MODEL G0609
12" PARALLELOGRAM JOINTER
OWNER'S MANUAL

#BL8452 PRINTED IN CHINA

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

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

The owner of this machine/equipment 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, blade/cutter 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

INTRODUCTION

Foreword

We are proud to offer the Model G0609 12" Parallelogram Jointer. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0609. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0609 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

MACHINE DATA SHEET

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

MODEL G0609 12" PARALLELOGRAM JOINTER

Product Dimensions:

Weight	875 lbs.
Length/Width/Height	84" x 33" x 43½"
Foot Print (Length/Width)	84" x 33"

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	1, 036 lbs.
Length/Width/Height	88⅜" x 29¾" x 40½"

Electrical:

Switch	Magnetic with Thermal Overload Protection
Switch Voltage	220V
Recommended Breaker Size	20 amp
Plug	No

Motors:

Main

Type	TEFC Capacitor Start Induction
Horsepower	3 HP
Voltage	220V
Prewired	220V
Phase	Single
Amps	18
Speed	3450 RPM
Cycle	60 Hz
Power Transfer	V-Belt Drive
Bearings	Shielded and Lubricated

Main Specifications:

Construction

Table Construction	Parallelogram Design, Precision Ground Cast Iron
Fence Assembly	Cast Iron
Body Assembly	Cast Iron
Stand	Cast Iron
Guard.	Moulded Aluminum

Capacity

Maximum Depth of Cut	1/8" in.
Maximum Rabbeting Depth	3/4"
Maximum Width of Cut	12"
Cutterhead Diameter	3 3/4"
Cutterhead Knife Size	12" x 1/8" x 1 9/64"
Cutterhead Speed	4950 RPM
Cuts Per Minute	19,800 RPM
Cutterhead	4-Knife

Other Specifications:

Country Of Origin	China
Warranty	1 Year
Serial Number Location	Data Label on front of cabinet
Assembly Time	45 minutes

Features:

Parallelogram Beds
Top Mount Switch Controls
5 3/8" Tall Fence
Included Push Blocks
5" Dust Port

Identification

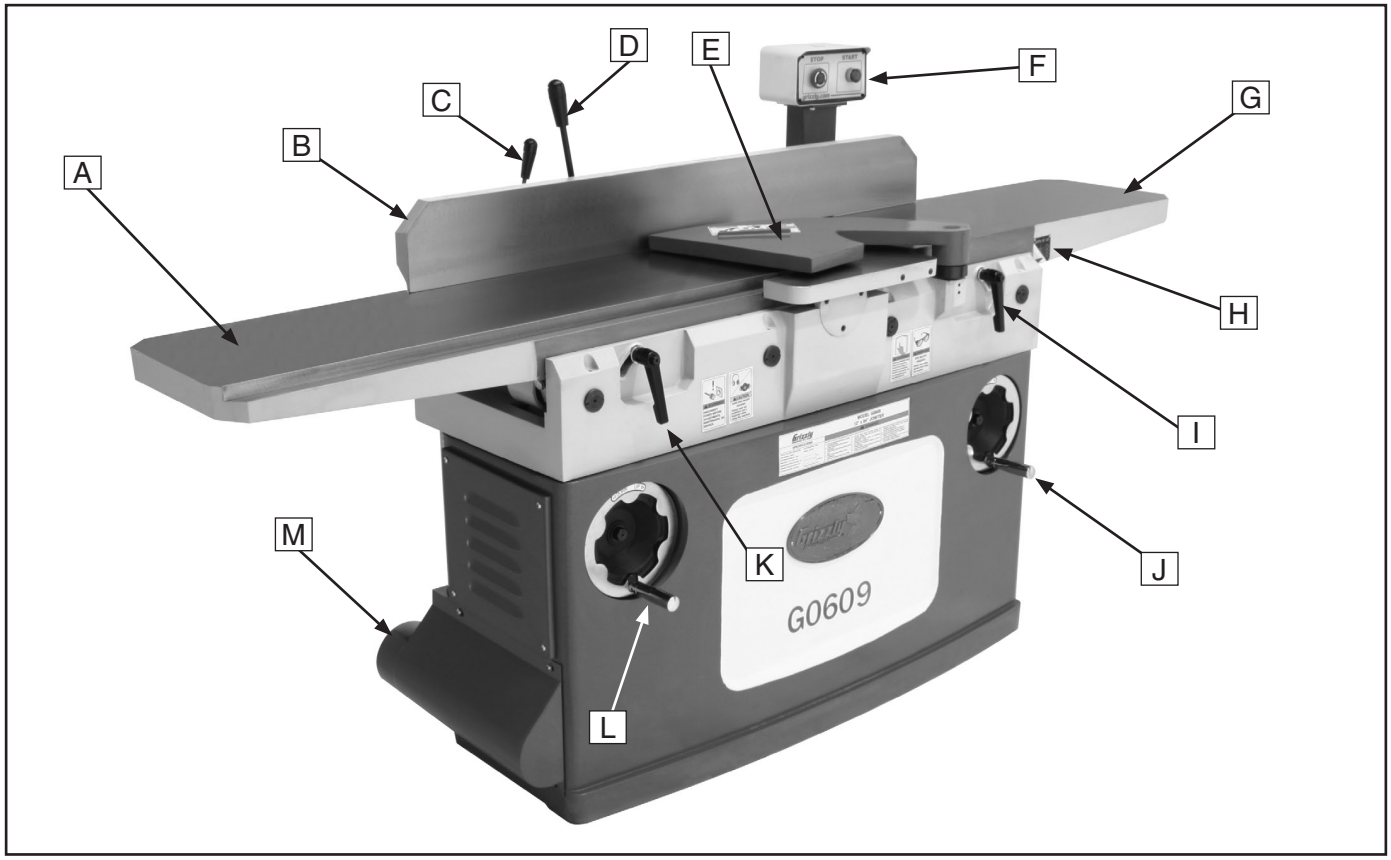


Figure 1. G0609 identification.

A. Outfeed Table
B. Fence
C. Fence Lock Handle
D. Fence Tilt Lever
E. Cutterhead Guard
F. Control Panel
G. Infeed Table
H. Depth Scale
I. Infeed Table Lock
J. Infeed Table Adjustment Handwheel
K. Outfeed Table Lock
L. Outfeed Table Adjustment Handwheel
M. Dust Port

SECTION 1: SAFETY

⚠WARNING

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 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 imminently 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 machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.

23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.

⚠WARNING
Additional Safety for Jointers

1. **JOINTER KICKBACK.** "Kickback" is when the workpiece is thrown off the jointer table by the force of the cutterhead. Always use push blocks and safety glasses to reduce the likelihood of injury from “kickback.” If you do not understand what kickback is, or how it occurs, **DO NOT** operate this machine.

2. **CUTTERHEAD ALIGNMENT.** Keep the top edge of the outfeed table aligned with the edge of the cutterhead at top dead center (TDC) to avoid kickback and personal injuries.

3. **PUSH BLOCKS.** Always use push blocks whenever surface planing. Never pass your hands directly over the cutterhead without a push block.

4. **WORKPIECE SUPPORT.** Supporting the workpiece adequately at all times while cutting is crucial for making safe cuts and avoiding injury. Never attempt to make a cut with an unstable workpiece.

5. **KICKBACK ZONE.** The "kickback zone" is the path directly through the end of the infeed table. Never stand or allow others to stand in this area during operation.

6. **MAXIMUM CUTTING DEPTH.** The maximum cutting depth for one pass is ⅛". Never attempt any single cut deeper than this!

7. **JOINTING WITH THE GRAIN**. Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

8. **KEEPING GUARDS IN PLACE.** With the exception of rabbeting, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

9. **PROPER CUTTING.** When cutting, always keep the workpiece moving toward the outfeed table until the workpiece has passed completely over the cutterhead. Never back the work toward the infeed table.

10. **USING GOOD STOCK.** Jointing safety begins with your lumber. Inspect your stock carefully before you feed it over the cutterhead. Never joint a board that has loose knots, nails, or staples. If you have any doubts about the stability or structural integrity of your stock, DO NOT joint it!

⚠WARNING

Like all machines there is danger associated with this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility 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.

SECTION 2: CIRCUIT REQUIREMENTS

220V Single-Phase

⚠WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. DO NOT connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0609 motor draws the following amps under maximum load:

Motor Draw at 220V ..... 18 Amps

Circuit Requirements

We recommend using a dedicated circuit for this machine. You MUST connect your machine to a grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

220V Circuit.....20 Amps

Plug/Receptacle Type

Recommended Plug/Receptacle....NEMA L6-20

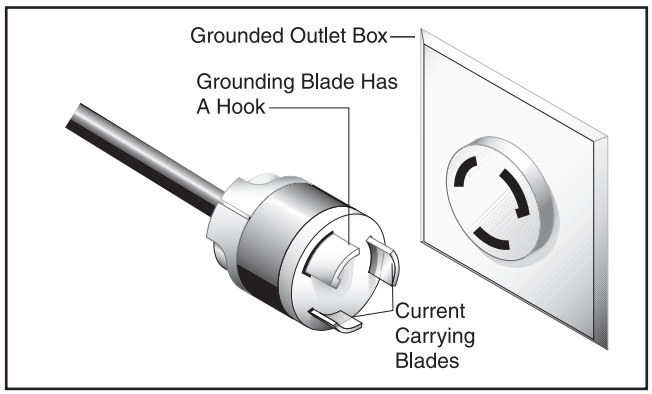
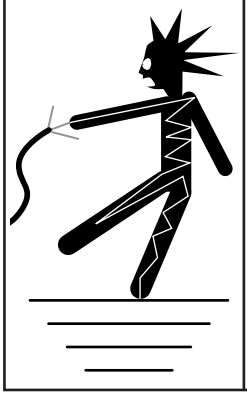


Figure 2. NEMA L6-20 plug and receptacle.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



⚠WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!

Extension Cords

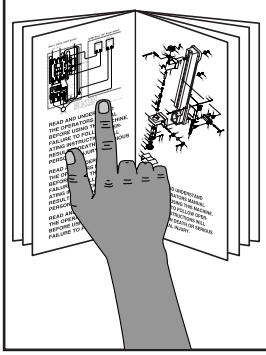
We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you find it absolutely necessary to use an extension cord at 220V with your machine:

- Use at least a 12 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

SECTION 3: SET UP

Set Up Safety

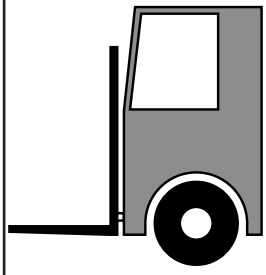


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire set up process!



⚠WARNING

The Model G0609 is a heavy machine (1,036 lbs shipping weight). Use power lifting equipment to lift this jointer. Otherwise serious personal injury may occur

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Safety Glasses (for each person)	1
• Solvent	1
• Shop Rags for Cleaning	As Needed
• Extra Person for Lifting Help	1
• Fork Lift, Engine Hoist, or Boom Crane	1
• Lifting Straps (900 lb. Capacity)	2
• Straightedge (see **Page 18**)	1
• Phillips Screwdriver #2	1

Unpacking

The Model G0609 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Inventory

After all the parts have been removed from the wood crate, you should have the following items:

Crate Contents: (Figure 3 & 4)	Qty
A. Jointer Assembly	1
B. Fence Assembly	1
C. Fence Bracket	1
D. Push Blocks	2
E. Knife Setting Jig	1

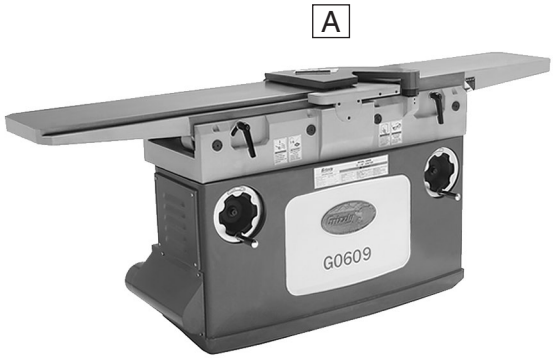


Figure 3. Crate contents.

Hardware and Tools	Qty
• Hex Wrenches 3, 4, 8, 10mm	1 Each
• Open End Wrench 10/12, 12/14,17/19mm	1 Each
• Cap Screws M12-1.75 x 30 (Fence)	2
• Flat Washers 12mm (Fence)	3
• Lock Washers 12mm (Fence)	2
• Lock Nut M12-1.75 (Fence)	1
• Flat Washers 10mm (Pedestal)	2
• Lock Washers 10mm (Pedestal)	2
• Cap Screws M10-1.5 x 25 (Pedestal)	2

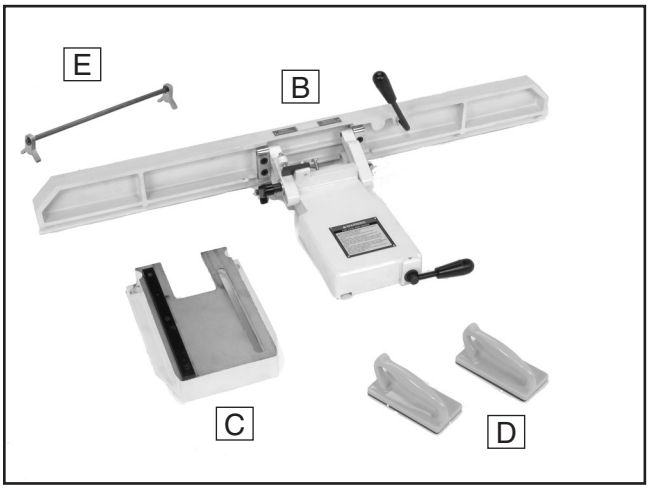


Figure 4. Additional crate contents.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

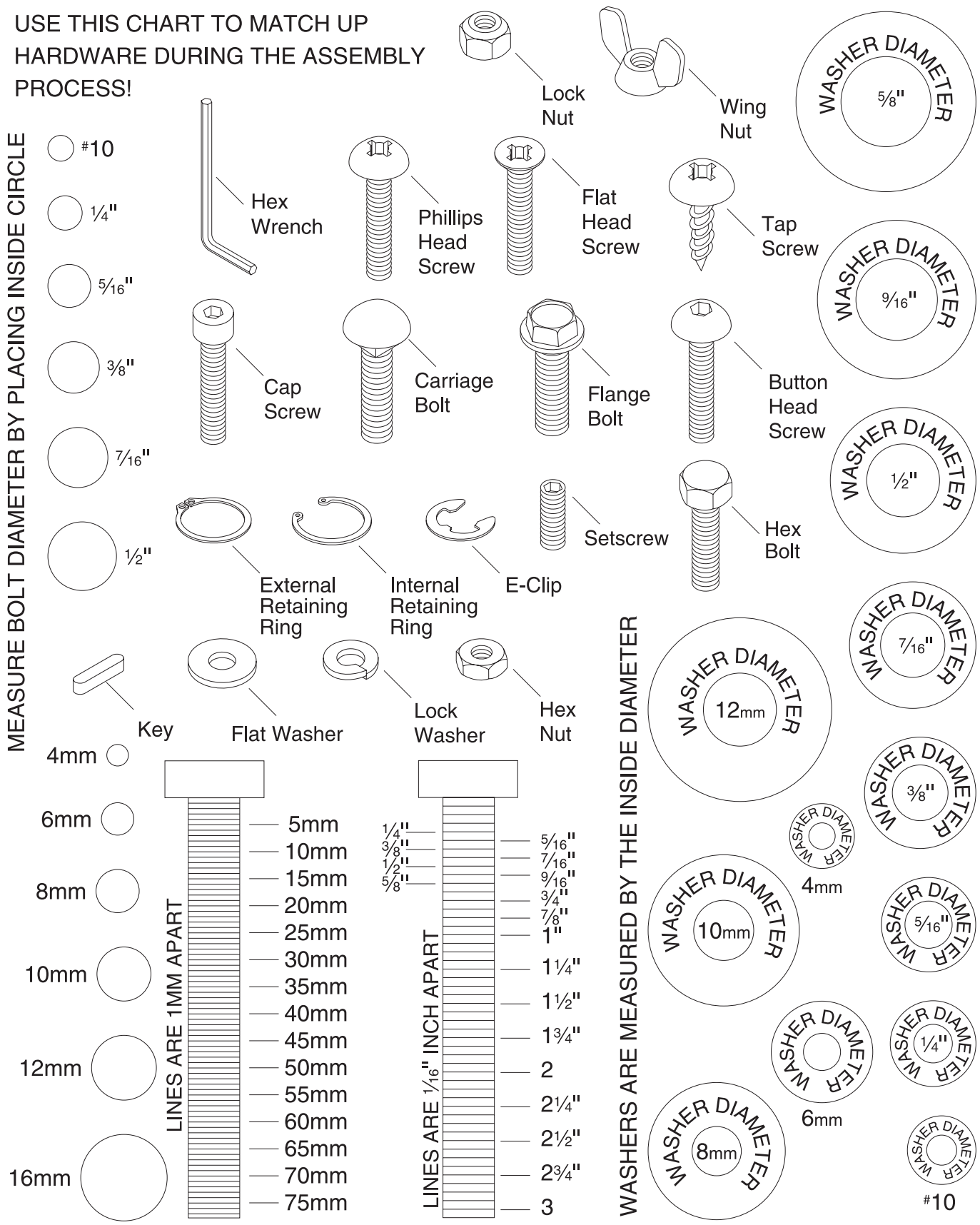
NOTICE

Some hardware/fasteners on the inventory list may arrive pre-installed on the machine. Check these locations before assuming that any items from the inventory list are missing.

⚠WARNING

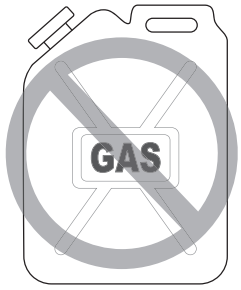
SUFFOCATION HAZARD!
Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

Hardware Recognition Chart



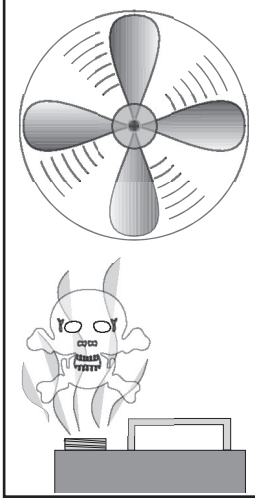
Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.



⚠WARNING

Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.



⚠CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Machine Placement

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 5** for the minimum working clearances.

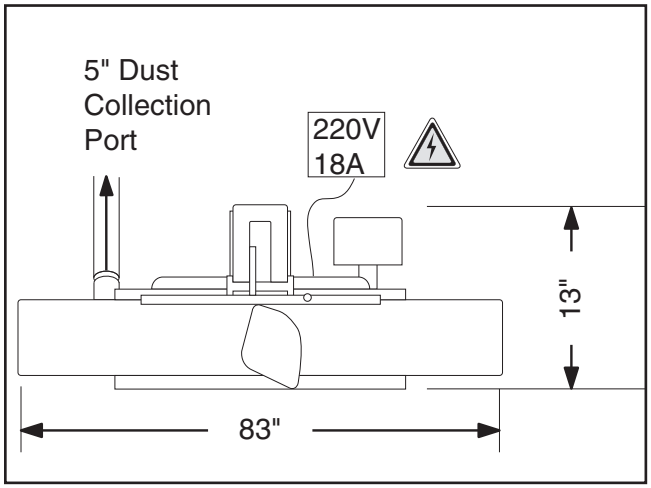
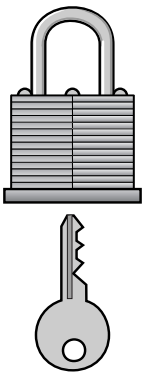


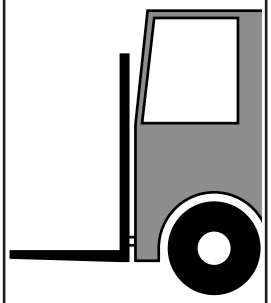
Figure 5. Minimum working clearances.



⚠CAUTION

Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!

Moving & Placing Jointer



⚠WARNING

The Model G0609 is an extremely heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.

The Model G0609 requires the use of lifting equipment such as a forklift, engine hoist, or boom crane. DO NOT lift the machine by hand.

If you are unsure how to lift this jointer, consult a qualified professional.

To lift the jointer:

1. Wrap lifting straps around the infeed and outfeed tables. Position the straps as close to the base as possible to prevent damaging the tables.

2. With lifting straps positioned evenly, lift the jointer (**Figure 6**) off of the pallet and onto the floor.

Figure 6. Model G0609 supported evenly by two lifting straps.

Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Both options are described below. Whichever option you choose, it is necessary to level your machine with a precision level.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 7**) and anchor studs are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

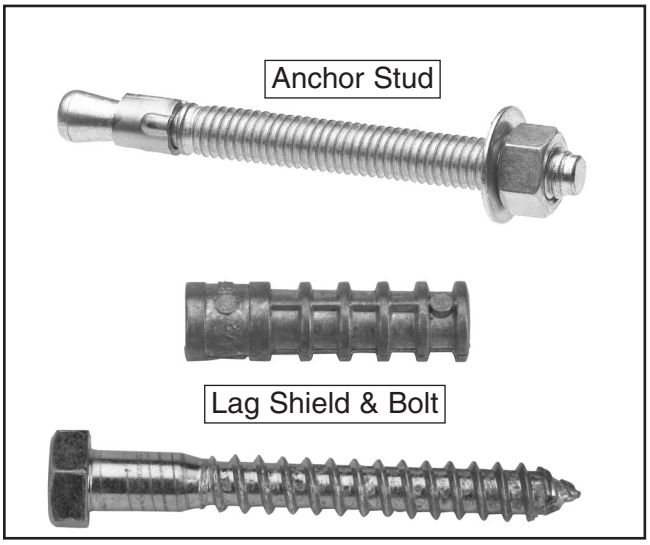


Figure 7. Typical fasteners for mounting to concrete floors.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

Fence

Make sure the fence, carriage, and table have been thoroughly cleaned of all the export grease before installing the fence, or the fence will not slide easily. The fence has a keyway slot built into the underside of it that fits over the key on the table. These keep the fence perpendicular to the cutterhead during adjustments.

⚠CAUTION

The fence is heavy. Seek assistance when lifting it onto the jointer stand.

Components and Hardware Needed:	Qty
Cap Screws M12-1.75 x 30	2
Flat Washers 12mm	3
Lock Washers 12mm	2
Lock Nut M12-1.75	1
Fence Bracket	1
Fence Assembly	1

To install the fence:

1. Align the mounting holes on the fence bracket and jointer, and fasten with the M12-1.75 x 30 cap screws, flat washers and lock washers as shown in **Figure 8**.

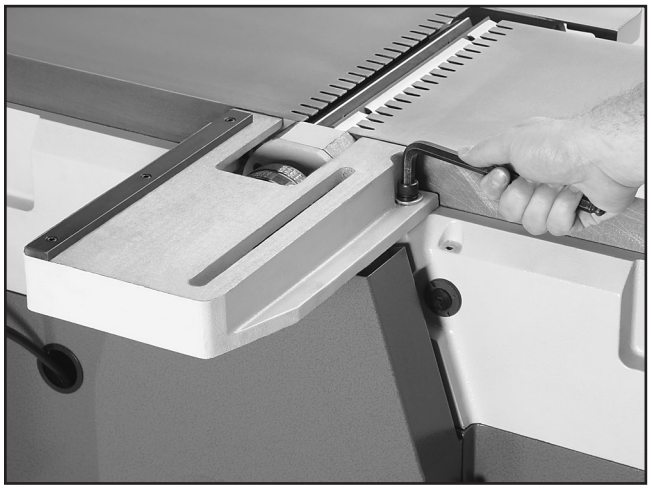


Figure 8. Installing fence bracket.

2. With the help of an assistant, lift the fence assembly over the fence bracket, slip the sliding bushing (**Figure 9**) into the fence bracket slot, and make sure the key and key-way slot fit snugly.

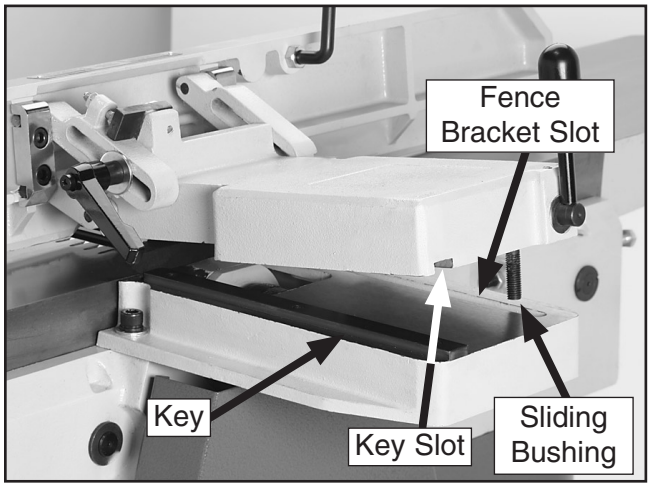


Figure 9. Installing fence assembly.

3. Secure the sliding bushing with a 12mm flat washer and lock nut.

Winding Cutterhead Guard

Though the cutterhead guard is pre-installed, you should check to make sure it works.

1. Pull the guard back and let it go. The guard should spring back over the cutterhead.

—If the guard drags across the table, loosen the set screws on the guard, raise it slightly, then tighten the set screws.

—If the guard does not spring back over the cutterhead, loosen the set screws on the jointer shown in **Figure 10**, hold the guard over the cutterhead, and wind the shaft collar clockwise. Tighten the set screws. Check to see if the guard works and adjust the collar as needed.

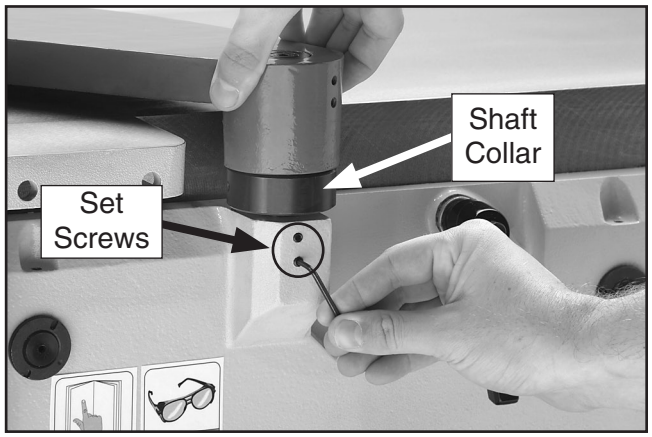


Figure 10. Loosening set screws.

Pedestal Switch

The pedestal switch is upside down for shipping purposes.

Components and Hardware Needed: Qty
- Flat Washers 10mm (Pedestal)..... 2
- Lock Washers 10mm (Pedestal)..... 2
- Cap Screws M10-1.5 x 25 (Pedestal)..... 2
- Pedestal Switch..... 1

To set up the pedestal switch:

1. Remove the M10-1.5 x 25 cap screws and flat washers shown in **Figure 11**.

2. Turn the pedestal upright and fasten it to the jointer with the cap screws and washers removed in **Step 1**, as shown in **Figure 12**.

Figure 11. Location of pedestal mounting hardware (one side shown).

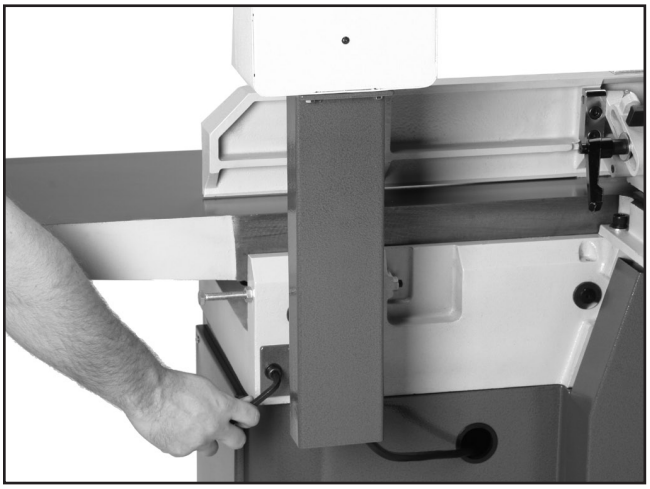


Figure 12. Mounting pedestal in upright position.

Knife Setting Jig

Assemble the jig as shown in **Figure 13**.

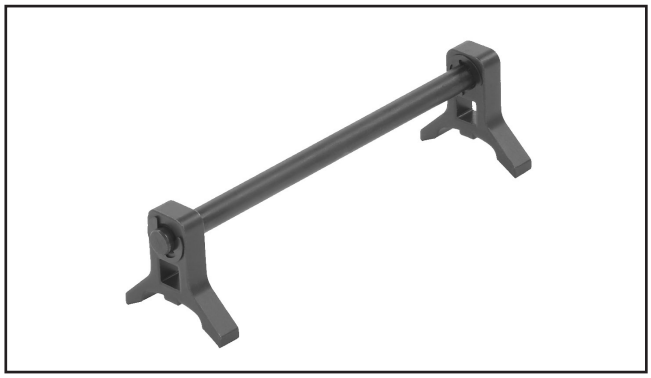


Figure 13. Knife setting jig assembly.

Checking Outfeed Table Height

The outfeed table MUST be level with the knives when they are at top-dead-center or the workpiece cannot be feed across the jointer safely. The outfeed table height is factory set, but we recommend that you check it to make sure that it didn't change during shipping.

To check the outfeed table height:

1. Place a straightedge on the outfeed table so it extends over the cutterhead.

2. Rotate the cutterhead pulley until one of the knives is at top-dead-center (TDC), as illustrated in **Figure 14**.

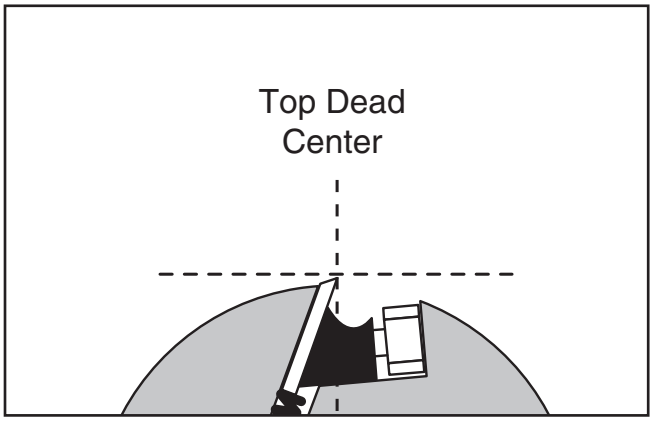


Figure 14. Cutterhead knife at top-dead center.

When correctly set, the knife will barely touch the straightedge, as shown in **Figure 15**.

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

—If the knife lifts the straightedge off the table or it is below the straightedge, then the outfeed table must be re-set. Refer to **Setting Outfeed Table Height** on **Page 39**.

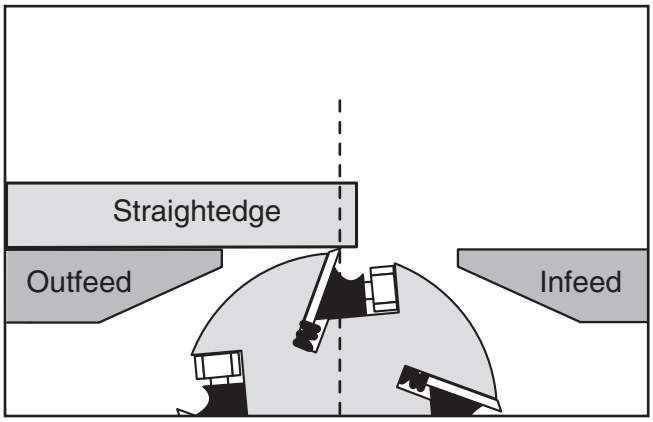


Figure 15. Using a straightedge to align outfeed table height with knife at TDC.

Dust Port

⚠CAUTION

DO NOT operate the Model G0609 without an adequate dust collection system. This machine creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

The dust port is installed at the factory, so just attach it to an adequate dust collection system.

Recommended CFM at Dust Port: .... 615 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must take into account many variables, including the CFM rating of the dust collector, the length of hose between the dust collector and the machine, the amount of branches or wyes, and the amount of other open lines throughout the system. Explaining this calculation is beyond the scope of this manual. If you are unsure of your system, consult an expert or purchase a good dust collection "how-to" book.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 32**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Connect the machine to the power source.
2. Twist the STOP button so it pops out.
3. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
4. Make sure all tools and objects used during set up are cleared away from the machine.
5. Turn the machine ***ON***.
6. Press the STOP button, then restart the jointer.
7. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

   —Immediately turn the jointer ***OFF*** if you suspect any problems, and refer to **Page 32** to troubleshoot/fix any problems before starting the jointer again.

   If the source of an unusual noise or vibration is not readily apparent, contact our Technical Support at (360) 546-9663.

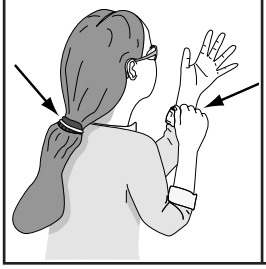
SECTION 4: OPERATIONS

Operation Safety

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.





⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

This section covers the basic controls used during routine operations.

START Button: Starts motor only if the STOP button is in the out position (**Figure 16**).

STOP Button: Stops motor when pushed in and disables the START button. Enable the START button by twisting the STOP button until it springs forward in the out position.

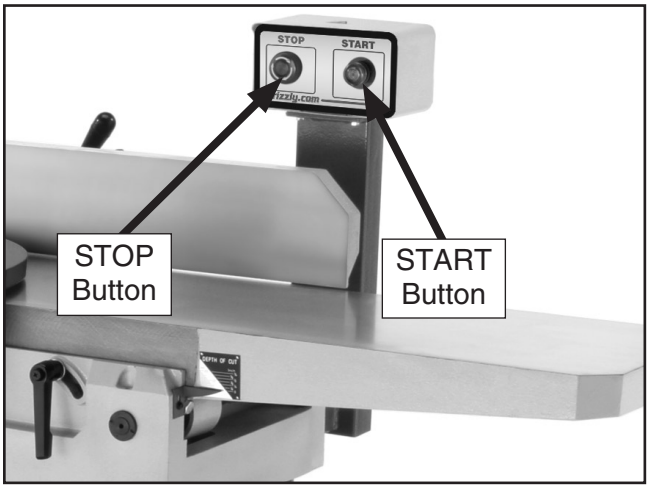


Figure 16. START/STOP button locations.

Table Movement: To move the infeed table, loosen the table lock (**Figure 17**), move the table with the table handwheel in the preset range, then tighten the table lock. The outfeed table is preset with no range of movement allowed, so if it gets accidentally unlocked it will not move. To adjust the preset range of movement, refer to **SECTION 7: SERVICE, Page 32** about setting table heights.

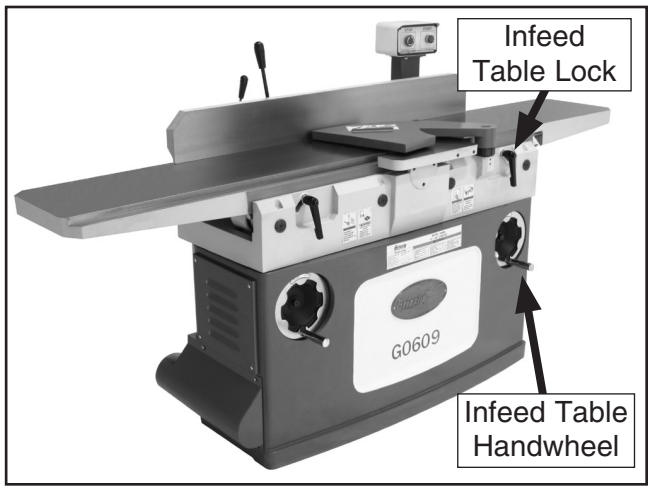


Figure 17. Table control locations.

Fence Movement: The fence has a lock handle that keeps it in position (**Figure 18**). To move the fence, loosen the lock handle and slide the fence where needed.

Fence Tilting: The tilt lock (**Figure 18**) secures the fence at any position in the available range. The stop block sets the fence tilt to 90°. Positive stops stop the fence at 45° inward and 45° outward, for common 45° bevel cuts. Even when the fence is resting against the positive stops, the tilt lock must be tightened before cutting.

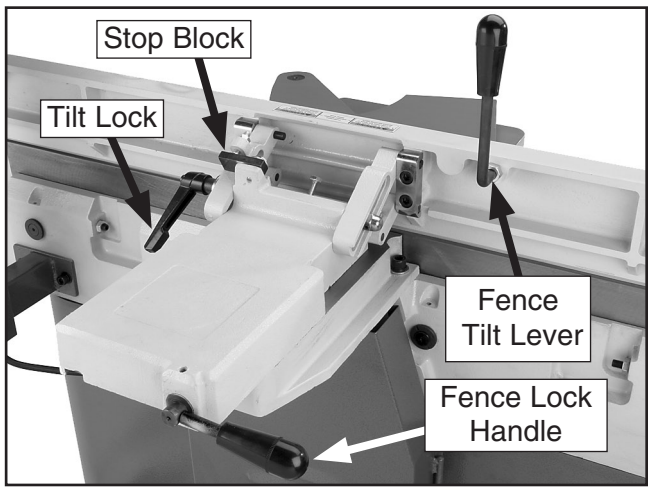


Figure 18. Fence lock, tilt lock and stop block locations.

Stock Inspection and Requirements

Here are some rules to follow when choosing and jointing stock:

- **DO NOT joint or surface plane stock that contains knots.** Injury to the operator or damage to the workpiece can occur if the knots become dislodged during the cutting operation.

- **DO NOT joint or surface plane against the grain direction.** Cutting against the grain increases the likelihood of stock kickback, as well as tear-out on the workpiece.

- **Jointing and surface planing with the grain produces a better finish and is safer for the operator.** Cutting with the grain is described as feeding the stock on the jointer so the grain points down and toward you as viewed on the edge of the stock (**Figure 19**).

  Note: *If the grain changes direction along the edge of the board, decrease the cutting depth and make additional passes.*

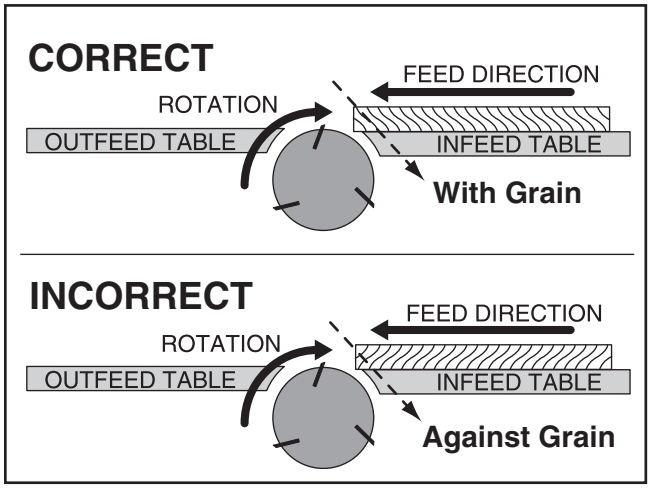


Figure 19. Correct and incorrect grain alignment to cutterhead.

- **Remove foreign objects from the stock.** Make sure that any stock you process with the jointer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects that may damage the jointer blades.

- **Only process natural wood fiber through your jointer.** Never joint MDF, particle board, plywood, laminates or other synthetically made materials.

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the knives and poor cutting results.

- **Make sure your workpiece exceeds the minimum dimension requirements (Figures 20 & 21) before edge jointing or surface planing, or it may break or kick back during the operation!**

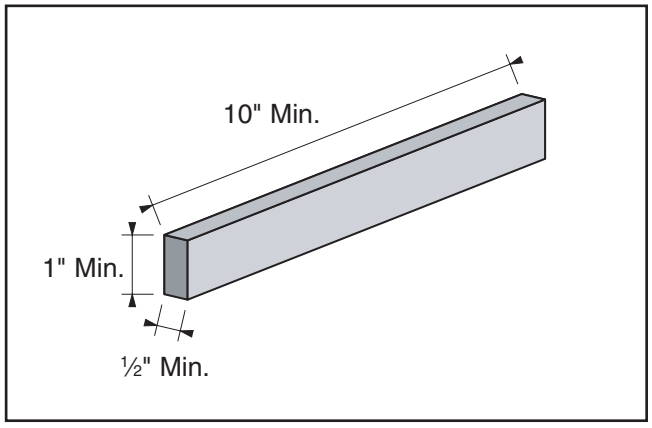


Figure 20. Minimum dimensions for edge jointing.

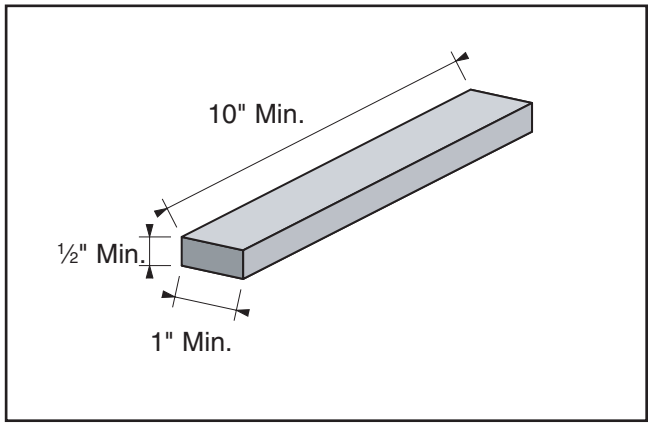
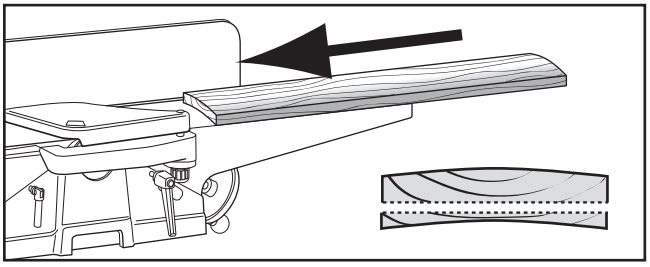


Figure 21. Minimum dimensions for surface planing.

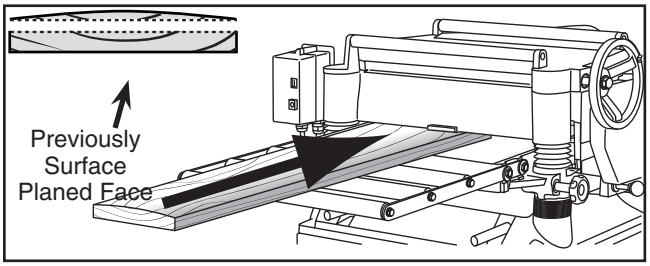
Squaring Stock

Squaring stock involves four steps performed in the order below:

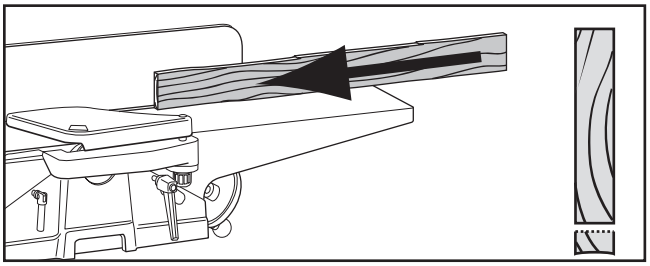
1. Surface Plane On The Jointer—The concave face of the workpiece is surface planed flat with the jointer.



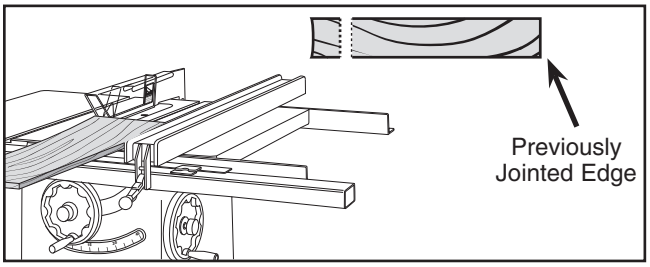
2. Surface Plane On a Thickness Planer—The opposite face of the workpiece is surface planed flat with a thickness planer.



3. Edge Joint On The Jointer—The concave edge of the workpiece is jointed flat with the jointer.



4. Rip Cut On A Table Saw—The jointed edge of the workpiece is placed against a table saw fence and the opposite edge cut off.



Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see **Figures 22 & 23**) to prepare it for surface planing on a thickness planer.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described. This procedure will better prepare you for the actual operation.

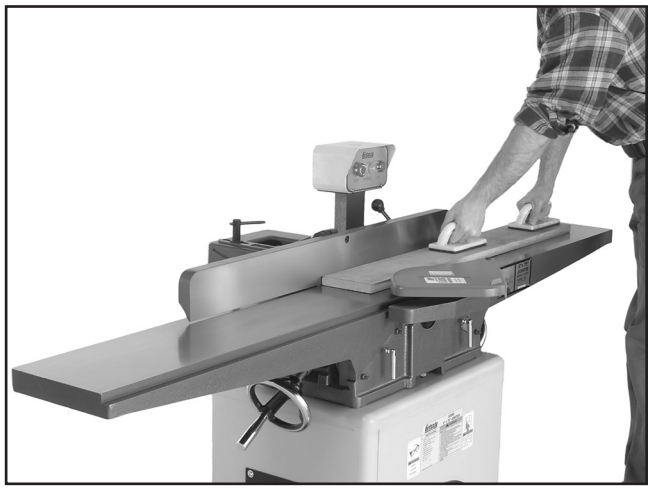


Figure 22. Typical surface planing operation.

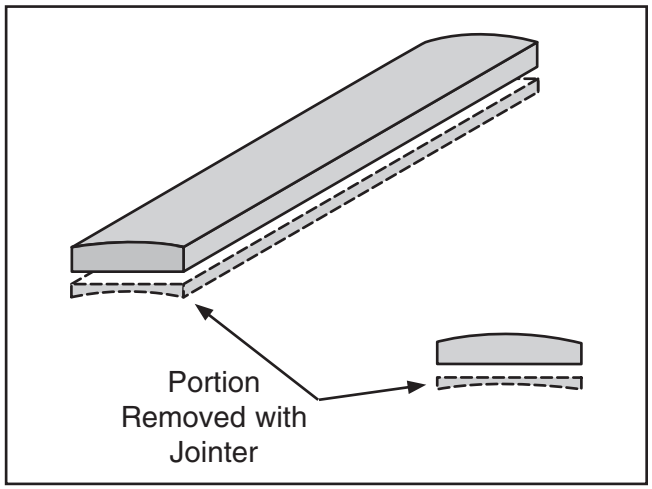


Figure 23. Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.

2. Inspect your stock for the dangerous conditions described in **Stock Inspection & Requirements** instructions, beginning on **Page 21**.

3. Set the cutting depth for your operation.

   Note: *We suggest 1/32" for surface planing, using a more shallow depth for hard wood species or for wide stock.*

4. Set the fence to 90° and place the workpiece on the jointer.

   —If your workpiece is cupped (warped), place it so the cupped or concave side is face own (**Figure 23**) on the surface of the infeed table.

5. Start the jointer.

⚠WARNING

The step below requires you to use push blocks. Failure to use push blocks when surface planing may result in cutterhead contact, which will cause serious personal injury. Always use push blocks to protect your hands when surface planing on the jointer.

6. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead (**Figure 22**).

   Note: *If your leading hand (with push block) gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

7. Repeat **Step 6** until the entire surface is flat.

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 24 & 25**) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

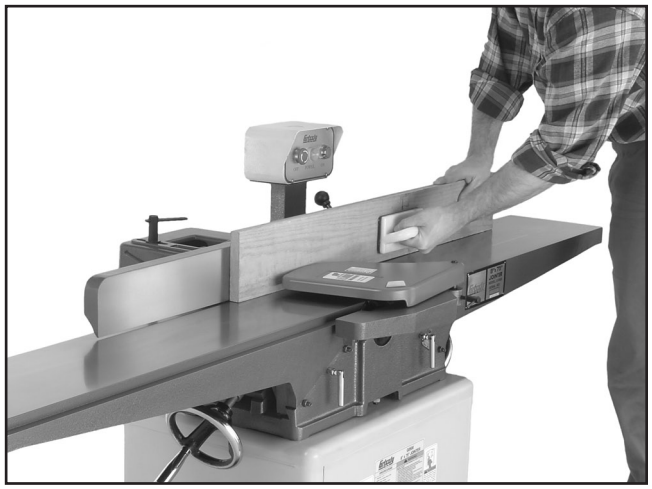


Figure 24. Typical edge jointing operation.

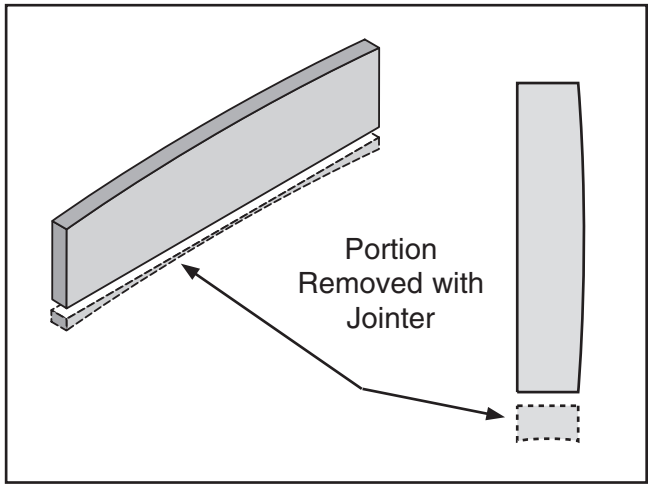


Figure 25. Illustration of edge jointing results.

To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.

2. Inspect your stock for the dangerous conditions described in **Stock Inspection** instructions, beginning on **Page 21**.

3. Set the cutting depth for your operation.

   Note: *We suggest between 1/16" and 1/8" for edge jointing, using a more shallow depth for hard wood species or for wide stock.*

4. Set the fence to 90° and place the workpiece on the jointer.

5. If your workpiece is cupped (warped), place it so the cupped edge is face down (**Figure 25**) on the surface of the infeed table.

6. Start the jointer.

⚠WARNING

The step below requires you to use a push block. Failure to use push blocks when surface planing may result in cutterhead contact, which will cause serious personal injury. Always use push blocks to protect your hands when surface planing on the jointer.

7. With a push block in your leading hand, press the workpiece against the table and fence with firm pressure. Use your trailing hand to guide the workpiece through the cut, and feed the workpiece over the cutterhead (See **Figure 24**).

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place it on the portion of the workpiece that is over the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

8. Repeat **Step 7** until the entire edge is flat.

Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece (see **Figures 26 & 27**).

The Model G0609 has preset fence stops at 45˚ inward, 90˚, and 45˚ outward (135˚). If your situation requires a different angle, the preset fence stops can be easily adjusted for your needs.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

Figure 26. Typical bevel cutting operation.

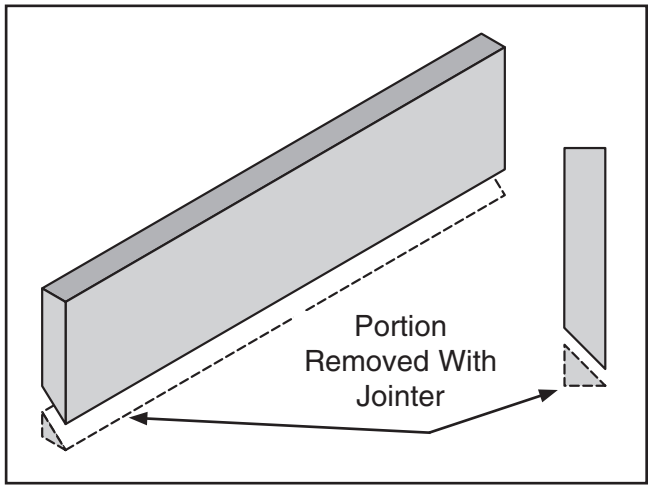


Figure 27. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.

2. Inspect your stock for the dangerous conditions described in **Stock Inspection** instructions, beginning on **Page 21.**

3. Set the cutting depth for your operation.

   Note: *We suggest between 1/16" and 1/8" for bevel cutting, using a more shallow depth for hard wood species or for wide stock.*

4. Set the fence to the angle of your desired cut and place the workpiece on the jointer.

   —If your workpiece is cupped (warped), place it so the cupped edge is face down on the surface of the infeed table.

5. Start the jointer.

⚠WARNING

The step below requires you to use a push block. Failure to use push blocks when surface planing may result in cutterhead contact, which will cause serious personal injury. Always use push blocks to protect your hands when surface planing on the jointer.

6. With a push block in your leading hand, press the workpiece against the table and fence (**Figure 26**) with firm pressure, and feed the workpiece over the cutterhead.

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

7. Repeat **Step 6** until the angled cut is satisfactory to your needs.

Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge (see **Figures 28 & 29**). When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

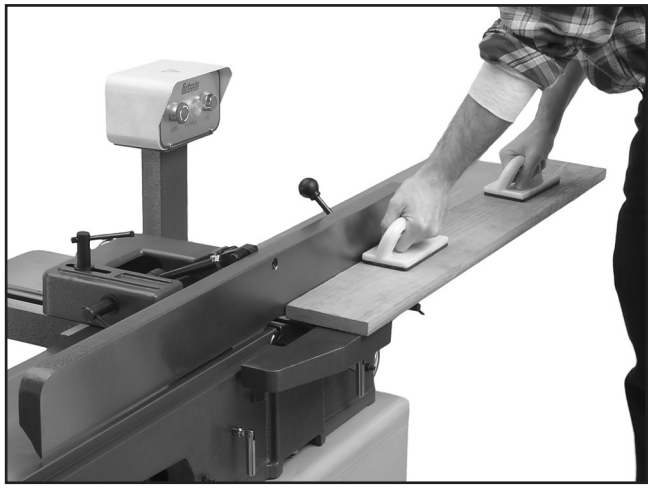


Figure 28. Typical rabbet cutting operation.

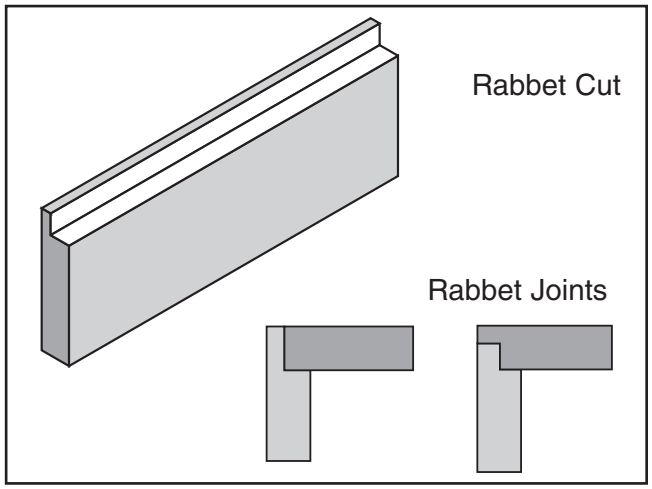


Figure 29. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.

2. Inspect your stock for the dangerous conditions described in the **Stock Inspection** instructions, beginning on **Page 21**.

3. Set the cutting depth for your operation. **Note**: *We suggest between 1/16" and 1/8" for rabbet cutting, using a more shallow depth for hard wood species or for wide stock.*

4. Loosen the set screws shown in **Figure 10, Page 17**, and remove the cutterhead guard.

5. Move your fence forward so the amount of infeed/outfeed table exposed is the same as the size of your rabbet. Also, make sure your fence is set to 90° and place the workpiece on the jointer.

6. Start the jointer.

7. With a push block in each hand, press the workpiece against the table and fence with firm pressure (**Figure 28**), and feed the workpiece over the cutterhead. **Note**: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

8. Repeat **Step 7** until the your rabbet is cut to depth.

9. Replace the cutterhead guard, wind the collar (See **Page 17**), and tighten the screws.

⚠WARNING

When the cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes the operator to the moving cutterhead. Always replace the cutterhead guard after rabbet cutting!

SECTION 5: ACCESSORIES

G3640—Power Twist® V-Belt - ½" x 48"
Smooth running with less vibration and noise than solid belts. The Power Twist® V-belts can be customized in minutes to any size—just add or remove sections to fit your needs. Size: ½" x 48"; replaces all "A" sized V-belts. Requires three Power Twist® V-belts to replace the stock V-belts on your Model G0609.

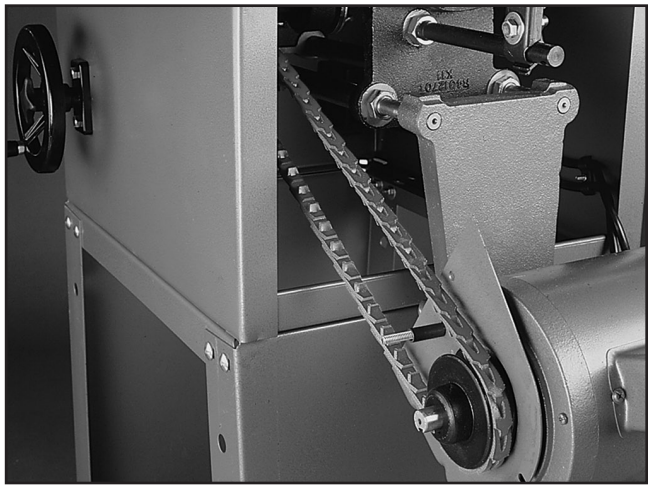


Figure 30. G3640 Power Twist® V-Belt.

H9291—12" Shellix Spiral Cutterhead
Made in the USA by Byrd®, these indexable carbide insert cutterheads are very well made and leave a great finish. The inserts are not only placed along a spiral pattern, they are also at an angle so that the shearing action leaves a glassy smooth cut on the toughest of woods. Each cutterhead comes with 5 extra replacement inserts.

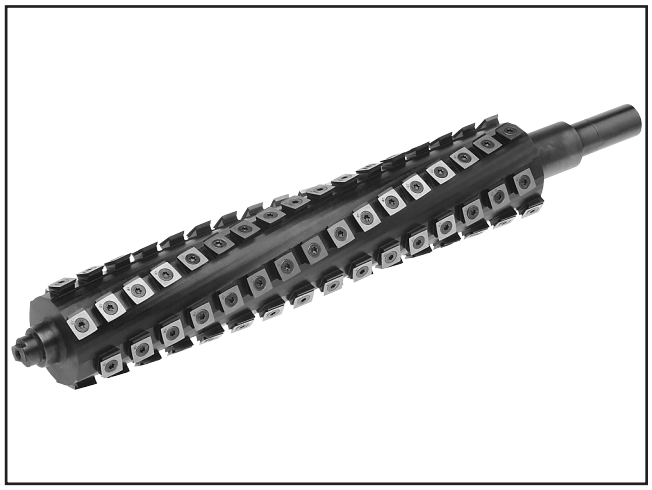


Figure 31. H9291 Spiral Cutterhead.

G3631—Jointer/Planer Knife Hone
Add a razor hone to your planer and jointer knives with this hand-held sharpening device. This handy tool sharpens flat and beveled surfaces quickly and easily. Great for touch-ups.

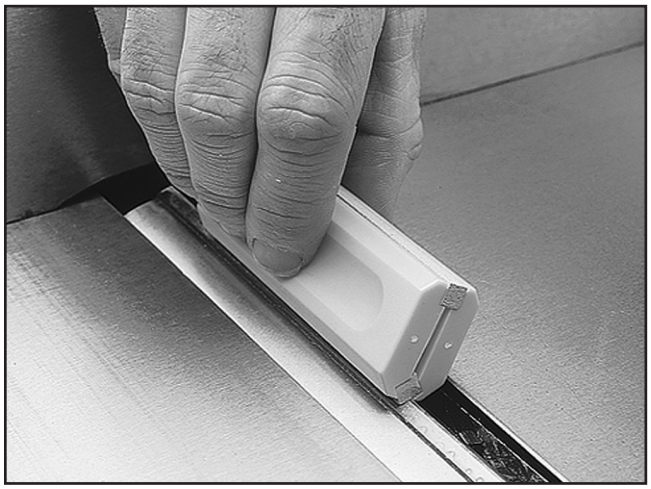


Figure 32. G3631 Jointer/Planer Knife Hone.

H2404—Jointer Pal®Magnetic Knife Jig (Up to 12" Carbide or HSS)
This patented knife-setting systems lets you set jointer knives in perfect alignment every time! It also allows you to shift nicked knives to get a perfect cut to an accuracy of + or - .001". Patents owned by Woodstock International, Inc.

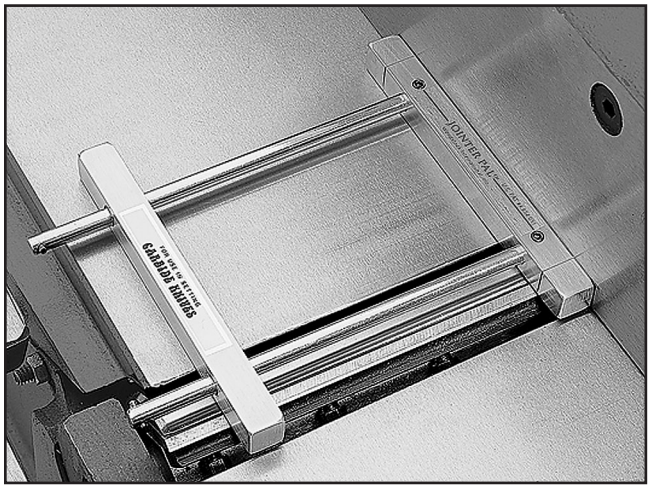


Figure 33. Model H2404 Jointer Pal®.

G9256—6" Dial Caliper
G9257—8" Dial Caliper
G9258—12" Dial Caliper
Required for jointing, planing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!

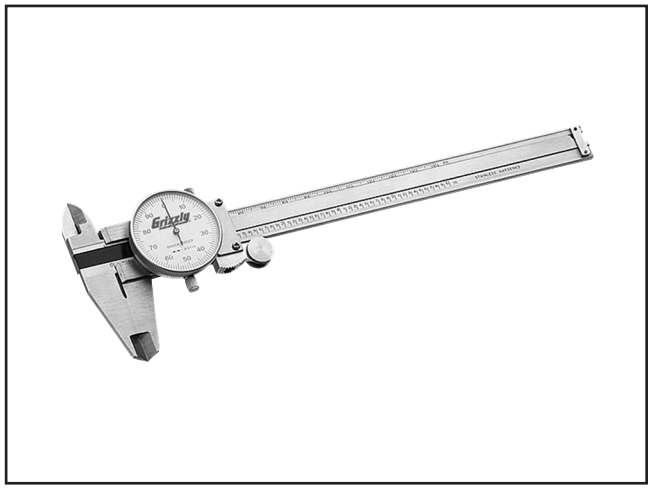


Figure 34. Grizzly® Dial Calipers.

H9247—Dispoz-A-Blade® System
H9248—Replacement Dispoz-A-Blade® HSS Knives
Install a Dispoz-A-Blade® Knife system in your new jointer and save up to 70% on knife replacements for the life of your jointer. Each knife insert is double-edged, so you get two knives in one, and is indexed so that all knife inserts can be installed at the same height in just minutes. Yes, that means you can throw away the knife jig!

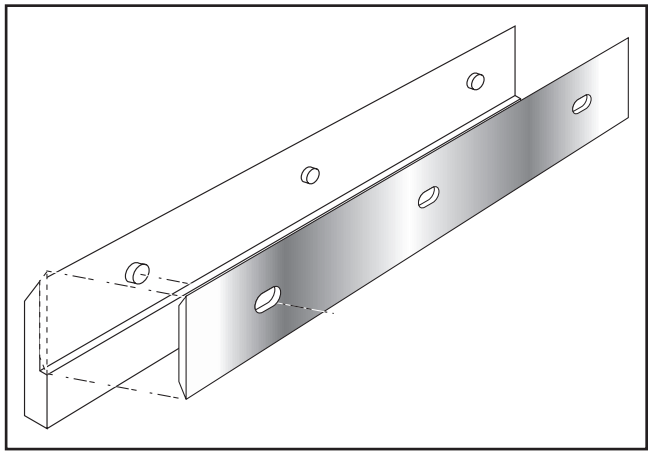


Figure 35. Dispoz-A-Blade® Holder and Knife.

H9246—12" HSS Replacement Jointer Knives (Set of 4)

H1411—PowerHands™ Safety Stick
This safety push stick features interchangeable traction treads; one for flat stock, and one for pressing against table and fence. It also has a spring loaded push-pin for full workpiece contact. Made in the USA.

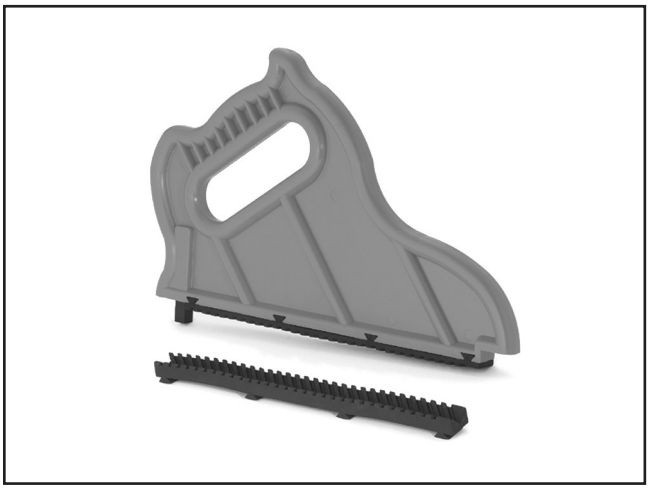


Figure 36. H1411 PowerHands™ Safety Stick.

G9643—8" Precision Straightedge
G9644—12" Precision Straightedge
H2675—16" Precision Straightedge
Ideal for aligning your outfeed bed to the cutterhead and calibrating your depth scale. These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.

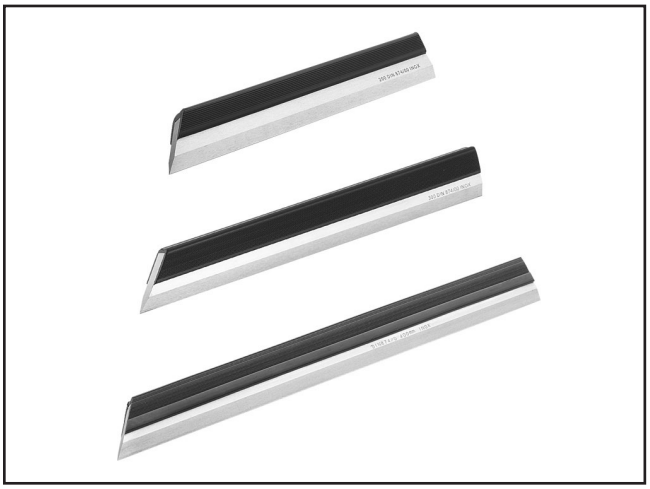


Figure 37. Straightedges.

G7984—Face Shield
H1298—Dust Sealed Safety Glasses
H1300—UV Blocking, Clear Safety Glasses
H2347—Uvex® Spitfire Safety Glasses
H0736—Shop Fox® Safety Glasses
Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

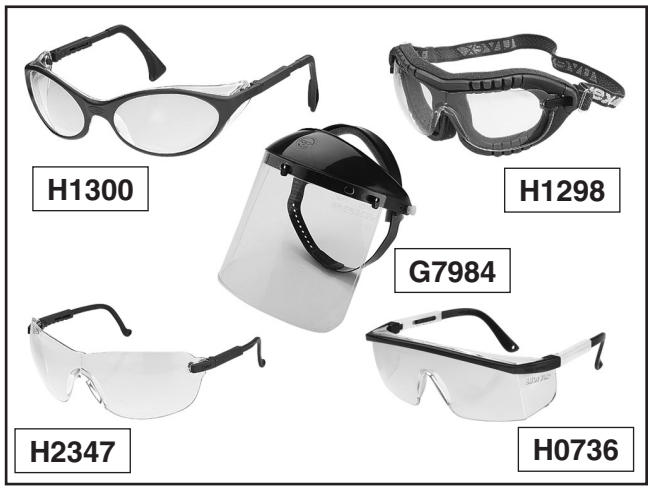


Figure 38. Our most popular safety glasses.

H6175—Power Respirator
H6892—3M Pre-Filter, 10-Pack
H6893—Filter Cartridge, 10-Pack, P100
Say goodbye to foggy safety glasses and labored breathing, this battery powered respirator supplies a constant breeze of fresh air all day long. Comes with its own plastic case for clean, sealed storage. Finally, a respirator you can look forward to wearing—at an affordable price!

Figure 39. H6175 Power Respirator.

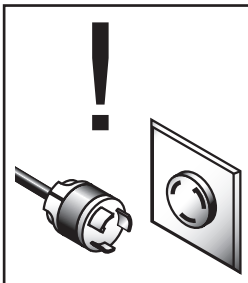
H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Disposable Cartridge Filter Pair P100
Wood dust is a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 40. Half-mask respirator and disposable cartridge filters.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 41. Recommended products for protecting unpainted cast iron/steel part on machinery.

SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Maintenance

- Vacuum all dust on and around the machine.
- Wipe down tables and all other unpainted cast iron with a metal protectant.

Monthly Maintenance

- Inspect V-belts for tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off of motor.

Cleaning

Cleaning the Model G0609 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **SECTION 5: ACCESSORIES** on **Page 27** for more details).

Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

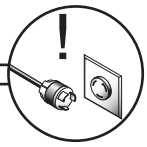
Maintenance Log

Date	Approximate Hours Of Use	Maintenance Performed

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Motor will not start or fuses or circuit breakers blow.	1. Power supply circuit breaker is blown/tripped.	1. Ensure correct size for machine load (refer to **Page 10**); replace weak breaker.
	2. Plug/receptacle is at fault or wired incorrectly.	2. Test for good contacts; correct the wiring.
	3. Start capacitor is at fault.	3. Test/replace if faulty.
	4. Thermal overload relay has tripped.	4. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting.
	5. Motor is at fault.	5. Test/repair/replace.
	6. Emergency stop button depressed.	6. Twist the emergency stop button to allow it to pop out.
	7. Motor ON button is at fault.	7. Replace faulty ON button.
	8. Open circuit in motor or loose connections.	8. Inspect all lead connections on motor for loose or open connections.
	9. Short circuit in line cord or plug.	9. Repair or replace cord or plug for damaged insulation and shorted wires.
	10. Circuit not adequate to handle load.	10. Install correct circuit breaker; reduce # of machines running on that circuit (circuit overload).
Motor overheats.	1. Motor overloaded during operation.	1. Reduce load on motor; take lighter cuts.
	2. Air circulation through the motor restricted.	2. Clean out motor to provide normal air circulation.
Motor stalls or shuts off during a cut.	1. Motor overloaded during operation.	1. Reduce load on motor; take lighter cuts.
	2. Thermal overload protection tripped in magnetic switch.	2. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting.
	3. Short circuit in motor or loose connections.	3. Repair or replace connections on motor for loose or shorted terminals or worn insulation.
	4. Circuit breaker tripped.	4. Install correct circuit breaker; reduce # of machines running on that circuit (circuit overload).
	5. Motor is at fault.	5. Test/repair/replace motor.
Blade slows when cutting, makes squealing noise.	1. V-belt loose.	1. Tighten V-belt (**Page 43**).
	2. V-belt worn out.	2. Replace V-belt (**Page 43**).
Loud repetitious noise coming from machine.	1. Pulley setscrews or keys are missing or loose.	1. Inspect keys and setscrews. Replace or tighten if necessary.
	2. Motor fan is hitting the cover.	2. Replace dented fan cover; replace loose/damaged fan.
	3. V-belts are damaged.	3. Replace V-belts (**Page 43**).
Vibration when running or cutting.	1. Loose, dull or misajusted blades.	1. Tighten or replace blades.
	2. Damaged V-belt.	2. Replace.
	3. Worn cutterhead bearings.	3. Check/replace cutterhead bearings.

Table

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	1. Table lock is engaged or partially engaged. 2. Table stops blocking movement.	1. Completely loosen the table lock. 2. Loosen/reset table positive stops.

Cutting

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	1. Outfeed table is set too low. 2. Operator pushing down on end of workpiece.	1. Align outfeed table with cutterhead knife at top dead center (**Page 18**). 2. Reduce/eliminate downward pressure on that end of workpiece.
Workpiece stops in the middle of the cut.	1. Outfeed table is set too high.	1. Align outfeed table with cutterhead knife at top dead center (**Page 18**).
Chipping.	1. Knots or conflicting grain direction in wood. 2. Nicked or chipped blades. 3. Feeding workpiece too fast. 4. Taking too deep of a cut.	1. Inspect workpiece for knots and grain (**Page 21**); only use clean stock. 2. Adjust one of the nicked knives sideways; replace knives (**Page 35**). 3. Slow down the feed rate. 4. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)
Fuzzy Grain.	1. Wood may have high moisture content or surface wetness. 2. Dull knives.	1. Check moisture content and allow to dry if moisture is too high. 2. Replace knives (**Page 35**).
Long lines or ridges that run along the length of the board	1. Nicked or chipped knives.	1. Adjust one of the nicked knives sideways; replace knives (**Page 35**).
Uneven cutter marks, wavy surface, or chatter marks across the face of the board.	1. Feeding workpiece too fast. 2. Knives not adjusted at even heights in the cutterhead.	1. Slow down the feed rate. 2. Adjust the knives so they are set up evenly in the cutterhead (**Page 35**).
Board edge is concave or convex after jointing.	1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.	1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on the starting condition of the board and the depth of cut.
Uneven cut or breakout when rabbeting.	1. Uneven feed rate. 2. Depth of cut too deep. 3. Knives not adjusted evenly with each other in the cutterhead. 4. Nicked or chipped knives.	1. Feed the board evenly and smoothly during the cut. 2. Raise the infeed table to take a smaller depth of cut. Never exceed 1/16" per pass when rabbeting. 3. Adjust the knives so they are set up evenly in the cutterhead (**Page 35**). 4. Adjust one of the nicked knives sideways; replace knives (**Page 35**).

Inspecting Knives

The height of the knives can be inspected with a straightedge to ensure that they are set evenly with the outfeed table at their highest point in the cutterhead rotation.

Tools Needed	Qty
Straightedge	1
Hex Wrench 3mm	1

To inspect the knives:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Loosen the set screws shown in **Figure 10, Page 17**, remove the guard, and open the pulley cover.

3. Rotate the cutterhead pulley to get access to one of the cutterhead knives.

4. Using a straightedge, check the height of each knife at its highest point in relation to the outfeed table, in each of the straightedge positions, as shown in **Figure 42**.

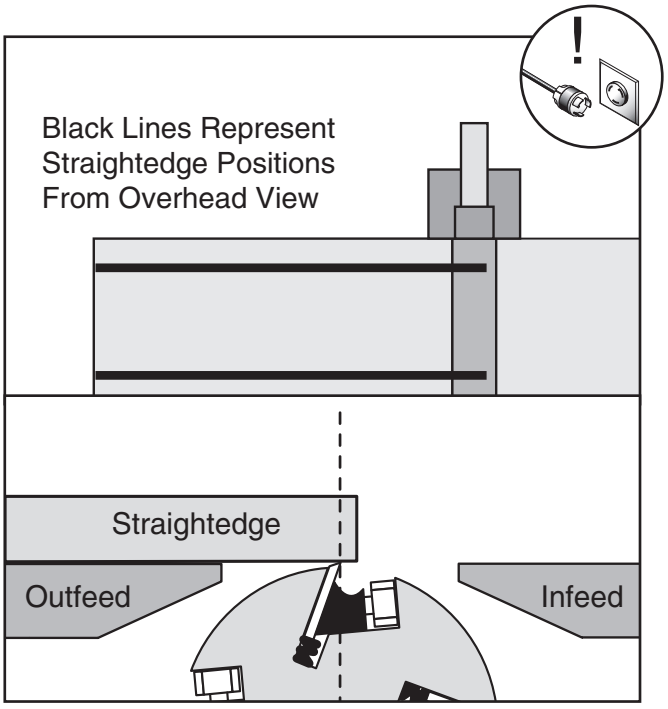


Figure 42. Checking knife height with a straightedge.

—The knives are set correctly when they just touch the bottom of the straightedge in each of the straightedge positions.

—If the knives do not touch the straightedge or they lift it up in any of the positions, then those knives need to be adjusted.

Adjusting/Replacing Knives

Setting the knives correctly is crucial to the proper operation of the jointer and is very important in keeping the knives sharp. If one knife is higher than the others, it will do the majority of the work, and thus, dull much faster than the others.

There are two options for setting the knives—the straightedge method and the knife setting jig method. Each option has advantages and disadvantages and the correct one for you will become a matter of personal preference. For best results, the tables must be parallel with each other (**Checking/Adjusting Table Parallelism** on **Page 37**) and the outfeed table height must be properly set (**Setting Outfeed Table Height** on **Page 39**).

Straightedge Method: A high quality straightedge is held flat against the outfeed table and the knife heights are set to the bottom of the straightedge, as shown in **Figure 42.** Because the knife projection height from the cutterhead is dependent on the outfeed table height, the outfeed table must be set as described in **Setting Outfeed Table Height** on **Page 39** for this method to work correctly.

When using a straightedge to set the knives, you will not need to move the outfeed table once it is set and you will always be assured that the knives are even with the outfeed table in their highest point of rotation—even if the cutterhead is not parallel with the outfeed table.

Knife Setting Jig Method: Both tables are lowered to fit the jig on the cutterhead, as shown in **Figure 43**, and the knife heights are set to just touch the middle pad of the jig.

The knife setting jig makes it easy to ensure that the knives project out of the cutterhead evenly. After using the knife setting jig to set the knives, you have to re-adjust the outfeed table height to ensure that it is even with the knives at their highest point of rotation. If you are using the positive stops on the tables, they will need to also be reset before operation.

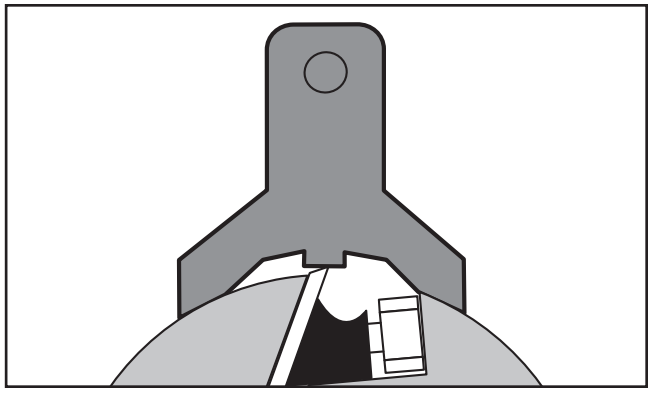


Figure 43. Using knife setting jig to set knife height.

The Model G0609 comes with jack screws inside the cutterhead to adjust the knives (see **Figure 44**).

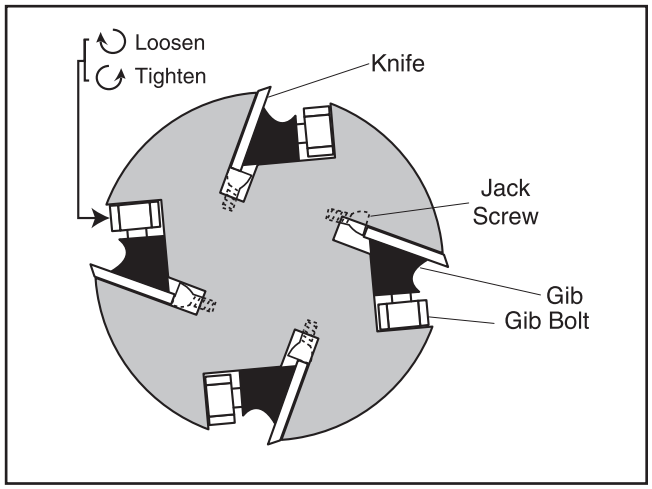


Figure 44. Cutterhead profile diagram.

Tools Needed	**Qty**
Straightedge	1
Knife Setting Jig (Optional)	1
Hex Wrench 3mm	1
Wrench 10mm	1

To adjust/replace the knives:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Loosen the set screws shown in **Figure 10, Page 17**, remove the cutterhead guard, and move the fence back as far as it will go.

3. Open the pulley cover to expose the cutterhead pulley.

4. Rotate the cutterhead pulley to get access to one of the cutterhead knives.

5. Loosen the cutterhead gib bolts, starting in the middle, and alternating back and forth until all of the gib bolts are loose, but not falling out.

   —If this is the first time you are setting the knives, remove the gib and knife from the cutterhead.

6. Remove and clean the gibs and clean inside the cutterhead slot to remove all pitch or sawdust. Coat the knives and gibs with a metal protectant (**Page 27**), then fit the gibs back in the cutterhead with the new knives.

7. Adjusting the knife heights:

   a. Using a 3mm hex wrench, find the jack screws through the access holes in the cutterhead (**Figure 45**) and rotate the jack screws to raise or lower the knife. When the knife is set correctly, it will barely touch the bottom of the straightedge or the knife setting jig middle pad.

   b. Snug the gib bolts tight enough to just hold the knife in place.

   c. Repeat on the other side of the cutterhead.

   d. Repeat **Steps 5–7** with the rest of the knives.

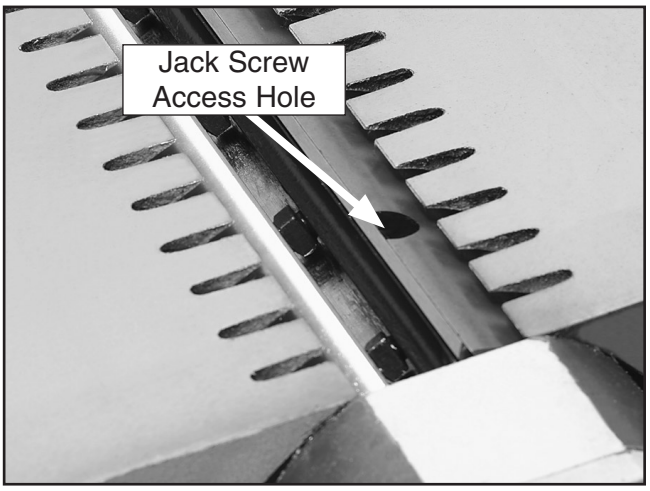


Figure 45. Jack screw access hole.

8. Rotate the cutterhead to the first knife you started with. Slightly tighten all the gib bolts, starting at the ends and working your way to the middle by alternating left and right (**Figure 46**). Repeat this step on the rest of the knives.

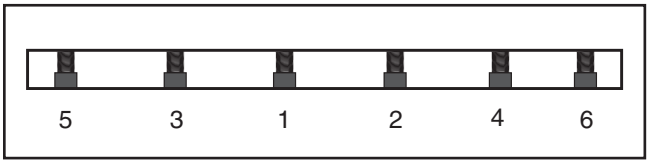


Figure 46. Gib bolt tightening sequence.

9. Repeat **Step 8**.

10. Repeat **Step 8**, but final tighten each gib bolt.

11. If you used the knife setting jig to set the knife heights, use the straightedge to adjust the outfeed table height evenly with the knives at top dead center (the highest point in their rotation). If you used the straightedge to set the knife heights, skip to the next step.

12. Replace the cutterhead guard, wind the shaft collar, and tighten the set screws.

13. Close the pulley cover.

Checking/Adjusting Table Parallelism

If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback can occur.

Tools Needed	Qty
Straightedge	1
Wrench 17mm	1
Wrench 19mm	1
Hex Wrench 5mm	1
Hex Wrench 3mm	1

Checking Outfeed Table

To check the outfeed table parallelism:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Loosen the set screws shown in **Figure 10, Page 17**, remove the guard, and remove the fence.

3. Loosen the outfeed table lock located at the front of the machine, and loosen the jam nuts and positive stop bolts located at the back of the machine (see **Figure 47**).

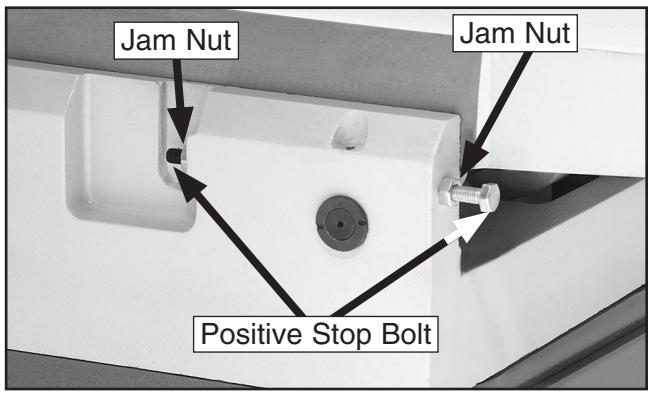


Figure 47. Table positive stop bolts.

4. Place the straightedge on the outfeed table so it hangs over the cutterhead, and lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 48** (rotate the cutterhead if necessary).

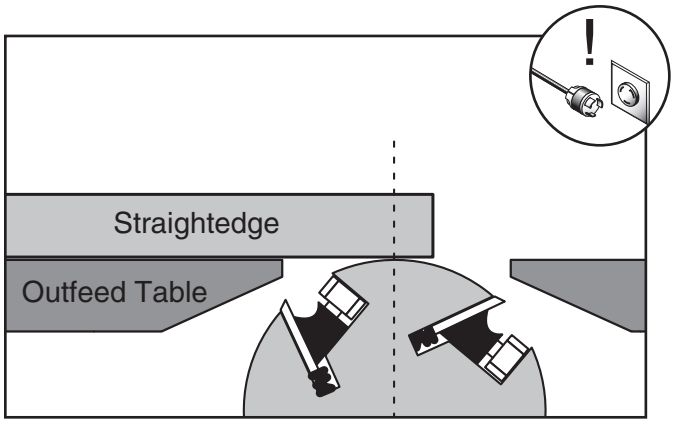


Figure 48. Adjusting outfeed table even with cutterhead body.

5. Place the straightedge in the positions shown in **Figure 49**. In each position, the straightedge should touch the cutterhead body and sit flat on the outfeed table.

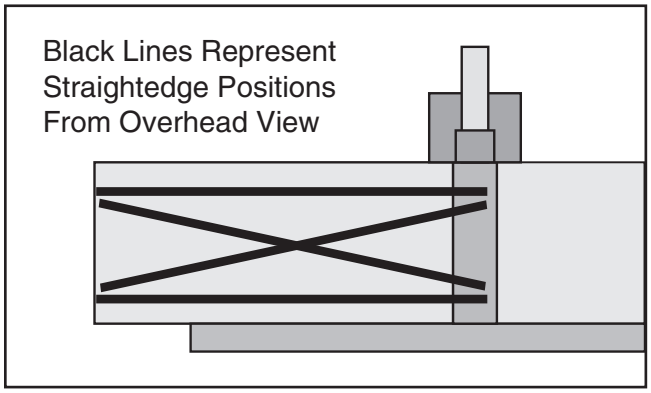


Figure 49. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

—If the straightedge touches the cutterhead and sits flat across the outfeed table in each position, then the outfeed table is already parallel with the cutterhead. Check the infeed table to make sure that it is parallel with the outfeed table.

—If the straightedge does not touch the cutterhead and sit flat on the outfeed table in any of the positions, then the outfeed table is not parallel with the cutterhead. Correct the outfeed table parallelism, then correct the infeed table parallelism.

Checking Infeed Table

To check the infeed table parallelism:

1. Follow all the steps for checking the outfeed table parallelism to first make sure that the outfeed table is parallel with the cutterhead.

2. Raise the outfeed table higher than the cutterhead.

3. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 50**.

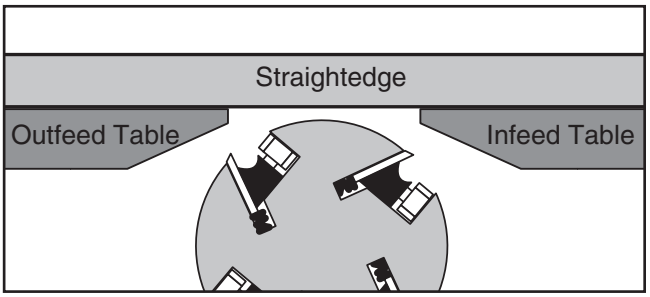


Figure 50. Infeed and outfeed tables set evenly.

4. Place the straightedge in the positions shown in **Figure 51**. In each position, the straightedge should sit flat against both the outfeed table and the infeed table.

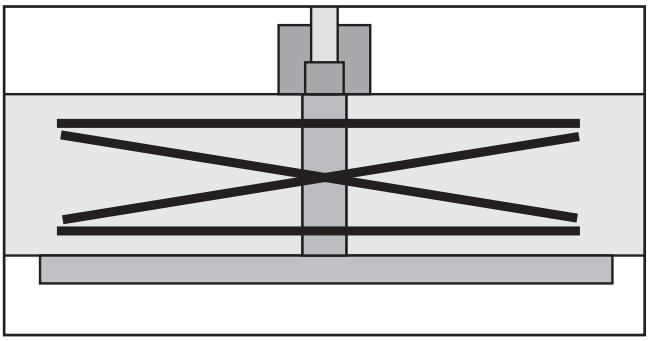


Figure 51. Straightedge positions for checking infeed/outfeed table parallelism.

—If the straightedge sits flat against both the infeed and outfeed table, then the tables are parallel. Set both table heights (**Pages 39 & 40**) and replace the cutterhead guard.

—If the straightedge does not sit flat against both the infeed and outfeed table in any of the positions, then follow the **Adjusting Table Parallelism** instructions.

Adjusting Table Parallelism

For safe and proper cutting results, the tables must be parallel to the cutterhead. Adjusting them to be parallel is a task of precision and patience, and may take up to one hour to complete. Luckily, this is considered a permanent adjustment and should not need to be repeated for the life of the machine.

Due to the complex nature of this task, we recommend that you double check the current table positions to make sure that they really need to be adjusted before starting.

The tables have four eccentric bushings under each corner that allow the tables to be adjusted parallel. These eccentric bushings are locked in place by piggybacked set screws (one on top of the other) and adjust when rotated.

The correct order for adjusting the table parallelism is to first adjust the outfeed table parallel with the cutterhead to within 0.010"-0.012", then adjust the infeed table parallel with the outfeed table.

When setting the outfeed table, all measurements must be made from the cutterhead body—not the knives—or results may get skewed the next time you change knives.

IMPORTANT: The steps below are intended to be performed in succession with the steps involved in checking the outfeed table. Do not continue until you have followed those steps.

To adjust the table parallelism:

1. Place the straightedge on the outfeed table so it hangs over the cutterhead, and lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 48** (rotate the cutterhead if necessary).

2. Remove the set screw from each of the four eccentric bushings (**Figure 52**) under the outfeed table, and loosen the set screws underneath those removed set screws.

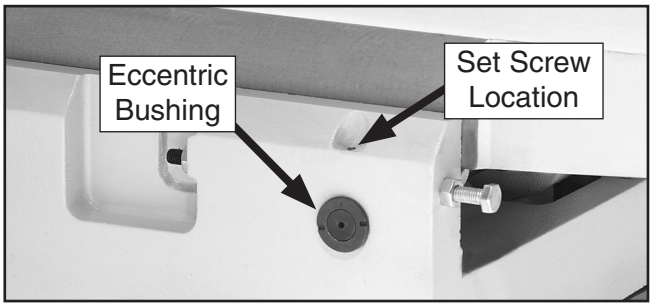


Figure 52. Eccentric bushing and set screw location.

3. Place the straightedge in one of the positions shown in **Figure 49**, and adjust the table (a small hammer and punch or pin-type spanner wrench may be necessary to turn the eccentric bushings) so that the straightedge touches the cutterhead while lying flat across the outfeed table. Repeat this step with each of the remaining straightedge positions as many times as necessary until the outfeed table is parallel with the cutterhead to within 0.010"-0.012".

Note: *Setting the outfeed table parallel to the cutterhead within 0.010"-0.012" will produce high quality results. Exceeding this number will produce minimal gain.*

4. Tighten/replace the set screws in the eccentric bushings on the outfeed table.

5. Remove the set screw from each of the four eccentric bushings under the infeed table, and loosen the set screws underneath those removed set screws.

6. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 50**.

7. Place the straightedge in one of the positions shown in **Figure 51**, and adjust the eccentric bushings under the infeed table so the straightedge lies flat against both tables. Repeat this step with each of the remaining straightedge positions as many times as necessary until the infeed table is parallel with the outfeed table.

8. Tighten/replace the set screws in the eccentric bushings on the infeed table.

9. Set the outfeed table height (refer to the next sub-section).

10. Set the knives (refer to **Page 35**).

11. Reinstall the cutterhead guard and fence.

Setting Outfeed Table Height

The outfeed table height must be even with the top of the cutterhead knives. If the outfeed table is set too low, there will be snipe. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

Tools Needed	**Qty**
Straightedge	1
Wrench 17mm	1
Wrench 19mm	1
Hex Wrench 5mm	1
Hex Wrench 3mm	1
Feeler Gauge(s) 0.062"	1

To set the outfeed table height:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Check/adjust the table parallelism.

3. Loosen the set screws shown in **Figure 10, Page 17**, remove the guard, and remove the fence.

4. Loosen the outfeed table lock located at the front of the machine, and loosen the jam nuts and positive stop bolts located at the back of the machine (see **Figure 47**).

5. Place the straightedge on the outfeed table so it hangs over the cutterhead, and lower the outfeed table until the straightedge is 0.062" (1/16") above the cutterhead body, as determined by using the feeler gauges (see **Figure 53**).

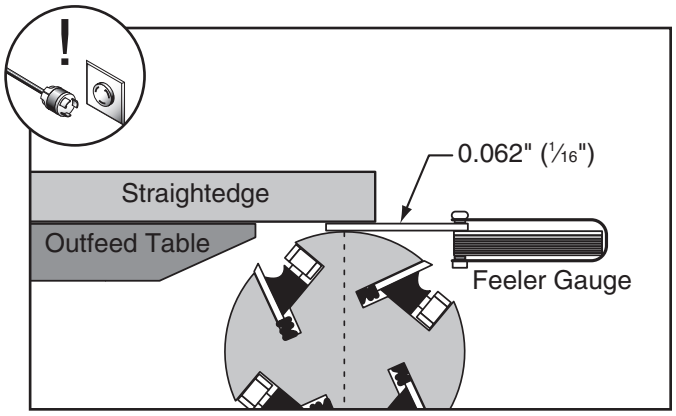


Figure 53. Using feeler gauges to set outfeed table height.

6. Tighten the outfeed table lock located at the front of the machine, and tighten the positive stop bolts and jam nuts located at the back of the machine (see **Figure 47**).

7. Set the knife heights (**Page 34**) to the new outfeed table height.

Setting Infeed Table

The infeed table on the Model G0609 has positive stop bolts that, when properly set up, allow the operator to quickly adjust the infeed table between finish/final cuts and shaping/heavy cuts.

We recommend setting the minimum depth of cut to 1/32" and the maximum depth of cut to 1/8" for most operations. **DO NOT exceed 1/8" cut per pass on this machine or kickback and serious injury may occur!**

Each positive stop bolt (**Figure 54**) controls the top or bottom range of the table movement. The jam nuts lock the positive stop bolts in position so they won't move during operation.

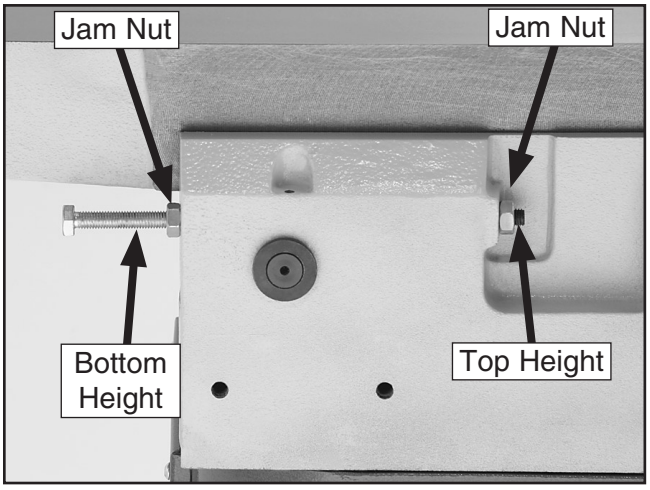


Figure 54. Positive stop bolts for infeed table.

Calibrating Depth Scale

The depth scale on the infeed table can be calibrated or "zeroed" if it is not correct.

Tools Needed	Qty
Straightedge	1
Phillips Screwdriver	1
Wrench 17mm	1
Hex Wrench 5mm	1

To calibrate the depth scale:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Loosen the infeed table positive stop bolts.

3. Use the straightedge to help adjust the infeed table exactly even with the outfeed table, as shown in **Figure 55**.

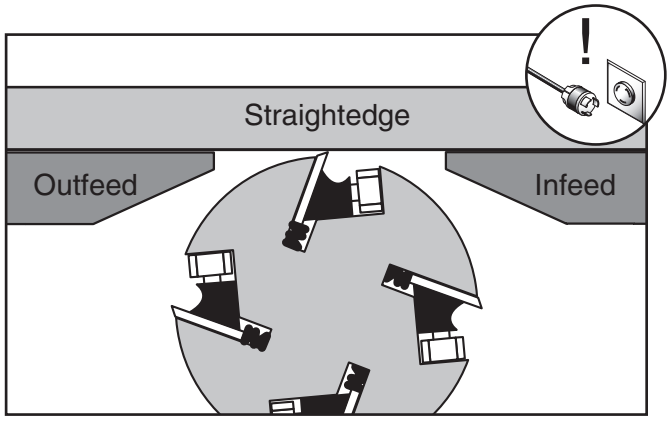


Figure 55. Infeed table even with outfeed table.

4. Using a screwdriver, adjust the scale pointer to "0" (**Figure 56**), then reset the infeed table positive stops.

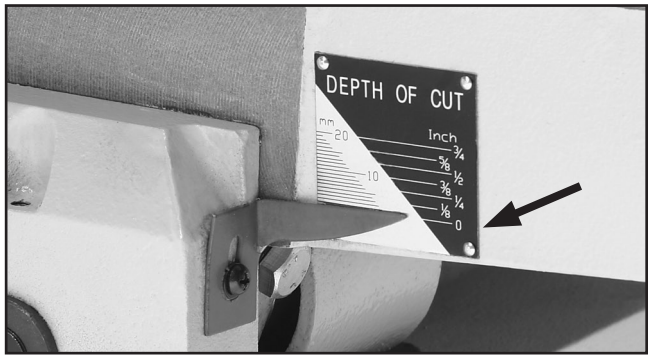


Figure 56. Depth scale adjusted to “0” position.

Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45˚ inward, 90˚, and 45˚ outward (135˚).

Tools Needed	Qty
45° Square	1
90° Square	1
Sliding Bevel	1
Wrench 14mm	1

To set the 45˚ inward fence stop:

1. Tilt the fence approximately 45° inward (**Figure 57**) onto the positive stop bolts using a square.

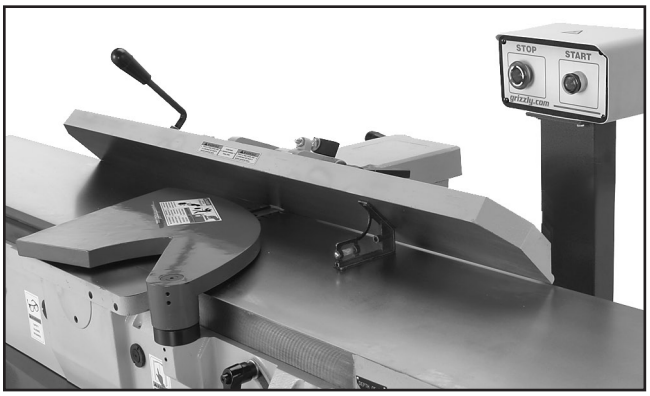


Figure 57. Fence adjusted 45˚ inward.

2. Loosen the jam nut on the 45° inward positive stop bolt shown in **Figure 58**.

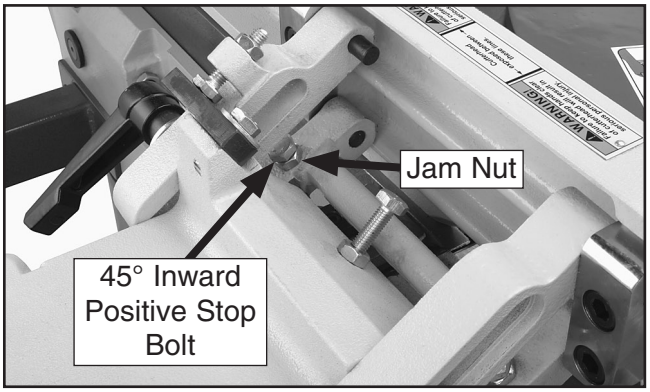


Figure 58. 45° inward positive stop bolt (one of two shown).

3. Adjust the positive stop bolts until the fence is exactly 45° inward while resting on the bolts (verify the angle with a 45° square).

4. Retighten the jam nut loosened in **Step 2**.

To set the 90˚ fence stop:

1. Lower the stop block against the fence, as shown in **Figure 59**, and loosen the fence tilt lock.

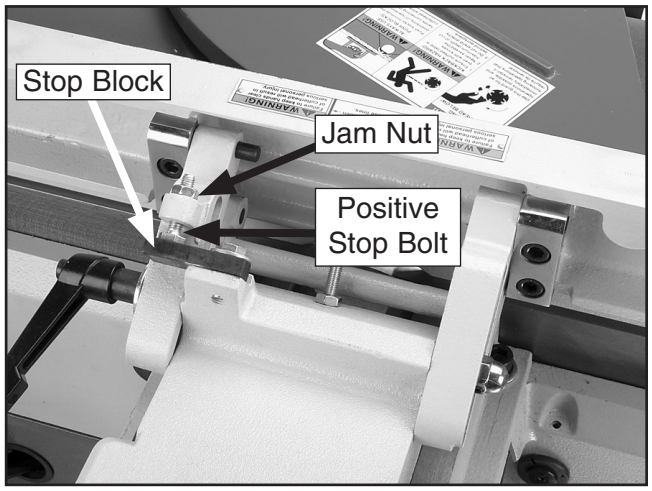


Figure 59. Adjusting fence to 90˚.

2. Tilt the fence to the 90° position.

3. Using a 90° square, check the fence angle.

   —If it is not set at exactly 90°, loosen the jam nut and adjust the positive stop bolt until the fence is exactly 90° as shown in **Figure 59**.

4. Tighten the jam nut.

To set the 45° outward fence stop:

1. Raise the stop block, loosen the fence tilt lock, and position the fence against the 45° outward positive stop bolt.

   —If the fence is not set at exactly 45˚ outward, loosen the jam nut on the 45˚ outward fence positive stop bolt (**Figure 60**).

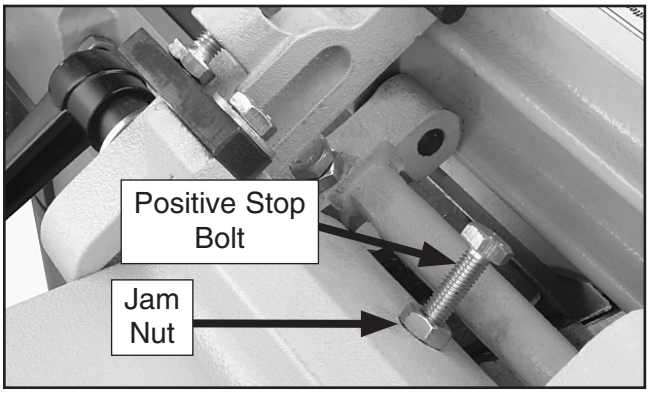


Figure 60. Adjusting fence 45˚ outward.

2. Adjust the 45˚ outward positive stop bolt until the fence is exactly 45° outward while resting on the bolt (check the angle with a sliding bevel set to 135°).

3. Retighten the jam nut loosened in **Step 2**.

V-Belts

Inspect the V-belts closely; if you notice fraying, cracking, glazing, or any other damage, replace the belts. A worn or damaged V-belt will not provide optimum power transmission from the motor to the drum and feed belt.

V-belt removal and replacement is simply a matter of loosening the V-belts, rolling them off of the pulleys, replacing them with new belts, then retensioning them.

Tools Needed: **Qty**
Wrench or Socket 19mm..... 1

To replace the V-belts:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Open the pulley cover.

3. Loosen the fasteners on the tension rod that hold the motor to the bracket (**Figure 61**).

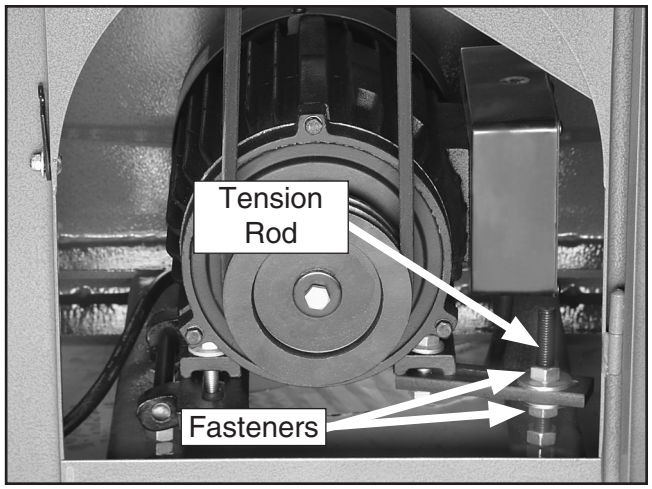


Figure 61. Fasteners needed to be loosened for V-belt replacement.

4. Lift the motor up and slide the V-belts off of the motor pulley and cutterhead pulley.

5. Slide the new belts onto the pulleys, tighten the motor bracket fasteners, and close the pulley cover.

Pulley Alignment

Pulley alignment is another important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplaner) for optimum performance.

Each pulley can be adjusted by loosening the motor mount fasteners, sliding the motor in or out, and retightening the fasteners to lock the motor pulley in place.

Tools Needed: **Qty**
Wrench or Socket 17mm..... 1

To align the pulleys:

1. DISCONNECT JOINTER FROM POWER SOURCE!

2. Open the pulley cover.

3. Visually check the alignment of the two pulleys to make sure that they are aligned and that the V-belts are straight up and down (see **Figure 62**).

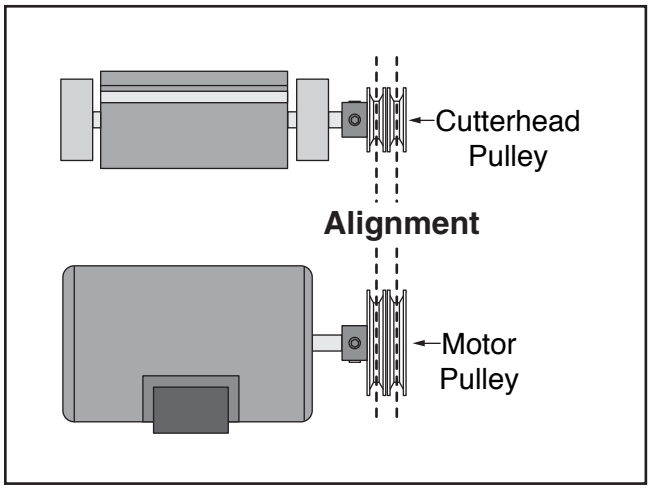


Figure 62. Pulleys aligned.

—If the pulleys are aligned, tighten the motor mounts and go to **Step 8**.

—If the pulleys are NOT aligned, do **Steps 4 & 5**.

4. Loosen the fasteners that hold the motor to the brackets shown in **Figure 63**.

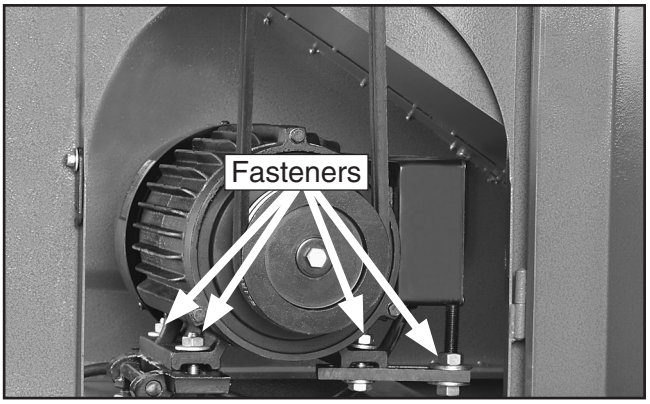


Figure 63. Motor mount fasteners for adjusting pulley alignment.

5. Shift the motor horizontally as needed to align the motor pulley with the cutterhead pulley.

6. Tighten the fasteners that hold the motor to the brackets. V-belts should be parallel and aligned as shown in **Figure 62**.

7. Adjust the pulleys again, if necessary, until they are coplanar (parallel and aligned) with each other.

8. Close the pulley cover.

G0609 Electrical Components

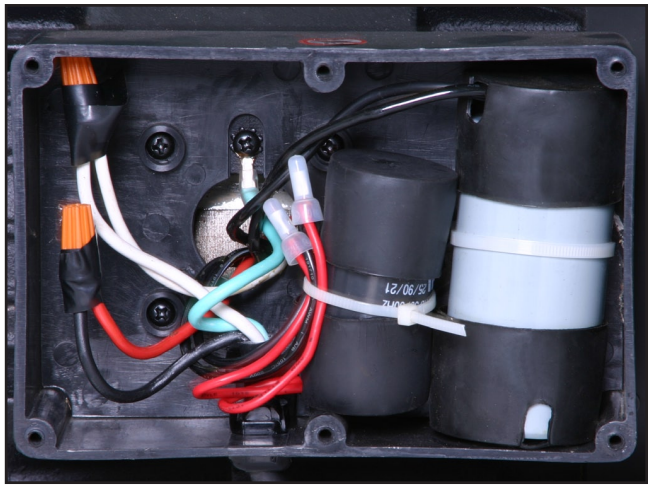


Figure 64. Motor junction box.

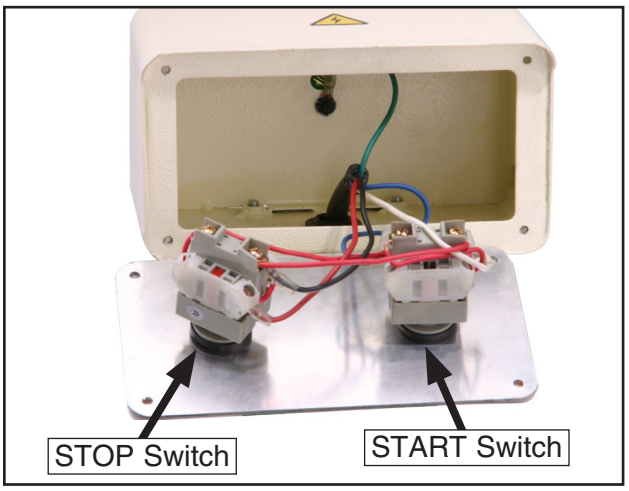


Figure 65. Control panel.

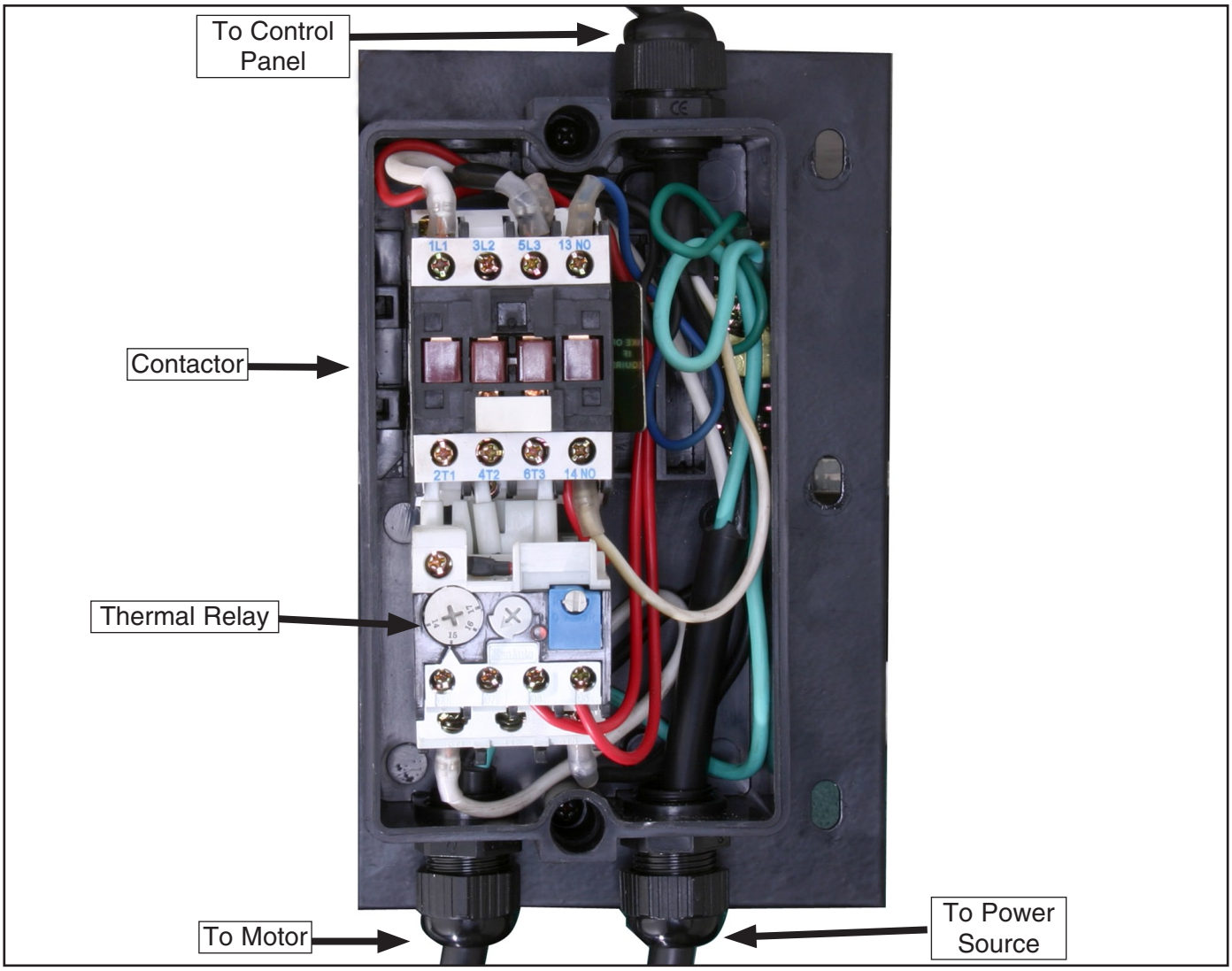
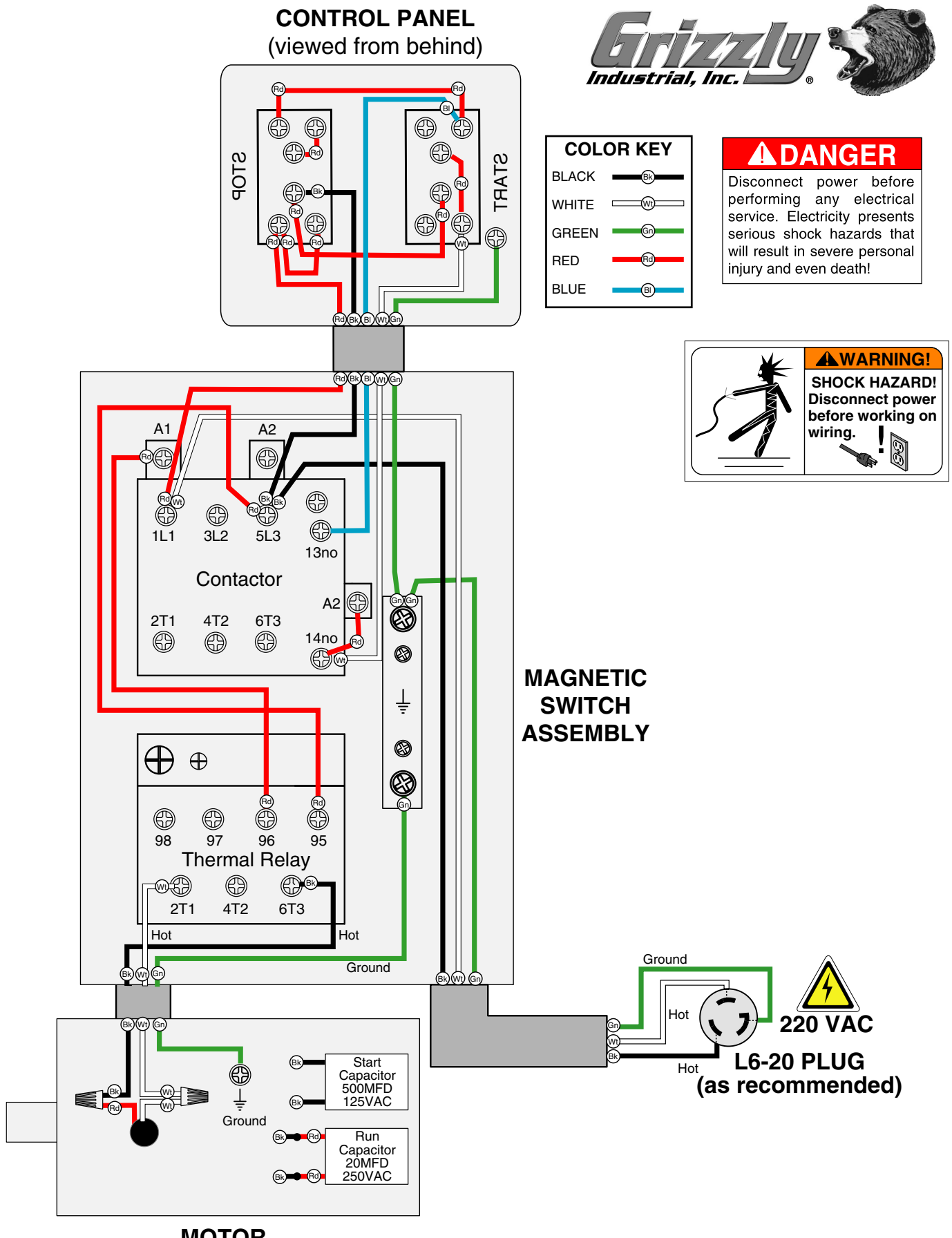
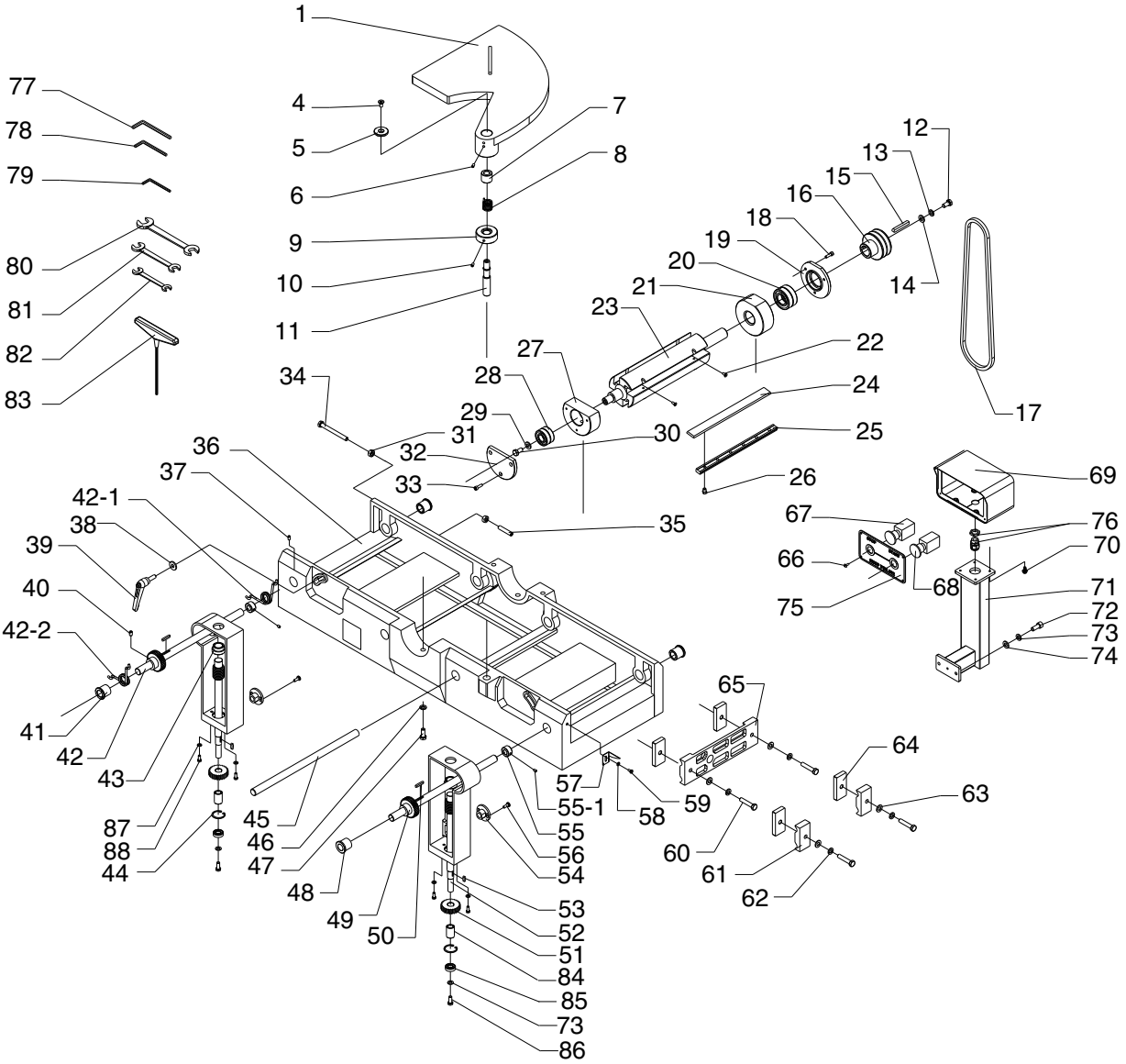


Figure 66. Magnetic switch assembly (behind right access panel).

G0609 Wiring Diagram



Base Assembly Parts Breakdown



Base Parts List

REF	PART #	DESCRIPTION
1	P0609001	CUTTERHEAD GUARD
4	PFH23M	FLAT HD SCR M8-1.25 X 16
5	P0609005	SPECIAL FLAT WASHER
6	PSS04M	SET SCREW M6-1 X 12
7	P0609007	ADAPTER
8	P0609008	TORSION SPRING
9	P0609009	SHAFT COLLAR
10	PSS04M	SET SCREW M6-1 X 12
11	P0609011	SHAFT
12	P0609012	SPECIAL CUTTERHEAD SCREW
13	PLW06M	LOCK WASHER 10MM
14	PW04M	FLAT WASHER 10MM
15	PK111	KEY 8 X 8 X 60
16	P0609016	CUTTERHEAD PULLEY
17	PVA53	V-BELT A-53 4L530
18	PSB02M	CAP SCREW M6-1 X 20
19	P0609019	BEARING COVER
20	P6206	BALL BEARING 6206ZZ
21	P0609021	BEARING SUPPORT
22	PFH05M	FLAT HD SCR M5-.8 X 12
23	P0609023	CUTTERHEAD
24	P0609024	KNIFE
25	P0609025	KNIFE BAR (GIB)
26	P0609026	KNIFE LOCK SCREW (GIB SCREW)
27	P0609027	BEARING SUPPORT
28	P62042RZ	BALL BEARING 62042RZ
29	PW01M	FLAT WASHER 8MM
30	P0609030	CUTTERHEAD SCREW
31	PN02M	HEX NUT M10-1.5
32	P0609032	BEARING COVER
33	PSB02M	CAP SCREW M6-1 X 20
34	PB156	HEX BOLT M10-1.5 X 150
35	PSS71M	SET SCREW M10-1.5 X 60
36	P0609036	BASE
37	PSS04M	SET SCREW M6-1 X 12
38	PW04M	FLAT WASHER 10MM
39	P0609039	LOCK HANDLE
40	PSS03M	SET SCREW M6-1 X 8
41	P0609041	ECCENTRIC BUSHING
42	P0609042	SHAFT
42-1	P0609042-1	LEFT TORSION SPRING
42-2	P0609042-2	RIGHT TORSION SPRING
43	P0609043	STOP BLOCK
44	PR21M	INT RETAINING RING 35MM
45	P0609045	SHAFT

REF	PART #	DESCRIPTION
46	PLW06M	LOCK WASHER 10MM
47	PB32M	HEX BOLT M10-1.5 X 25
48	P0609048	BUSHING
49	P0609049	WORM GEAR
50	PK12M	KEY 5 X 5 X 30
51	P0609051	GEAR
52	P0609052	WORM
53	PK37M	KEY 4 X 4 X 16
54	P0609054	SLIDE STOP BLOCK
55	P0609055	SLIDE STOP BLOCK
55-1	PSS16M	SET SCREW M8-1.25 X 10
56	P0609056	SPECIAL FLAT SCREW
57	P0609057	POINTER
58	PW02M	FLAT WASHER 5MM
59	PS09M	PHLP HD SCR M5-.8 X 10
60	PB73M	HEX BOLT M10-1.5 X 50
61	P0609061	CLAMP BLOCK
62	PLW06M	LOCK WASHER 10MM
63	PW04M	FLAT WASHER 10MM
64	P0609064	CLAMPING BLOCK
65	P0609065	CLAMP PLATE
66	PHTEK4M	TAP SCREW M4 X 8
67	P0609067	STOP BUTTON
68	P0609068	START BUTTON
69	P0609069	SWITCH BOX
70	PFS16M	FLANGE SCREW M8-1.25 X 16
71	P0609071	SWITCH BOX BRACKET
72	PB32M	HEX BOLT M10-1.5 X 25
73	PLW06M	LOCK WASHER 10MM
74	PW04M	FLAT WASHER 10MM
75	P0609075	BUTTON PLATE
76	P0609076	BALL STRAIN RELIEF
77	PAW10M	HEX WRENCH 10MM
78	PAW08M	HEX WRENCH 8MM
79	PAW03M	HEX WRENCH 3MM
80	PWR1719	WRENCH 17 X 19
81	PWR1214	COMBO WRENCH 12/14MM
82	PWR1012	COMBO WRENCH 10/12MM
83	P0609083	T-HANDLE WRENCH 4MM
84	P0609084	BUSHING
85	P6202	BALL BEARING 6202ZZ
86	PB06M	HEX BOLT M8-1.25 X 12
87	PW03M	FLAT WASHER 6MM
88	PB02M	HEX BOLT M6-1 X 12

Table Assembly Parts Breakdown

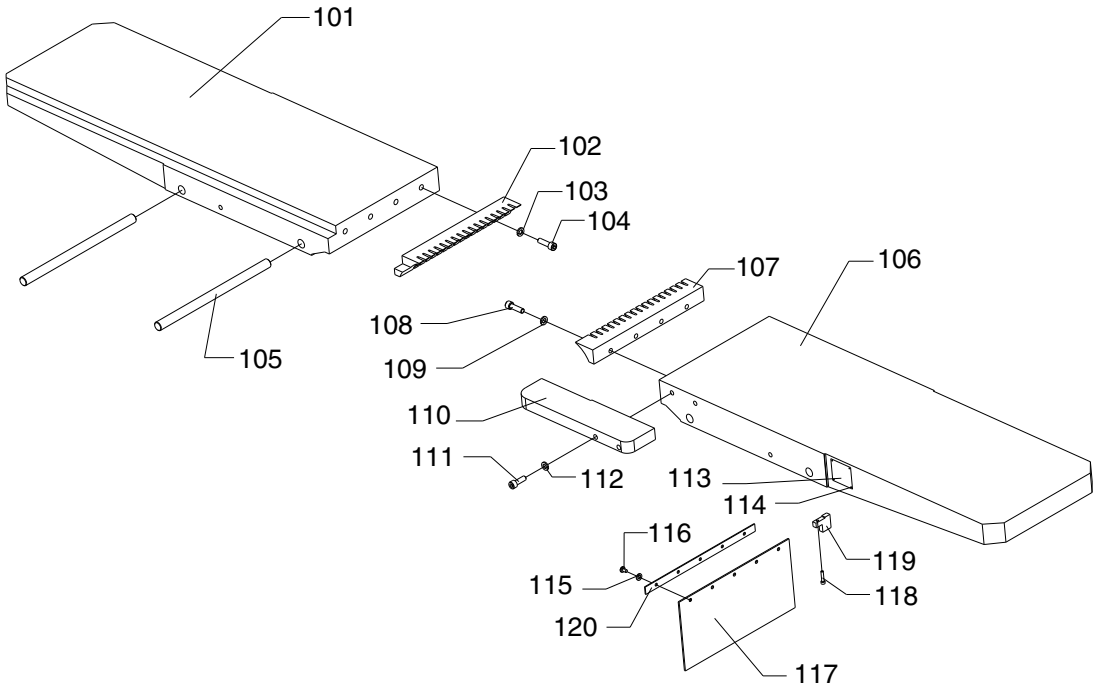
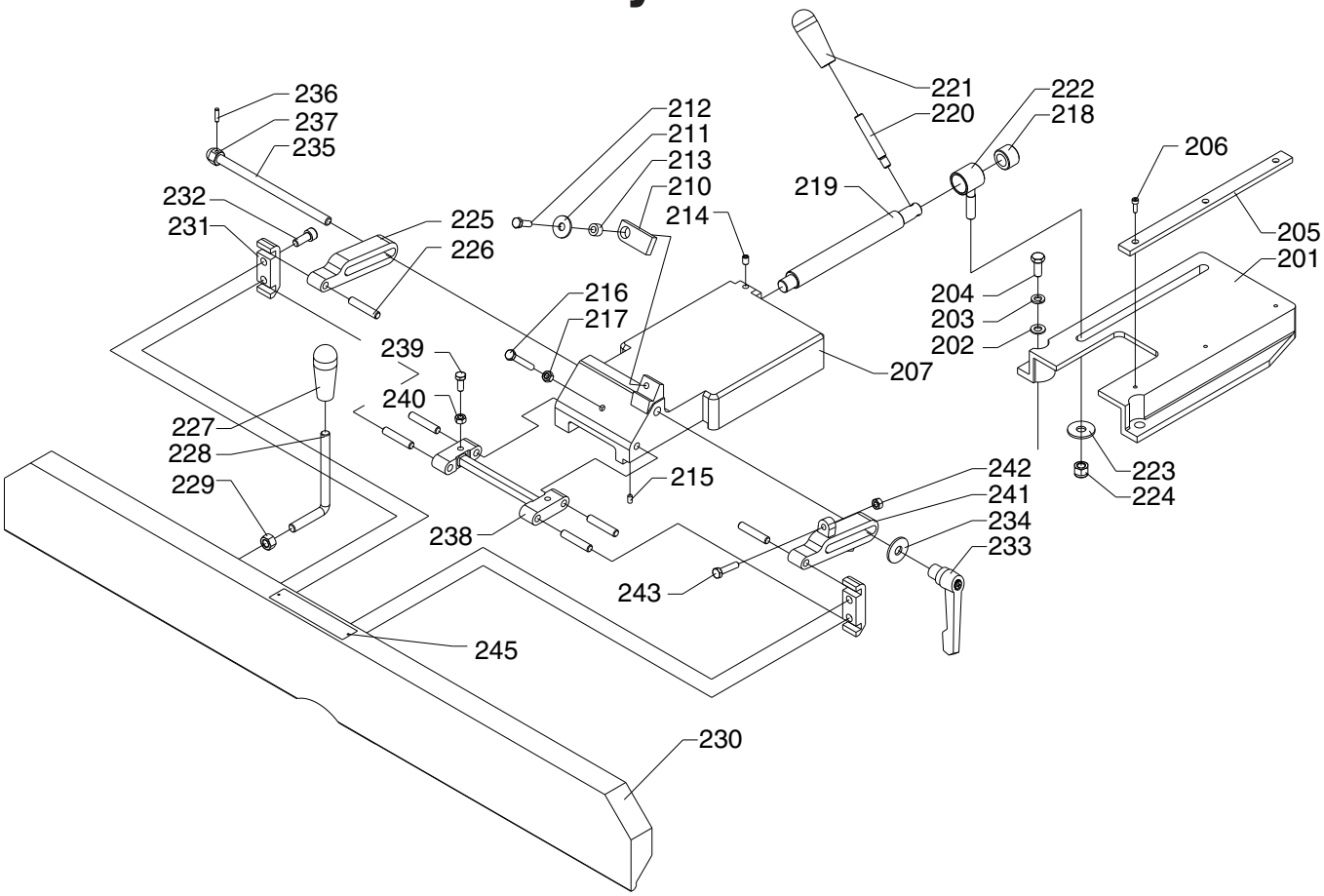


Table Parts List

REF	PART #	DESCRIPTION
101	P0609101	TABLE (LEFT)
102	P0609102	TABLE LIP (LEFT)
103	PLW06M	LOCK WASHER 10MM
104	PSB84M	CAP SCREW M10-1.5 X 35
105	P0609105	SHAFT
106	P0609106	TABLE (RIGHT)
107	P0609107	TABLE LIP (RIGHT)
108	PSB84M	CAP SCREW M10-1.5 X 35
109	PLW06M	LOCK WASHER 10MM
110	P0609110	RABBETING ARM

REF	PART #	DESCRIPTION
111	PSB72M	CAP SCREW M10-1.5 X 30
112	PLW06M	LOCK WASHER 10MM
113	P0609113	DEPTH SCALE
114	P0609114	RIVET 2 X 4
115	PW03M	FLAT WASHER 6MM
116	P0609116	CAP SCREW M6-1.0 X10
117	P0609117	DUST DEFLECTOR
118	PSB38M	CAP SCREW M5-.8 X 25
119	P0609119	STOP BLOCK
120	P0609120	BAR

Fence Assembly Parts Breakdown

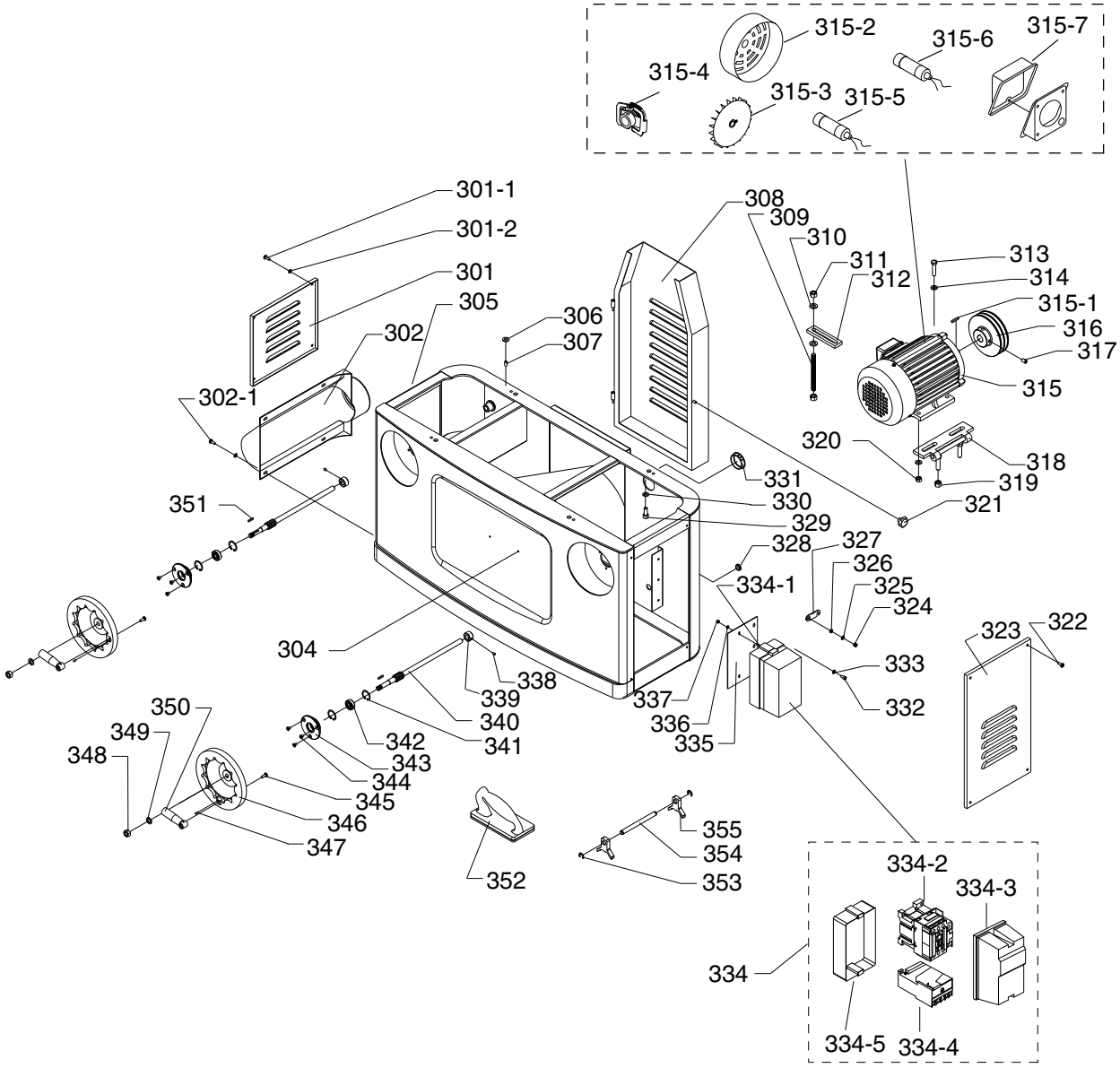


Fence Parts List

REF	PART #	DESCRIPTION
201	P0609201	FENCE BRACKET
202	PW06M	FLAT WASHER 12MM
203	PLW05M	LOCK WASHER 12MM
204	PSB77M	CAP SCREW M12-1.75 X 30
205	P0609205	SLIDING RAIL
206	PSB20M	CAP SCREW M5-.8 X 14
207	P0609207	SLIDING BRACKET
210	P0609210	BLOCK
211	PW01M	FLAT WASHER 8MM
212	PB07M	HEX BOLT M8-1.25 X 25
213	P0609213	COLLAR
214	PSS14M	SET SCREW M8-1.25 X 12
215	PSS04M	SET SCREW M6-1 X 12
216	PB30M	HEX BOLT M8-1.25 X 55
217	PN03M	HEX NUT M8-1.25
218	P0609218	COLLAR
219	P0609219	ECCENTRIC SHAFT
220	P0609220	HANDLE ROD
221	P0609221	HANDLE
222	P0609222	SLIDING BUSHING ASSY
223	PW06M	FLAT WASHER 12MM

REF	PART #	DESCRIPTION
224	P0609224	SPECIAL HEX NUT M12
225	P0609225	LEFT BRACKET
226	P0609226	PIN
227	P0609227	HANDLE
228	P0609228	HANDLE ROD
229	PN09M	HEX NUT M12-1.75
230	P0609230	FENCE
231	P0609231	CLAMP
232	PSB64M	CAP SCREW M10-1.5 X 25
233	P0609233	LOCK LEVER ASSY
234	P0609234	SPECIAL FLAT WASHER
235	P0609235	DOUBLE END THREADED ROD
236	P0609236	ROLL PIN 5 X 20
237	P0609237	M12 SPECIAL NUT
238	P0609238	SUPPORT BRACKET
239	PB09M	HEX BOLT M8-1.25 x 20
240	PN03M	HEX NUT M8-1.25
241	P0609241	RIGHT BRACKET
242	PN03M	HEX NUT M8-1.25
243	PB20M	HEX BOLT M8-1.25 X 35
245	P0609245	RIVET 2 X 5

Stand Assembly Parts Breakdown

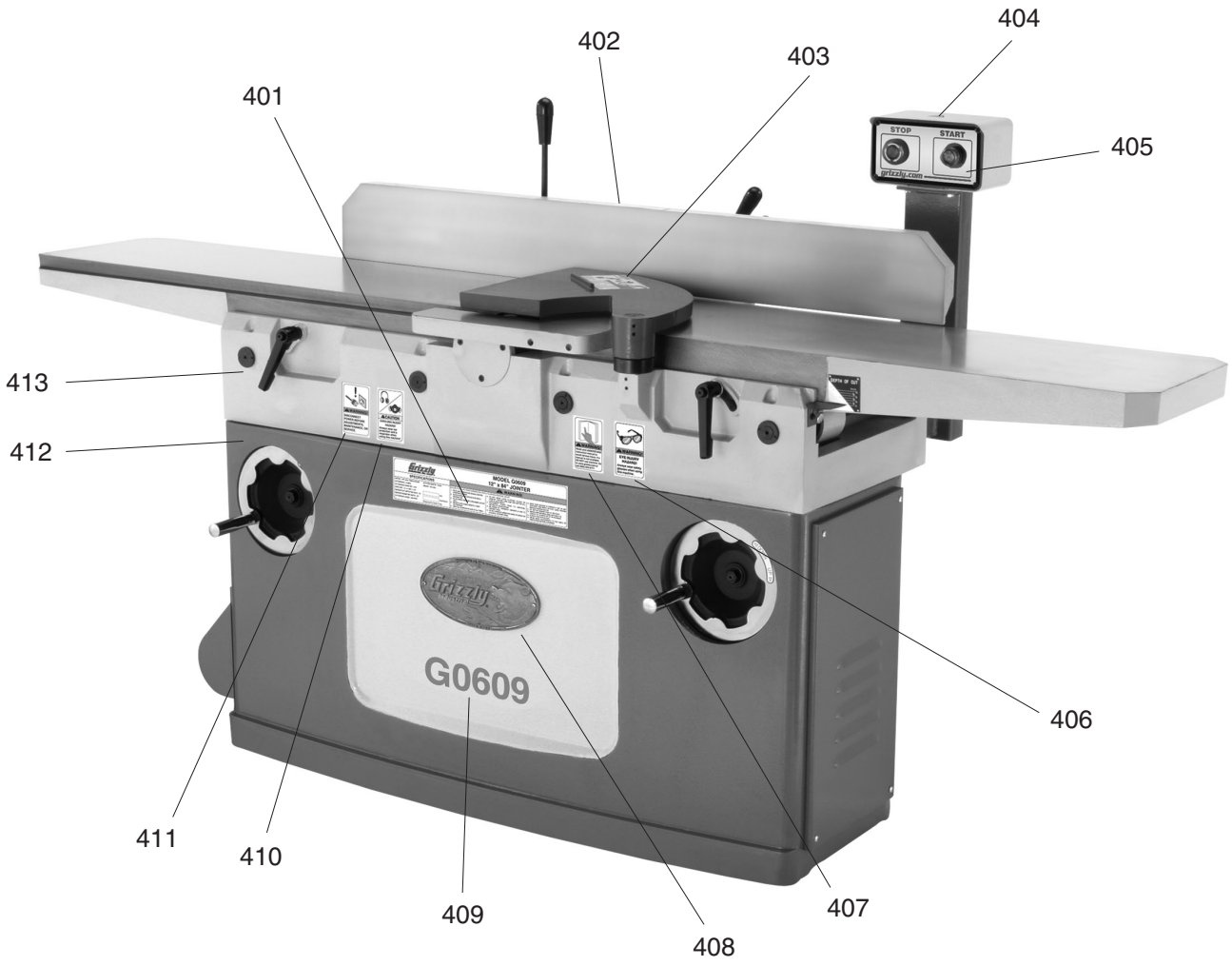


Stand Parts List

REF	PART #	DESCRIPTION
301	P0609301	LEFT ACCESS DOOR
301-1	PSBS18M	BUTTON HD CAP SCR M6-1 X 18
301-2	PW03M	FLAT WASHER 6MM
302	P0609302	DUST HOOD
302-1	PSBS11M	BUTTON HD CAP SCR M6-1 X 10
304	PHTEK4M	TAP SCREW M4 X 8
305	P0609305	CABINET
306	P0609306	RUBBER WASHER 8MM
307	PSS80M	SET SCREW M8-1.25 X 15
308	P0609308	PULLEY COVER
309	P0609309	TENSION ROD
310	PW06M	FLAT WASHER 12MM
311	PN09M	HEX NUT M12-1.75
312	P0609312	TENSION PLATE
313	PB116M	HEX BOLT M10-1.5 X 45
314	PW04M	FLAT WASHER 10MM
315	P0609315	MOTOR
315-1	PK33M	KEY 5 X 5 X 45
315-2	P0609315-2	MOTOR FAN COVER
315-3	P0609315-3	MOTOR FAN
315-4	P0609315-4	CENTRIFUGAL SWITCH
315-5	P0609315-5	START CAPACITOR 500MFD 125VAC
315-6	P0609315-6	RUN CAPACITOR 20MFD 250VAC
315-7	P0609315-7	JUNCTION BOX
316	P0609316	MOTOR PULLEY
317	PSS75M	SET SCREW M10-1.5 X 16
318	P0609318	MOTOR BRACKET
319	PN09M	HEX NUT M12-1.75
320	PN02M	HEX NUT M10-1.5
321	P0609321	PULLEY COVER LOCK KNOB
322	PSBS18M	BUTTON HD CAP SCR M6-1 X 18
323	P0609323	RIGHT ACCESS DOOR
324	P0609324	SPECIAL HEX NUT M6
325	PW03M	FLAT WASHER 6MM
326	P0609326	ADAPTOR

REF	PART #	DESCRIPTION
327	P0609327	LATCH
328	P0609328	SMALL STRAIN RELIEF
329	PSB88M	CAP SCREW M10-1.25 X 25
330	PLW06M	LOCK WASHER 10MM
331	P0609331	BIG STRAIN RELIEF
332	PSB04M	CAP SCREW M6-1 X 10
333	PW03M	FLAT WASHER 6MM
334	P0609334	MAGNETIC SWITCH
334-1	PS06M	PHLP HD SCR M5-.8 x 20
334-2	P0609334-2	CONTACTOR
334-3	P0609334-3	MAG SWITCH FRONT COVER
334-4	P0609334-4	THERMAL OVERLOAD RELAY
334-5	P0609334-5	MAG SWITCH BACK COVER
335	P0609335	SWITCH PLATE
336	PW02M	FLAT WASHER 5MM
337	PN06M	HEX NUT M5-.8
338	PSS03M	SET SCREW M6-1 X 8
339	P0609339	COLLAR
340	P0609340	SPIRAL GEAR SHAFT
341	PR29M	INT RETAINING RING 32MM
342	P6201	BALL BEARING 6201ZZ
343	P0609343	BEARING SUPPORT
344	PFH04M	FLAT HD SCR M6-1 X 8
345	PFS14M	FLANGE SCREW M6-1 X 16
346	P0609346	HANDWHEEL
347	PRP78M	ROLL PIN 4 X 10
348	PN09M	HEX NUT M12-1.75
349	PW06M	FLAT WASHER 12MM
350	P0609350	FOLDING HANDLE
351	PK34M	KEY 5 X 5 X 20
352	P0609352	PUSH BLOCK
353	PR39M	EXT RETAINING RING 8MM
354	P0609354	KNIFE GAUGE ROD
355	P0609355	KNIFE GAUGE BLOCK

Warning Label Parts List



REF	PART #	DESCRIPTION
401	P0609401	MACHINE ID LABEL
402	P0609402	CUTTERHEAD WARNING LABEL
403	P0609403	CUTTERHEAD GUARD WARNING LABEL
404	PLABEL-14	ELECTRICITY LABEL
405	P0609405	CONTROL PANEL FACE
406	PLABEL-11	SAFETY GLASSES LABEL
407	PLABEL-12A	READ MANUAL LABEL

REF	PART #	DESCRIPTION
408	G8589	GRIZZLY NAME PLATE-LARGE
409	P0609409	MODEL NUMBER LABEL
410	P0609410	RESPIRATOR-HEARING LABEL
411	P0609411	UNPLUG POWER 220V LABEL
412	PPAINT-1	GRIZZLY GREEN PAINT
413	PPAINT-11	PUTTY TOUCH UP PAINT

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

WARRANTY AND 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.

To take advantage of 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.

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.

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.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Modeltec
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE