

# *Grizzly* **Industrial, Inc.** ®

## **MODEL G0455/G0480 10" EXTREME SERIES JOINTER OWNER'S MANUAL**



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# 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 chemical 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.

## 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](http://www.grizzly.com) to order new labels.

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# INTRODUCTION

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## Foreword

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We are proud to offer the Model G0455/G0480 10" Extreme Series 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 G0455/G0480. 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 G0455/G0480 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](http://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

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

Grizzly Industrial, Inc.  
% Technical Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069

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](mailto: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 G0455 10" EXTREME SERIES JOINTER

Design Type:..... Cabinet

### Overall Dimensions:

Table Size ..... 11" W x 84" L  
 Height (from floor to table) ..... 32 $\frac{5}{8}$ "  
 Overall Length ..... 84"  
 Overall Width ..... 31"  
 Overall Height ..... 44"  
 Net Weight ..... 896 lbs.  
 Shipping Weight ..... 1034 lbs.  
 Shipping Box Size ..... 91"L x 31 $\frac{1}{2}$ "W x 41"  
 Stand Footprint ..... 44" W x 21" D  
 Cutterhead Diameter ..... 3 $\frac{1}{16}$ "

### Capacities:

Maximum Rabbeting Capacity .....  $\frac{1}{2}$ "  
 Maximum Depth of Cut (per pass) .....  $\frac{1}{8}$ "  
 Maximum Width of Cut ..... 10"  
 Cutterhead Speed ..... 5000 RPM  
 Cuts Per Minute ..... 20,000

### Construction:

Tables ..... Independently Adjustable, Precision Ground Cast Iron  
 Ways ..... Dovetailed, Adjustable  
 Fence Assembly ..... Cast Iron  
 Body Assembly ..... Cast Iron  
 Stand ..... Cast Iron  
 Cutterhead ..... 4 Knife  
 Cutterhead Size ..... 3 $\frac{1}{16}$ "  
 Knife Size ..... 10" L x  $\frac{3}{4}$ " W x  $\frac{1}{8}$ " T  
 Knife Adjustment ..... Spring or Jack Screw  
 Guard ..... Die Cast Metal  
 Bearings ..... Shielded and Lubricated

### Motor:

Type ..... TEFC Capacitor Start Induction  
 Horsepower ..... 3 HP  
 Phase / Voltage ..... Single-Phase 220V  
 Amps ..... 18A  
 Cycle / RPM ..... 60 Hertz / 3450 RPM  
 Switch ..... Magnetic w/Thermal Overload Protection  
 Power Transfer ..... Triple V-Belt Drive  
 Bearings ..... Shielded & Lubricated Ball Bearings

### Features:

..... Top Mount Switch Controls  
 ..... Super Long 84" Bed  
 ..... Wide-Angle Cabinet Design Provides Rock Solid Stability  
 ..... Included 4" Dust Port

*Specifications, while deemed accurate, are not guaranteed.*





# MACHINE DATA SHEET

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

## MODEL G0480 SPIRAL CUTTERHEAD 10" EXTREME SERIES JOINTER

**Design Type:**..... Cabinet

**Overall Dimensions:**

Table Size ..... 11" W x 84" L  
 Height (from floor to table) ..... 32<sup>9</sup>/<sub>16</sub>"  
 Overall Length ..... 84"  
 Overall Width ..... 31"  
 Overall Height ..... 44"  
 Net Weight ..... 896 lbs.  
 Shipping Weight ..... 1034 lbs.  
 Shipping Box Size ..... 91" L x 31<sup>1</sup>/<sub>2</sub>" W x 41"  
 Stand Footprint ..... 44" W x 21" D  
 Cutterhead Diameter ..... 3<sup>1</sup>/<sub>16</sub>"

**Capacities:**

Maximum Rabbeting Capacity ..... 1/2"  
 Maximum Depth of Cut (per pass) ..... 5/64"  
 Maximum Width of Cut ..... 10"  
 Cutterhead Speed ..... 5000 RPM  
 Cuts Per Minute ..... 20,000 (Effective)

**Construction:**

Tables ..... Independently Adjustable, Precision Ground Cast Iron  
 Ways ..... Dovetailed, Adjustable  
 Fence Assembly ..... Cast Iron  
 Body Assembly ..... Cast Iron  
 Stand ..... Cast Iron  
 Cutterhead ..... Spiral w/Indexable Carbide Inserts  
 Cutterhead Size ..... 3<sup>1</sup>/<sub>16</sub>"  
 Number of Carbide Inserts ..... 48  
 Guard ..... Die Cast Metal  
 Bearings ..... Shielded and Lubricated

**Motor:**

Type ..... TEFC Capacitor Start Induction  
 Horsepower ..... 3 HP  
 Phase / Voltage ..... Single-Phase 220V  
 Amps ..... 18A  
 Cycle / RPM ..... 60 Hertz / 3450 RPM  
 Switch ..... Magnetic w/Thermal Overload Protection  
 Power Transfer ..... Triple V-Belt Drive  
 Bearings ..... Shielded & Lubricated Ball Bearings

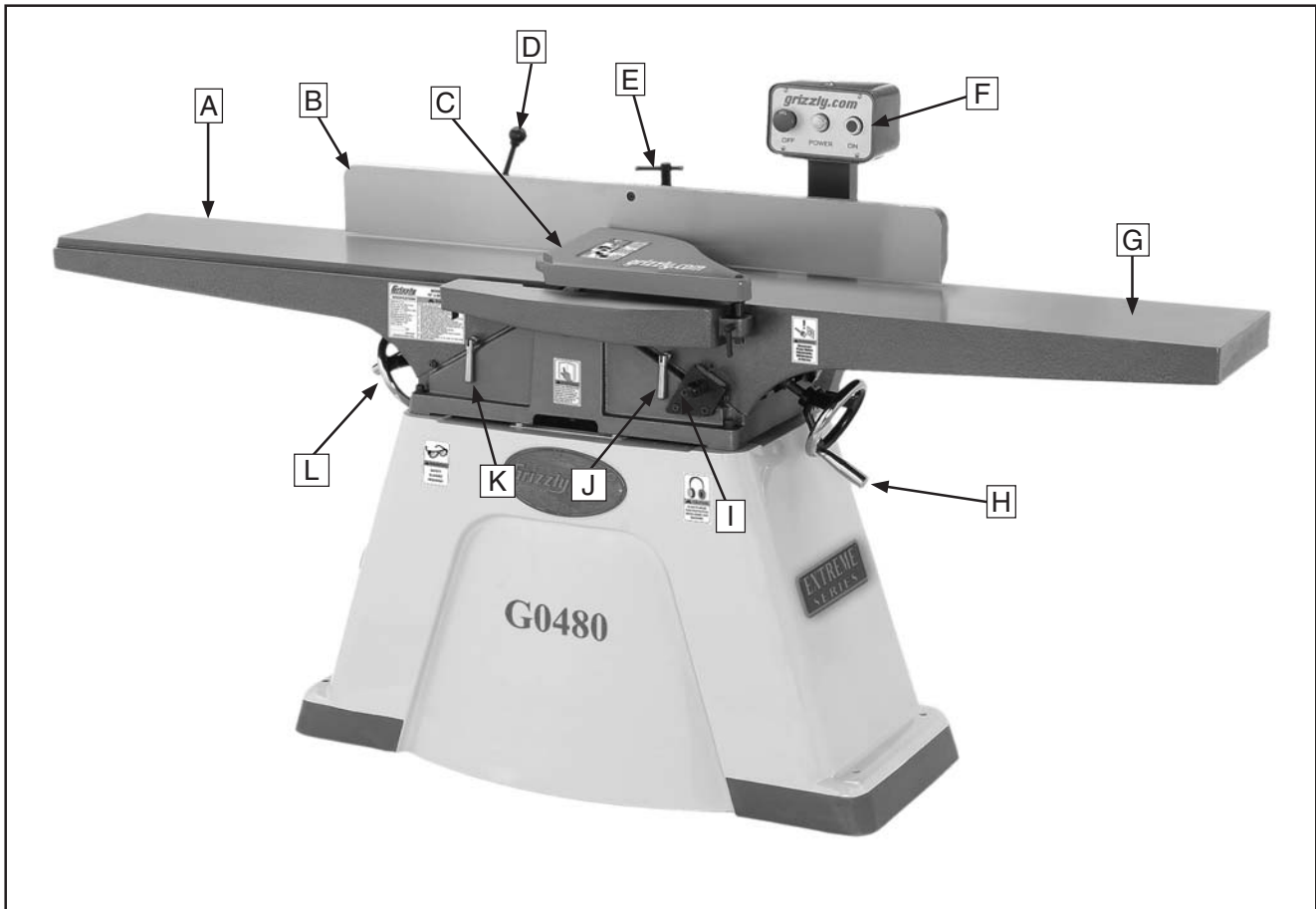
**Features:**

..... Top Mount Switch Controls  
 ..... Super Long 84" Bed  
 ..... Wide-Angle Cabinet Design Provides Rock Solid Stability  
 ..... Included 4" Dust Port

*Specifications, while deemed accurate, are not guaranteed.*



# Identification



- A. Outfeed Table
- B. Fence
- C. Cutterhead Guard
- D. Fence Tilt Handle
- E. Fence Lock
- F. Control Panel
- G. Infeed Table
- H. Infeed Table Handwheel
- I. Depth Scale with Indexing Stop
- J. Infeed Table Lock
- K. Outfeed Table Lock
- L. Outfeed Table Handwheel





# 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 AN ANSI 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 WOODS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to and always wear an approved respirator.



# **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 top edges of the knives at top dead center (TDC) to reduce chance of 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  $\frac{1}{8}$ " for the Model G0455 and  $\frac{5}{64}$ " for the Model G0480. 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 the Model G0455/G0480. 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 motor on the Model G0455/G0480 will draw the following amps at maximum load:

Motor Load at 220V ..... 18 Amps

### Circuit Requirements

We recommend connecting this machine to a dedicated circuit with a verified ground, using the circuit breaker size given below. Never replace a circuit breaker 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, you may create a fire hazard—consult a qualified electrician to reduce this risk.**

220V Circuit Breaker ..... 20 Amps

### Plug/Receptacle Type

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

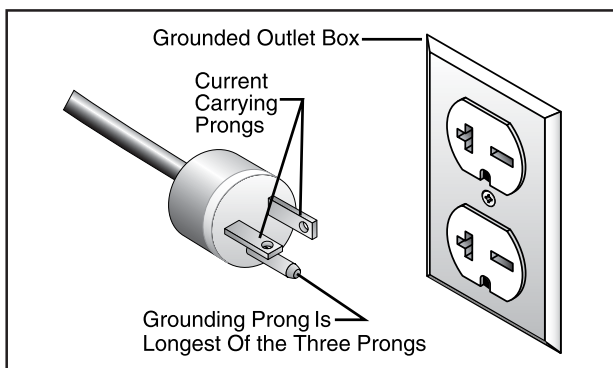
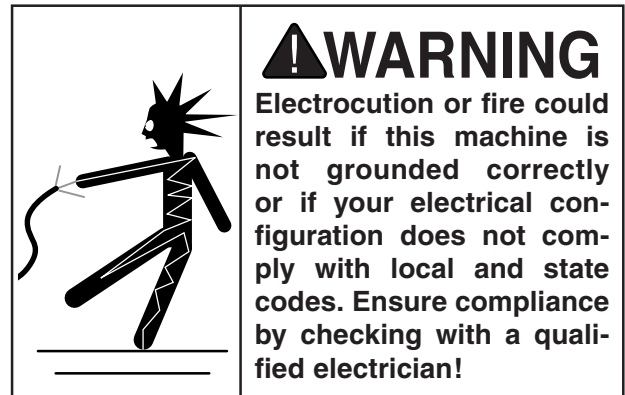


Figure 1. NEMA 6-20 plug and receptacle.

### Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which 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.



### 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.

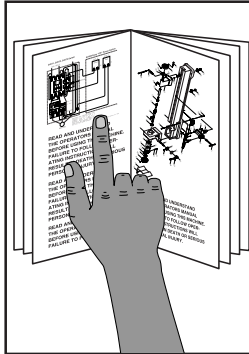
If you find it absolutely necessary to use an extension cord at 220V with your machine:

- Use at least a 10 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.



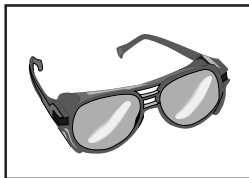
# SECTION 3: SET UP

## Set Up Safety



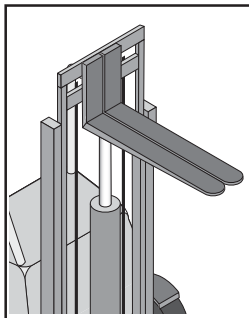
### **!WARNING**

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 G0455/G0480 is a very heavy machine that can cause serious injury if moved without mechanical or power lifting equipment, such as a forklift or hoist.

## 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
• Straightedge (see <b>Page 25</b> ) .....	1
• Phillips Head Screwdriver #2 .....	1
• Wrench 1/2" or 13mm .....	1
• Wrench 19mm .....	1
• Lifting Equipment (Forklift or Hoist).....	1
• An Assistant .....	1

## Unpacking

The Model G0455/G0480 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 crate, you should have the following items:

<b>Common Components (Figure 2)</b>		<b>Qty</b>
<b>A.</b>	Jointer Assembly .....	1
<b>B.</b>	Fence Assembly .....	1
<b>C.</b>	Cutterhead Guard Assembly .....	1
<b>D.</b>	Push Blocks .....	2
<b>E.</b>	Fence Lock Hardware Bag .....	1
	—Fence Lock Handle .....	1
	—Flat Washer 1/2" .....	1
	—Fence Lock Nut .....	1
<b>F.</b>	Tool Bag .....	1
	—Hex Wrench 5mm .....	1
	—Open End Wrench 12 x 14mm .....	1

## G0455 ONLY

### Knife Setting Jig Hardware (Figure 3)

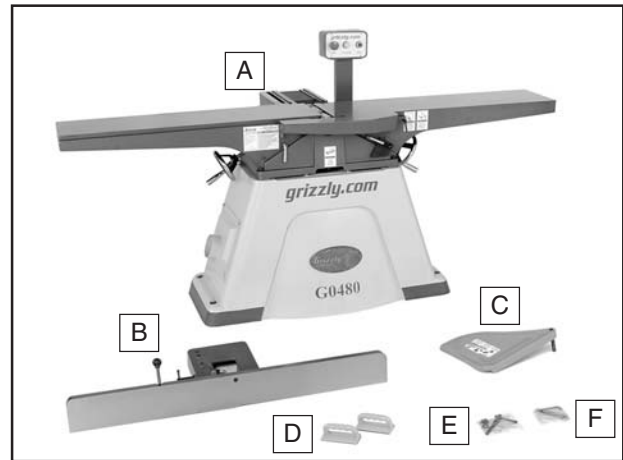
- Knife Setting Jig Rod .....
- Knife Setting Jig Foot .....
- E-Clip .....
- Open End Wrench 8 x 10mm .....

## G0480 ONLY

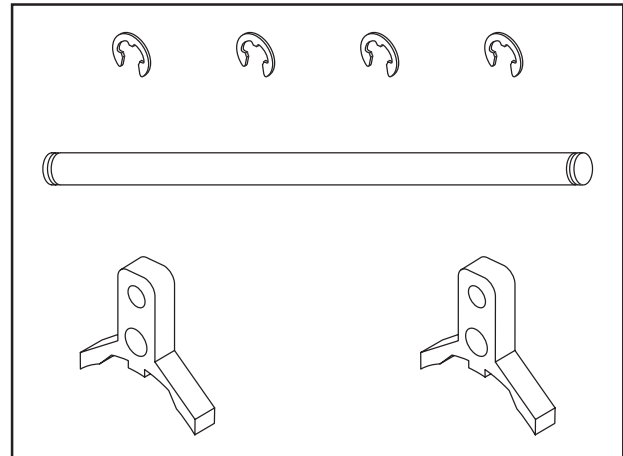
### Spiral Cutterhead Hardware (Figure 4)

- Torx Screw Driver T-Handle 6mm .....
- Torx Bits T-20 .....
- Carbide Inserts .....
- Flat-Head Torx Screws .....

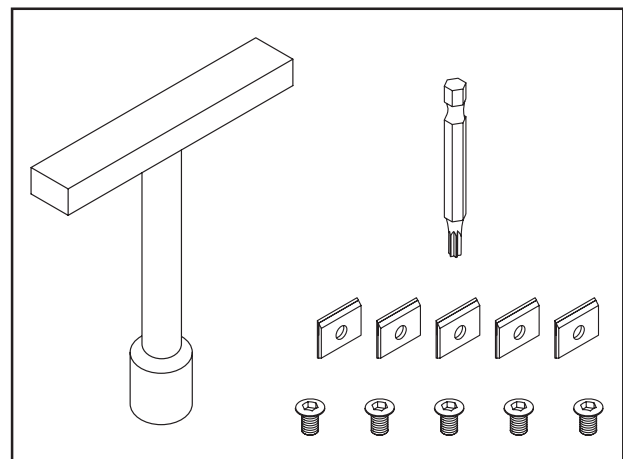
In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



**Figure 2.** Jointer components common to both models.



**Figure 3.** G0455 knife setting jig hardware.




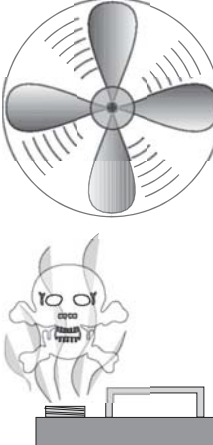
**Figure 4.** G0480 spiral cutterhead hardware.



# 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.

	<p><b>! WARNING</b> Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. <b>DO NOT</b> use gasoline or petroleum products to clean the machinery.</p>
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	<p><b>! CAUTION</b> 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.</p>
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# Site Considerations

## Floor Load

The Model G0455/G0480 is a very heavy machine. Refer to the **Machine Data Sheet** for the weight load and footprint size. Concrete floors are suitable for your machine; however, wood-built floors may require additional reinforcement to support both the machine and operator.

## Working Clearances

Consider the jointer dimensions and 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 jointer. See **Figure 5** for the Model G0455/G0480 overhead dimensions.

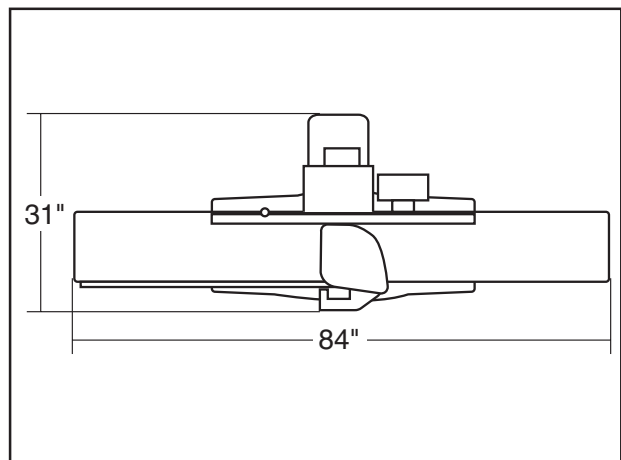
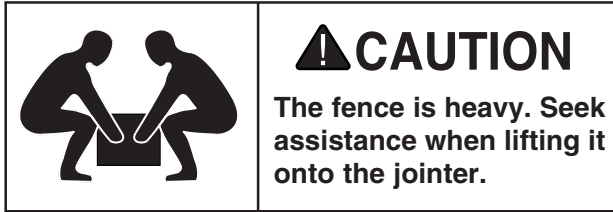


Figure 5. Model G0455/G0480 overhead dimensions.

	<p><b>! CAUTION</b> 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 <b>DO NOT</b> allow unsupervised children or visitors in your shop at any time!</p>
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# Installing Fence Assembly



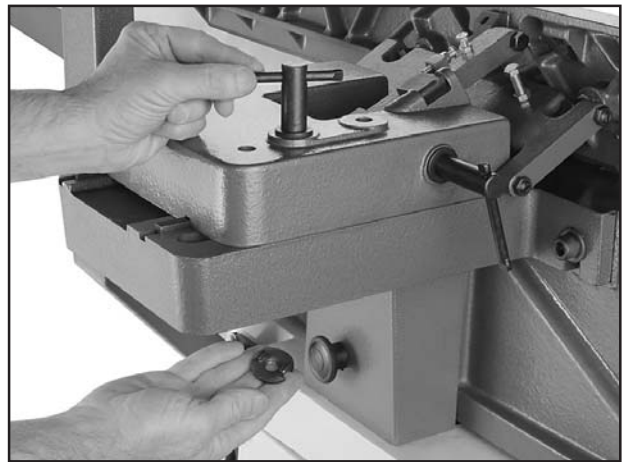
Make sure the underside of the fence and top of the table have been thoroughly cleaned of all the export grease before installing the fence, or the fence will not slide easily and will get quickly gummed up when exposed to sawdust.

The fence has two keyway slots built into the underside of it that fit over the keys on the table. These keys keep the fence perpendicular to the cutterhead during adjustments.

Components and Hardware Needed:	Qty
Fence Assembly .....	1
Fence Lock Handle .....	1
Flat Washer 1/2" .....	1
Fence Lock Nut .....	1

## To install the fence:

1. Have another person help you lift the fence onto the jointer table.
2. Position the fence keyway slots over the keys on the jointer, so the fence sits firmly against the table.
3. Lock the fence to the table with the lock handle, washer, and lock nut, as shown in **Figure 6**, making sure to keep the tabs on the lock nut facing up during installation.



**Figure 6.** Securing the fence to the jointer table.



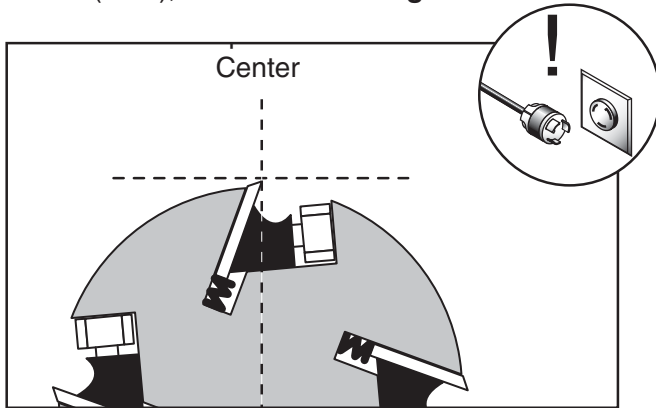


# Setting Outfeed Table Height

The outfeed table **MUST** be level with the knives or carbide inserts when they are at top-dead-center, or you cannot safely operate the jointer.

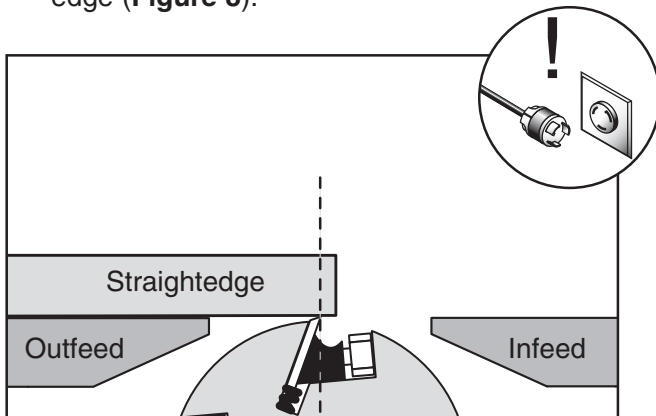
## To set the outfeed table height:

1. Place a straightedge on the outfeed table so it extends over the cutterhead.
2. Rotate the cutterhead pulley until one of the knives (or carbide inserts) is at top-dead-center (TDC), as illustrated in **Figure 7**.



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

3. Raise or lower the outfeed table until the knife (or carbide insert) just touches the straightedge (**Figure 8**).



**Figure 8.** Using a straightedge to align outfeed table height with knife at TDC.

4. Lock the outfeed table. (Refer to **Identification on Page 6** to locate the lock handle.)

# Cutterhead Guard

## ⚠ CAUTION

The cutterhead guard is a critical safety feature on this machine. A torsion spring is mounted on the cutterhead guard shaft to help it return to its proper position over the cutterhead after a cutting operation. This torsion spring must have spring pressure during guard installation to work properly.

## To install the cutterhead guard:

1. Slide the guard shaft into the casting and adjust the cutterhead guard about 1/2" above the table.
2. Using a 13mm or 1/2" wrench, as shown in **Figure 9**, wind the guard shaft back a half turn, and tighten the shaft lock.



**Figure 9.** Guard mounted with spring tang in the correct position for proper return tension.

3. Test the guard by pulling it back and letting go.
  - The guard should snap back over the cutterhead without dragging across the table.
  - If the guard drags across the table, raise it until it won't drag, then tighten the shaft lock.
  - If the guard does not snap back, remove it and repeat **Steps 1 & 2**, increasing the spring tension as needed.



# Pedestal Switch

The pedestal switch is mounted sideways for shipping purposes.

### To correctly position the pedestal switch:

1. Remove it from the jointer stand.
2. Install it upright and reattach it to the jointer stand with the same hardware you removed in **Step 1**. The pedestal switch should be positioned as shown in **Figure 10**.

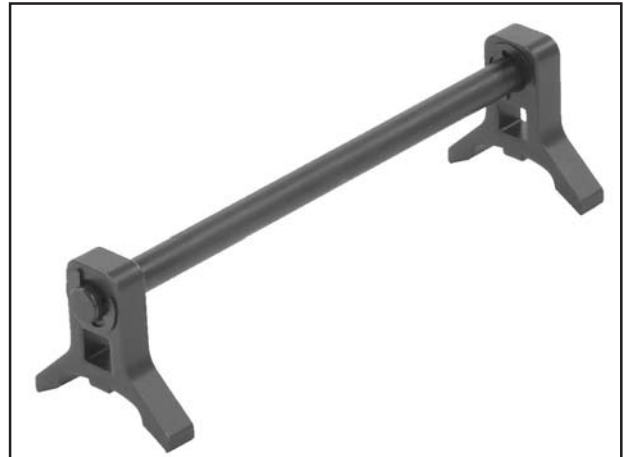


**Figure 10.** Switch positioned above the fence so it is accessible from the front.

# Knife Setting Jig

Components and Hardware Needed:	Qty
Knife Setting Jig Rod.....	1
Knife Setting Jig Foot.....	2
E-Clip.....	4

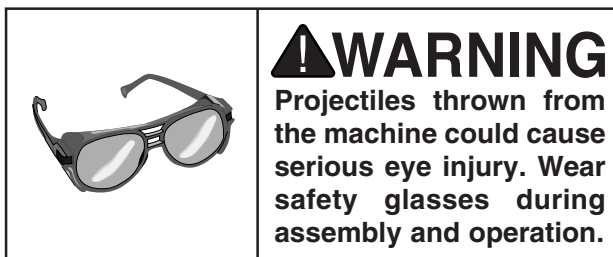
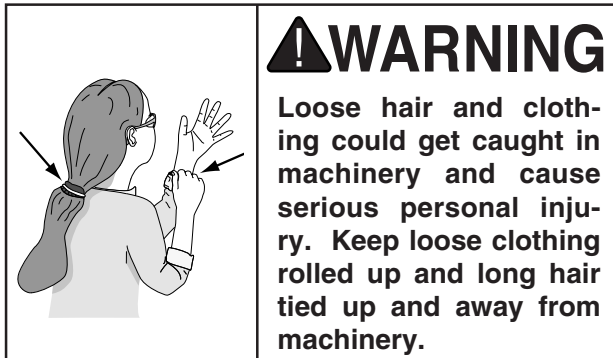
Assemble the knife setting jig as shown in **Figure 11**.



**Figure 11.** Knife setting jig assembly.



## Test Run



### Starting the machine:

1. Read the entire instruction manual.
2. Make sure the cutterhead guard is installed and correctly adjusted (**Page 15**).
3. Make sure all tools and foreign objects have been removed from the machine.
4. Review **SECTION 2: CIRCUIT REQUIREMENTS (Page 10)** and connect your machine to the power source.
5. Press the START button to turn the machine **ON**.

—The jointer should run smoothly with little or no vibration.

—Immediately stop the jointer if you suspect any problems, and refer to **Page 28** to troubleshoot/fix any problems before starting the jointer again.

## Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your jointer.

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new jointer.

Step-by-step instructions for these adjustments can be found in **SECTION 7: SERVICE**.

### Factory adjustments that should be verified:

1. Knife Settings (For G0455, **Page 30**).
2. Depth Scale Calibration (**Page 33**).
3. Fence Stop Accuracy (**Page 34**).

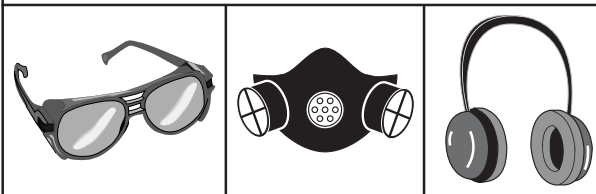


# SECTION 4: OPERATIONS

## Operation Safety

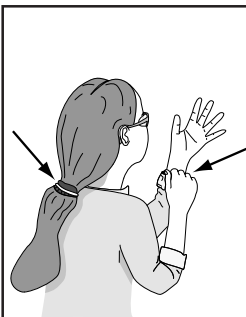
### ⚠ WARNING

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 moving parts and cause serious personal injury. Keep loose clothing and long hair away from the machine.



### NOTICE

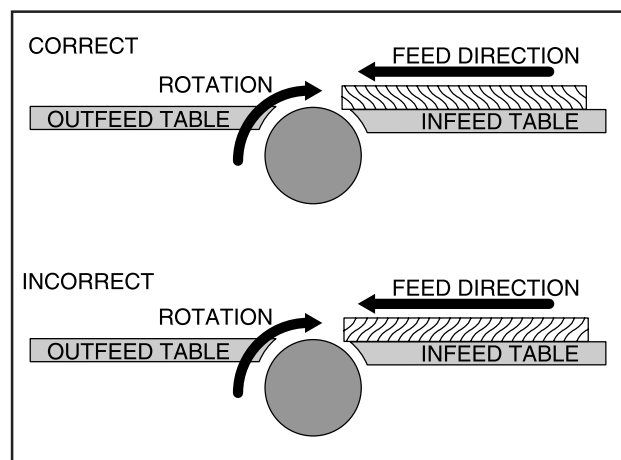
If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

## 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 from the edge (**Figure 12**).

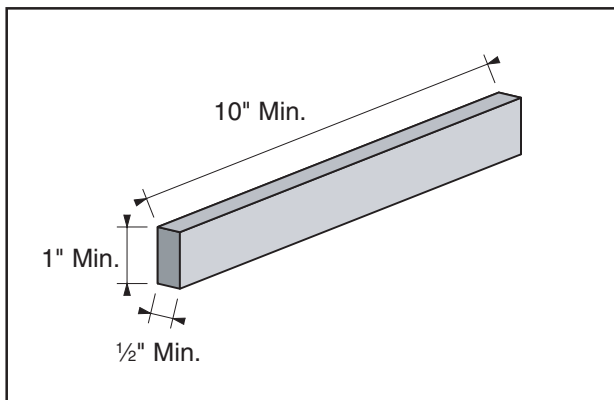
**Note:** If the grain changes direction along the edge of the board, decrease the cutting depth and make additional passes.



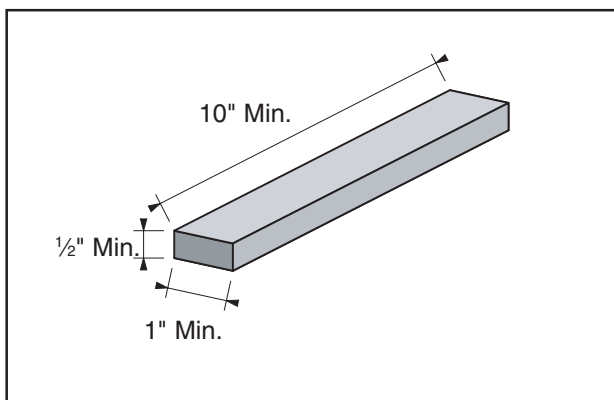
**Figure 12.** Correct and incorrect grain alignment to cutterhead.



- **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 13 & 14) before edge jointing or surface planing, or it may break or kick back during the operation!**



**Figure 13.** Minimum dimensions for edge jointing.

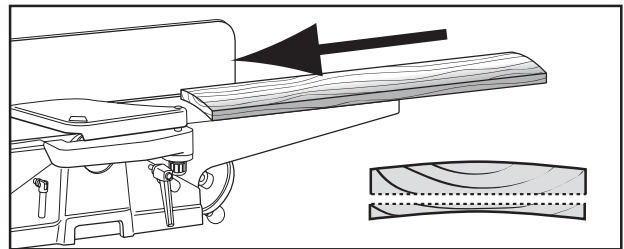


**Figure 14.** Minimum dimensions for surface planing.

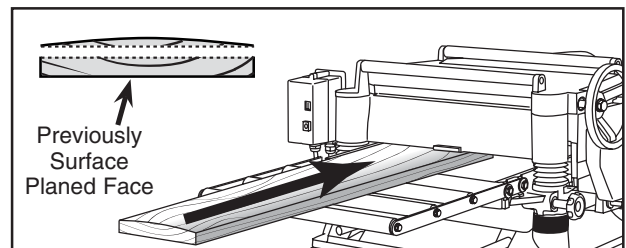
## Squaring Stock

Squaring stock involves four steps performed in the order below:

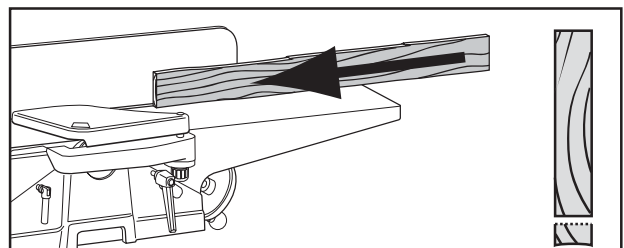
1. **Surface Plane on the Jointer**—The concave face of the workpiece is surface planed flat with the jointer.



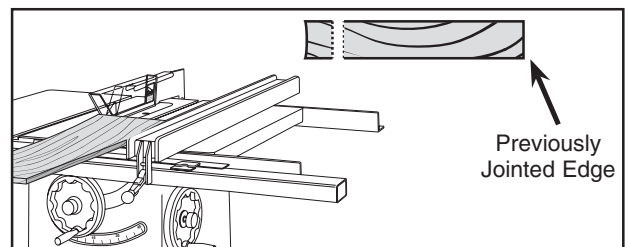
2. **Surface Plane on a Thickness Planer**—The opposite face of the workpiece is surface planed flat with a thickness planer.



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.

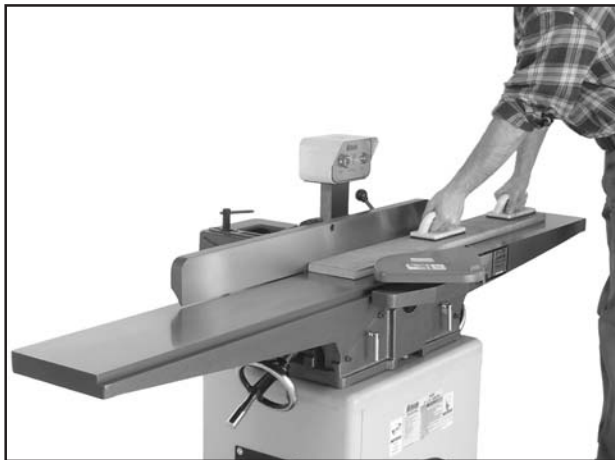


# Surface Planing

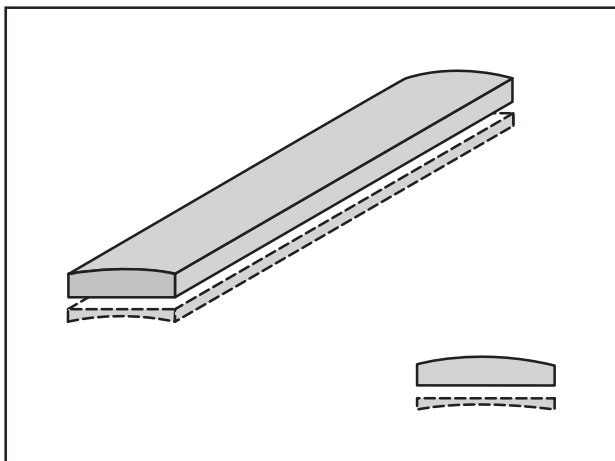
The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see **Figures 15 & 16**) to prepare it for surface planing on a thickness planer.

## 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 15.** Typical surface planing operation.



**Figure 16.** Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 18**.
3. Set the cutting depth for your operation. (We suggest  $\frac{1}{32}$ " for surface planing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure your fence is set to  $90^\circ$ .
5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.
6. Start the jointer.

## !WARNING

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 each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

**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!

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



# Edge Jointing

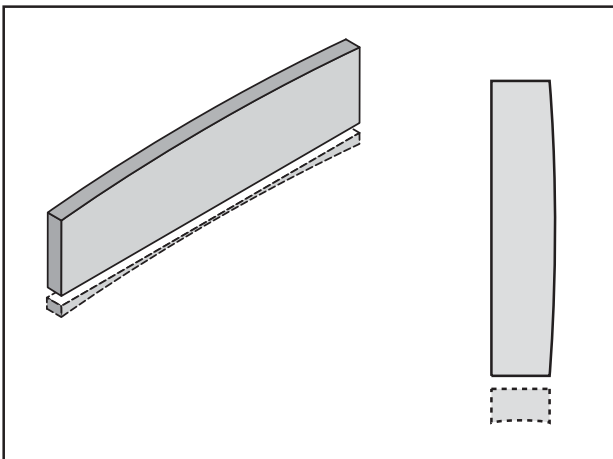
The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 17 & 18**) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

## 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 17.** Typical edge jointing operation.



**Figure 18.** Illustration of edge jointing results.

To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 18**.
3. Set the cutting depth for your operation. (We suggest between  $\frac{1}{16}$ " and  $\frac{1}{8}$ " for edge jointing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure the fence is set to  $90^\circ$ .
5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.
6. Start the jointer.
7. 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.

**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 19 & 20**).

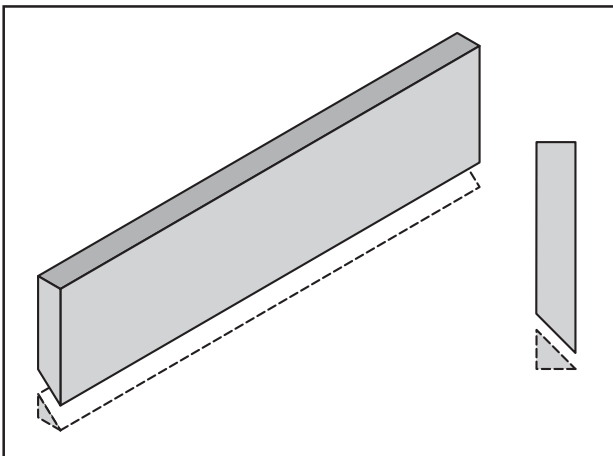
The Model G0455/G0480 has preset fence stops at 45° inward, 90°, and 45° outward (135°). If your situation requires a different angle, the preset fence stops can be easily adjusted for your needs.

## 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 19.** Typical bevel cutting operation.



**Figure 20.** Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 18**.
3. Set the cutting depth for your operation. (We suggest between  $\frac{1}{16}$ " and  $\frac{1}{8}$ " for bevel cutting, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure your fence is set to the angle of your desired cut.
5. If your workpiece is cupped (warped), place it so the concave side is face down on the surface of the infeed table.
6. Start the jointer.
7. With a push block in your leading hand, press the workpiece against the table and fence 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!*

8. Repeat **Step 7** 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 21 & 22**). 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.

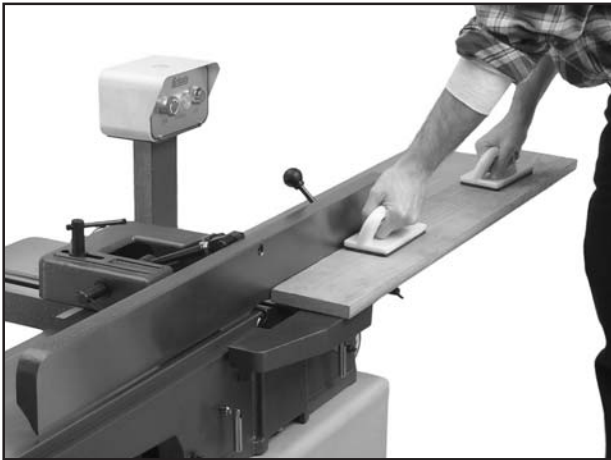


Figure 21. Typical rabbet cutting operation.

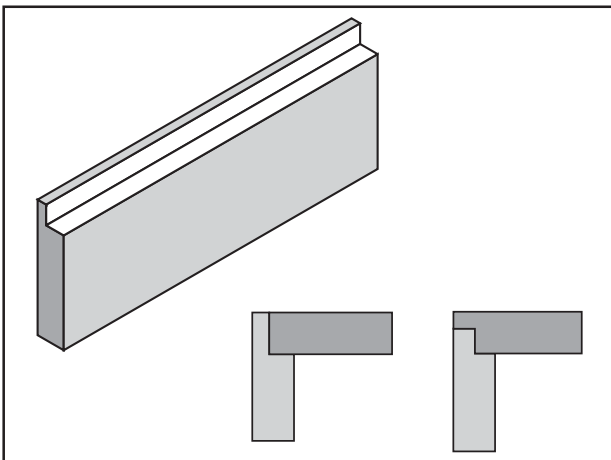


Figure 22. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 18**.
3. Set the cutting depth for your operation. (We suggest between  $\frac{1}{16}$ " and  $\frac{1}{8}$ " for rabbet cutting, using a more shallow depth for hard wood species or for wide stock.)
4. Remove the cutterhead guard.
5. Make sure your fence is moved 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  $90^\circ$ .
6. Start the jointer.
7. 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.

**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 6** until the rabbet is cut to depth.

## ⚠ WARNING

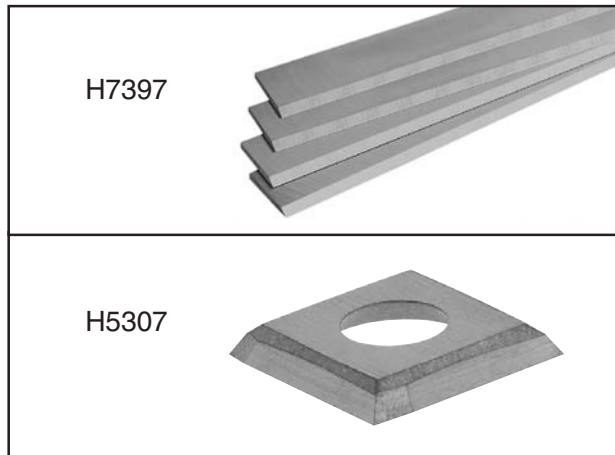
When the cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes the operator to the moving cutterhead. Always replace the cutterhead guard after rabbet cutting!



# SECTION 5: ACCESSORIES

**H7397—10" HSS Replacement Jointer Knives (Set of 4)**

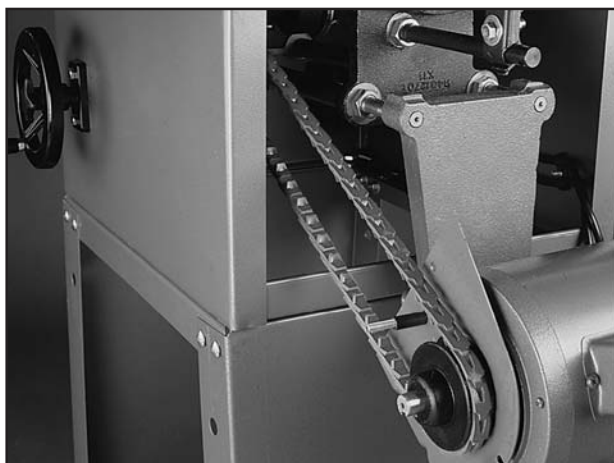
**H5307—10 Pack of Indexable Carbide Inserts for Spiral Cutterhead**



**Figure 23.** Replacement knives and inserts.

**G3639—Power Twist® V-Belt - 3/8" 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: 3/8" x 48"; replaces all "M" sized V-belts. Requires four Power Twist® V-belts to replace the stock V-belts on your Model G0455/G0480.



**Figure 24.** G3639 Power Twist® V-Belt.

**G1753—Jointer Pal® Magnetic Knife Jig (For HSS & Cobalt Knives)**

**G1756—Jointer Pal® Magnetic Knife Jig (For Carbide Knives)**

This patented magnetic knife-setting system 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 - 0.001".



**Figure 25.** G1753 Jointer Pal® Knife Jig.

**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.



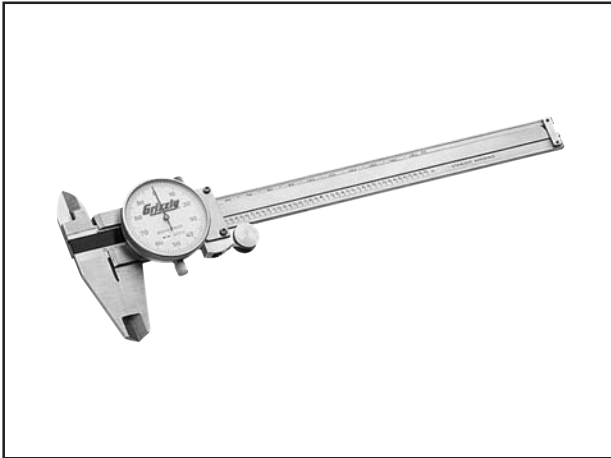
**Figure 26.** G3631 Jointer/Planer Knife Hone.

**Call 1-800-523-4777 To Order**



**G9256—6" Dial Caliper**  
**G9257—8" Dial Caliper**  
**G9258—12" Dial Caliper**

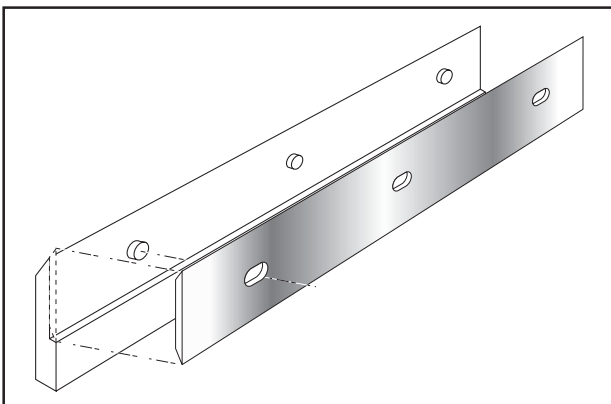
Required for jointing, planing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!



**Figure 27.** Grizzly® Dial Calipers.

**H7431—Dispoz-A-Blade® System 10" (Includes 4 Holders & Knife Inserts)**  
**H7432—Dispoz-A-Blade® Knife Inserts 10" HSS (Set of 4)**  
**H7433—Dispoz-A-Blade® Knife Inserts 10" Cobalt (Set of 4)**

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 28.** Dispoz-A-Blade® Holder and Knife.

**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 29.** 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 30.** Straightedges.

**Call 1-800-523-4777 To Order**



- 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 31. 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 32. 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 33. 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 34. Recommended products for protecting unpainted cast iron/steel parts on machinery.

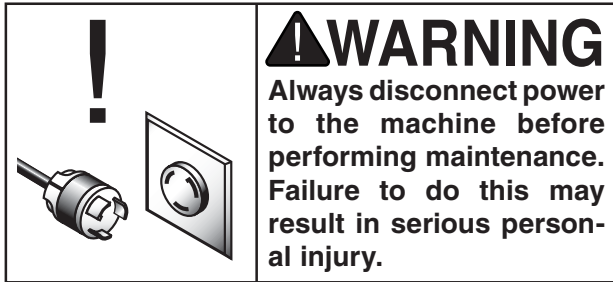
**Call 1-800-523-4777 To Order**



# SECTION 6: MAINTENANCE

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## Schedule

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

### Daily:

- Vacuum all dust on and around the machine.
- Wipe down tables and other unpainted cast iron with a metal protectant (see **Page 26**).

### Monthly Check:

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

## V-Belts

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To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition (free from cracks, fraying and wear) and properly aligned and tensioned (refer to the instructions on **Page 32**).

## Cleaning

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Cleaning the Model G0455/G0480 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.

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.

## Lubrication

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

Table ways and the fence assembly should not be lubricated. If the tables appear to be stuck, disassemble and clean any foreign materials from the ways. Re-assemble and reset the gibs.



# 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 Guide



### Motor & Machine Operation

Symptom	Possible Cause	Possible Solution
Motor will not start.	<ol style="list-style-type: none"> <li>1. Emergency stop button depressed.</li> <li>2. Low voltage.</li> <li>3. Open circuit in motor or loose connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Twist the emergency stop button to allow it to pop out.</li> <li>2. Check power line for proper voltage.</li> <li>3. Inspect all lead connections on motor for loose or open connections.</li> </ol>
Fuses or circuit breakers blow.	<ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug.</li> </ol>	<ol style="list-style-type: none"> <li>1. Repair or replace cord or plug for damaged insulation and shorted wires.</li> </ol>
Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).	<ol style="list-style-type: none"> <li>1. Power supply circuit overloaded with lights, appliances, and other motors.</li> <li>2. Undersized wires or circuits too long.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on circuit.</li> <li>2. Increase wire sizes or reduce length of the circuit.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>1. Motor overloaded during operation.</li> <li>2. Air circulation through the motor restricted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor; take lighter cuts.</li> <li>2. Clean out motor to provide normal air circulation.</li> </ol>
Motor stalls or shuts off during a cut.	<ol style="list-style-type: none"> <li>1. Motor overloaded during operation.</li> <li>2. Thermal overload protection tripped in magnetic switch.</li> <li>3. Short circuit in motor or loose connections.</li> <li>4. Circuit breaker tripped.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor; take lighter cuts.</li> <li>2. Press the "Reset" button on the thermal overload relay, located inside the magnetic switch.</li> <li>3. Repair or replace connections on motor for loose or shorted terminals or worn insulation.</li> <li>4. Install correct circuit breaker; reduce # of machines running on that circuit (circuit overload).</li> </ol>
Blade slows when cutting or makes a squealing noise, especially on start-up.	<ol style="list-style-type: none"> <li>1. V-belt loose.</li> <li>2. V-belt worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten V-belt (<b>Page 32</b>).</li> <li>2. Replace V-belt (<b>Page 32</b>).</li> </ol>
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> <li>1. Pulley setscrews or keys are missing or loose.</li> <li>2. Motor fan is hitting the cover.</li> <li>3. V-belts are damaged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect keys and setscrews. Replace or tighten if necessary.</li> <li>2. Adjust fan cover mounting position, tighten fan, or shim fan cover.</li> <li>3. Replace V-belts (<b>Page 32</b>).</li> </ol>
Vibration when running or cutting.	<ol style="list-style-type: none"> <li>1. Loose or damaged blade.</li> <li>2. Damaged V-belt.</li> <li>3. Worn cutterhead bearings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten or replace blade.</li> <li>2. Replace.</li> <li>3. Check/replace cutterhead bearings.</li> </ol>



## Table

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	1. Table lock is engaged or partially engaged. 2. Table gibs are too tight.	1. Completely loosen the table lock. 2. Re-adjust the table gibs ( <b>Page 35</b> ).
Excessive play in table movement.	1. Table gibs are too loose.	1. Re-adjust the table gibs ( <b>Page 35</b> ).

## 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 trailing end of workpiece.	1. Align outfeed table with cutterhead knife at top dead center ( <b>Page 15</b> ). 2. Reduce/eliminate downward pressure on trailing 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 ( <b>Page 15</b> ).
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 ( <b>Page 18</b> ); only use clean stock. 2. Adjust one of the nicked knives side-ways; replace knives ( <b>Page 30</b> ). 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 ( <b>Page 30</b> ).
Long lines or ridges that run along the length of the board.	1. Nicked or chipped knives.	1. Adjust one of the nicked knives side-ways; replace knives ( <b>Page 30</b> ).
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 ( <b>Page 30</b> ).
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 starting condition of board and 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.	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 ( <b>Page 30</b> ).

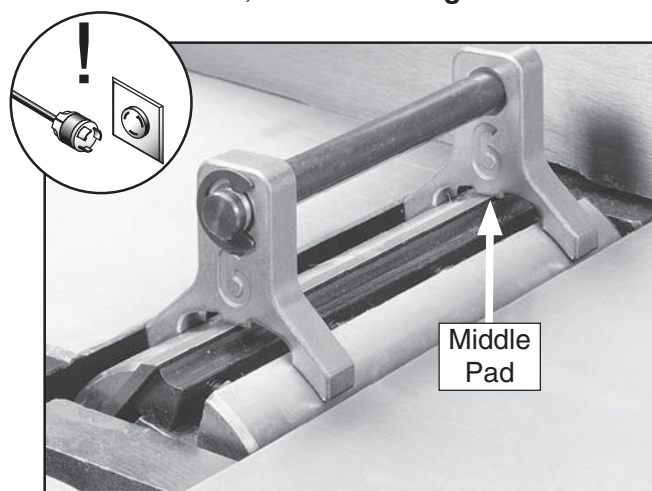


# Inspecting Knives (G0455 Only)

The height of the knives can be inspected with the knife setting jig. This inspection will ensure that the knives are set in the cutterhead as they should be. Usually this is done before calibrating the outfeed table or when troubleshooting.

## To inspect the knives:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the cutterhead guard.
3. Lower the infeed table to the ½" scale mark.
4. Place the knife jig on the cutterhead, directly over a knife, as shown in **Figure 35**.



**Figure 35.** Jig positioned over cutterhead knife.

5. Carefully inspect how the jig touches the cutterhead and the knife.

—If both outside legs of the jig sit firmly on the cutterhead and the middle pad just touches the knife, then that knife is set correctly. (Repeat this inspection with the other knives.)

—If the jig does not sit firmly on the cutterhead and touch the knife edge as described, then reset that knife. (Repeat this inspection with the other knives before resetting.)

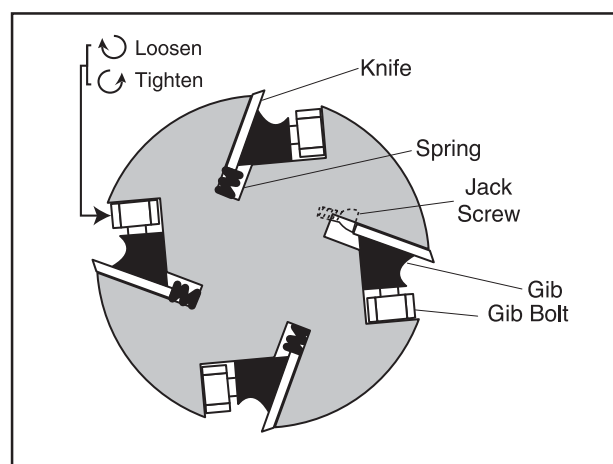
6. REPLACE CUTTERHEAD GUARD!

# Setting Knives (G0455 Only)

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 and make a wavy cut.

The knife jig included with the jointer is designed to set the knives at the correct height.

The Model G0455 comes with both jack screws and springs to provide you with two options for cutterhead adjustments (see **Figure 36**). **Note:** Only one of these options is needed to set the knives—see **Step 5\*** for clarification.



**Figure 36.** Cutterhead profile diagram.

## To set the knives:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the cutterhead guard from the table and lower the infeed and outfeed tables as far as they go. This will give you unrestricted access to the cutterhead.
3. Remove the belt guard to expose the cutterhead pulley.
4. Rotate the cutterhead pulley to give you good access to one of the cutterhead knives.

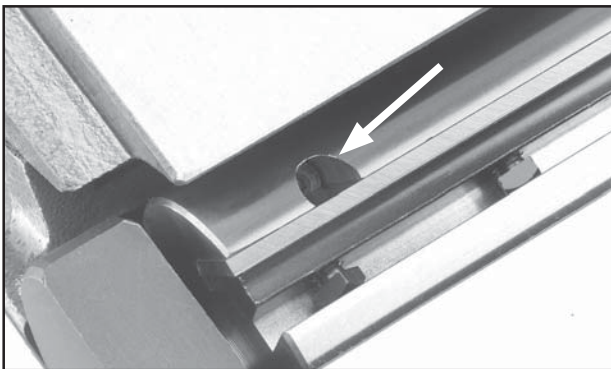




- Loosen the cutterhead gib bolts, starting in the middle and working toward the ends until the gib bolts are loose.

*\*If you decide to use the jack screws, remove the springs from the cutterhead. If you decide to use the springs, thread the jack screws completely into the cutterhead so they will not get lost.*

- Position the knife gauge over the knife as shown in **Figure 35** and loosen the gib bolts until the knife is completely loose.
- Jack Screws:** Using a 3mm hex wrench, find the jack screws through the access holes in the cutterhead (**Figure 37**) and rotate them to raise/lower the knife. When the knife is set correctly, it will barely touch the middle pad of the knife setting jig. For now, only tighten the gib bolts enough to hold the knife in place. Repeat **Steps 5–7** with the other knives.



**Figure 37.** Jack screw access hole.

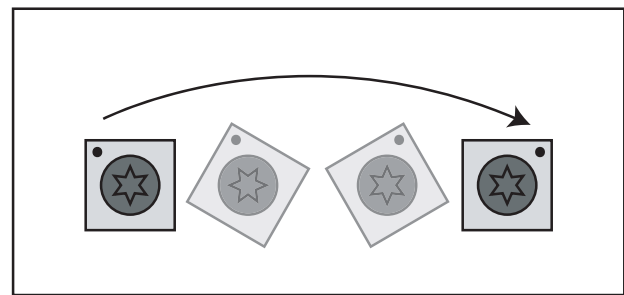
**Springs:** Push the knife down with the jig so that the knife edge is touching the middle pad of the jig. Hold the jig down and only tighten the gib bolts enough to hold the knife in place. Repeat **Steps 5–7** with the other knives.

- Rotate the cutterhead to the first knife, and tighten the gib bolts by starting at the middle and working your way to the ends, alternating left and right. Repeat this step on the rest of the knives.
- Repeat **Step 8** to verify gib bolts are tight.
- Adjust the outfeed table even with the new knife heights and **REPLACE THE CUTTERHEAD GUARD!**

## Replacing Inserts (G0480 Only)

The spiral cutterhead consists of 48 indexable carbide inserts. Each insert has four cutting edges, which can be easily rotated if the current cutting edge becomes dull or damaged.

A reference dot is on one corner of each insert to indicate when that insert has been rotated. After all four edges have been used, the dot will be back to its original position, indicating that the insert should be replaced. **Note:** *To avoid confusion about which edges are sharp, always rotate inserts clockwise.*



**Figure 38.** Rotating carbide inserts.

### To replace or rotate the inserts:

- DISCONNECT JOINTER FROM POWER!**
- Clean out the Torx screw head for the insert that you wish to replace or rotate.

### **NOTICE**

Replacing an insert with wood dust or debris underneath will cause poor cutting results.

- Remove the Torx screw, replace or rotate the insert, lubricate the threads of the Torx screw with a light machine oil, and torque the screw to 50 inch pounds.

### **NOTICE**

Over-tightening Torx screws may strip the cutterhead threads!



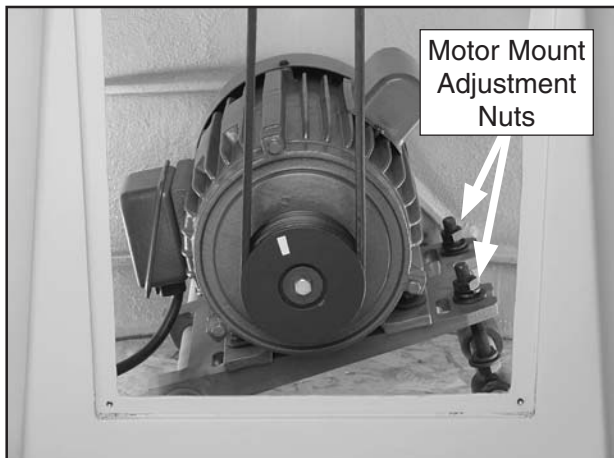
# Replacing V-Belts

The V-belts should always be replaced together as a matching set.

Tools Needed:	Qty
Phillips Head Screwdriver .....	1
Wrench 19mm .....	1

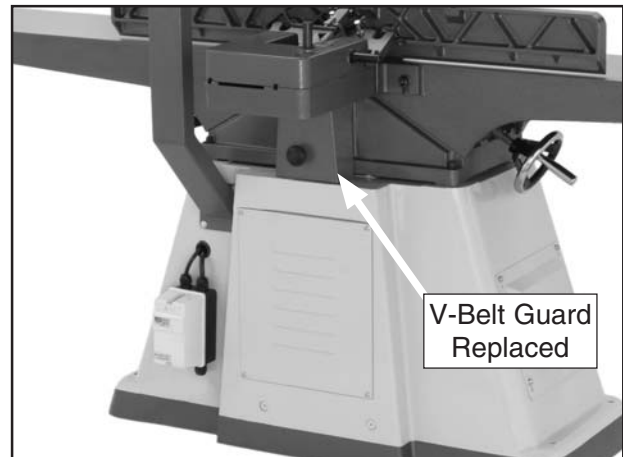
## To install the V-belt:

1. Remove the back access panel and the V-belt guard from the jointer.
2. Using a 19mm wrench, loosen the motor mount adjustment nuts above the motor mount plate (**Figure 39**).



**Figure 39.** Motor mount adjustment nuts.

3. Turn the motor mount adjustment nuts underneath the motor mount plate to raise the motor enough to replace the V-belts on the pulleys.
4. Using the motor adjustment nuts, move the motor downward to tension the V-belts until there is approximately  $\frac{3}{4}$ " deflection when the V-belts are pushed with moderate pressure.
5. Replace the access cover and V-belt guard on the jointer (**Figure 40**).



**Figure 40.** V-belt guard replaced.

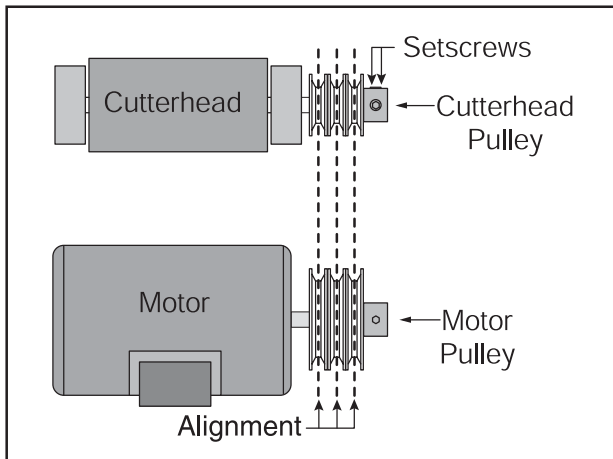


# Aligning V-Belts

Properly aligned V-belts last longer, run cooler, allow your machine to work more efficiently, and contribute to increased lifespan of the motor and cutterhead bearings.

## To check and align the V-belts:

1. Move the fence forward and visually check the alignment of the two pulleys (**Figure 41**) to make sure that they are aligned.



**Figure 41.** The pulleys should be aligned so the V-belts are straight up and down.

- If the pulleys are aligned, then no adjustments are necessary.
- If the pulleys are NOT aligned, perform **Steps 2 & 3**.

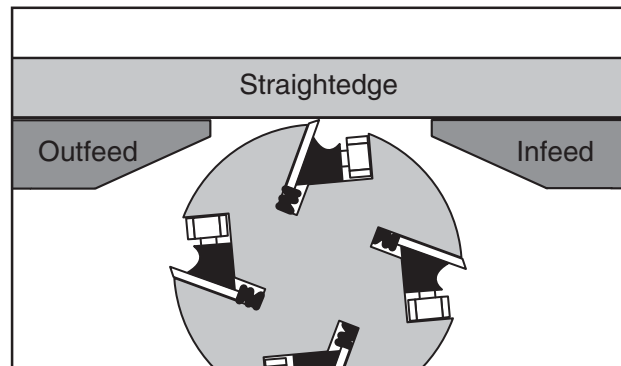
2. Remove the V-belts, loosen the set screws on the end of the cutterhead pulley, and align the cutterhead pulley with the motor pulley.
3. Tighten the set screws, replace the V-belts, and repeat **Step 1**.

# Calibrating Depth Scale

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

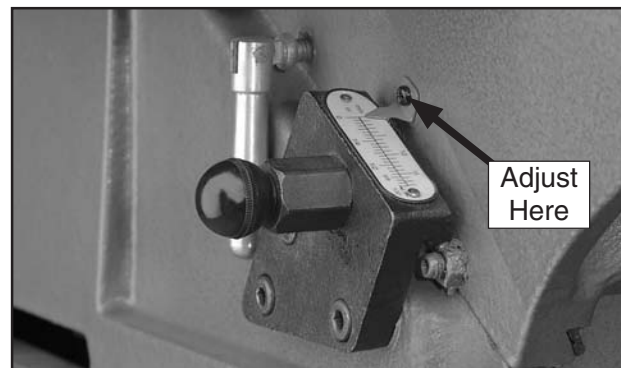
## To calibrate the depth scale:

1. Set the outfeed table height as described in the **Outfeed Table Height** sub-section on **Page 15**.
2. Place a straightedge across the infeed and outfeed tables.
3. Adjust the infeed table until it is level with the outfeed table, as illustrated in **Figure 42**.



**Figure 42.** Infeed table adjusted even with outfeed table and knife at TDC.

4. Using a screwdriver, adjust the scale pointer exactly to "0" (**Figure 43**).



**Figure 43.** Depth-of-cut pointer adjusted to "0" position.

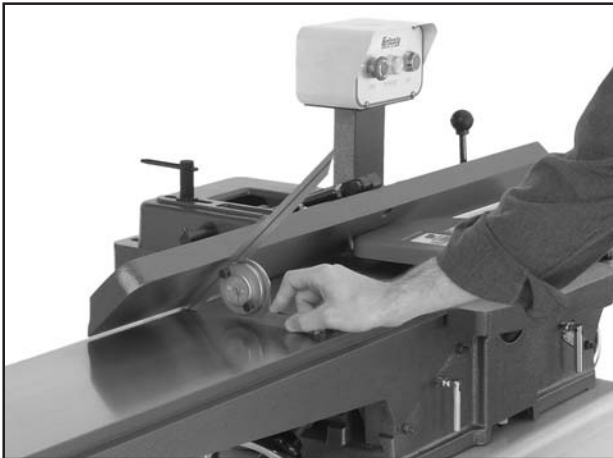


# Setting Fence Stops

The fence stops are adjustable nuts and bolts that simplify the task of adjusting the fence to 45° inward, 90°, and 45° outward (135°).

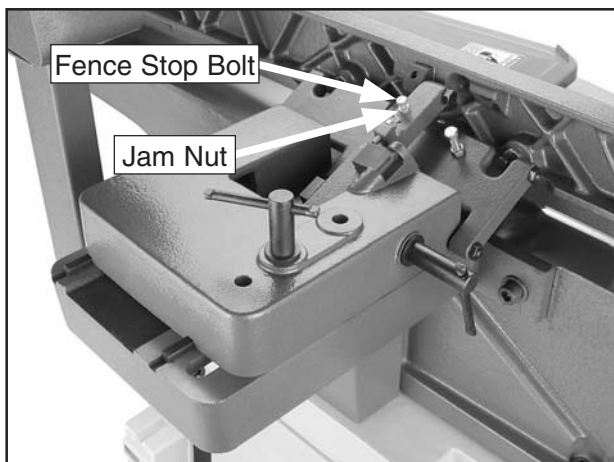
## To set the 45° inward fence stop:

1. Using a 45° square, adjust the fence to the 45° inward position, as shown in **Figure 44**.



**Figure 44.** Typical 45° inward fence adjustment.

2. Loosen the jam nut shown in **Figure 45**.



**Figure 45.** 45° inward fence stop components.

3. Adjust the 45° inward fence stop bolt until it makes contact with the fence bracket.
4. Retighten the jam nut loosened in **Step 2**.

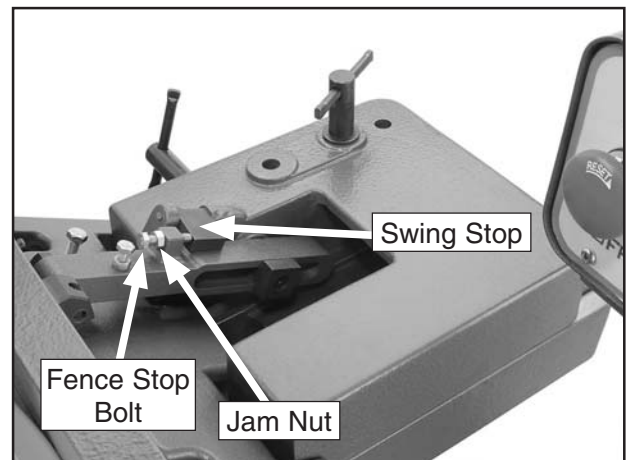
## To set the 90° fence stop:

1. Using a 90° square, adjust the fence to the 90° position, as shown in **Figure 46**.



**Figure 46.** Typical 90° fence adjustment.

2. Flip the 90° swing stop into the position shown in **Figure 47**.



**Figure 47.** 90° swing stop engaged.

3. Loosen the jam nut on the 90° fence stop bolt (**Figure 47**).
4. Adjust the 90° fence stop bolt until it makes contact with the 90° swing stop.
5. Retighten the jam nut loosened in **Step 3**.



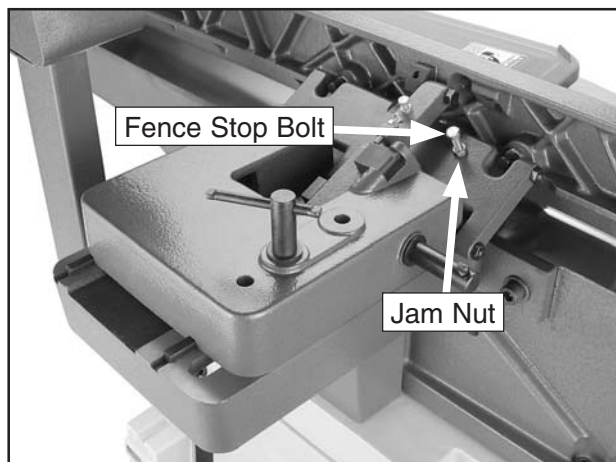
### To set the 45° outward fence stop:

1. Using a sliding bevel adjusted to 135°, adjust the fence to the 135° (45° outward) position, as shown in **Figure 48**.



**Figure 48.** Typical 45° outward fence adjustment.

2. Loosen the jam nut on the 45° outward fence stop bolt (**Figure 49**).



**Figure 49.** 45° outward fence stop jam nut.

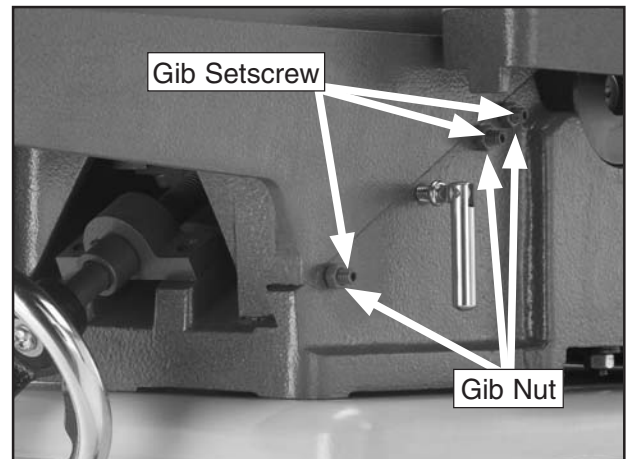
3. Adjust the 45° outward fence stop bolt until it makes contact with the back of the fence.
4. Retighten the jam nut loosened in **Step 2**.

## Adjusting Gibs

The function of the table gibs is to eliminate excessive play in the table movement. The gibs also control how easy it will be to move the tables up and down.

### To adjust the table gibs:

1. Using a 12mm wrench, loosen the outfeed table gib nuts on the side of the jointer base (**Figure 50**).



**Figure 50.** Outfeed table gib controls.

2. Using a 4mm hex wrench, evenly tighten the gib setscrews a small amount, then check the table by moving it up and down. Adjust the setscrews as needed until the friction of the table movement is balanced between minimal play and ease of movement.

**Note:** *Tighter gibs reduce play but make it harder to adjust the tables.*

3. Repeat **Steps 1-2** with the other table.
4. Set the outfeed table height as described in **Setting Outfeed Table Height** on **Page 15**.



# Wiring Diagram

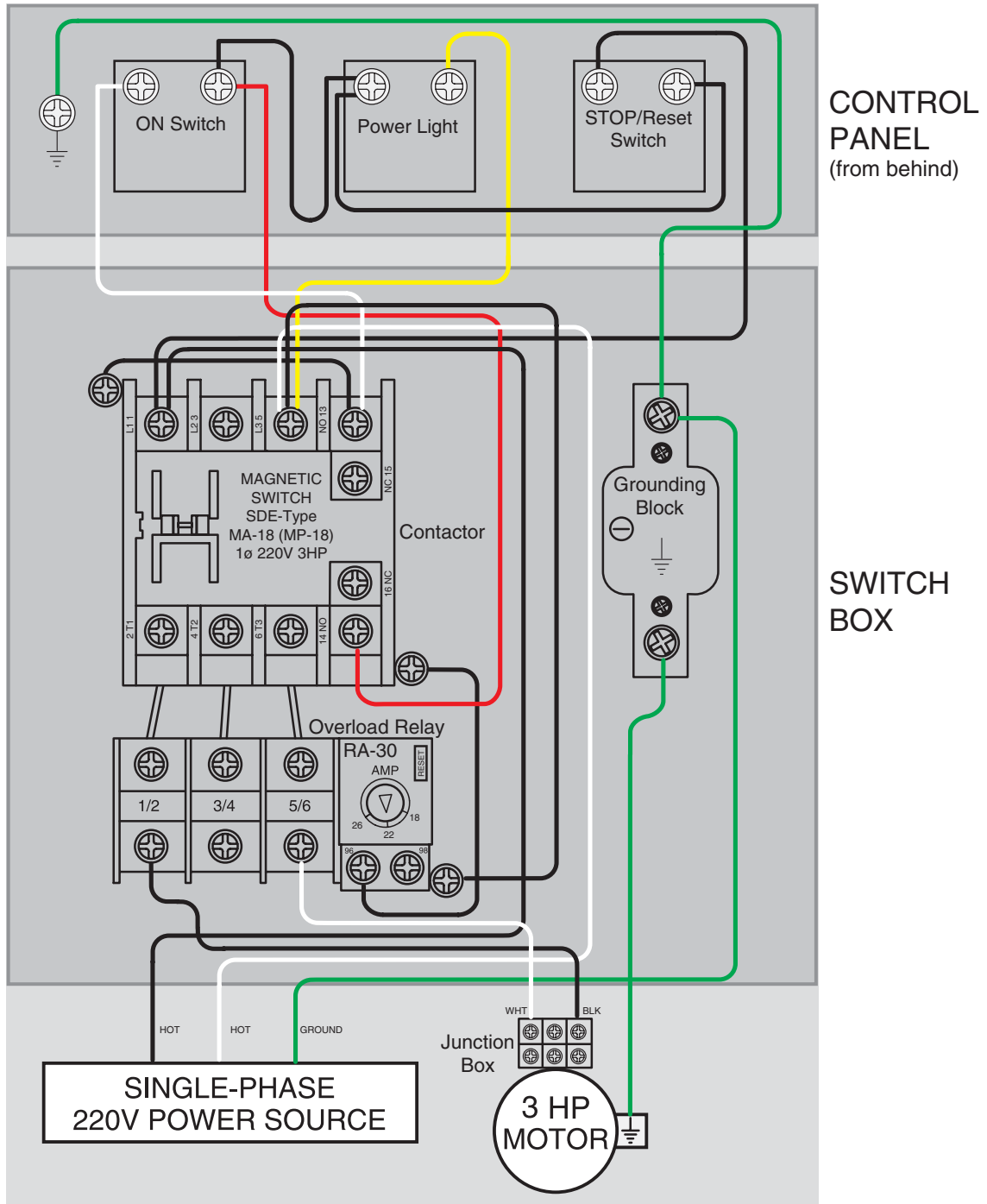


## ⚠ DANGER

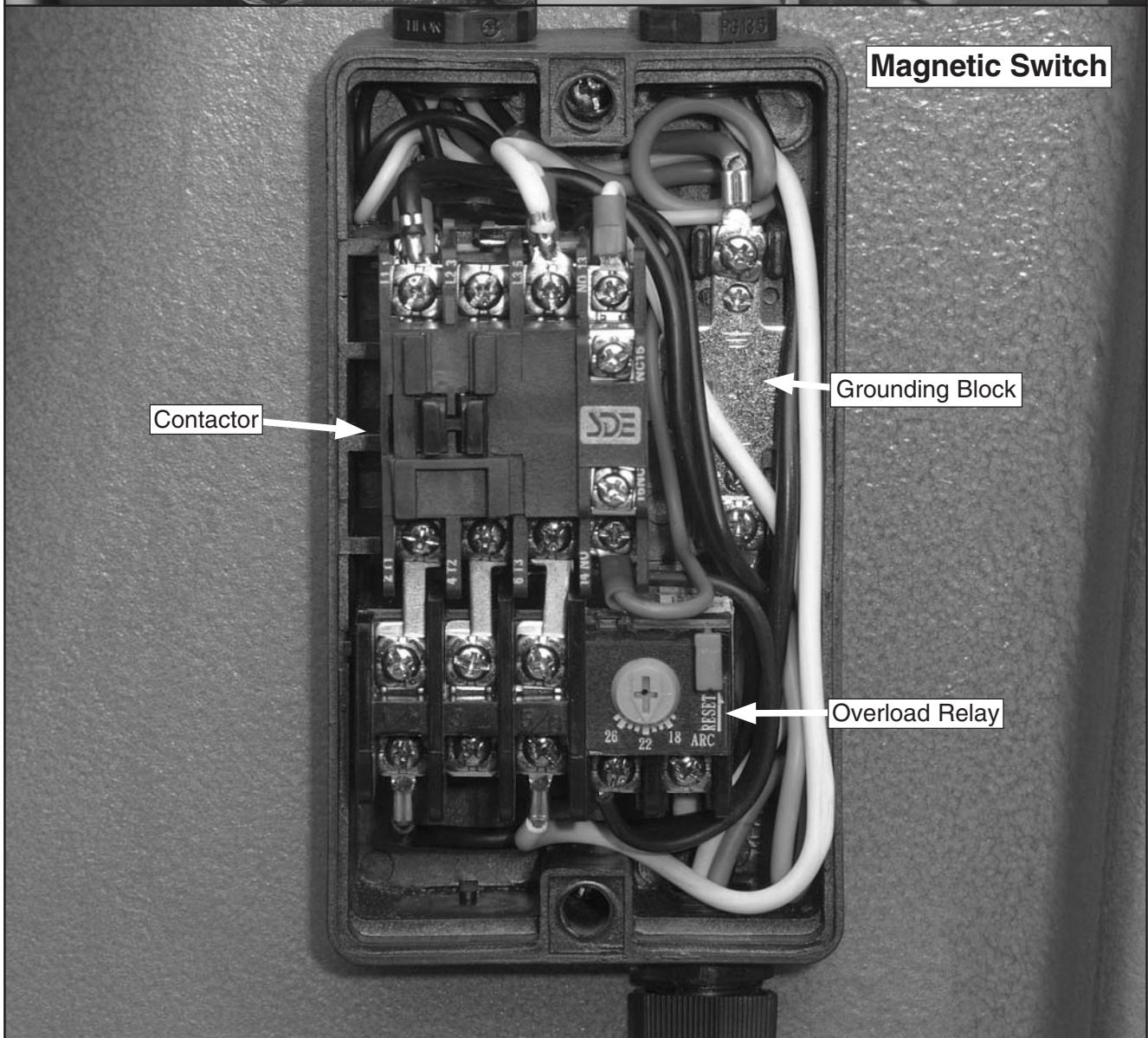
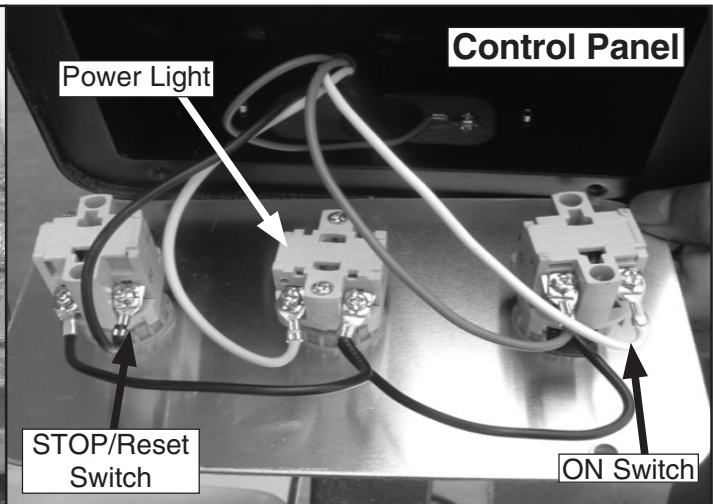
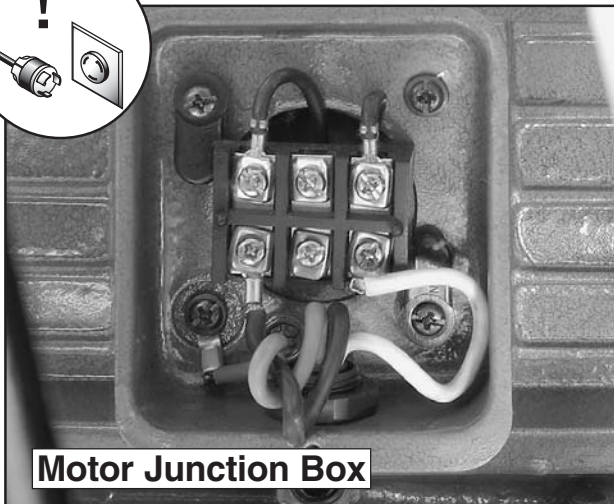
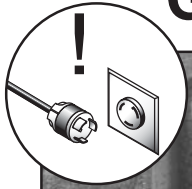
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!



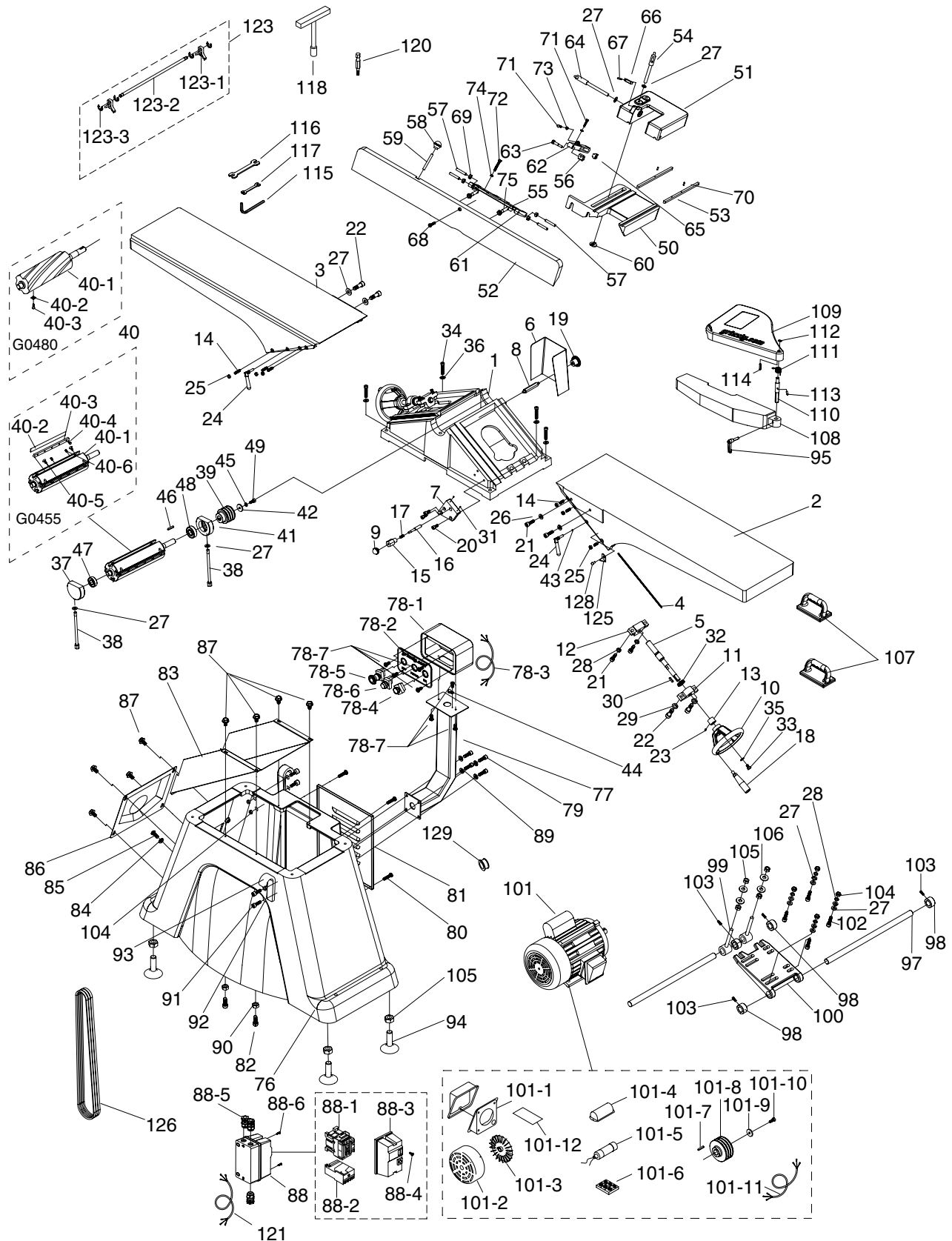
## MODEL G0455/G0480



# G0455/G0480 Electrical Components



# Jointer Parts Breakdown





# Jointer Parts List

REF	PART #	DESCRIPTION
1	P0455001	BASE
2	P0455002	INFEED TABLE (G0455)
2	P0480002	INFEED TABLE (G0480)
3	P0455003	OUTFEED TABLE
4	P0455004	GIB
5	P0455005	LEAD SCREW
6	P0455006	BELT GUARD
7	P0455007	STOP PIN BLOCK
8	P0455008	STUD M8-1.25
9	P0455009	PLUNGER KNOB
10	P0455010	HANDWHEEL
11	P0455011	BRACKET
12	P0455012	BRACKET
13	P0455013	COLLAR
14	PSS19	SET SCREW 5/16-18 X 1-1/4
15	P0455015	PLUNGER HOUSING
16	P0455016	PLUNGER
17	P0455017	COMPRESSION SPRING
18	P0455018	HANDLE
19	P0455019	ROUND KNOB M8-1.25
20	PSB14M	CAP SCREW M8-1.25 X 20
21	PSB19	CAP SCREW 3/8-16 X 1-1/4
22	PSB76	CAP SCREW 1/2-12 X 1-1/2
23	PSS03	SET SCREW 1/4-20 X 3/8
24	P0455024	SWIVELING LOCK HANDLE
25	PN02	HEX NUT 5/16-18
26	PW04M	FLAT WASHER 10MM
27	PW01	FLAT WASHER 1/2
28	PLW04	LOCK WASHER 3/8
29	PLW07	LOCK WASHER 1/2
30	PK01M	KEY 5 X 5 X 22
31	P0455031	RIVET 2 X 5
32	P51103	THRUST BEARING 51103
33	PB06M	HEX BOLT M8-1.25 X 12
34	PSB143M	CAP SCREW M10-1.5 X 50
35	PW01M	FLAT WASHER 8MM
36	PW04M	FLAT WASHER 10MM
37	P0455037	BEARING HOUSING
38	P0455038	CUTTERHEAD BOLT
39	P0455039	CUTTERHEAD PULLEY
40	P0455040	CUTTERHEAD ASSY (G0455)
40	P0480040	SP CUTTERHEAD ASSY (G0480)
40-1	P0455040-1	CUTTERHEAD (G0455)
40-1	P0480040-1	SPIRAL CUTTERHEAD (G0480)
40-2	H7397	10" KNIVES X 4 (G0455)
40-2	H5307	CARBIDE INSERTS X 10 (G0480)
40-3	P0455040-3	KNIFE GIB (G0455)
40-3	PFH35M	FLAT HD TORX SCR (G0480)
40-4	P0455040-4	HEX HD GIB BOLT (G0455)

REF	PART #	DESCRIPTION
40-5	P0455040-5	JACK SCREW M5-.8 X 10 (G0455)
40-6	P0455040-6	COMPRESSION SPRING (G0455)
41	P0455041	BEARING HOUSING
42	PW01M	FLAT WASHER 8MM
43	P0455043	STEEL BALL 6MM
44	P0455044	STRAIN RELIEF ACC-2.5
45	PLW04M	LOCK WASHER 8MM
46	PK12M	KEY 5 X 5 X 30
47	P6203	BALL BEARING 6203
48	P6204	BALL BEARING 6204
49	PSB14M	CAP SCREW M8-1.25 X 20
50	P0455050	TABLE BRACKET
51	P0455051	FENCE BRACKET
52	P0455052	FENCE
53	P0455053	FENCE KEY 9.5 X 9.5 X 300
54	P0455054	FENCE LOCK STUD
55	P0455055	STUD
56	P0455056	BRACKET
57	P0455057	STUD
58	P0455058	BALL KNOB 3/8-16
59	P0455059	STUD 3/8-16
60	P0455060	FENCE LOCKING NUT
61	P0455061	FENCE LINK
62	P0455062	LOCKING LINK
63	P0455063	STUD
64	P0455064	LOCKING STUD
65	P0455065	T-NUT 1/2
66	P0455066	STOP BLOCK
67	P0455067	PIN
68	PFH23	FLAT HD SCR 5/16-18 X 1-1/2
69	PN08	HEX NUT 3/8-16
70	P0455070	PIN 4 X 14
71	PB13	HEX BOLT 1/4-20 X 1-1/4
72	PB11	HEX BOLT 5/16-18 X 1-1/2
73	PN05	HEX NUT 1/4-20
74	PN02	HEX NUT 5/16-18
75	PN01	HEX NUT 1/2-20
76	P0455076	STAND
77	P0455077	PEDESTAL ARM
78	P0455078	CONTROL BOX ASSY
78-1	P0455078-1	CONTROL BOX
78-2	P0455078-2	SWITCH PANEL
78-3	P0455078-3	CONTROL CORD
78-4	P0455078-4	STOP SWITCH 25
78-5	P0455078-5	POWER LIGHT 25
78-6	P0455078-6	START SWITCH 25
78-7	PS09M	PHLP HD SCR M5-.8 X 10
79	PSB14M	CAP SCREW M8-1.25 X 20



# Jointer Parts List

REF	PART #	DESCRIPTION
80	PS06M	PHLP HD SCR M5-.8 X 20
81	P0455081	COVER
82	PSB40M	CAP SCREW M8-1.25 X 35
83	P0455083	BRACKET
84	PW03M	FLAT WASHER 6MM
85	PSB132M	BUTTON HD CAP SCR M6-1 X 15
86	P0455086	DUST HOOD
87	PFB09M	FLANGE BOLT M6-1 X 10
88	P0455088	SWITCH ASSY
88-1	P0455088-1	CONTACTOR MA-18 SDE
88-2	P0455088-2	OVERLOAD RELAY RA-30 18~26
88-3	P0455088-3	SWITCH COVER
88-4	PSW01-1	PLASTIC SWITCH SCREW
88-5	P0455088-5	STRAIN RELIEF M20
88-6	PS08	PHLP HD SCR 10-24 X 3/4
89	PLW04M	LOCK WASHER 8MM
90	PN03M	HEX NUT M8-1.25
91	PB01M	HEX BOLT M10-1.5 X 30
92	PW04M	FLAT WASHER 10MM
93	P0455093	HOOK
94	P0455094	FOOT PAD
95	P0455095	ALL WAY HANDLE 5/16-18 X 1-3/8
97	P0455097	MOUNTING SHAFT
98	P0455098	COLLAR
99	P0455099	PIVOT STUD
100	P0455100	MOTOR MOUNT PLATE
101	P0455101	MOTOR ASSY
101-1	P0455101-1	JUNCTION BOX
101-2	P0455101-2	FAN COVER
101-3	P0455101-3	MOTOR FAN
101-4	P0455101-4	CAPACITOR COVER
101-5	P0455101-5	S CAPACITOR 600MFD 125VAC
101-6	P0455101-6	TERMINAL BAR

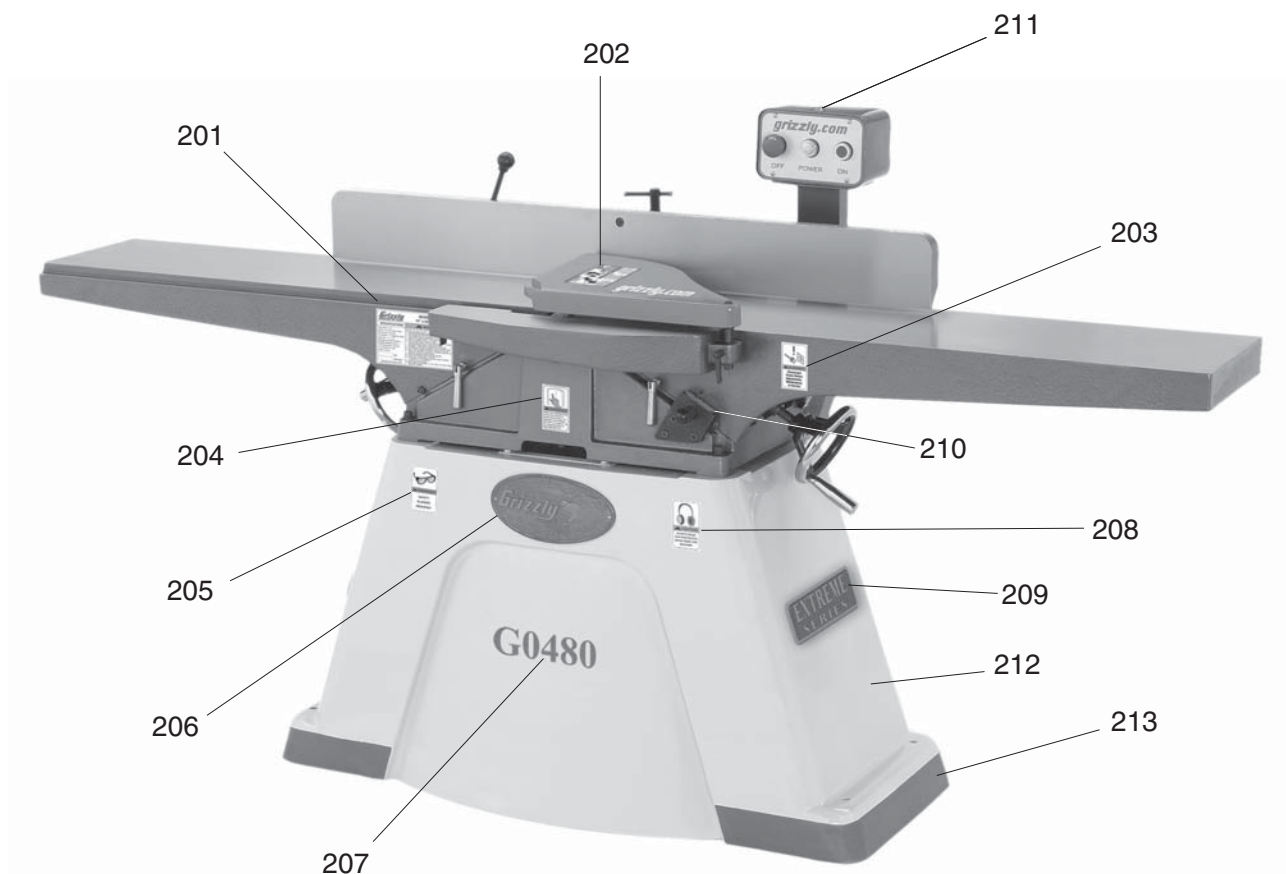
REF	PART #	DESCRIPTION
101-7	PK12M	KEY 5 X 5 X 30
101-8	P0455101-8	MOTOR PULLEY
101-9	P0455101-9	SPECIAL WASHER 8MM
101-10	PB09M	HEX BOLT M8-1.25 X 20
101-11	P0455101-11	MOTOR CORD 12AWG
101-12	P0455101-12	MOTOR LABEL
102	PSB47M	CAP SCREW M10-1.5 X 40
103	PSS06	SET SCREW 1/4-20 X 3/4
104	PN02M	HEX NUT M10-1.5
105	PN09M	HEX NUT M12-1.75
106	PW06M	FLAT WASHER 12MM
107	P0455107	PUSH BLOCK
108	P0455108	RABBET TABLE
109	P0455109	CUTTERHEAD GUARD
110	P0455110	PIVOT SHAFT
111	P0455111	TORSION SPRING
112	PR16M	EXT RETAINING RING 9MM
113	P0455113	PIN 5 X 25
114	P0455114	PIN 6 X 20
115	PAW05M	HEX WRENCH 5MM
116	PWR810	WRENCH 8 X 10
117	PWR1214	WRENCH 12 X 14
118	P0480118	T-HANDLE DRIVER 6MM (G0480)
120	P0480120	TORX BIT T-20 (G0480)
121	P0455121	POWER CORD 12AWG
123	P0455123	KNIFE SETTING JIG ASSY
123-1	P0455123-1	KNIFE SETTING JIG FOOT
123-2	P0455123-2	KNIFE SETTING JIG ROD
123-3	PEC10M	E-CLIP 9MM
125	P0455125	INDICATOR
126	PVM52	BELT M-52 3L520
128	PS23	PHLP HD SCR 8-32 X 1/4
129	P0455129	PROTECTOR



# Safety Label Locations

## ⚠ 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](http://www.grizzly.com) to order new labels.



REF	PART #	DESCRIPTION
201	P0455201	G0455 MACHINE ID LABEL
201	P0480201	G0480 MACHINE ID LABEL
202	P0455202	CUTTERHEAD GUARD LABEL
203	P0455203	DISCONNECT POWER LABEL
204	PLABEL-12	READ MANUAL LABEL
205	PLABEL-11	SAFETY GLASSES LABEL
206	G8588	GRIZZLY NAMEPLATE
207	P0455207	G0455 MODEL NUMBER LABEL
207	P0480207	G0480 MODEL NUMBER LABEL
208	PLABEL-15	EAR PROTECTION LABEL
209	P0455209	EXTREME SERIES PLATE
210	P0455210	CUTTING DEPTH SCALE
211	PLABEL-14	ELECTRICITY LABEL
212	P0455212	TOUCH UP PAINT "PUTTY"
213	P0455213	TOUCH UP PAINT "HT GREEN"



# WARRANTY AND RETURNS

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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.





# 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
- Card Deck
- Friend
- Website
- Catalog
- Other:

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

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

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: \_\_\_\_\_

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CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

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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



# *grizzly.com*

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