:

1. DISCONNECT MACHINE FROM POWER!

2. Open planer/moulder top door.

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

3. Remove planer knives from cutterhead you wish to mould with, as described in Model G0984 manual.

4. Fully thread (1) M6-1 x 10 hex bolt into each gib (see **Figure 2**).

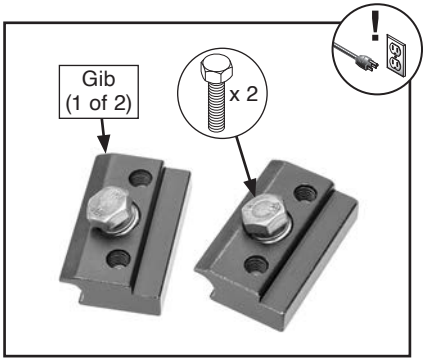


Figure 2. Hex bolts threaded into gibs.

5. Seat desired moulding knives on gibs so knife holes fit on gib pegs (see **Figure 3**).

   Note: *Moulding knives will be installed on either side of cutterhead and must have identical profiles.*

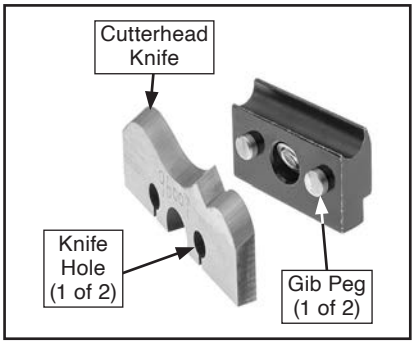


Figure 3. Seating moulding knife on gib (crown moulding knife shown).

6. Insert (1) gib and knife into cutterhead moulding slot (see **Figure 4**).

   Note: *In moulding slots, there is an opening with enough clearance for gib/knife assembly (see **Figure 4**).*

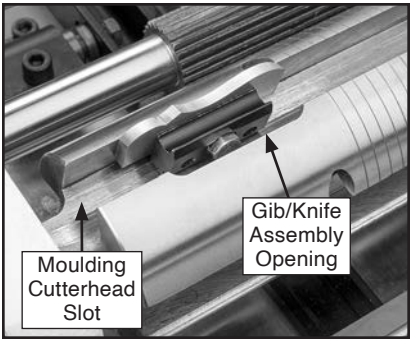


Figure 4. Gib and knife inserted into moulding cutterhead slot (upper cutterhead shown).

7. Position knife along cutterhead, as needed for operation, then turn hex bolt counterclockwise to secure (see **Figure 5**).

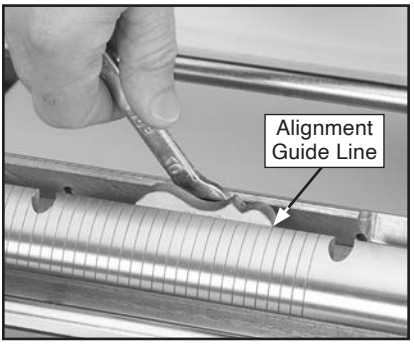


Figure 5. Securing gib and knife in cutterhead (upper cutterhead shown).

8. Repeat **Step 6** with remaining gib and knife on opposite cutterhead moulding slot.

9. Align second knife with knife from **Step 7**, then turn hex bolt counterclockwise to secure.

   Tip: *Use lines on cutterhead (see **Figure 5**) as reference for aligning knives.*

10. Close and secure top door.