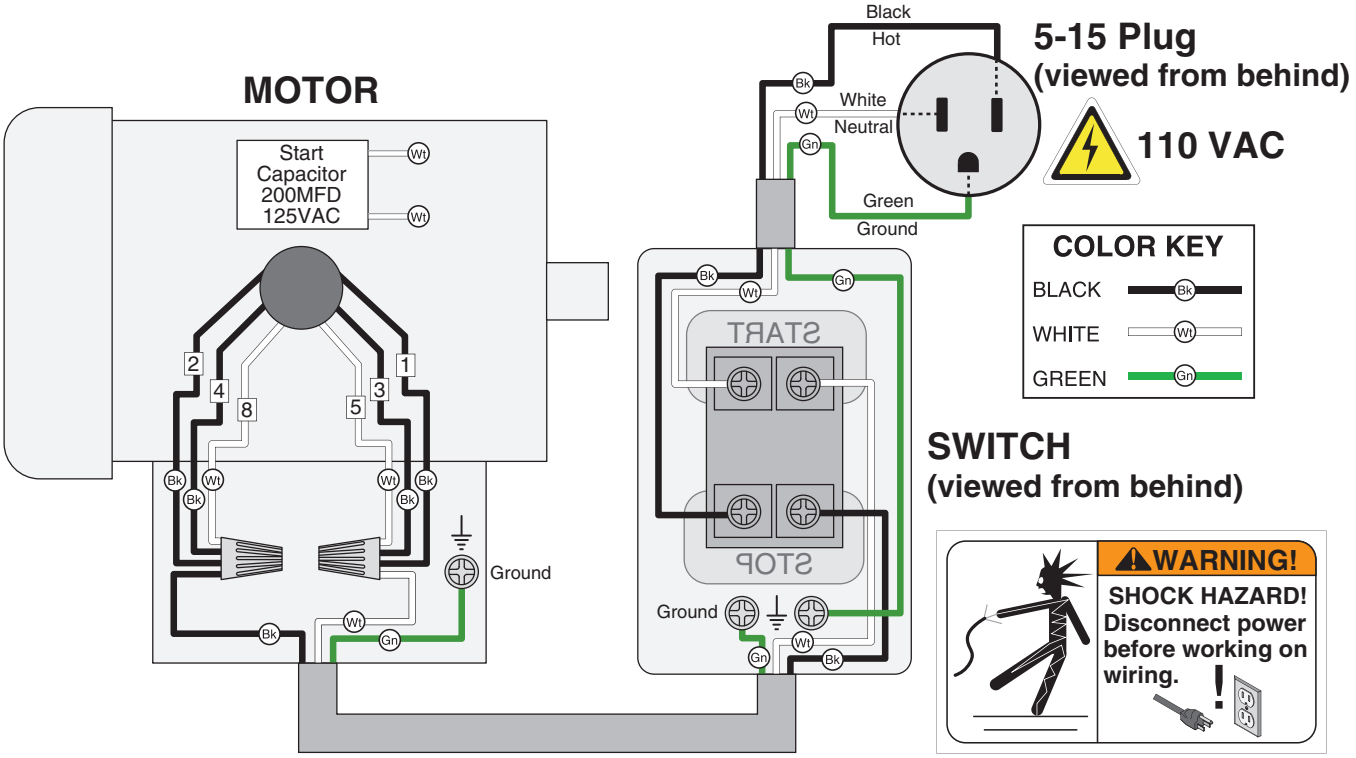
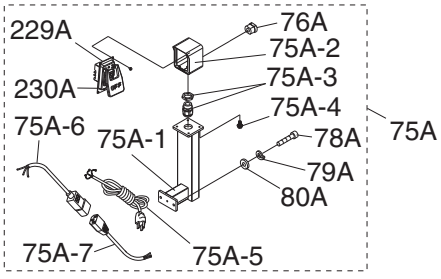
MODEL G0452
6" JOINTER
MANUAL UPDATE

We put a new style switch on this machine that is not shown in the original Model G0452 manual. This update page shows the wiring and replacement parts for this new switch. Keep this page with your owner's manual in case you need to refer to it in the future. Before operating your new machine, you MUST read and understand the original manual to reduce the risk of injury from improper use or setup.

If you need additional help with any of these procedures, contact our Tech Support at (570) 546-9663 or by email at techsupport@grizzly.com.





REF	PART #	DESCRIPTION
75A	P0452075A	SWITCH ARM ASSY V2.07.07
75A-1	P0452075A-1	SWITCH ARM
75A-2	P0452075A-2	SWITCH BOX
75A-3	P0452075A-3	STRAIN RELIEF 13.5MM
75A-4	P0452075A-4	FLANGE BOLT M6-1 X 16
75A-5	P0452075A-5	POWER CORD
75A-6	P0452075A-6	SWITCH CORD

REF	PART #	DESCRIPTION
75A-7	P0452075A-7	MOTOR CORD
76A	P0452076A	STRAIN RELIEF V2.07.07
78A	PSB31M	CAP SCREW M8-1.25 X 25
79A	PLW04M	LOCK WASHER 8MM
80A	PW01M	FLAT WASHER 8MM
229A	P0452229A	SWITCH PLATE V2.07.07
230A	P0452230A	SWITCH V2.07.07

Grizzly Industrial, Inc.®

6" x 46" MOBILE JOINTER

MODEL G0452

INSTRUCTION MANUAL

#PC7250 PRINTED IN CHINA

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 G0452 6" Mobile 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 G0452. 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 G0452 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

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 G0452
6" X 46" MOBILE JOINTER

Design Type: ..... Cabinet

Overall Dimensions:

Table Size	6" W x 46" L
Height (from floor to table)	32½"
Overall Length	46"
Overall Width	27½"
Shipping Weight	176 lbs.
Net Weight	163 lbs.
1st Box Size	48½" L x 21" W x 15" H
2nd Box Size	20½" L x 15¾" W x 28¾" H
Foot Print	18" x 13½"

Capacities:

Maximum Depth of Cut	⅛"
Maximum Width of Cut	6"
Cutterhead Diameter	2½"
Cutterhead Speed	4800 RPM
Cuts Per Minute	14,400

Construction:

Tables	Independently Adjustable, Precision Ground Cast Iron
Stand	Preformed Steel
Ways	Dovetailed, Adjustable
Fence Assembly	Cast Iron
Body Assembly	Cast Iron
Base	One Piece Steel Cabinet
Cutterhead	3 Knife Slots w/Jack Screws and Springs
Guard	Die Cast Metal
Bearings	Sealed and Permanently Lubricated

Motor:

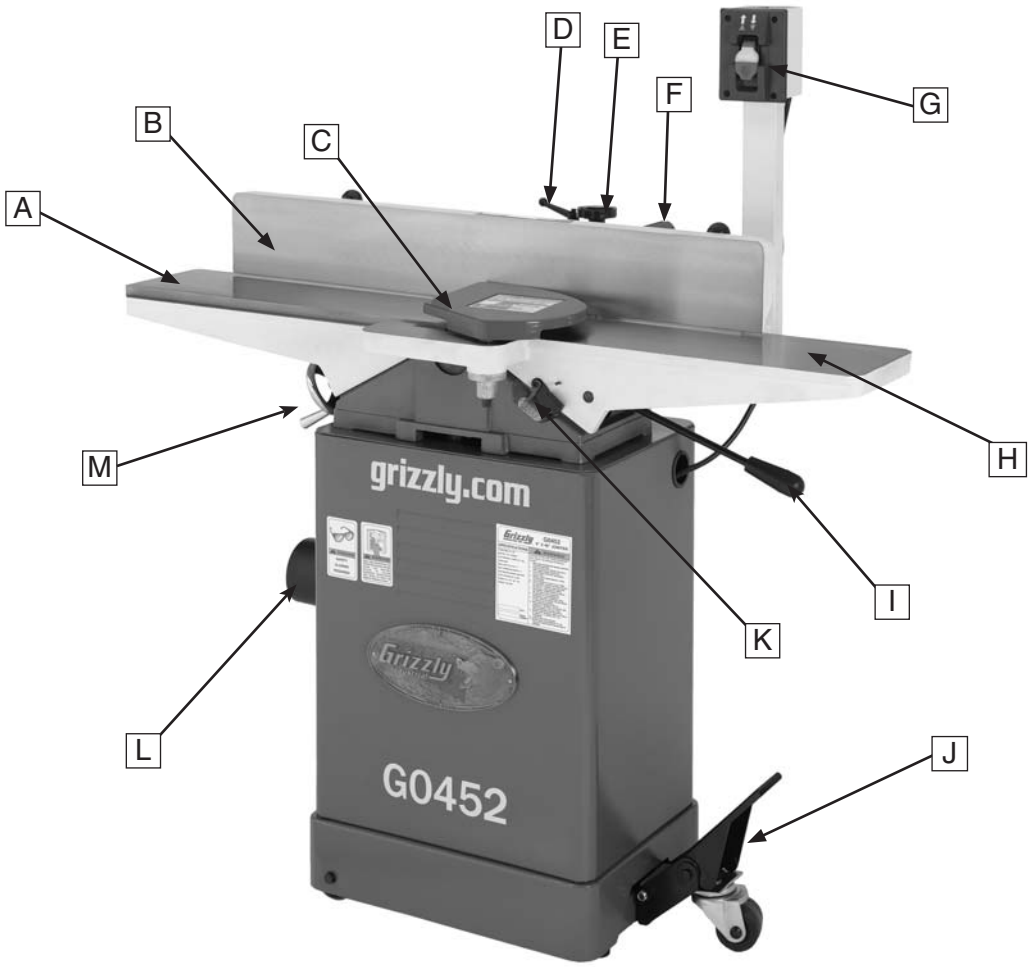
Type	TEFC Capacitor Start Induction
Horsepower	1 HP
Phase / Voltage	Single-Phase 110V
Amps	14A
Cycle / RPM	60 Hertz / 3450 RPM
Power Transfer	V-Belt Drive
Bearings	Sealed & Lubricated Ball Bearings

Features:

Fence	Center Mounted, Positive Stops at 45° and 90°
Table Movement	Handwheel/Lever
Infeed & Outfeed Tables	½" Rabbeting Capacity Built-In

Specifications, while deemed accurate, are not guaranteed.

Identification



A. Outfeed Table
B. Fence
C. Cutterhead Guard
D. Fence Lock
E. Fence Adjustment Knob
F. Fence Tilt Handle
G. Control Panel
H. Infeed Table
I. Infeed Table Lever
J. Locking Foot Pedal
K. Depth Scale
L. Dust Port
M. 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 edge of the knife 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.

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 behind 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 increases the chance of kickback 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 cutterhead guard in place. After rabbeting, be sure to replace the cutterhead 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 G0452. 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

110V Operation

⚠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 1 HP motor on the Model G0452 will draw the following amps:

Motor Draw ..... 14 Amps

Circuit Requirements

Only connect your machine to a circuit that meets the requirements below. Always check to see if the wires and circuit breaker in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

Minimum Circuit Requirement ..... 15 Amp

Plug/Receptacle Type

Included Plug Type ..... NEMA 5-15

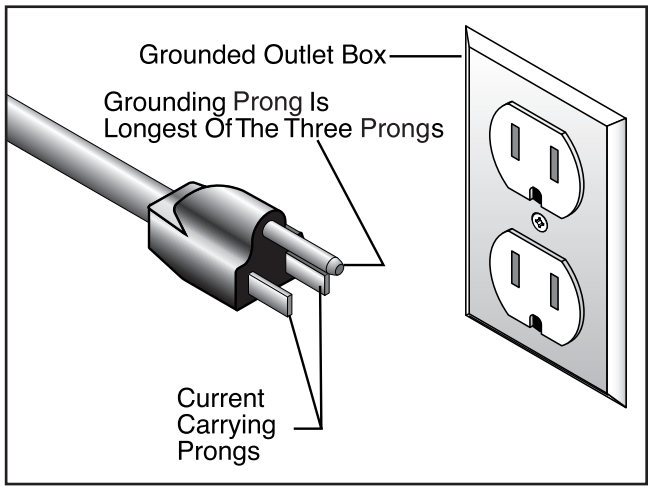
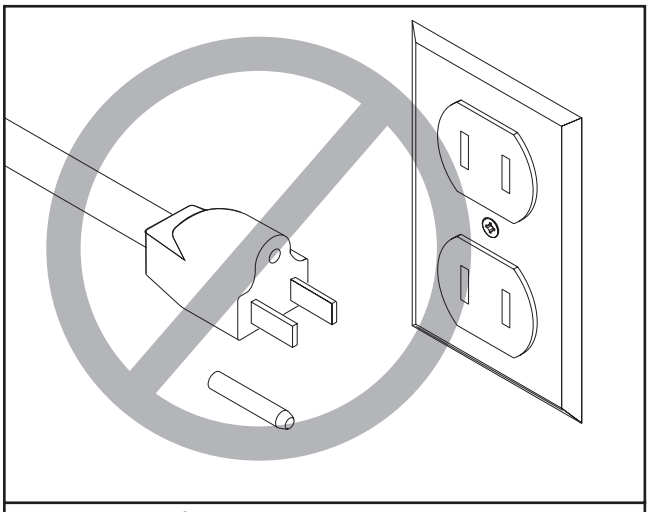


Figure 1. Typical type 5-15 plug.

⚠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!



⚠CAUTION

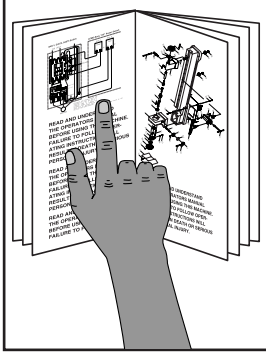
This machine must have a ground prong in the plug to help ensure that it is grounded. DO NOT remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

- Make sure the cord is rated Standard Service (grade S) or better.
- The extension cord must contain a ground wire and plug pin.
- Use at least a 16 gauge cord. Use a 14 gauge cord if the cord is between 51-100 feet.
- Do not use extension cords over 100 feet.

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 G0452 weighs 163 lbs. DO NOT overexert yourself while unpacking or moving your machine—get assistance.

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 4' (or longer)	1
• Safety Glasses (for each person)	1
• Dust Collection System (optional)	1
• 4" Dust Hose (optional)	1
• 4" Hose Clamp (optional)	1
• Phillips Head Screwdriver	1
• Wrench 13mm	1
• Wrench 17mm	1
• Wrench 19mm	1
• Socket Wrench 17mm	1
• Level	1

Unpacking

The Model G0452 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 two boxes, you should have the following items:

Box 1: (Figure 2)	Qty
A. Table Assembly	1
B. Fence Carriage Assembly	1
C. Carriage Mounting Bracket	1
D. Infeed Table Lever	1
E. Fence Tilt Handles	2
F. Cutterhead Guard	1
G. Push Blocks	2
H. Outfeed Table Handwheel	1
I. Fence Assembly	1
J. Cutterhead Jig	1

Hardware and Tools	Qty
• Wrenches 8/10mm & 12/14mm	1 each
• Hex Wrenches 2.5, 3, 4, 6, & 8mm	1 each
• Cap Screws M10-1.5 x 20	3
• Cap Screws M10-1.5 x 25	2
• Hex Bolts M10-1.5 x 55	2
• Lock Washers 10mm	5
• Flat Washers 10mm	7
• Hex Nuts M10-1.5	2
• Hex Bolt M8-1.25 x 50	1
• Cap Screws M8-1.25 x 60	4
• Cap Screws M8-1.25 x 25	4
• Cap Screws M8-1.25 x 20	2
• Lock Washers 8mm	8
• Flat Washers 8mm	11
• Phillip Head Screws M5-.8 x 15	5
• Flat Washers 5mm	5

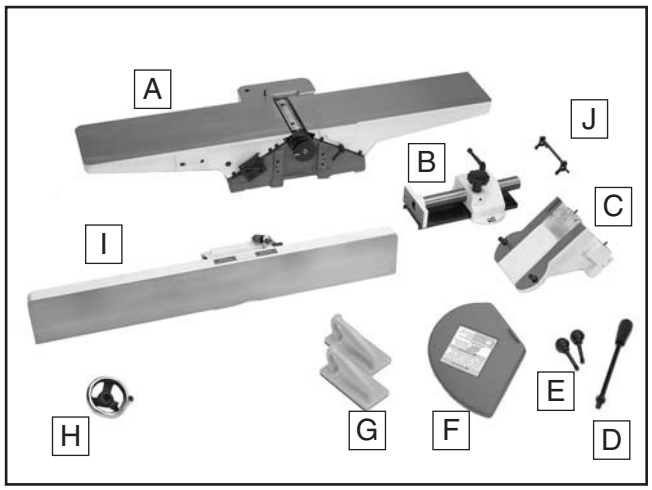


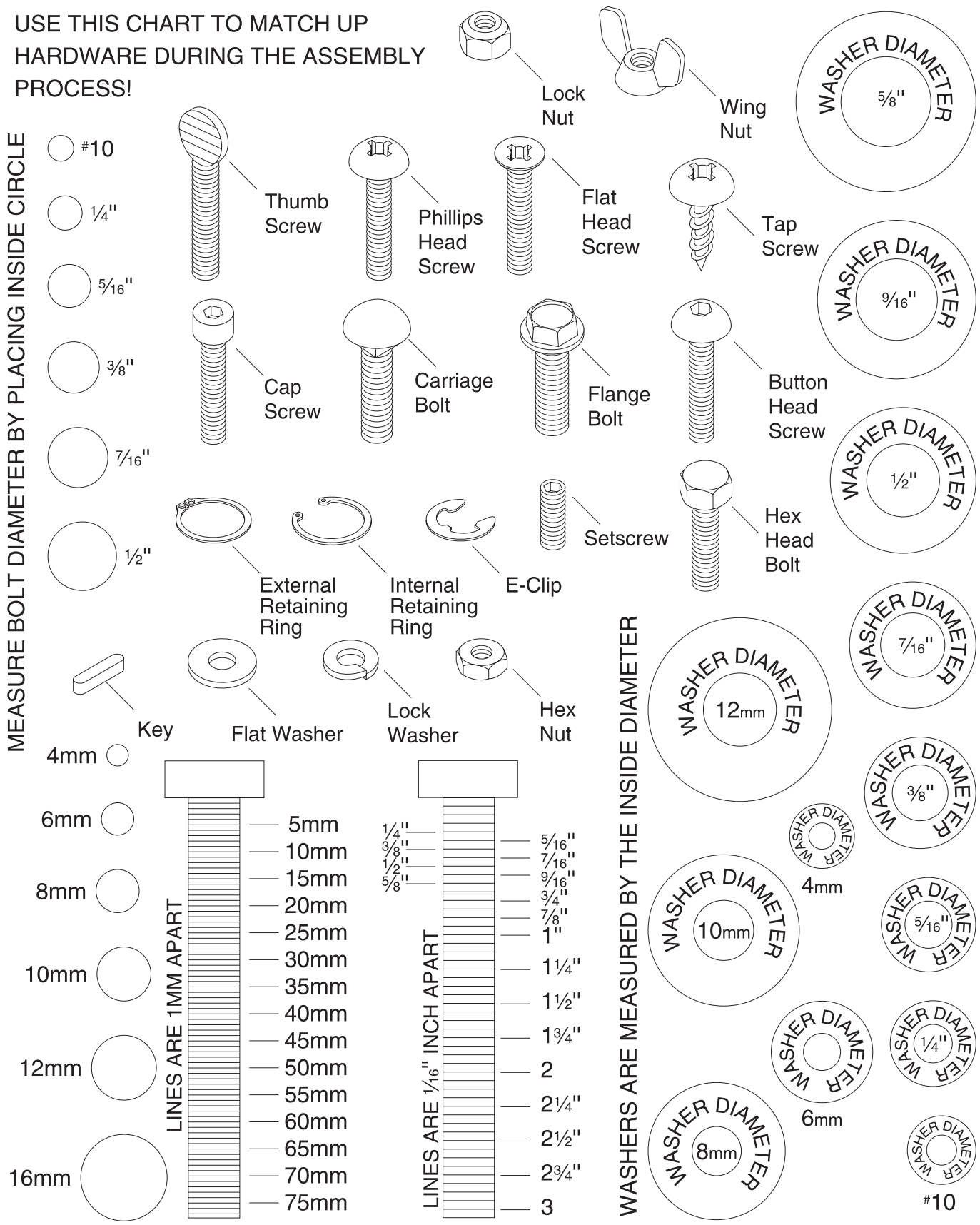
Figure 2. Box 1 inventory.

Box 2: (Figure 3)	
K. Cabinet	1
L. Power Switch and Support Arm	1
M. V-Belt	1
N. Locking Foot Pedal Assembly	1
O. Dust Port	1

Figure 3. Box 2 inventory.

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.

Hardware Recognition Chart

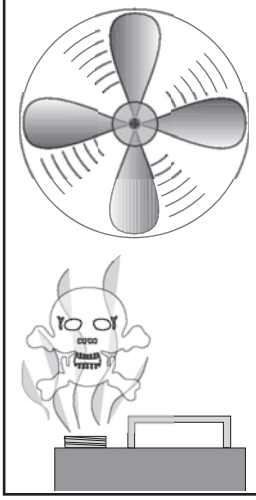


Clean Up

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

The Model G0452 weighs 163 lbs. and has a base footprint of 18" W x 13½" D. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

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 jointer. See **Figure 4** for the minimum working clearances of the Model G0452.

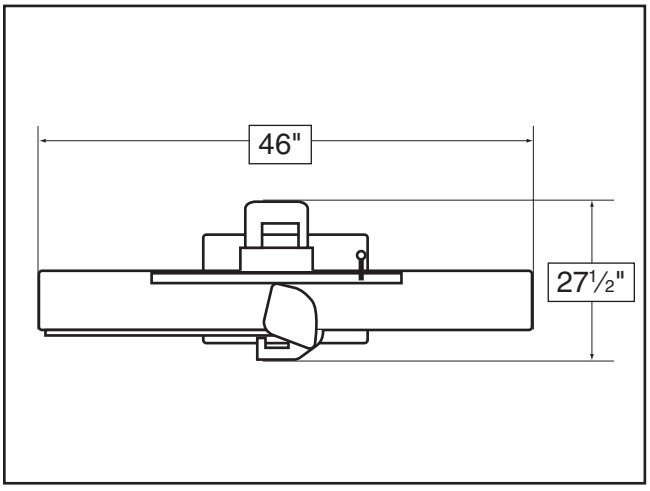
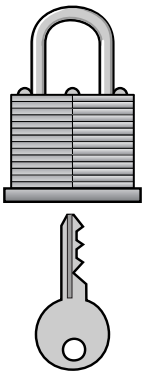


Figure 4. G0452 working clearances.



⚠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!

Locking Foot Pedal

Components and Hardware Needed:	Qty
Cabinet	1
Locking Foot Pedal Assembly	1
Hex Bolts M10-1.5 x 55	2
Flat Washers 10mm	4
Hex Nuts M10-1.5	2
Hex Bolt M8-1.25 x 50	1
Flat Washer 8mm	1

Tools Needed:	Qty
Wrench 17mm	1
Socket Wrench 17mm	1
Wrench 13mm	1
Level	1

To install the locking foot pedal:

1. Lay the cabinet on its side as shown in **Figure 5.**

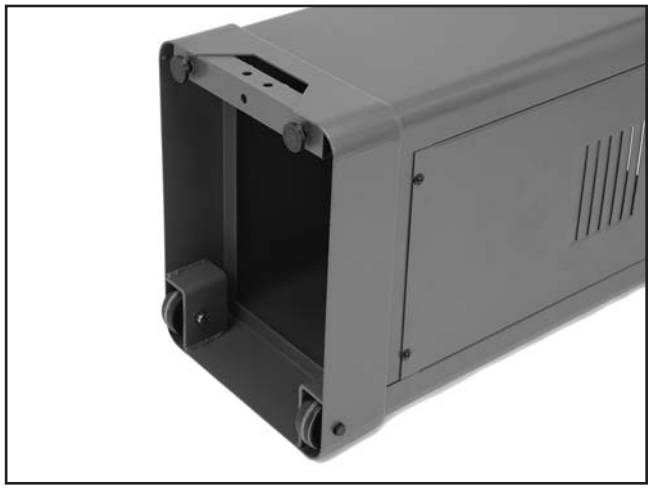


Figure 5. Cabinet.

2. Place the locking foot pedal assembly onto the cross brace.

3. Use a 13mm wrench to install the M8-1.25 x 50mm hex bolt and washer as shown in **Figure 6**.

Note: The hex bolt installs from inside.

Figure 6. Installing locking foot pedal.

4. Install the two M10-1.5 x 55 hex bolts, flat washers, and hex nuts through the front of the locking foot pedal assembly as shown in **Figure 7**.

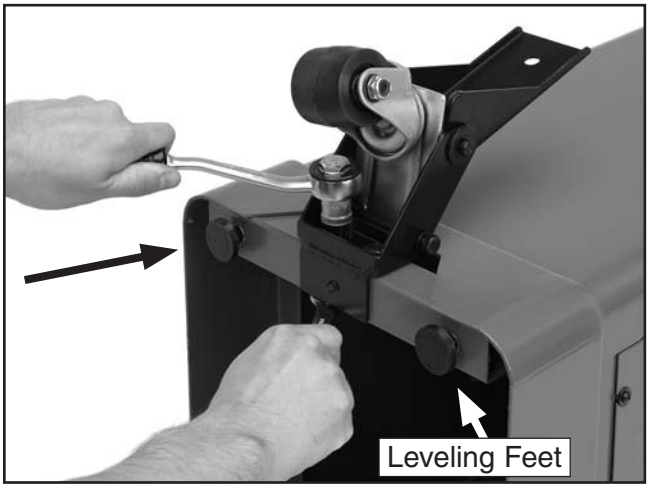


Figure 7. Installing locking foot pedal.

5. Raise the cabinet upright.

6. Lock the foot pedal down.

7. Level the cabinet front-to-back and side-to-side by adjusting the leveling feet.

Mounting Jointer

Components and Hardware Needed:	Qty
Table Assembly	1
Cabinet	1
Cap Screws M10-1.5 x 20	3
Lock Washers 10mm	3
Flat Washers 10mm	3

Tools Needed:	Qty
Hex Wrench 8mm	1
Extra Person for Lifting Help	1

⚠CAUTION

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

To mount the jointer to the stand:

1. Remove the outer cover of the cabinet.

2. With the help of an assistant, lift the jointer onto the cabinet.

3. Align the three bolt holes on the jointer with the three holes on the cabinet (**Figure 8**).

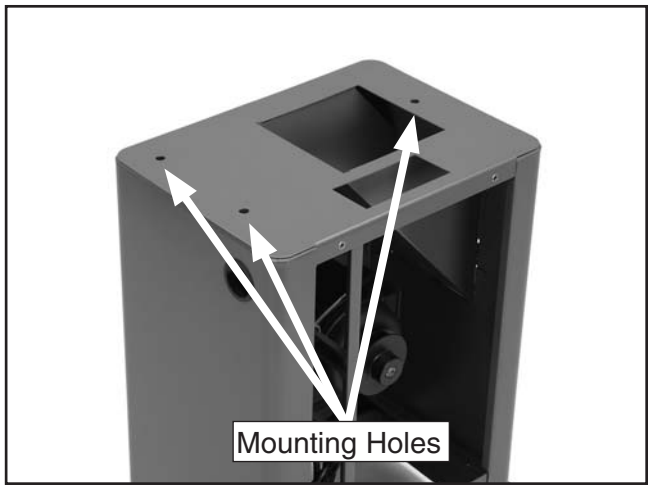


Figure 8. Mounting holes.

4. Using the 8mm hex wrench, secure the jointer to the cabinet with the M10-1.5 x 20 cap screws, flat washers, and lock washers.

Note: Reach through the dust vent for access to the forward mounting hole as shown in **Figure 9.**

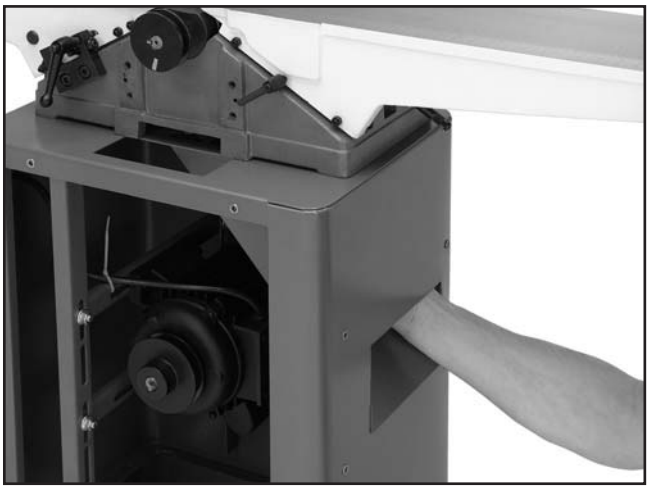


Figure 9. Installing forward mounting bolt.

V-Belt

Components and Hardware Needed:	Qty
V-Belt	1

Tools Needed:	Qty
Wrench or Socket 13mm	1
Hex Wrench 6mm	1

To install the V-belt:

1. Using a 13mm wrench, loosen, but DO NOT remove the motor mount bolts.

2. Lift the motor upward far enough to allow the V-belts to be placed around the cutterhead pulley and the motor pulley (see **Figure 10**).

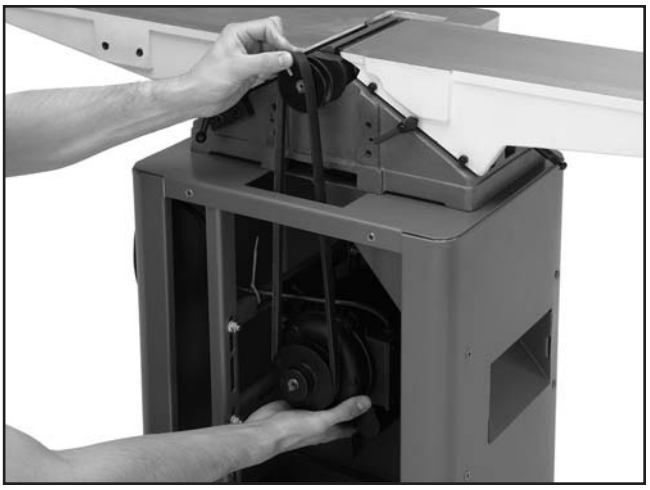


Figure 10. Installing V-belt.

3. Carefully allow the motor to slide downward, tensioning the V-belts with the weight of the motor.

4. Looking from the top, sight down the V-belt and pulleys and check to see that the pulleys are parallel and aligned with each other (see **Figure 11**).

   — If the pulleys are aligned, tighten the motor mounts loosened in **Step 1** and go to **Step 7**.

   — If the pulleys are NOT aligned, perform **Steps 5 & 6**.

5. Remove the V-belt, loosen the set screws on the end of the motor pulley, and align the motor pulley with the cutterhead pulley. If needed, the motor can be loosened and moved in or out to bring the motor pulley into alignment with the cutterhead pulley.

6. Tighten the set screws, replace the V-belts, and repeat **Step 4**. Belts should be perfectly parallel and aligned as shown in **Figure 11.**

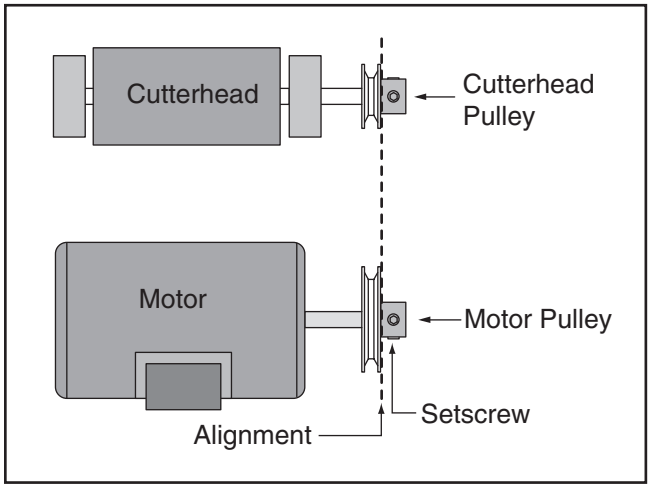


Figure 11. The pulleys should be parallel and aligned.

7. Replace the access cover on the cabinet.

Carriage Mounting Bracket

Components and Hardware Needed:	Qty
Carriage Mounting Bracket	1
Cap Screws M8-1.25 x 60	4
Lock Washers 8mm	4
Flat Washers 8mm	4

Tools Needed:	Qty
Hex Wrench 6mm	1

To install the carriage mounting bracket:

1. Align the locating pins on the back of the carriage mounting bracket with the sockets on the jointer table (see **Figure 12**).

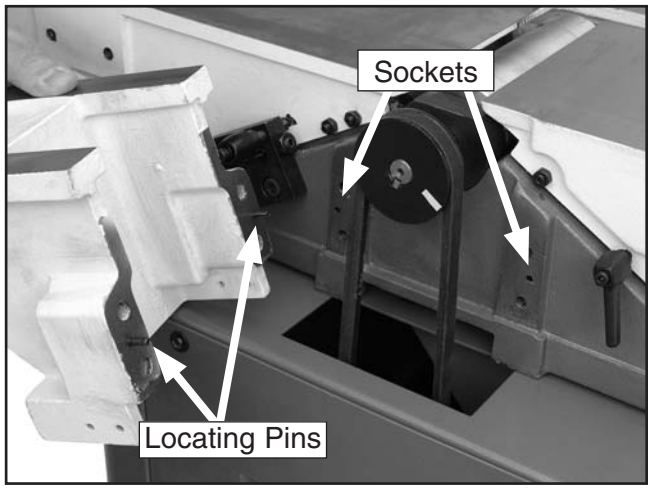


Figure 12. Locating pins.

2. Tighten the carriage mounting bracket to the jointer table with the cap screws, lock washers, and flat washers (see **Figure 13**).

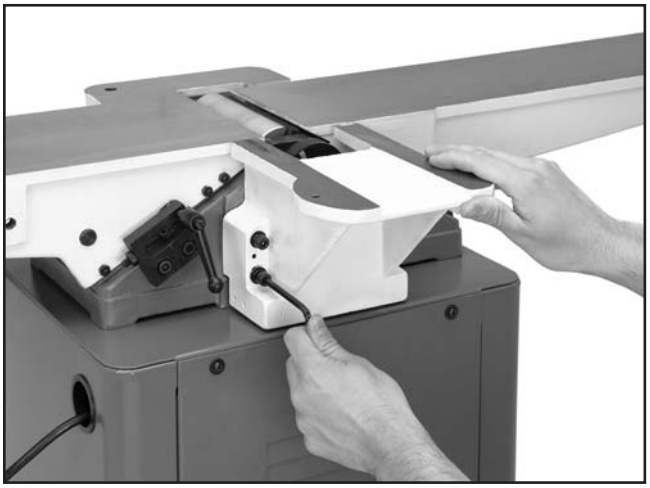


Figure 13. Assembled carriage mounting bracket.

Fence Carriage Assembly

Components and Hardware Needed:	Qty
Fence Carriage Assembly	1
Cap Screws M8-1.25 x 20	2
Lock Washers 8mm	2
Flat Washers 8mm	2

Tools Needed:	Qty
Hex Wrench 6mm	1

To install the fence carriage assembly:

1. Use two M8-1.25 x 20 cap screws, lock washers, and flat washers to secure the fence carriage assembly to the carriage mounting bracket (see **Figure 14**).

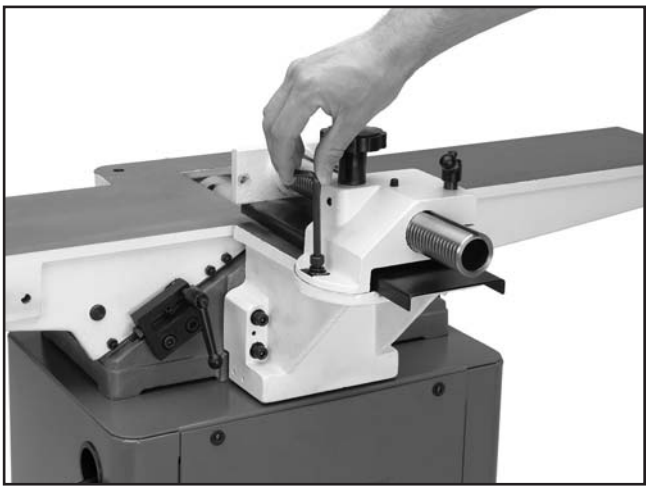


Figure 14. Fence carriage assembly.

Fence Assembly

Components and Hardware Needed:	Qty
Fence Assembly	1
Cap Screws M8-1.25 x 25	2
Lock Washers 8mm	2
Flat Washers 8mm	2
Fence Tilting Handles	2

To install the fence carriage assembly:

1. Use two M8-1.25 x 25 cap screws, lock washers, and flat washers to secure the fence assembly to the fence carriage assembly (see **Figure 15**).

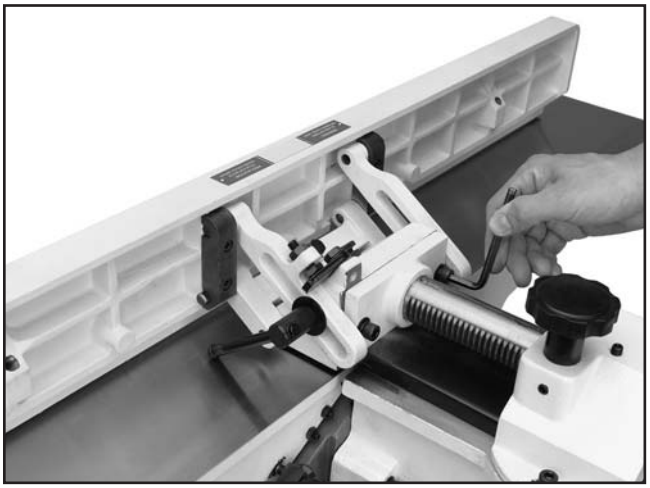


Figure 15. Installing fence assembly.

2. Thread the fence tilting handles into the fence (see **Figure 16**).

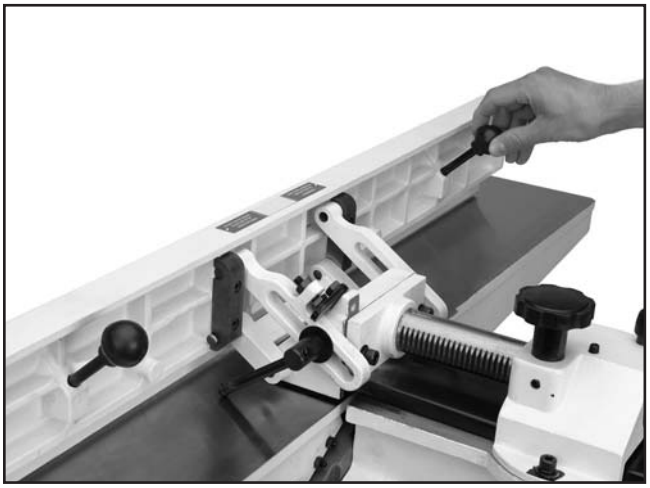


Figure 16. Installing fence tilting handles.

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.

Components and Hardware Needed:	Qty
Cutterhead Guard	1

Tools Needed:	Qty
Hex Wrench 2.5mm	1

To install the cutterhead guard:

1. Remove the set screw in the cutterhead guard shaft (see **Figure 17**).

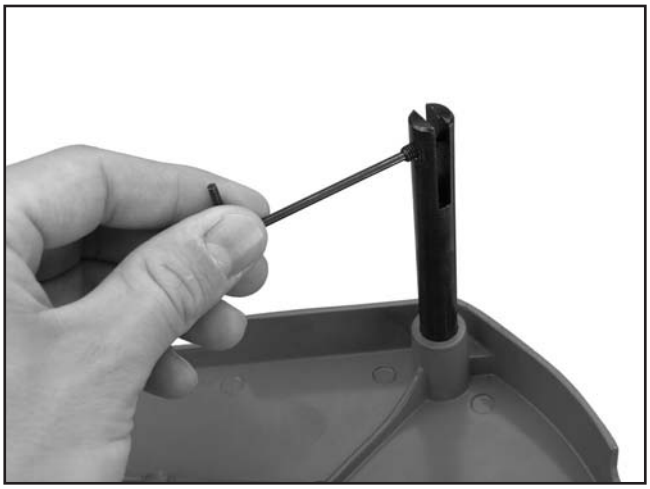


Figure 17. Set screw location.

2. Wind the torsion spring knob back counterclockwise a half turn, and slide the guard shaft into the casting shown in **Figure 18**. Make sure the slot on the cutterhead guard shaft fits over the pin that sits inside the spring knob barrel (hidden from view).

Figure 18. Setting torsion spring knob.

3. Test the guard by pulling it back and letting go.

—The guard should snap back over the cutterhead. If it does, reinsert the set screw (see **Figure 19**).

—If the guard is slow to return across the table, remove the shaft, and add a half turn to the spring knob and test again. Repeat this step as necessary.

Figure 19. Reinstalling set screw.

Dust Port

Components and Hardware Needed: **Qty**
Dust Port 1
Phillips Head Screws M5-.8 x 15..... 4
Flat Washers 5mm 4

Tools Needed: **Qty**
Phillips Head Screwdriver 1

To install the dust port:

Note: If you choose to not use a dust collection system, don't install the dust port. Chips will build up inside the cabinet and clog.

1. Place the dust port over the dust vent in the side of the cabinet.

2. Use the four M5-.8 x 15 Phillips head screws and flat washers to secure the dust port to the cabinet (see **Figure 20**).

Figure 20. Dust port installation.

3. Attach to dust collection system.

Power Switch

Components and Hardware Needed: **Qty**
Power Switch & Support Arm..... 1
Cap Screws M8-1.25 x 25 2
Flat Washers 8mm 2

Tools Needed: **Qty**
Hex Wrench 6mm..... 1

To install the power switch & support arm:

1. Install the support arm with the M8-1.25 x 25 cap screws and flat washers as shown in **Figure 21**.

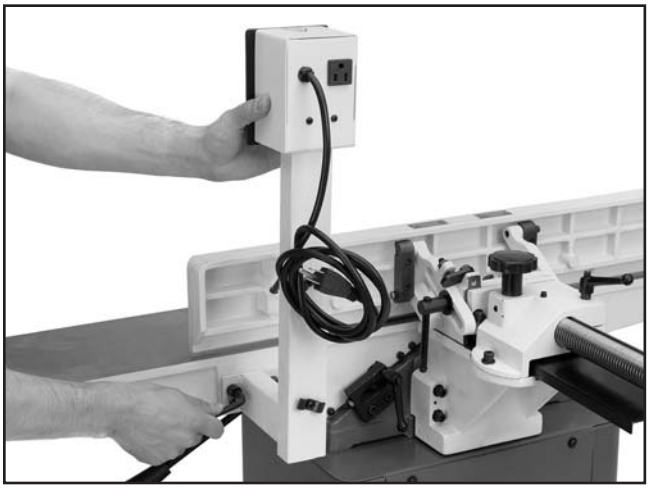


Figure 21. Installing support arm.

2. Plug the motor cord into the back of the switch box, then secure the loose cords with the hold downs shown in **Figure 22.**

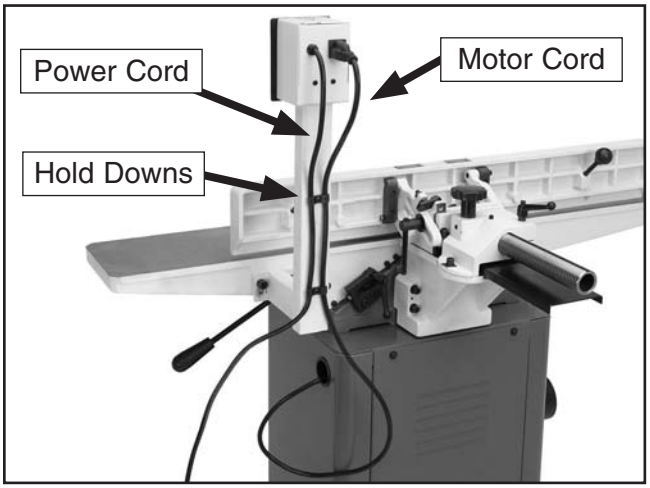


Figure 22. Cord locations.

Handwheels

Components and Hardware Needed: **Qty**
Outfeed Table Handwheel 1
Phillips Head Screw M5-.8 x 15 1
Flat Washer 5mm 1

Tools Needed: **Qty**
Phillips Head Screwdriver 1

To install the handwheel:

1. Remove the screw and flat washer already mounted to the handwheel shaft.

2. Secure the handwheel to the shaft with the hardware removed in **Step 1**.

Figure 23. Securing the handwheel.

Infeed Table Lever

Components and Hardware Needed: **Qty**
Infeed Table Lever 1

Tools Needed: **Qty**
Wrench 19mm 1

To install the infeed table lever:

1. Thread the infeed table lever into the hole shown in **Figure 24**.

2. Tighten the locknut with a 19mm wrench.

Figure 24. Installing infeed table lever.

Setting Outfeed Table Height

The outfeed table must be level with the knives when they are at top-dead-center. This adjustment has been made at the factory but should be checked again before operating your jointer. This adjustment will also have to be made any time you perform maintenance on the cutterhead or knives.

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 is at top-dead-center (TDC), as illustrated in **Figure 25**.

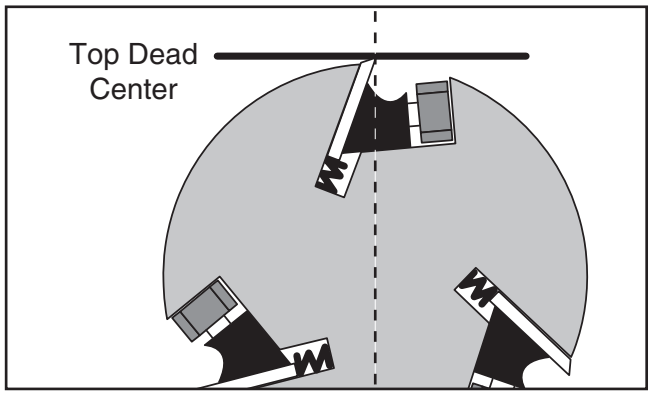


Figure 25. Cutterhead knife at top-dead-center.

3. Raise or lower the outfeed table until the knife just touches the straightedge (**Figure 26**).

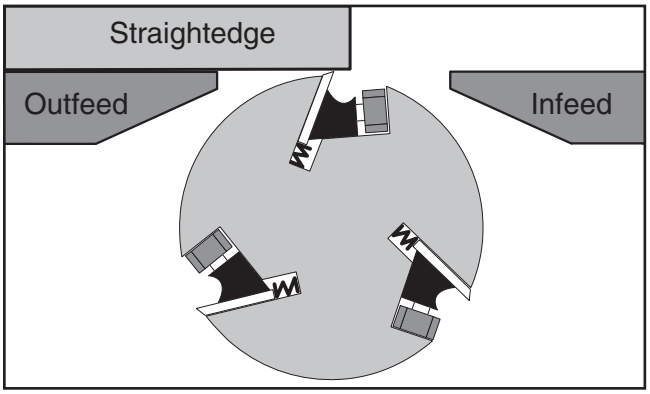


Figure 26. Using a straightedge to align outfeed table height with knife at TDC.

4. Lock the outfeed table in **Figure 27.**

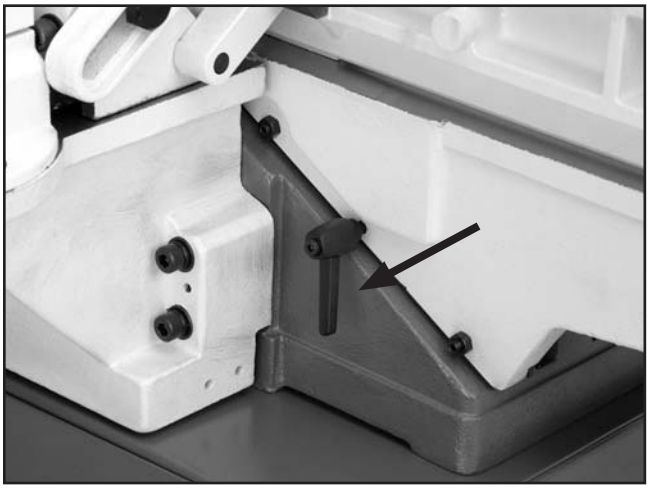
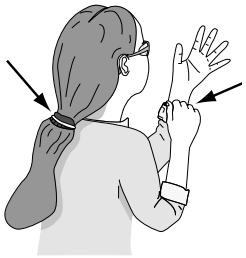


Figure 27. Outfeed table lock.

Test Run



⚠WARNING

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

⚠WARNING

Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

Starting the machine:

1. Read the entire instruction manual.
2. Make sure the cutterhead guard is installed and correctly adjusted (**Page 19**).
3. Make sure all tools and foreign objects have been removed from the machine.
4. Review **SECTION 2: CIRCUIT REQUIREMENTS** on **Page 9** 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 36** to troubleshoot/fix any problems before starting the jointer again.

   —If you need any help with your jointer call our Tech Support at (570) 546-9663.

Recommended Adjustments

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

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 machine.

Step-by-step instructions for these adjustments can be found in **SECTION 7: SERVICE** on **Page 32.**

Factory adjustments that should be verified:

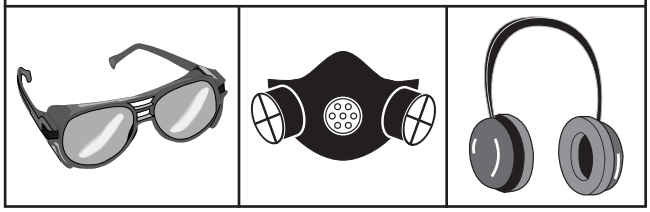
1. Knife Settings (**Page 38**).
2. Depth Scale Calibration (**Page 40**).
3. Fence Stop Accuracy (**Page 41**).

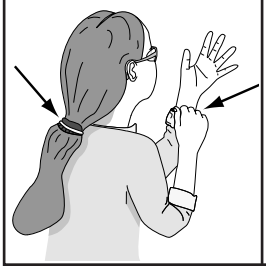
SECTION 4: OPERATIONS

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.

Infeed Table Adjustment

Proper infeed table adjustment must be made to safely and efficiently use the jointer. DO NOT set the infeed table depth greater than 1/16" on your first pass and never greater than 1/8" when rabbeting

⚠WARNING

Kickback can occur if excessive depth of cut is made. Limit a single pass from 1/16" to 1/8". Serious personal injury could occur in the event of a kickback.

To adjust the infeed table:

1. Loosen the infeed table lock in **Figure 28**.

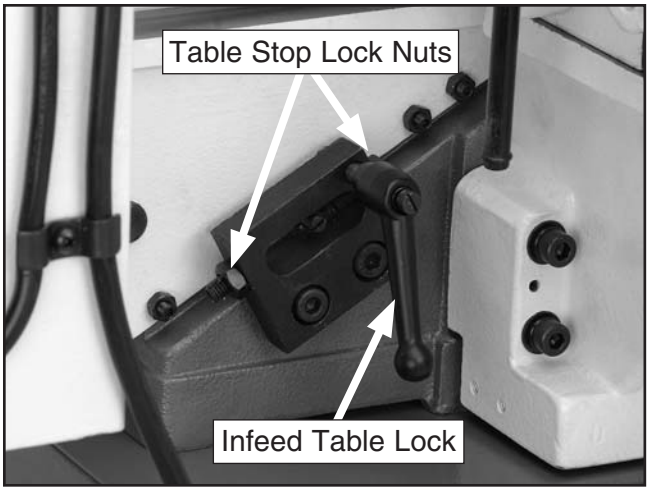


Figure 28. Infeed table lock.

Continued on next page →

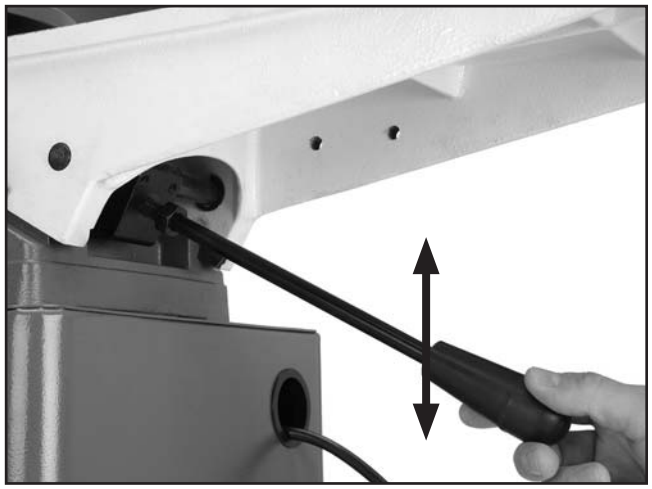


Figure 29. Adjusting infeed table height.

2. Use the infeed table lever to raise or lower the infeed table (**Figure 29).**

3. Use the depth of cut scale to set the infeed table to the desired depth and lock the table in position.

   Note: The infeed table stops can be adjusted to return the table height to the same height every time by loosening the lock nuts and adjusting the set screws.

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 30**).

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

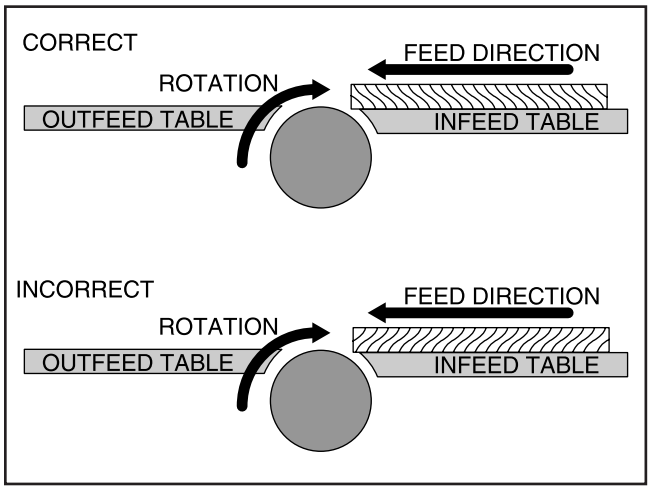


Figure 30. Correct and incorrect grain alignment to cutterhead.

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

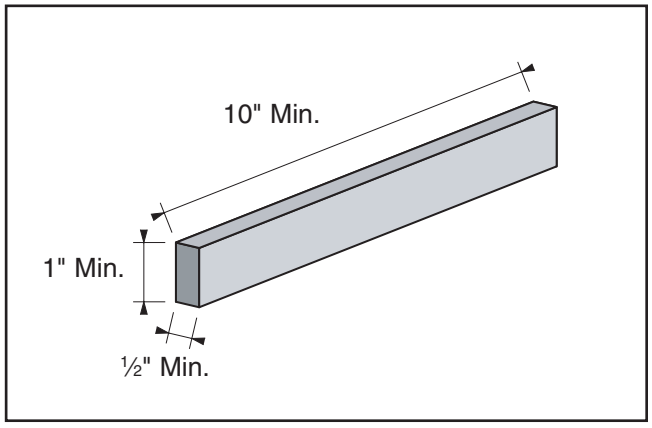


Figure 31. Minimum dimensions for edge jointing.

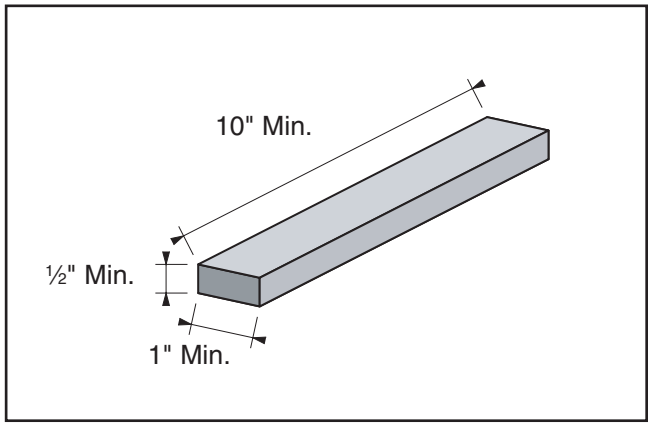
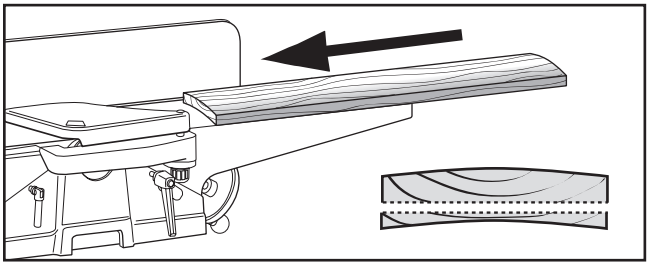


Figure 32. Minimum dimensions for surface planing.

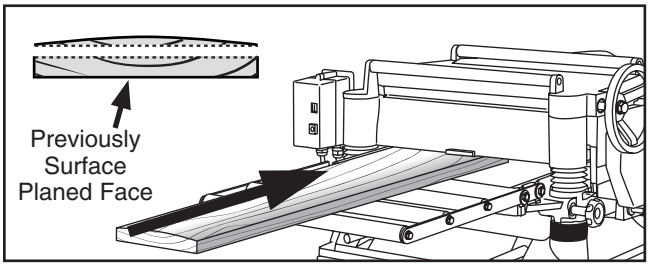
Squaring Stock

Squaring stock involves four steps performed in the order below:

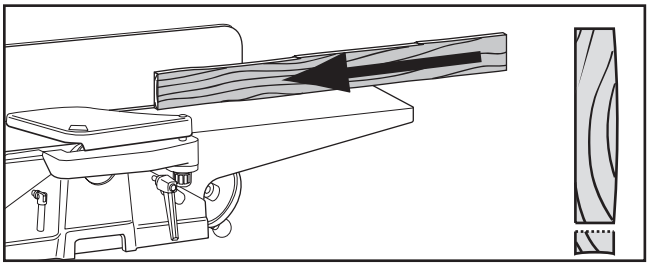
1. Surface Plane on the Jointer—The concave face of the workpiece is surface planed flat with the jointer.



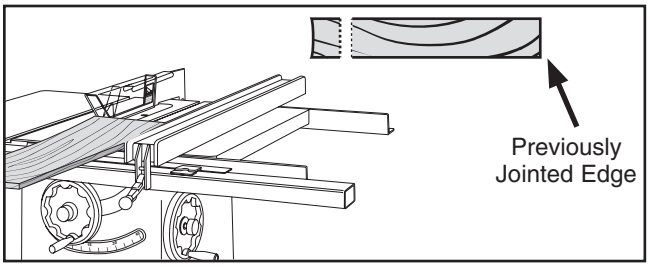
2. Surface Plane on a Thickness Planer—The opposite face of the workpiece is surface planed flat with a thickness planer.



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 33 & 34**) to prepare it for thickness planing on a 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.

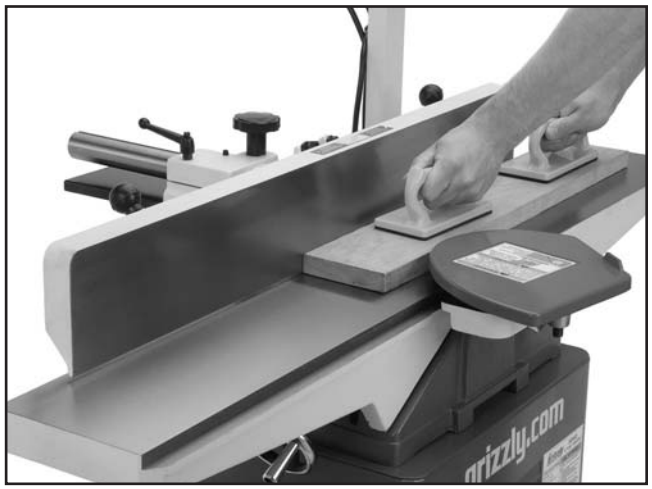


Figure 33. Typical surface planing operation.

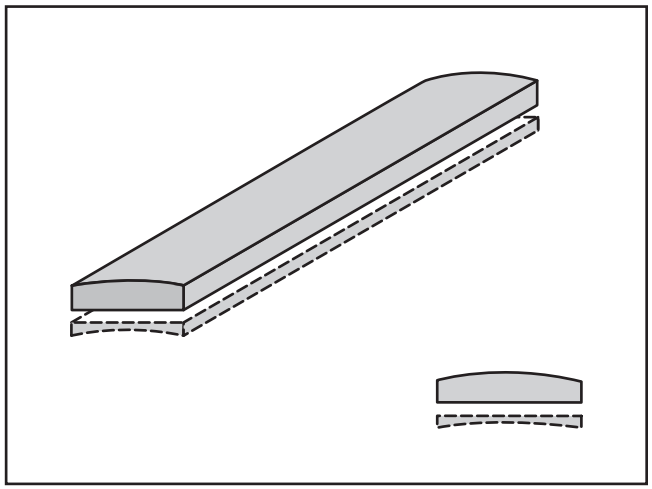


Figure 34. Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY,** beginning on **Page 6**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 25**.

3. Set the cutting depth for your operation. (We suggest 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˚.

5. If your workpiece is cupped (warped), place it so the concave side is face down (**Figure 34**) 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 (see **Figure 33**).

   Note: When 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.

   Note: If 2nd edge is jointed it will not likley be parallel with the 1st.

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 35 & 36**) 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 35. Typical edge jointing operation.

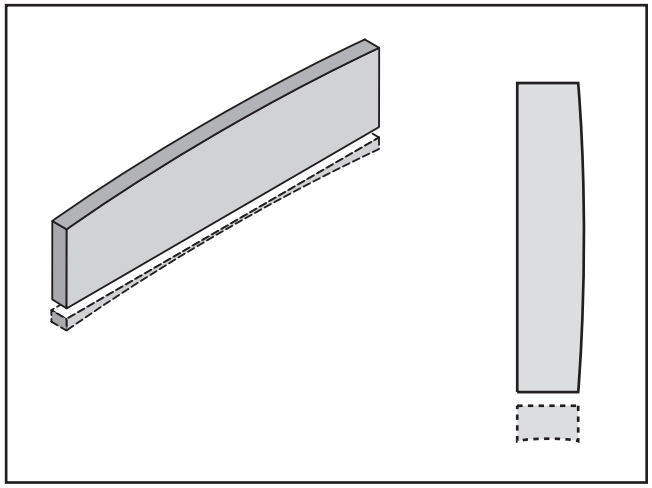


Figure 36. Illustration of edge jointing results.

To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6.**

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection** instructions, beginning on **Page 25**.

3. Set the cutting depth for your operation. (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. Make sure the fence is set to 90˚.

5. If your workpiece is cupped (warped), place it so the concave side is face down (**Figure 36**) on the surface of the infeed table.

6. Start the jointer.

7. Press the workpiece against the table and fence (**Figure 35**) with firm pressure. Use your trailing hand to guide the workpiece through the cut, and feed the workpiece over the cutterhead.

   Note: When 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.

   Note: If 2nd edge is jointed it will not likley be parallel with the 1st.

Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece (see **Figures 37 & 38**).

The Model G0452 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 37. Typical bevel cutting operation.

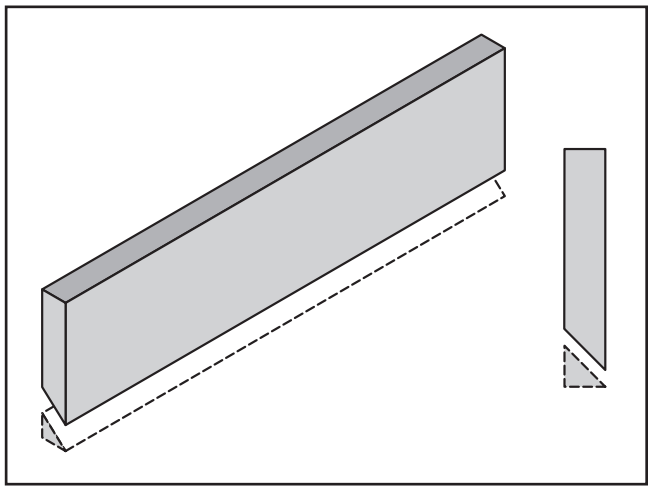


Figure 38. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection** instructions, beginning on **Page 25.**

3. Set the cutting depth for your operation. (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. 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: When 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 39 & 40**). 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 39. Typical rabbet cutting operation.

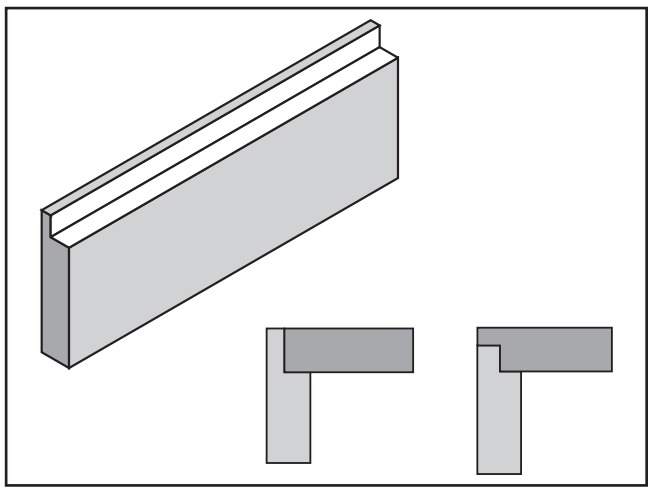


Figure 40. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 6**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection** instructions, beginning on **Page 25**.

3. Set the cutting depth for your operation. (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. 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°.

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: When 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.

⚠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.

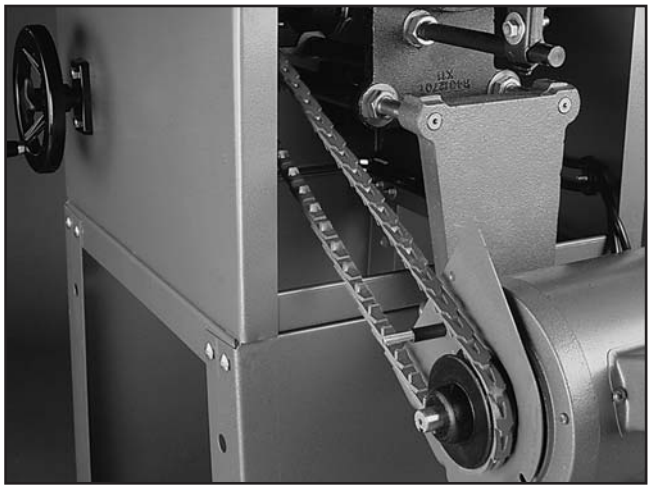


Figure 41. G3640 Power Twist® V-Belt.

H1302—Standard Earmuffs
H4979—Deluxe Twin Cup Hearing Protector
H4977—Work-Tunes Radio Headset Earmuffs
Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.

Figure 42. Our most popular earmuffs.

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 ± 0.001".

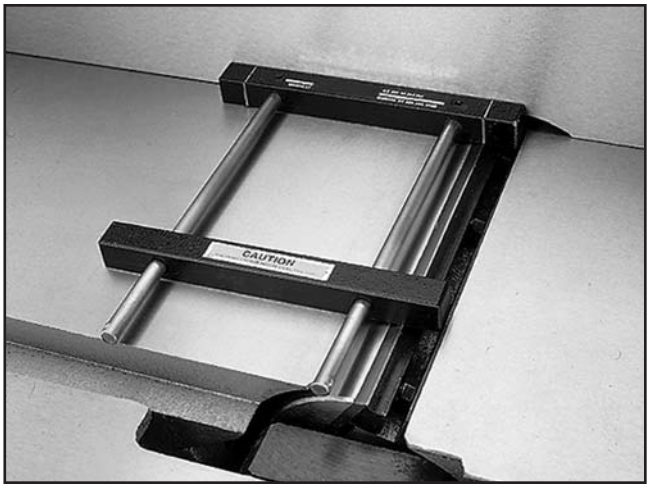


Figure 43. G1753 Jointer Pal® Knife Jig.

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.

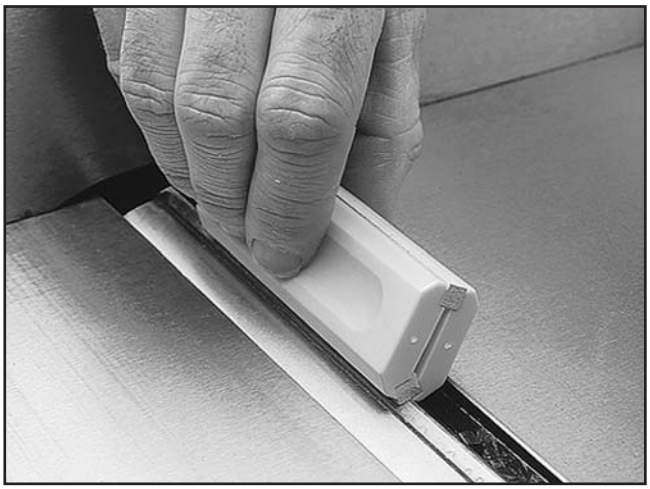


Figure 44. G3631 Jointer/Planer Knife Hone.

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!

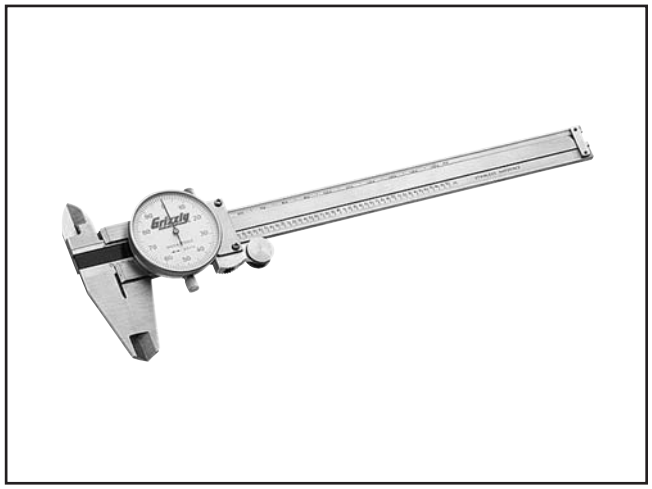


Figure 45. Grizzly® Dial Calipers.

G6660—Dispoz-A-Blade® System (Includes 3 Holders & Knife Inserts)
G6665—Dispoz-A-Blade® Knife Inserts (Set of 3)
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!

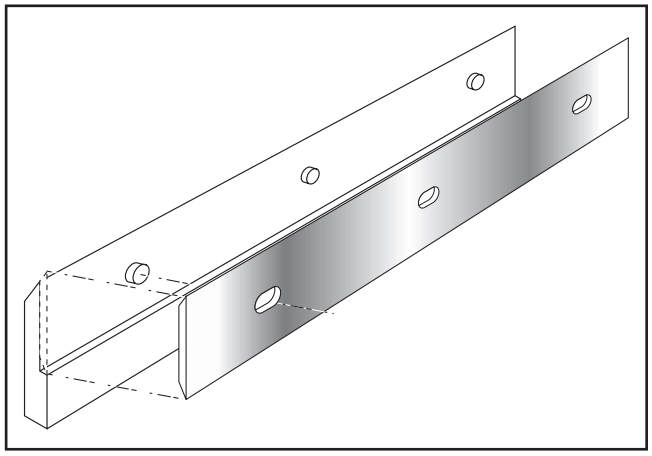


Figure 46. Dispoz-A-Blade® Holder and Knife.

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.

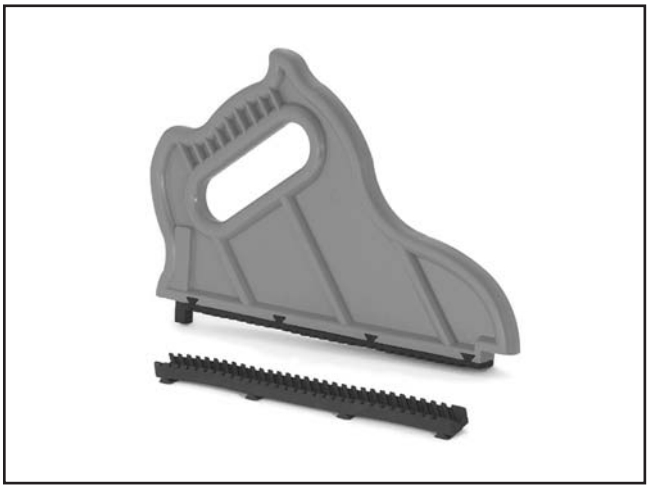


Figure 47. H1411 PowerHands™ Safety Stick.

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.

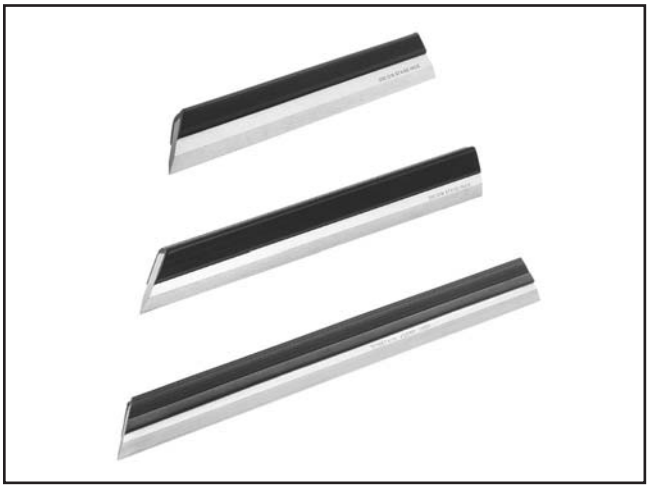


Figure 48. Straightedges.

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 49. 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 50. H6175 Power Respirator.

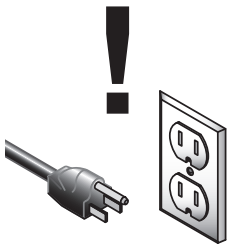
H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Disposable Cartridge Filter Pair P100
Wood dust is a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator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

Figure 51. 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 52. 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:
- Vacuum all dust on and around the machine.
- Wipe down tables and all other unpainted cast iron with a metal protectant.

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

V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition (free from cracks, fraying and wear) and properly aligned and tensioned (refer to the instructions on **Page 16**).

Cleaning

Cleaning the Model G0452 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 31** for more details).

Lubrication

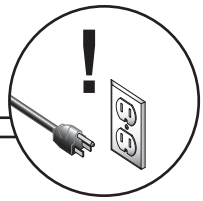
Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

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.

Maintenance Log

Date	Approximate Hours Of Use	Maintenance Performed

SECTION 7: SERVICE

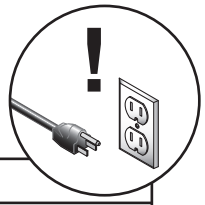


Motor & Machine Operation

Symptom	Possible Cause	Possible Solution
Motor will not start.	1. Emergency stop button depressed. 2. Low voltage. 3. Open circuit in motor or loose connections.	1. Lift the cover on the emergency stop button to allow it to pop out. 2. Check power line for proper voltage. 3. Inspect all lead connections on motor for loose or open connections.
Fuses or circuit breakers blow.	1. Short circuit in line cord or plug.	1. Repair or replace cord or plug for damaged insulation and shorted wires.
Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).	1. Power supply circuit overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long.	1. Reduce load on circuit. 2. Increase wire sizes or reduce length of the circuit.
Motor overheats.	1. Motor overloaded during operation. 2. Air circulation through the motor restricted.	1. Reduce load on motor; take lighter cuts. 2. Clean out motor to provide normal air circulation.
Motor stalls or shuts off during a cut.	1. Motor overloaded during operation. 2. Short circuit in motor or loose connections. 3. Circuit breaker tripped.	1. Reduce load on motor; take lighter cuts. 2. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 3. Install correct circuit breaker; reduce # of machines running on that circuit (circuit overload).
Blade slows when cutting or makes a squealing noise, especially on start-up.	1. V-belt loose. 2. V-belt worn out.	1. Tighten V-belt (**Page 16**). 2. Replace V-belt (**Page 16**).
Loud repetitious noise coming from machine.	1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are damaged.	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belts (**Page 16**).
Vibration when running or cutting.	1. Loose or damaged blade. 2. Damaged V-belt. 3. Worn cutterhead bearings.	1. Tighten or replace blade. 2. Replace. 3. Check/replace cutterhead bearings.

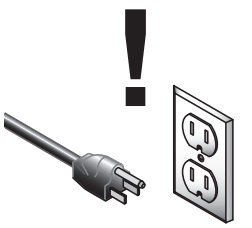
Table

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	1. Table lock is engaged or partially engaged. 2. Table gibs are too tight.	1. Completely loosen the table lock. 2. Re-adjust the table gibs (**Page 42**).
Excessive play in table movement.	1. Table gibs are too loose.	1. Re-adjust the table gibs (**Page 42**).



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 22**). 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 22**).
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 25**); only use clean stock. 2. Adjust one of the nicked knives sideways; or replace knives (**Page 38**). 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 38**).
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; or replace knives (**Page 38**).
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 38**).
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 38**). 4. Adjust one of the nicked knives sideways; replace knives (**Page 38**).



WARNING

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

About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department.

If any adjustments arise that are not described in this manual or you are unsure of how to perform the procedures in this section, then feel free to call Technical Support at (570) 546-9663.

Inspecting Knives

The height of the knives can be easily and quickly 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 outside table or when troubleshooting.

To inspect the knives:

1. **Disconnect the jointer from the power source!**

2. Remove the cutterhead guard or block it out of the way.

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 53**.

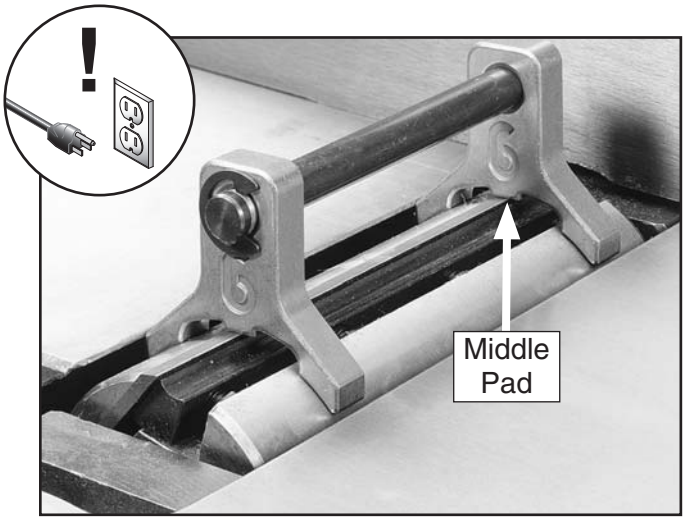


Figure 53. Jig positioned over cutterhead knife.

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.)

Setting 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.

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

The Grizzly G0452 Jointer comes with both jack screws and springs to provide you with two options for cutterhead adjustments (see **Figure 54**). **Note:** Only one of these options is needed to set the knives—see **Step 5*** for clarification.

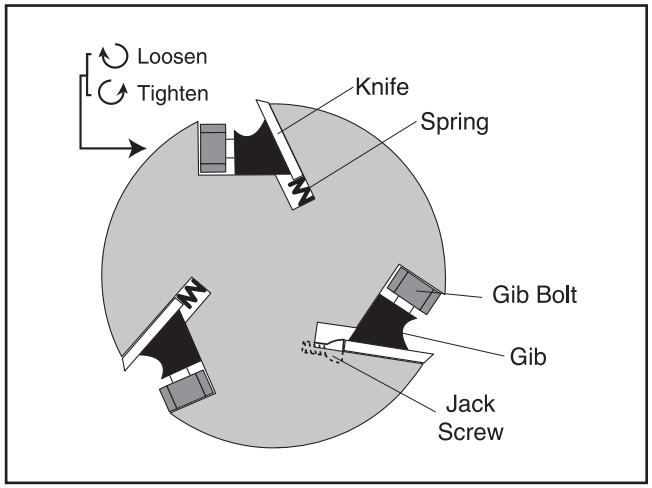


Figure 54. Cutterhead profile diagram.

To set the knives:

1. **Disconnect the jointer from the power source!**

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 cabinet cover to expose the V-belt.

4. Use the V-belt to rotate the cutterhead to access 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.

   ***Note:** If this is the first time you are setting the knives, remove the gib and knife from the cutterhead. Decide which adjustment option you are going to use between the jack screws and the springs. If you decide to use the jack screws, remove the springs from the cutterhead. If you decide to use the springs, you can just thread the jack screws completely into the cutterhead so they will not get lost. Replace the gib and knife.

6. Position the knife gauge over the knife as shown in **Figure 53** and loosen the gib bolts until the knife is completely loose.

7. **Jack Screws**—Using a 3mm hex wrench, find the jack screws through the access holes in the cutterhead (**Figure 55**) and rotate the jack screws to raise or lower the knife. When the knife is set correctly, it will barely touch the middle pad of the knife setting jig. Snug the gib bolts tight enough to just hold the knife in place. Repeat **Steps 5-7** with the rest of the knives.

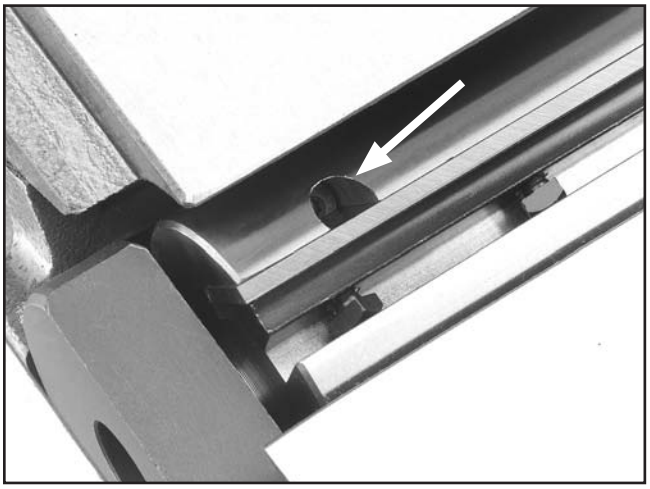


Figure 55. Jack screw access hole.

   Springs—Push the knife down with the jig so the knife edge is touching the middle pad of the jig. Hold the jig down and tighten the gib bolts just tight enough to hold the knife in place. Repeat **Steps 5-7** with the rest of the knives.

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. Repeat this step on the rest of the knives.

9. Final tighten each gib bolt.

10. Adjust the outfeed table to match the new knife heights.

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 **Setting Outfeed Table Height** sub-section.

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 56**.

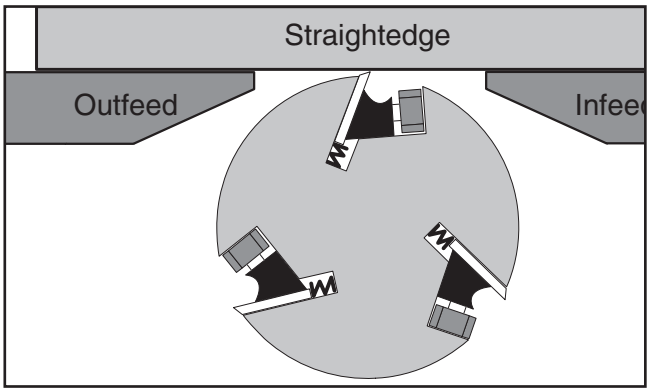


Figure 56. Infeed table adjusted even with outfeed table and knife at TDC.

4. Using a screwdriver, adjust the scale pointer exactly to “0” (**Figure 57**).

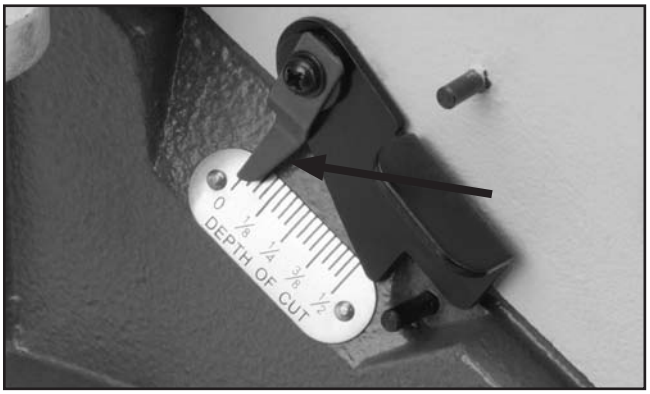


Figure 57. Depth-of-cut pointer adjusted to “0” position.

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 58**.

Figure 58. Adjusting fence 45˚ inward.

2. Loosen the jam nut shown in **Figure 59**.

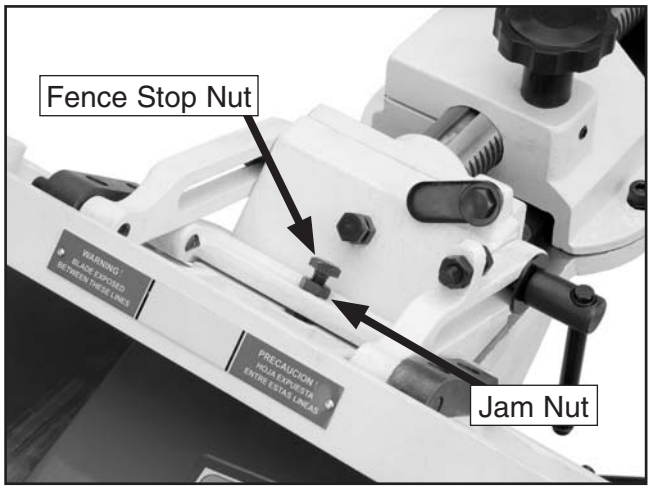


Figure 59. 45˚ inward fence stop jam nut.

3. Adjust the 45˚ inward fence stop nut until it makes contact with the back of the fence bracket.

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

To set the 90˚ fence stop:

1. Flip the 90˚ swing stop into the position shown in **Figure 60**.

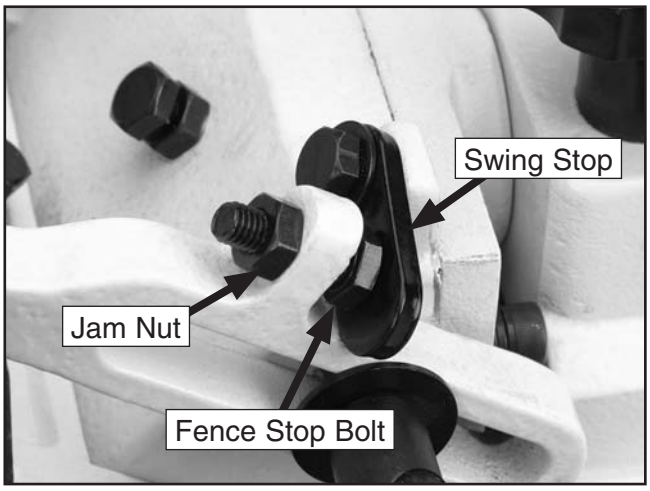


Figure 60. 90˚ swing stop engaged.

2. Using a 90˚ square, adjust the fence to the 90˚ position in **Figure 61** using the fence stop bolt and jam nut.

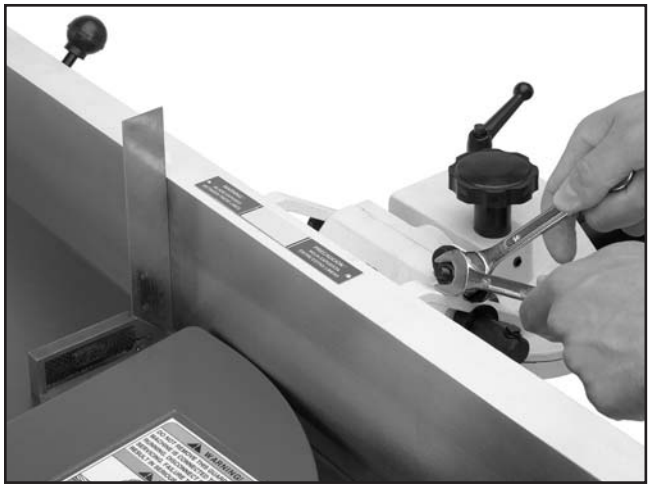


Figure 61. Adjusting fence to 90˚.

3. Loosen the jam nut on the 90˚ fence stop bolt (**Figure 60**).

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** and recheck.

To set the 45˚ outward fence stop:

1. Flip the 90˚ swing stop out of the way as shown in **Figure 62.**

2. Using a sliding bevel adjusted to 135˚, adjust the fence to the 135˚ (45˚ outward) position.

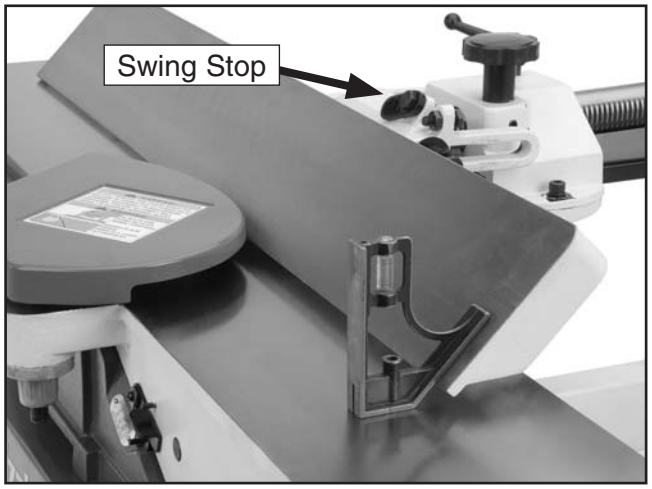


Figure 62. Adjusting fence 45˚ outward.

3. Loosen the jam nut on the 45˚ outward fence stop bolt (**Figure 63**).

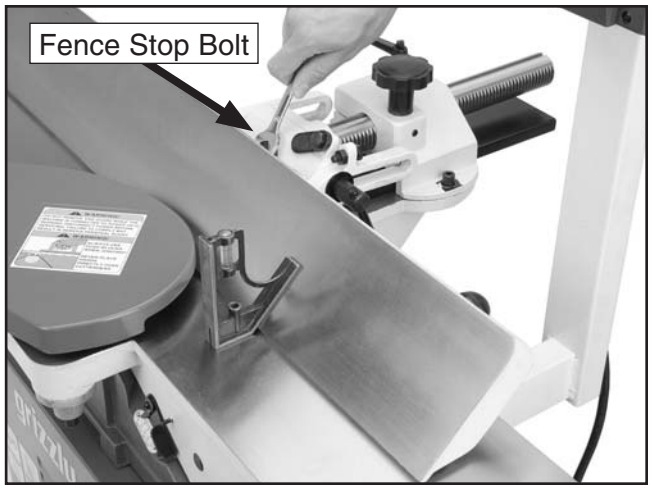


Figure 63. 45˚ outward fence stop jam nut.

4. Adjust the 45˚ outward fence stop bolt until it makes contact with the back of the fence.

5. Retighten the jam nut loosened in **Step 3** and recheck.

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 10mm wrench, loosen the two outfeed table gib nuts on the side of the jointer base (**Figure 64**).

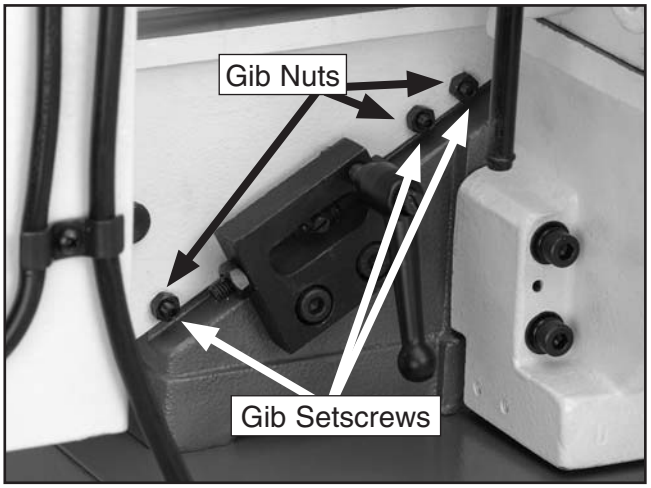


Figure 64. Outfeed table gib controls.

2. Using a 3mm 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 22**.

Electrical Components

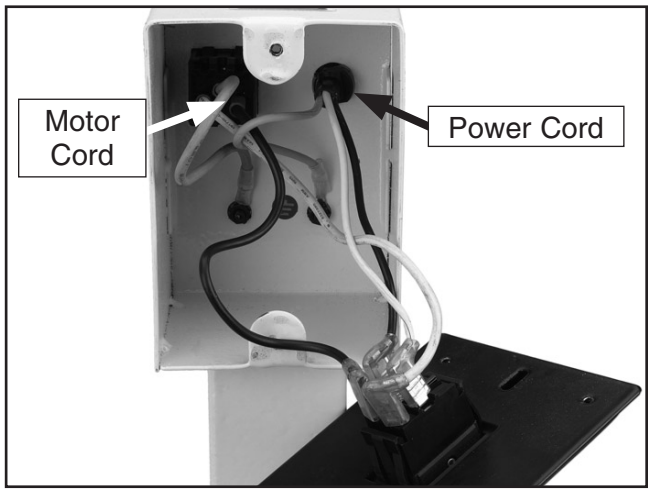


Figure 65. G0452 switch.

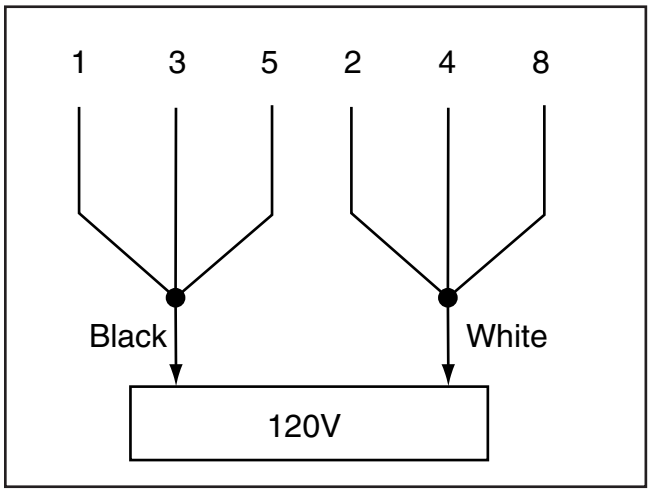
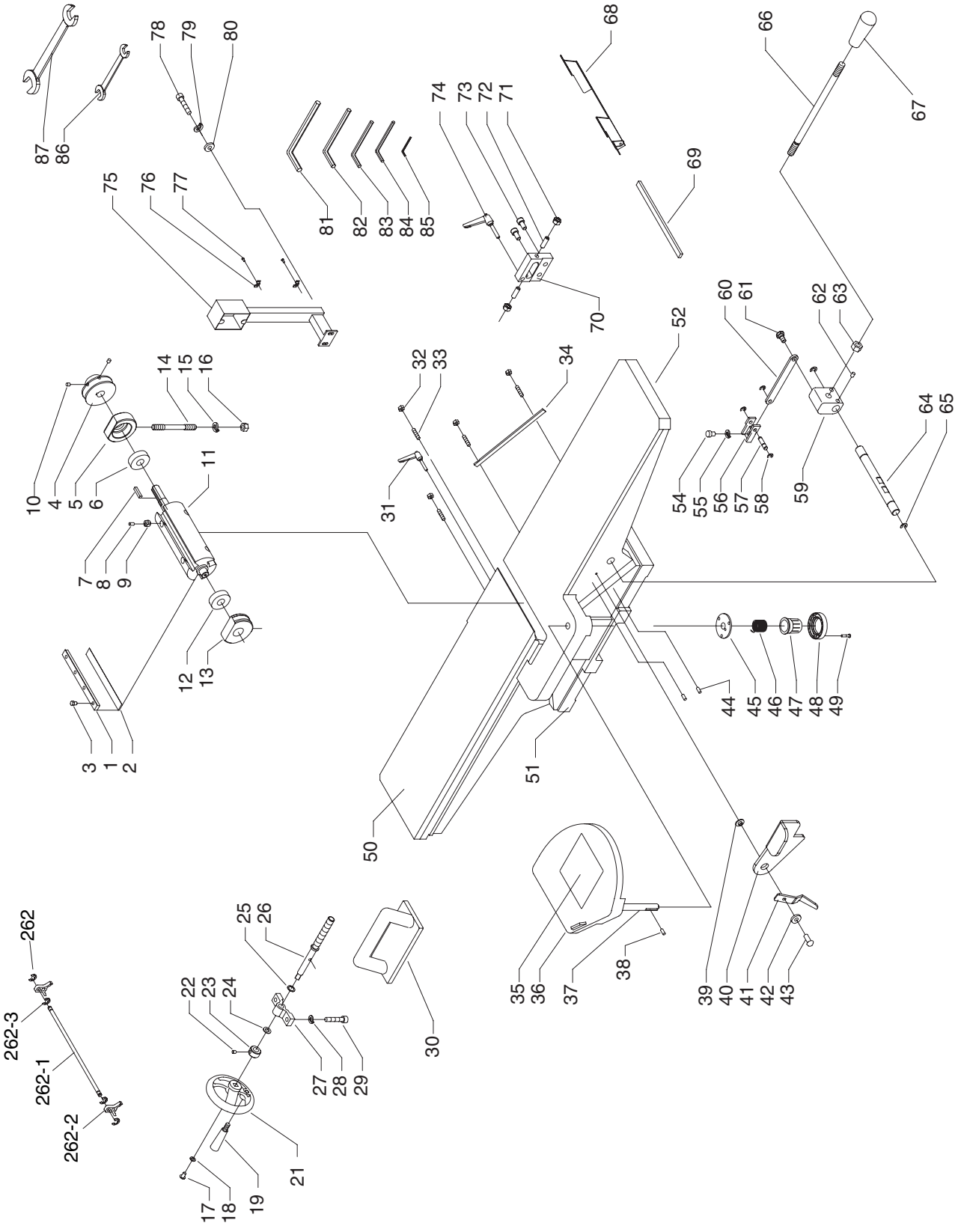


Figure 66. G0452 motor wiring diagram.

Note: Always refer to the cover on your junction box for the most up to date information regarding your specific motor wiring.

G0452 Table Parts Breakdown

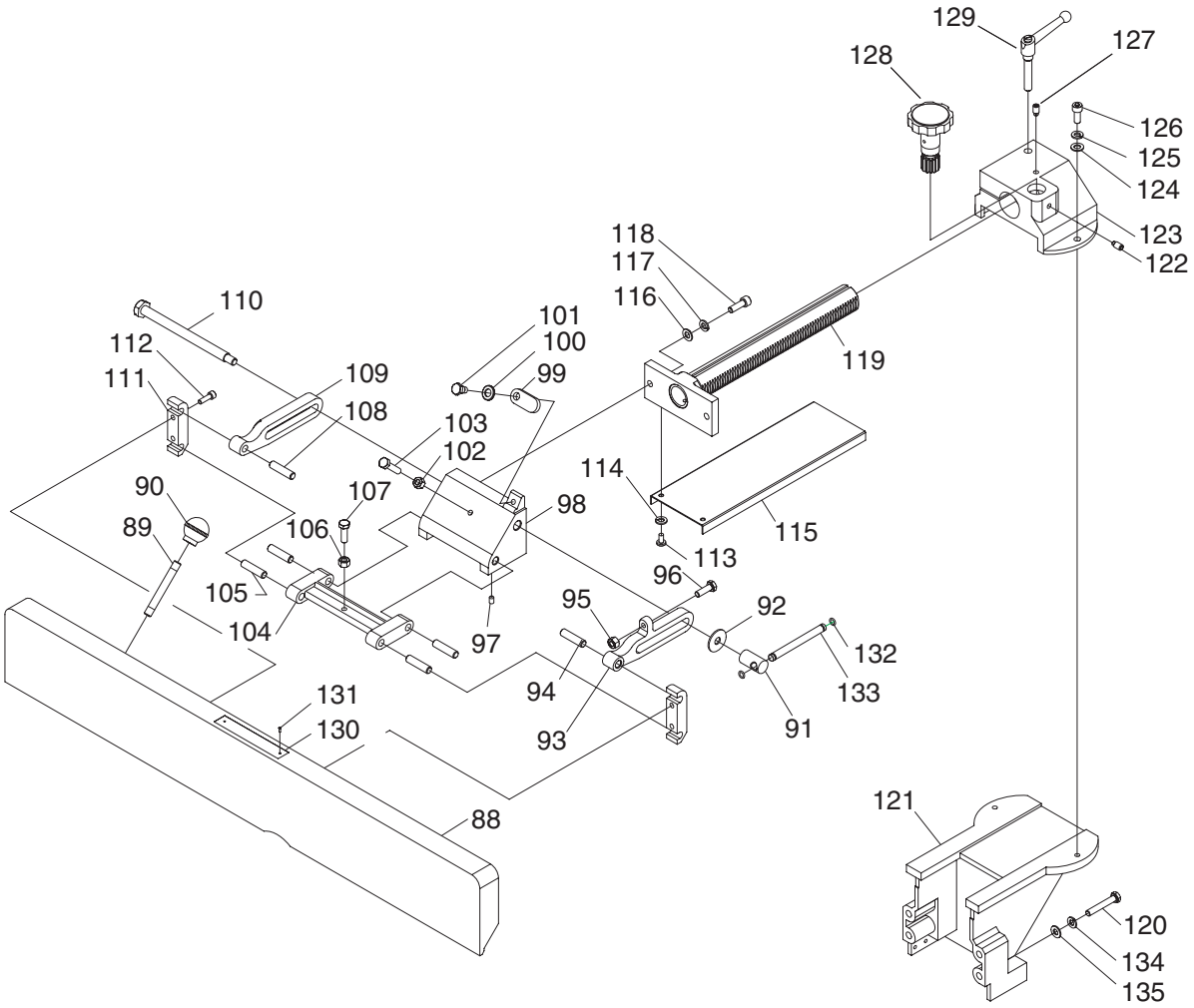


G0452 Table Parts List

REF	PART #	DESCRIPTION
1	P0452001	GIB
2	P0452002	KNIVES
3	P0452003	GIB SCREW 1/4-28 X 9/32"
4	P0452004	PULLEY
5	P0452005	BEARING BLOCK RIGHT
6	P6203	BALL BEARING 6203ZZ
7	PK12M	KEY 5 X 5 X 30
8	PSS53M	SET SCREW M5-.8 X 12
9	P0452009	SPECIAL NUT
10	PSS01M	SET SCREW M6-1 X 10
11	P0452011	CUTTERHEAD
12	P6202	BALL BEARING 6202ZZ
13	P0452013	BEARING BLOCK LEFT
14	P0452014	STUD M10-1.5 X 100
15	PLW06M	LOCK WASHER 10MM
16	PN02M	HEX NUT M10-1.5
17	PSBS09M	BUTTON HD CAP SCR M6-1 X 12
18	PW03M	FLAT WASHER 6MM
19	P0452019	HANDLE
21	P0452021	HANDWHEEL
22	PSS02M	SET SCREW M6-1 X 6
23	P0452023	COLLAR
24	PW06M	FLAT WASHER 12MM
25	PW06M	FLAT WASHER 12MM
26	P0452026	SCREW SHAFT
27	P0452027	BLOCK
28	PLW04M	LOCK WASHER 8MM
29	PSB05M	CAP SCREW M8-1.25 X 50
30	P0452030	JOINTER PUSH BLOCK
31	P0452031	LOCK HANDLE
32	PN01M	HEX NUT M6-1
33	PSS12M	SET SCREW M6-1 X 25
34	P0452034	GIB
35	P0452035	CUTTER GUARD LABEL
36	P0452036	CUTTER HEAD GUARD
37	P0452037	POST
38	PSS47M	SET SCREW M3-.5 X 10
39	P0452039	SPACER
40	P0452040	STOP
41	P0452041	POINTER
42	PW05M	FLAT WASHER 4MM
43	PSBS14M	BUTTON HD CAP SCR M4-.7 X 15
44	PRP39M	ROLL PIN 4 X 20

REF	PART #	DESCRIPTION
45	P0452045	PLATE
46	P0452046	TORSION SPRING
47	P0452047	CUP
48	P0452048	RETAINER
49	PSBS15M	BUTTON HD CAP SCR M4.7 X 18
50	P0452050	OUTFEED TABLE
51	P0452051	BASE
52	P0452052	INFEED TABLE
54	PSB100M	CAP SCREW M8-1.25 X 15
55	PLW04M	LOCK WASHER 8MM
56	P0452056	BRACKET
57	P0452057	PIN
58	PR73M	EXT RETAINING RING 5MM
59	P0452059	BLOCK
60	P0452060	LINK
61	P0452061	SPECIAL BOLT
62	PSS20M	SET SCREW M8-1.25 X 8
63	PN09M	HEX NUT M12-1.75
64	P0452064	SHAFT
65	PR03M	EXT RETAINING RING 12MM
66	P0452066	LEVER ROD
67	P0452067	HANDLE
68	P0452068	DUST CHUTE
69	P0452069	SEAL
70	P0452070	BLOCK
71	PN03M	HEX NUT M8-1.25
72	PSS21M	SET SCREW M8-1.25 X 25
73	PSB11M	CAP SCREW M8-1.25 X 16
74	P0452074	LOCK LEVER ASSY
75	P0452075	SWITCH MOUNTING BRACKET
76	P0452076	STRAIN RELIEF
77	PSBS06M	BUTTON HD CAP SCR M5-.8 X 12
78	PSB64M	CAP SCREW M10-1.5 X 25
79	PLW06M	LOCK WASHER 10MM
80	PW04M	FLAT WASHER 10MM
81	PAW08M	HEX WRENCH 8MM
82	PAW06M	HEX WRENCH 6MM
83	PAW04M	HEX WRENCH 4MM
84	PAW03M	HEX WRENCH 3 MM
85	PAW2.5M	HEX WRENCH 2.5 MM
86	PWR810	OPEN END WRENCH M8 X10
87	PWR1214	OPEN END WRENCH M12 X14

G0452 Fence Parts Breakdown

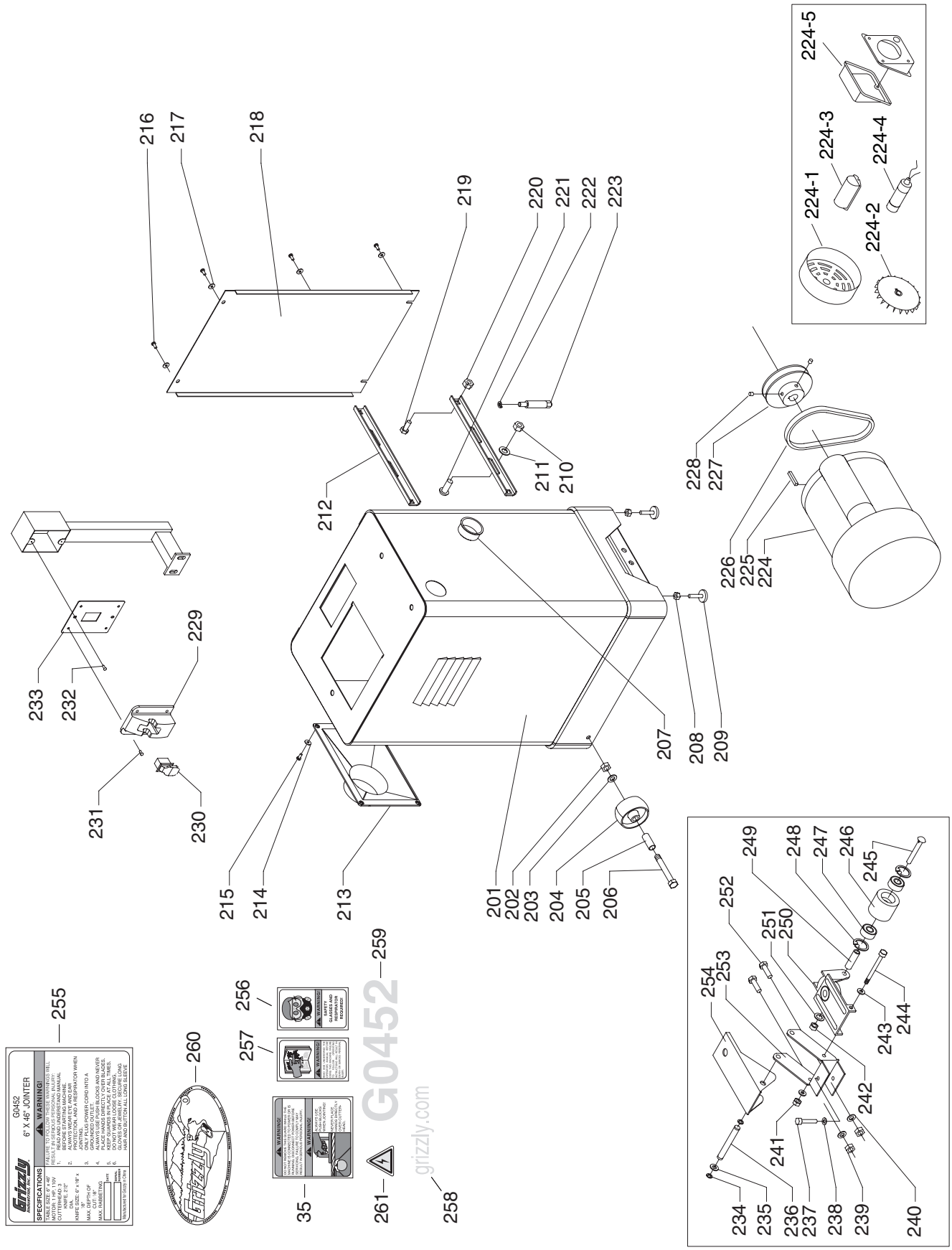


G0452 Fence Parts List

REF	PART #	DESCRIPTION
88	P0452088	FENCE
89	P0452089	LEVER ROD
90	P0452090	BALL KNOB
91	P0452091	HANDLE HUB
92	PW04M	FLAT WASHER 10MM
93	P0452093	RIGHT BRACKET
94	P0452094	PIN
95	PN03M	HEX NUT M8-1.25
96	PB07M	HEX BOLT M8-1.25 X 25
97	PSS01M	SET SCREW M6-1 X 10
98	P0452098	FENCE BRACKET
99	P0452099	STOP
100	PW04M	FLAT WASHER 10MM
101	P0452101	SHOULDER BOLT M8-1.25 X 15
102	PN03M	HEX NUT M8-1.25
103	PB07M	HEX BOLT M8-1.25 X 25
104	P0452104	SUPPORT
105	P0452105	PIN
106	PN03M	HEX NUT M8-1.25
107	PB07M	HEX BOLT M8-1.25 X 25
108	P0452108	PIN
109	P0452109	LEFT BRACKET
110	P0452110	SPECIAL SCREW
111	P0452111	REAR CLAMP

REF	PART #	DESCRIPTION
112	PSB02M	CAP SCREW M6-1 X 20
113	PS14M	PHLP HD SCR M6-1 X 12
114	PLW04M	LOCK WASHER 8MM
115	P0452115	GUARD
116	PW01M	FLAT WASHER 8MM
117	PLW04M	LOCK WASHER 8MM
118	PSB31M	CAP SCREW M8-1.25 X 25
119	P0452119	RAM
120	PSB35M	CAP SCREW M8-1.25 X 60
121	P0452121	BRACKET
122	PSS14M	SET SCREW M8-1.25 X 12
123	P0452123	BRACKET
124	PW01M	FLAT WASHER 8MM
125	PLW04M	LOCK WASHER 8MM
126	PSB14M	CAP SCREW M8-1.25 X 20
127	PSS14M	SET SCREW M8-1.25 X 12
128	P0452128	HANDWHEEL
129	P0452129	LEVER ASSEMBLY
130	P0452130	FENCE WARNING LABEL
131	P0452131	ALUMINIUM RIVET
132	P0452132	O RING
133	P0452133	LOCK BAR
134	PLW04M	LOCK WASHER 8MM
135	PW01M	FLAT WASHER 8MM

G0452 Base Parts Breakdown



G0452 Base Parts List

REF	PART #	DESCRIPTION
201	P0452201	CABINET
202	PN03M	HEX NUT M8-1.25
203	PW01M	FLAT WASHER 8MM
204	P0452204	WHEEL
205	P0452205	SLEEVE
206	PSB66M	CAP SCREW M8-1.25 X 65
207	P0452207	STRAIN RELIEF
208	PN08	HEX NUT 3/8-16
209	P0452209	ADJUSTING SCREW
210	PN02	HEX NUT 5/16-18
211	PW04M	FLAT WASHER 10MM
212	P0452212	MOTOR BRACKET
213	P0452213	DUST CHUTE
214	PW02M	FLAT WASHER 5MM
215	PSBS16M	BUTTON HD CAP SCR M5-.8 X 16
216	PSBS16M	BUTTON HD CAP SCR M5-.8 X 16
217	PW02M	FLAT WASHER 5MM
218	P0452218	CABINET REAR COVER
219	PB07	HEX BOLT 5/16-18 X 3/4
220	PN02	HEX NUT 5/16-18
221	PCB11	CARRIAGE BOLT 5/16-18 X 1
222	PLW06M	LOCK WASHER 10MM
223	P0452223	SPECIAL BOLT
224	P0452224	MOTOR ASSY 1HP,1-PHASE
224-1	P0452224-1	FAN COVER
224-2	P0452224-2	MOTOR FAN
224-3	P0452224-3	CAPACITOR COVER
224-4	P0452224-4	START CAPACITOR 200MFD 125V
224-5	P0452224-5	JUNCTION BOX
225	PK12M	KEY 5 X 5 X 30
226	PVA38	V-BELT A-38 4L380
227	P0452227	MOTOR PULLEY
228	PSS02M	SET SCREW M6-1 X 6
229	P0452229	SWITCH BOX
230	P0452230	PADDLE SWITCH

REF	PART #	DESCRIPTION
231	PHTEK4M	TAP SCREW M4 X 8
232	PHTEK4M	TAP SCREW M4 X 8
233	P0452233	SWITCH PLATE
234	PR16M	EXT RETAINING RING 9MM
235	PW06M	FLAT WASHER 12MM
236	P0452236	SHAFT
237	PB22M	HEX BOLT M8-1.25 X 50
238	PW01M	FLAT WASHER 8MM
239	PN02M	HEX NUT M10-1.5
240	PW04M	FLAT WASHER 10MM
241	PN03M	HEX NUT M8-1.25
242	PN02M	HEX NUT M10-1.5
243	PW01M	FLAT WASHER 8MM
244	PB45M	HEX BOLT M8-1.25 X 100
245	P0452245	SPECIAL BOLT
246	P0452246	TROLLEY WHEEL
247	P6202	BALL BEARING 6202ZZ
248	PR21M	INT RETAINING RING 35MM
249	P0452249	SLEEVE
250	P0452250	TROLLEY UNIVERSAL KIT
251	PW04M	FLAT WASHER 10MM
252	PB144M	HEX BOLT M10-1.5 X 55
253	P0452253	BRACKET
254	P0452254	TREADLE
255	P0452255	MACHINE ID LABEL
256	PLABEL-37	RESPIRATOR/GLASSES LABEL
257	PLABEL-12	READ MANUAL LABEL
258	P0452258	GRIZZLY.COM LABEL
259	P0452259	G0452 LABEL
260	G8588	GRIZZLY LOGO PLATE
261	PLABEL-14	ELECTRICITY LABEL
262	P0452262	KNIFE JIG
262-1	P0452262-1	ROD
262-2	P0452262-2	KNIFE JIG FOOT
262-3	P0452262-3	E-CLIP 9MM

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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.

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____ Journal of Light Cont.
____ Live Steam
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____ Modeltec
____ Old House Journal
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____ Popular Science
____ Popular Woodworking
____ Practical Homeowner
____ Precision Shooter
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____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
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____ Woodwork
____ Woodworker West
____ Woodworker's Journal
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4. What is your age group?

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____ 50-59 ____ 60-69 ____ 70+

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