

Grizzly **Industrial, Inc.**®

MODEL G0725

6" JOINTER

OWNER'S MANUAL

(For models manufactured since 09/11)



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#KN14361 PRINTED IN CHINA



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Manual Accuracy

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

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

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		WARNING!	
Motor:		Manufacture Date of Your Machine When using this machine: 1. Always wear eye protection, ear protection, and respirator. 2. Read and understand the manual before starting. 3. Do not touch the machine until you are properly trained. 4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. 5. DO NOT expose to rain or dampness. 6. DO NOT modify this machine in any way. 7. DO NOT remove safety guards. 8. Never leave machine running unattended. 9. DO NOT operate under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.	
Specification:			
Specification:			
Specification:			
Weight:			
<input type="text"/>	Date		
<input type="text"/>	Serial Number		
Manufactured for Grizzly in Taiwan			

For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

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

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

Machine Description

The G0726 6" Jointer is a benchtop machine; its compact size makes for convenient placement in any shop. It mounts and dismounts quickly to a workbench making it portable when necessary.

It is primarily used to produce straight, flat faces on a workpiece, in order to properly square the material for further layout, construction and joining.



Identification

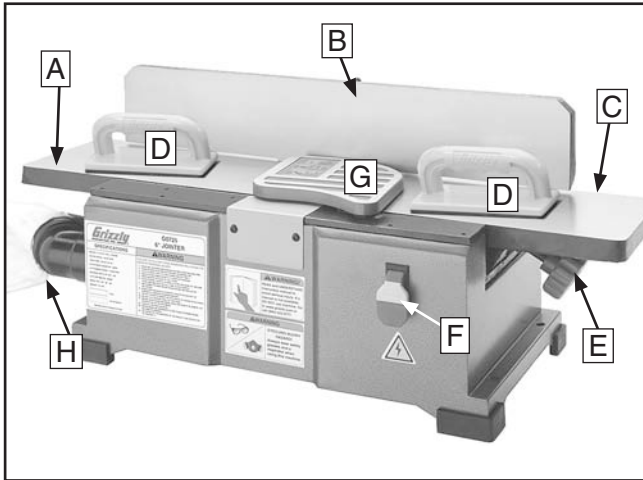


Figure 1. G0725 identification — front view.

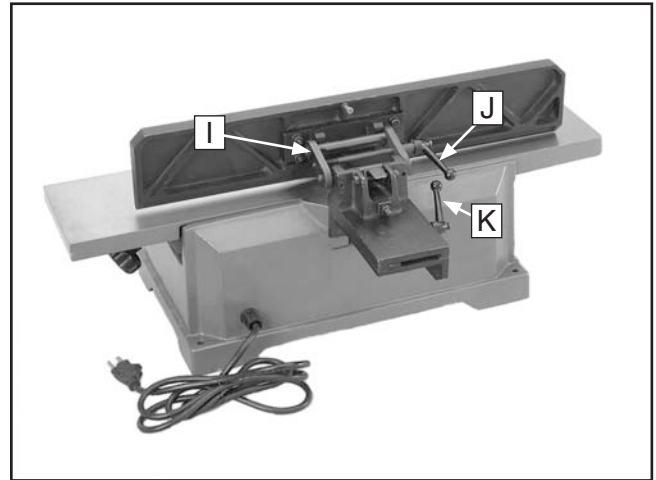
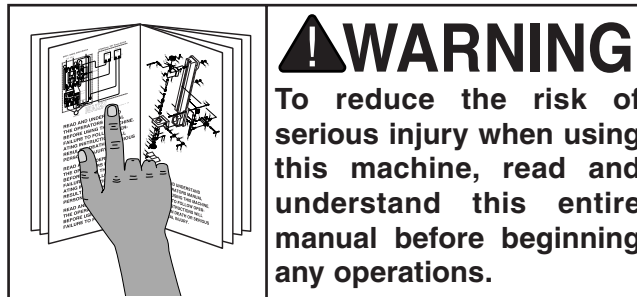


Figure 2. G0725 identification — back view.

- A. Outfeed Table
- B. Fence
- C. Infeed Table
- D. Push Blocks
- E. Depth of Cut Adjusting Knob
- F. ON/OFF Switch w/ Disabling Key
- G. Cutterhead Guard
- H. Dust Collection Bag

- I. Fence Bracket Assembly
- J. Fence Tilting Handle
- K. Fence Sliding Handle



!WARNING

For Your Own Safety, Read Instruction Manual Before Operating Jointer

- a) Wear eye protection.
- b) Always keep cutterhead and drive guards in place and proper operating condition.
- c) Always use hold down/push blocks for jointing material narrower than 3 inches, or planing material thinner than 3 inches.
- d) Never perform jointing or planing on pieces shorter than 8 inches.



Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this jointer and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is **VERY** important to us at Grizzly!

Bed Length: The combined length of the infeed and outfeed table.

Bed Width: The width of the infeed and outfeed tables.

Bevel Edge Jointing: Tilting the fence to an angle between 0° and 45° inward and outward to joint a beveled edge onto a workpiece.

Burn: A material defect appearing as a dark spot on the material. It is caused by the friction of the material passing over the cutterhead.

Concave Cuts: A material defect where the center of the material is concave, caused by non-parallel tables.

Convex Cuts: A material defect where the center of the material is convex, caused by non-parallel tables.

Cutterhead: The spinning head that holds the jointer knives.

Cutterhead Guard: A spring mounted cover that prevents operator contact with the cutterhead, yet allows the workpiece to pass over the cutterhead.

Cutterhead Rotation: The direction the cutterhead spins when jointer is in operation.

Depth-of-Cut: The amount of material the jointer removes in a single pass.

Feed Direction: The direction in which material is passed over the jointer during a jointing operation.

Fence: The metal guide along which the workpiece rides when passing over the jointer. Its angle is adjustable. Proper angle adjustment is essential for accurate jointer operations.

Infeed Table: The adjustable section of the jointer on which the material rides before passing over cutterheads. This is the part of the jointer that adjusts the depth-of-cut setting.

Outfeed Table: The stationary portion of the jointer upon which the material rides after passing over the cutterhead.

Push Blocks: Safety devices that allow the operator's hands to stay away from the cutterhead while feeding the material through the jointer.

Rough Cuts: A material defect where the jointer blades fail to sever wood fibers and tear out occurs.

Ripples: A material defect where the feed rate is too fast and the cut of the knives is exaggerated.

Ribbed Cut: A material defect where an uneven surface is produced on the jointed face of the material; it usually appears as narrow high spots over the length of the material.

Snipe: A material defect appearing as a beveled edge on the back of the material, usually caused by the outfeed table being too low.





MACHINE DATA SHEET

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

MODEL G0725 6" JOINTER

Product Dimensions:

Weight..... 76 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 24 x 6 x 7-3/4 in.
 Footprint (Length x Width)..... 18-7/8 x 11 in.

Shipping Dimensions:

Type..... Cardboard
 Content..... Machine
 Weight..... 80 lbs.
 Length x Width x Height..... 26 x 8 x 10 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
 Minimum Circuit Size..... 15 Amp
 Cord Length..... 8 ft.
 Cord Gauge..... 16 AWG
 Plug Included..... Yes
 Included Plug Type..... NEMA 5-15

Motors:

Main

Type..... Universal
 Horsepower..... 1-1/2 HP
 Voltage..... 110V
 Phase..... Single-Phase
 Amps..... 12A
 Speed..... 20,000 RPM
 Cycle..... 60 Hz
 Number of Speeds..... 1
 Power Transfer Belt Drive
 Bearings..... Shielded and Lubricated

Main Specifications:

Cutting Capacities

Bevel Jointing..... Left & Right 45 deg.
 Maximum Width of Cut..... 6 in.
 Maximum Depth of Cut..... 1/8 in.
 Number of Cuts Per Minute..... 20,000

Fence Information

Fence Length..... 22-7/8 in.
 Fence Width..... 3/4 in.
 Fence Height..... 4-5/16 in.
 Fence Stops..... 45 & 90 deg.

Cutterhead Information

Cutterhead Type..... 2 Knife
 Cutterhead Diameter..... 1-7/8 in.
 Cutterhead Speed..... 10,000 RPM



Knife Information

Number of Knives..... 2
Knife Type..... Straight
Knife Length..... 6-1/2 in.
Knife Width..... 7/8 in.
Knife Thickness..... 3/32 in.
Knife Adjustment..... Jack Screw

Table Information

Table Length..... 28-1/2 in.
Table Width..... 6-1/4 in.
Table Thickness..... 1/4 in.
Floor to Table Height..... 73-1/4 in.
Table Adjustment Type..... Knob
Table Movement Type..... Swing

Construction

Base..... Pre-formed Steel
Body Assembly..... Pre-formed Steel
Cabinet..... Pre-formed Steel
Fence Assembly..... Cast Iron
Guard..... Aluminum
Table..... Precision-Ground Cast Iron
Paint..... Powder Coated

Other Information

Number of Dust Ports..... 1
Dust Port Size..... 2-1/2 in.

Other Specifications:

Country Of Origin China
Warranty 1 Year

Features:

- 45 Degree Inward, 90 and 45 Degree Outward Stops
- Jack Screw Knife Adjustment
- 2-1/2 in. Dust Port
- 2 Safety Push Blocks
- Dust Collection Fan, Chute and Bag



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 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

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

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

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



WARNING

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in dark areas. Keep work area clean, dry, and well-lighted.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify machine for a purpose not intended by the manufacturer!

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

CHILDREN & BYSTANDERS. Keep children and bystanders a safe distance away from work area. Stop using machine if children or bystanders become a distraction.

REMOVE ADJUSTING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

NEVER STAND ON MACHINE. Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

STABLE MACHINE. Unexpected movement during operations greatly increases risk of injury or loss of control. Before starting, verify machines are stable and mobile base (if used) is locked.

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

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

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine increases risk of injury.

CHECK DAMAGED PARTS. Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



WARNING

Additional Safety for Jointers

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.

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

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

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

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.

MAXIMUM CUTTING DEPTH. The maximum cutting depth for one pass is $\frac{1}{8}$ ". Never attempt any single cut deeper than this!

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.

KEEPING GUARDS IN PLACE. All operations must be performed with the guard in place. ALWAYS ensure cutterhead guard is working properly before turning on the machine.

PROPER JOINTING. When jointing, 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.

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

CAUTION

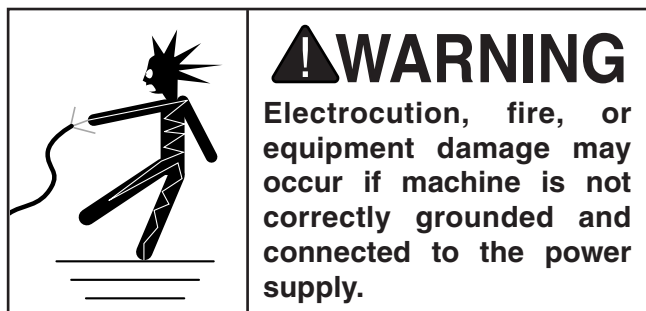
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 110V..... 12 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

! WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Circuit Requirements

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V/120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps

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

! CAUTION

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

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



Grounding & Plug Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

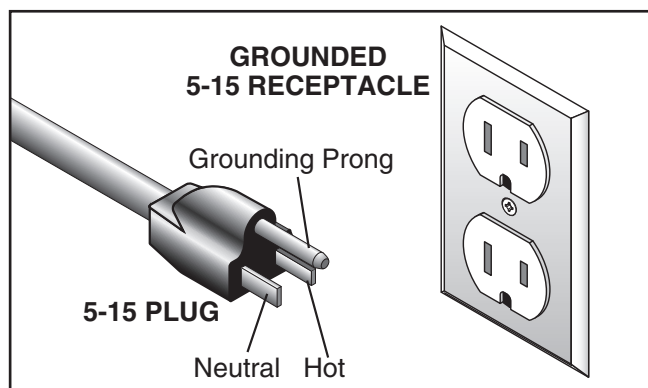
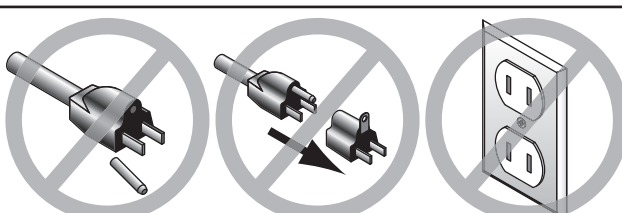


Figure 3. Typical 5-15 plug and receptacle.

⚠ CAUTION



SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

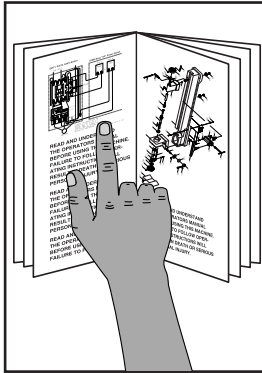
Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size14 AWG
Maximum Length (Shorter is Better).....50 ft.




SECTION 3: SETUP



!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 setup process!



!WARNING
This machine and its components are very heavy. Get lifting help if needed.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Additional People	1
• Straightedge 3'	1
• Screwdriver Phillips #2	1
• Hex Wrench 6mm.....	1
• Hex Wrench 4mm.....	1
• Scrap Block of Wood.....	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately 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, inventory the contents.



!WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials unpacked with this machine. Discard immediately.



Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Jointer Inventory: (Figures 4–5)	Qty
A. Jointer Bed Assembly.....	1
B. Fence.....	1
C. Dust Collection Bag.....	1
D. Push Blocks.....	2
E. Fence Tilting Handle	1
F. Fence Bracket Assembly.....	1
G. Fence Sliding Handle	1
H. Locking Plate Assembly	1
I. Fence Support.....	1
J. Dust Chute	1
K. Dust Collection Bag Clamp	1

Hardware (Not Shown)	Qty
• Cap Screws M8-1.25 x 20	6
• Lock Washers 8mm.....	6
• Hex Wrench 4mm.....	1
• Hex Wrench 6mm.....	1

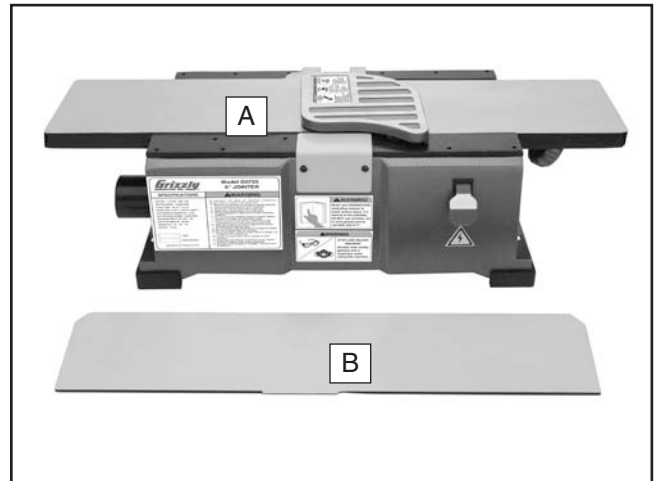


Figure 4. Large components.

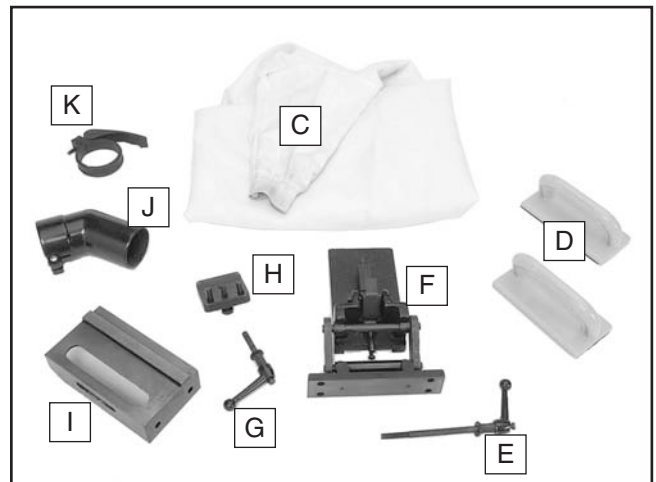


Figure 5. Small components.

NOTICE

If you cannot find an item on this list, check the mounting location on the machine or the packaging materials. Sometimes parts are pre-installed for shipping, or they become hidden by packaging materials.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

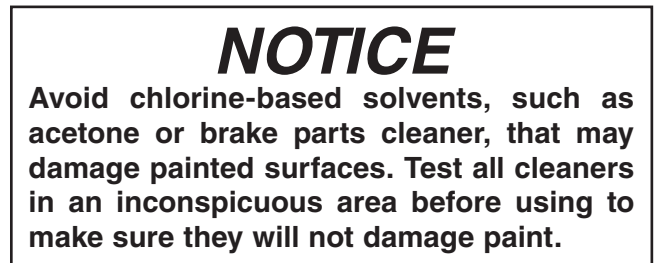
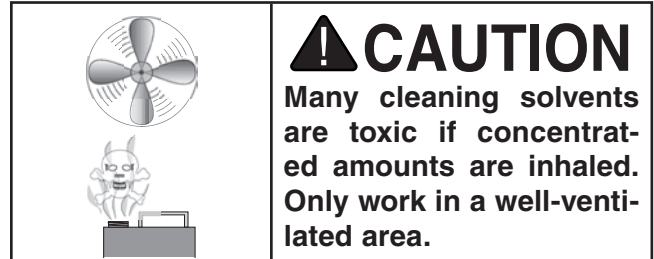
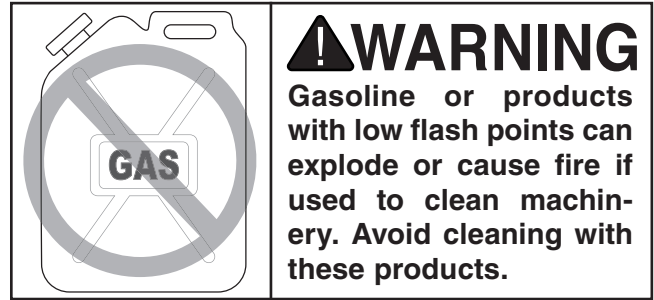
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



Site Considerations

Workbench Load

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

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 6** for the overall machine measurements.

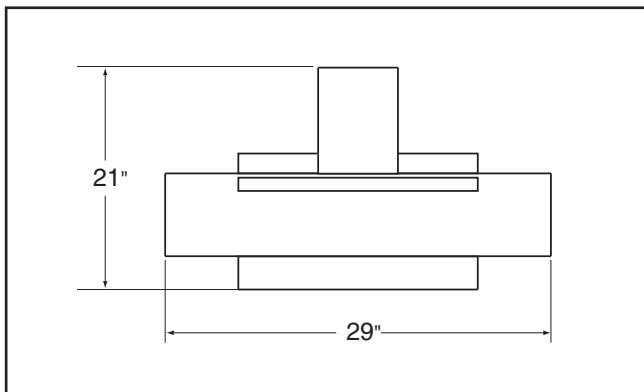
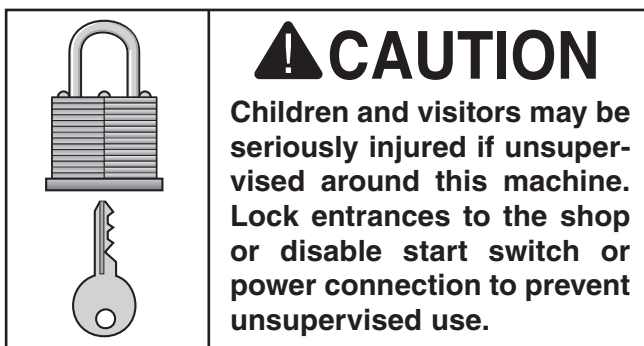


Figure 6. Machine overall measurements.



Mounting

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

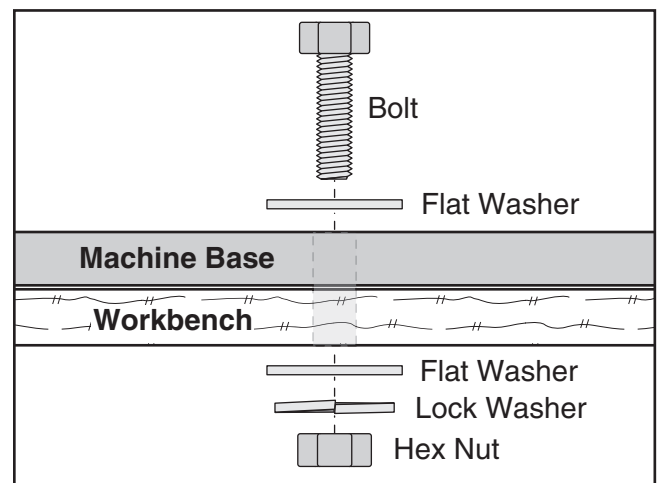


Figure 7. Example of a "Through Mount" setup.

Another option is a "Direct Mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

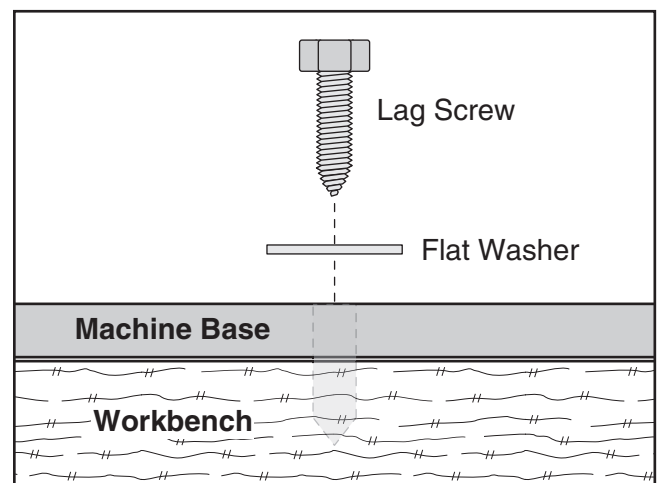


Figure 8. Example of a "Direct Mount" setup.



Installing Fence

1. DISCONNECT JOINTER FROM POWER!
2. Use (2) M8-1.25 x 20 cap screws and (2) 8mm lock washers to attach the fence support to the jointer bed (see **Figure 9**).

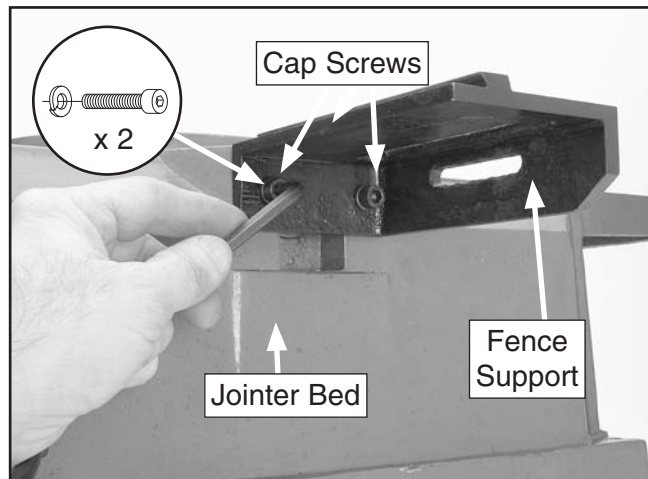


Figure 9. Attaching the fence support to the bed assembly.

3. Insert the locking plate assembly into the fence support, positioning it so the two pins are against the bottom edge of the fence support, as shown in **Figure 10**.

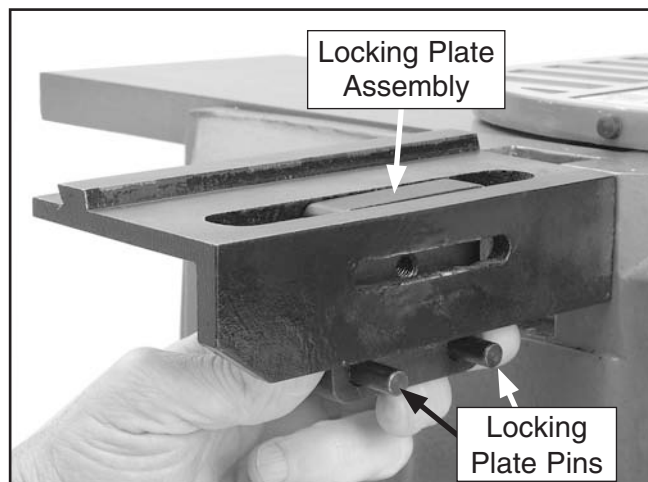


Figure 10. Inserting the locking plate.

4. Attach the fence sliding handle to the locking plate assembly. Secure the locking plate in position by tightening the fence sliding handle, as shown in **Figure 11**.

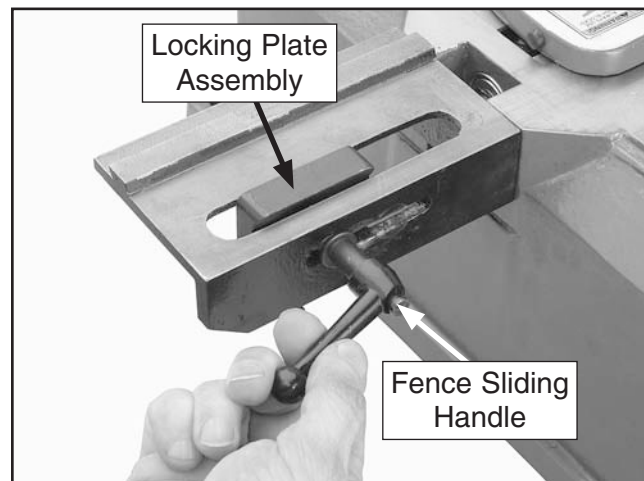


Figure 11. Securing the locking plate assembly with the fence sliding handle.

5. Use the (4) M8-1.25 x 20 and (4) 8mm lock washers to attach the fence to the fence bracket assembly, as shown in **Figure 12**.

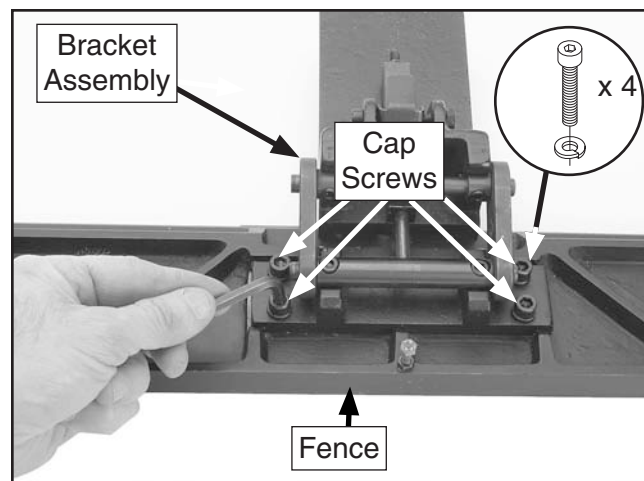


Figure 12. Assembling the fence assembly.



- Slide the fence bracket assembly over and onto the support dovetails, as shown in **Figure 13**.

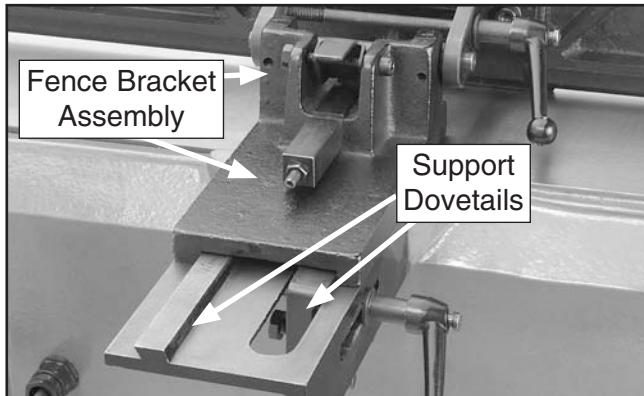


Figure 13. Installing fence assembly.

- Install the fence tilting handle by threading the handle shaft into the bracket assembly, as shown in **Figure 14**.

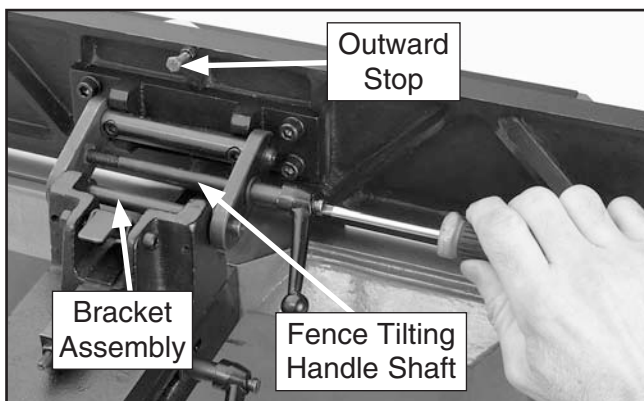


Figure 14. Installing the fence tilting handle.

- Slide the fence forward until it contacts the cutterhead guard. The guard should completely cover the cutterhead, as shown in **Figure 15**.

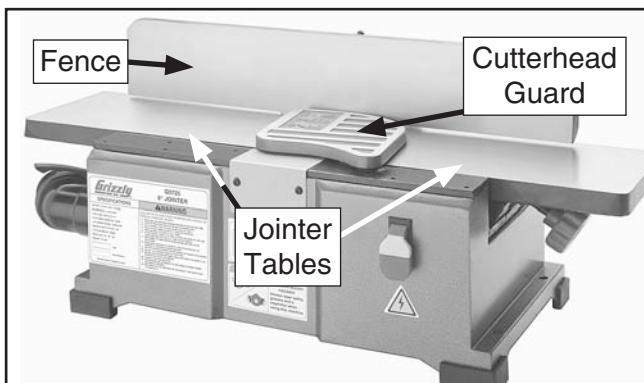


Figure 15. Fence positioned over the jointer tables.

Checking Outfeed Table Alignment

The cutterhead knives **MUST** be level with the outfeed table when they are at top dead center (their highest point during rotation) or the workpiece cannot be fed across the jointer safely.

To check the outfeed table alignment:

- DISCONNECT JOINTER FROM POWER!**
- Place a straightedge on the outfeed table so it extends over the cutterhead. For best results, use a straightedge that will stand on edge without having to be held in place.
- Rotate the cutterhead under the straightedge until one of the knives is at top dead center, as illustrated in **Figure 16**.

—If your cutterhead knives brush the straightedge and move it slightly ($\frac{1}{8}$ ") forward and back when you turn the cutterhead, then no adjustments are necessary.

—If the knives fall below the straightedge and do not move it, or if the knives lift the straightedge and move it more than $\frac{1}{8}$ " , the knives must be adjusted.

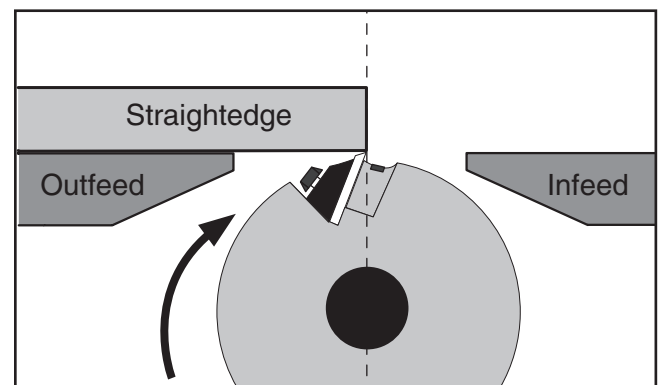


Figure 16. Illustration of a typical outfeed table alignment setup.



To adjust the height of the cutterhead knives:

1. DISCONNECT JOINTER FROM POWER!
2. Block the cutterhead guard back so the cutterhead is fully exposed.
3. Locate the knife clamp screws and knife adjustment jack screws (see **Figures 17–18**).

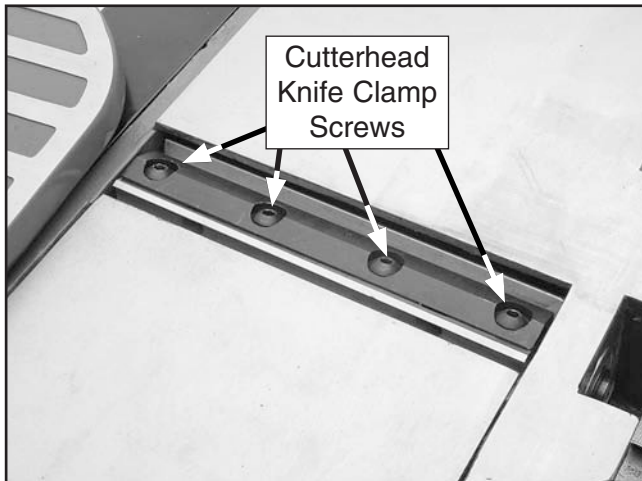


Figure 17. Cutterhead knife clamp screws.

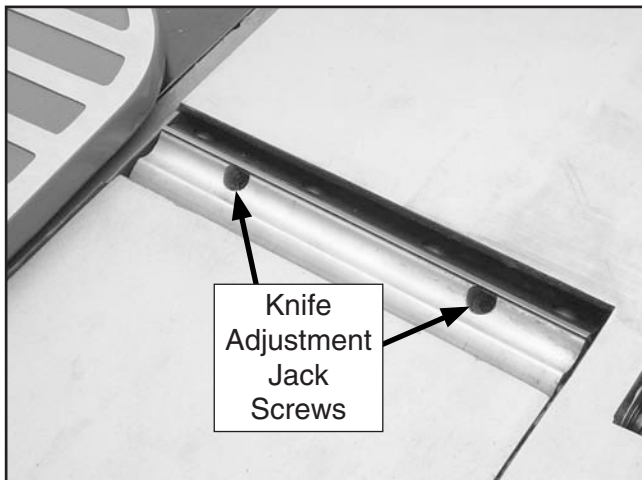


Figure 18. Knife adjustment jack screws.

4. Loosen the four knife clamp screws.

5. Loosen the two jack screws, then, using the scrap wood block, push the knife blade down until both ends are slightly below the straightedge.
6. Move the straightedge to position **A**, as shown in **Figure 19**. Turn the jack screw nearest the fence clockwise $\frac{1}{8}$ of a turn until the end of the knife touches the straightedge.

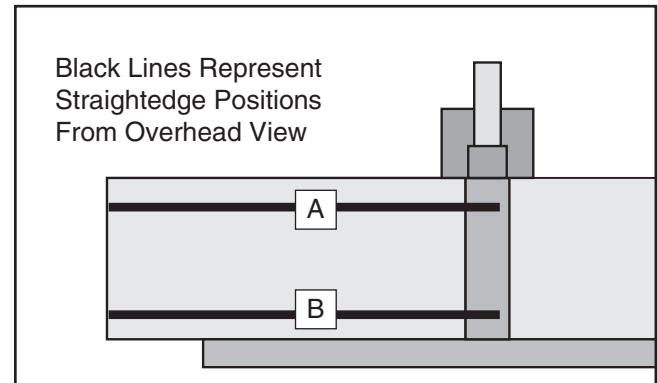


Figure 19. Straightedge positions A and B.

7. Move the straightedge to position **B**, as shown in **Figure 19**. Turn the jack screw nearest the guard clockwise $\frac{1}{8}$ of a turn until the end of the knife touches the straightedge.
8. Rotate the cutterhead slightly without disturbing the knife clamp to check the knife height.
 - If the knife moves the straight edge slightly ($\frac{1}{8}$ ") forward and back on the table, the knife height is set correctly.
 - If the knife does not move the straightedge slightly ($\frac{1}{8}$ ") forward and back on the table, continue to make fine adjustments with the jack screws until the knife is set correctly.
9. Repeat **Steps 4–8** with the other cutterhead knife.
10. When the knife height is set correctly, firmly tighten each of the knife clamp screws.



Dust Collection

The Model G0725 has a built in dust collection fan and includes a dust collection bag. It can also be hooked up to a pre-existing dust collection system.

⚠ CAUTION

DO NOT operate the Model G0725 without an adequate dust collection system. This machine creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 150 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To Install the dust collection chute and bag:

1. Install the dust chute by attaching the dust chute to the chip exhaust and tighten the hex nut.
2. Slip the bag clamp over the collection bag, then attach the collection bag to the chute and clamp it, as shown in **Figure 20**.



Figure 20. Attaching the dust collection bag.

Power Connection

After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine.

Connecting Power

1. Turn the machine power switch **OFF**.
2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

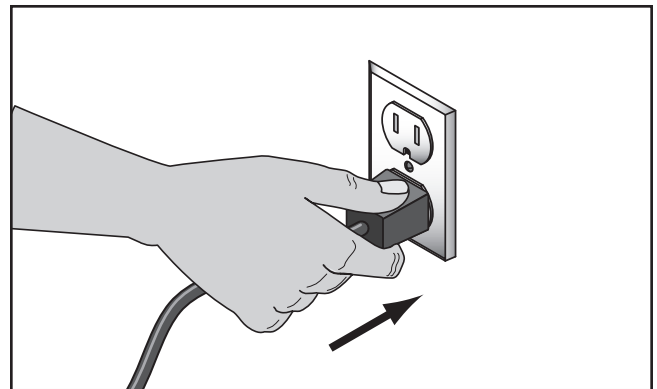


Figure 21. Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.
2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.

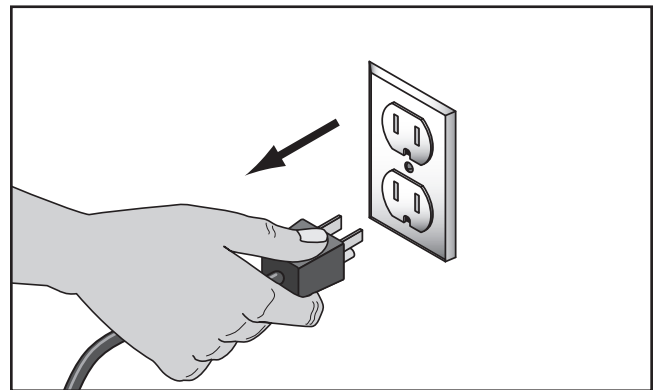


Figure 22. Disconnecting power.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following:
1) The motor powers up and runs correctly, and
2) the safety disabling mechanism on the switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 34**.

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

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Verify that the machine is operating correctly by turning the machine **ON**.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

4. Turn the machine **OFF**.
5. Remove the switch disabling key, as shown in **Figure 23**.

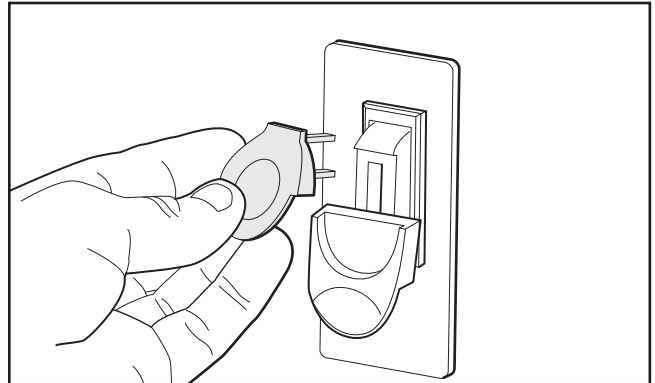


Figure 23. Removing switch key from paddle switch.

6. Try to the start the machine with the paddle switch.
 - If the machine does not start, the switch disabling feature is working as designed.
 - If the machine starts, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

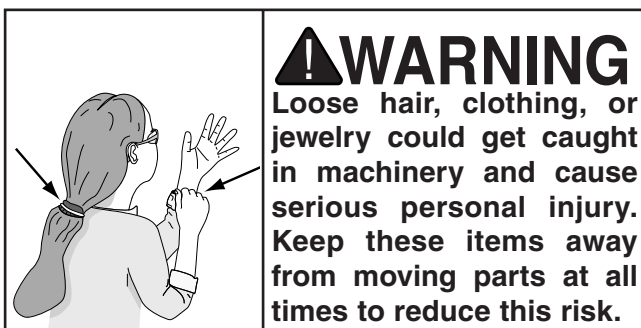
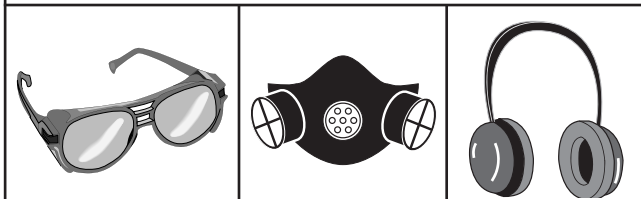


SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



NOTICE

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, review industry 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.

To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for jointing. Also ensures entire workpiece can be handled safely throughout jointing operation.
2. Adjusts the fence position according to the width of the workpiece.
3. Checks the fence for square or adjusts the fence to the proper tilt for bevel edge jointing.
4. Sets the depth of the cut by adjusting the infeed table height.
5. Ensures that cutterhead guard position and operation are functioning properly.
6. Puts on safety glasses and a respirator, and locates push blocks if needed.
7. Starts the jointer. Feeds the workpiece all the way through the jointer while maintaining firm pressure on the workpiece against the fence and table—keeping hands and fingers away from the cutterhead at all times.
8. Stops the machine.



Basic Controls

This section covers the basic parts and controls used during routine operations. See **Figures 24–25** for basic parts and control locations.

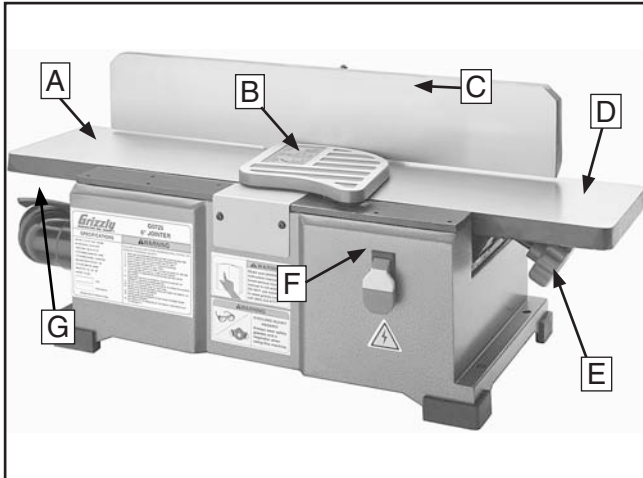


Figure 24. G0725 parts and controls (front view).

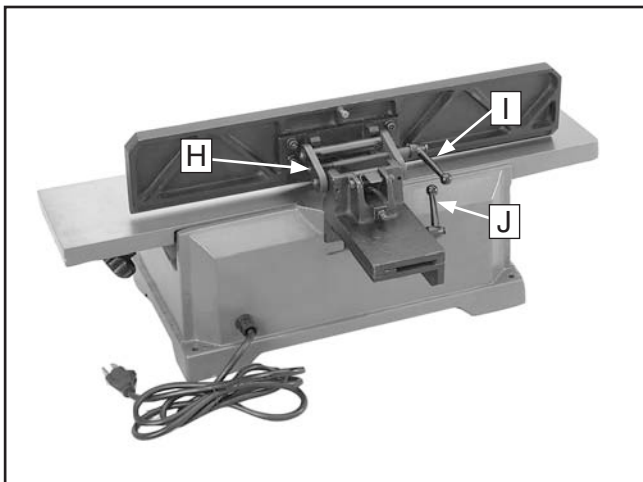


Figure 25. G0725 parts and controls (back view).

- A. Outfeed Table:** Supports the workpiece after it passes over the cutterhead.
- B. Cutterhead Guard:** Shields the cutterhead for operator safety during operation. The cutterhead guard is under spring tension—it must (unless blocked) snap forward to hit the fence. **DO NOT** operate the jointer if the guard is not functioning properly.
- C. Fence:** The fence guides the workpiece uniformly over the cutterhead at the desired angle.

D. Infeed Table: Supports the workpiece as it is pushed over the cutterhead. The height of the infeed table relative to the cutterhead determines the depth of the cut.

E. Depth of Cut Adjustment Knob: This knob adjusts the height of the infeed table, controlling the depth of cut. Best results are achieved by limiting the maximum depth to $\frac{1}{8}$ " when edge jointing and $\frac{1}{32}$ " when surface planing. You can set the depth of cut precisely with this adjustment knob. To determine the depth of stock the cutterhead will remove from your workpiece, place a straightedge across the outfeed table and use a ruler to measure the gap between the straightedge and the infeed table.

F. ON/OFF Switch: This paddle switch starts and stops the cutterhead rotation. The yellow part of the switch is a safety device. When it is removed (by pulling it out), the switch locks in the OFF position. Always remove this yellow key before leaving the jointer work area. This prevents unsupervised persons in your shop (especially children) from starting the jointer.

G. Dust Collection Chute and Bag: This assembly collects debris from the workpiece as it is cut. The internal fan—powered by the motor—pulls debris away from the cutterhead and blows it through the chute into the bag.

H. Fence Bracket Assembly: The various parts of this assembly let you change the position of the fence relative to the tables and secure it in position during operation.

I. Fence Tilting Handle: Lets you change the angle of the fence and lock it at the angle desired. The fence can be quickly set to 90° (perpendicular to the tables), 45° inward, and 45° outward by setting and using the fence stops on the bracket assembly.

J. Fence Sliding Handle: This handle locks the position of the fence across the tables. **ALWAYS** firmly tighten the sliding handle before you begin operations. The position of the fence determines the maximum width of the cut as you pass the workpiece over the cutterhead.



Fence Angle Stops

Using the angle stops, you can quickly set the fence angle at 90° (perpendicular to the tables), 45° inward, and 45° outward. This section provides instructions for setting the fence stops precisely at these angles.

Before making these adjustments, take a moment to identify the various stop parts of the fence bracket assembly (see **Figure 26**).

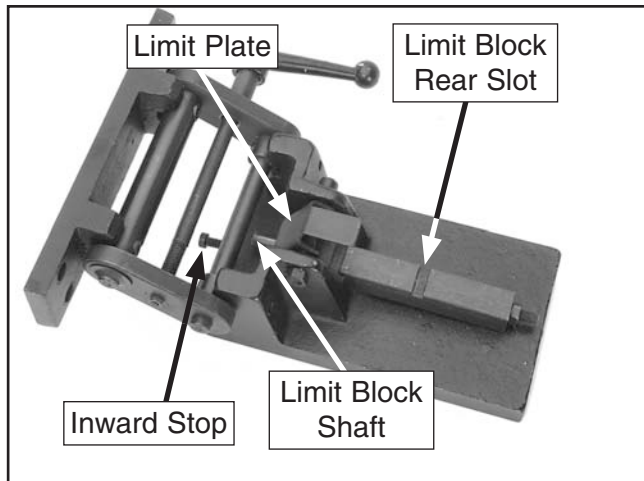


Figure 26. Fence stop parts identification.

To set the 90° stop:

1. DISCONNECT JOINTER FROM POWER!
2. With the fence positioned over the bed and with the sliding handle locked, loosen the fence tilting handle.
3. Press the forward tab of the limit plate into the rear slot of the limit block.

4. Pull the fence as far as it will go towards 90° (perpendicular to the table), then tighten the fence tilting handle.

Note: When you pull the fence towards 90°, it will stop when it hits the limit block shaft.

5. Use a machinist's combination square to check the angle of the fence, as shown in **Figure 27**.



Figure 27. Checking the 90° stop.

—If the fence is perpendicular to the table according to the machinist's square, the 90° stop is set correctly. Move ahead to set the 45° stops, on the next page.

—If the fence is not perpendicular to the table, adjust the 90° stop by doing **Steps 6–9**.

6. Loosen the fence tilting handle, bring the fence to 90° with the machinist's square set against the fence, then tighten the handle.

Note: Keep the limit plate in the rear slot of the limit block (see **Figure 26**).



7. Loosen the jam nut located at the rear of the limit block shaft.
8. Using a screwdriver, turn the limit block set screw until the limit block shaft contacts the fence.
9. Tighten the jam nut. The 90° stop is now set precisely.

To set the inward 45° stop:

1. DISCONNECT JOINTER FROM POWER!
2. With the fence positioned over the bed and the sliding handle locked, loosen the fence tilting handle.
3. Tip the fence towards the table as far as it will go, then tighten the fence tilting handle.

Note: When you tip the fence towards the table, it will stop when it contacts the inward stop bolt.

4. Use a machinist's combination square to check the angle of the fence, as shown in **Figure 28**.



Figure 28. Checking the inward 45° stop.

5. Loosen the fence tilting handle, bring the fence to 45° with the machinist's square set against the fence, then tighten the handle.

Note: Keep the limit plate in the rear slot of the limit block.

—If the fence leans 45° towards the table, the inward 45° stop is set correctly; move ahead to set the outward 45° stop.

—If the fence does not lean 45° towards the table, adjust the inward 45° stop by repeating **Step 5**.

6. Remove the limit block from the fence bracket assembly and set it aside.
7. Adjust the inward stop bolt (see **Figure 29**) until it contacts the fence at precisely 45° inward, then tighten the jam nut (where the bolt meets the bracket assembly) while holding the stop bolt in place. Replace the limit block and set the limit plate.

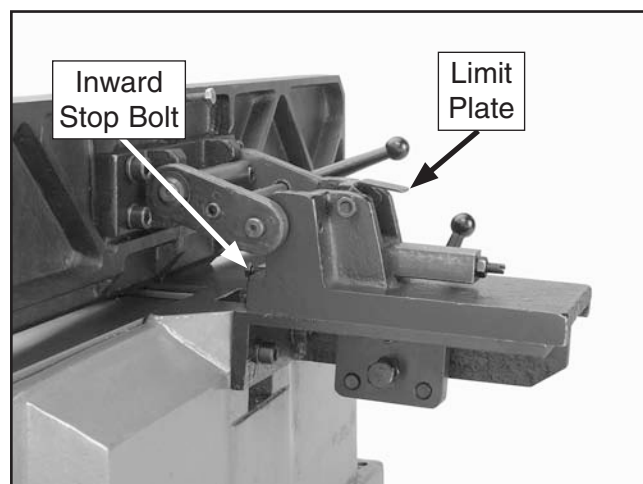


Figure 29. Adjusting the inward stop.

To set the outward 45° stop:

1. DISCONNECT JOINTER FROM POWER!
2. Loosen the fence tilting handle, remove the limit block and set it aside.
3. Tip the fence back (away from the table) until it stops.

Note: The fence will stop when the outward stop bolt hits the fence bracket.



4. Use a machinist's combination square to check the angle of the fence, as shown in **Figure 30**.



Figure 30. Checking the outward 45° stop.

- If the fence is tilting away from the table at 45°, the outward stop is set correctly. Put the limit block back, bring the fence to 90° and tighten the tilting handle.
- If the fence is not tilting away from the table at 45°, do **Steps 5–6** to set the outward stop correctly.

5. With the outward stop bolt resting against the fence bracket, adjust the length of the stop until the fence is at 45°, then tighten the jam nut (see **Figure 31**).

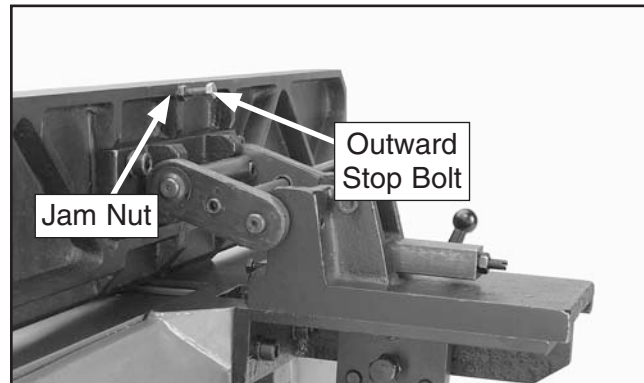


Figure 31. Outward stop bolt detail.

6. Put the limit block back, bring the fence to 90° and tighten the fence tilting handle.

NOTICE

Check the accuracy of these settings frequently with a machinist's combination square and readjust them if necessary.



Choosing and Jointing Stock

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

- **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 32**).

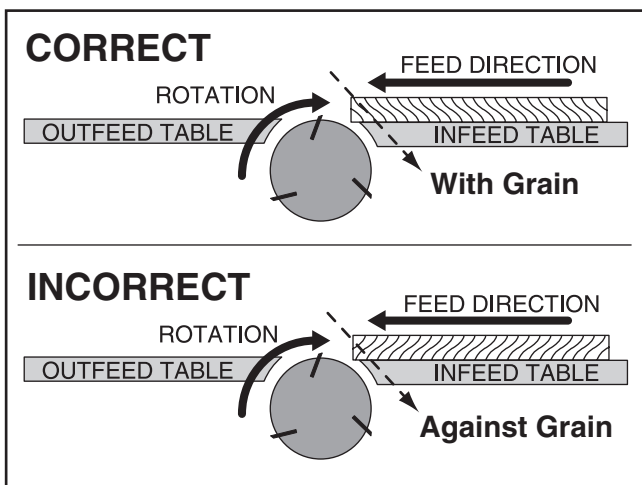


Figure 32. Illustration showing correct and incorrect grain alignment with cutterhead.

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

- **DO NOT joint or surface plane stock that contains large or loose 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.

- **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 33–34) before edge jointing or surface planing, or it may break or kick back during the operation!**

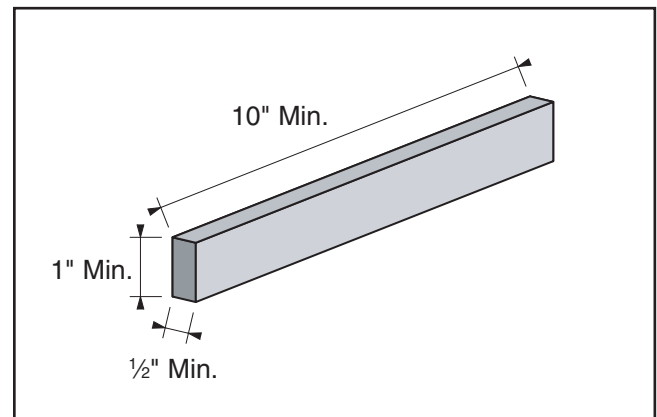


Figure 33. Illustration showing the minimum workpiece dimensions for edge jointing.

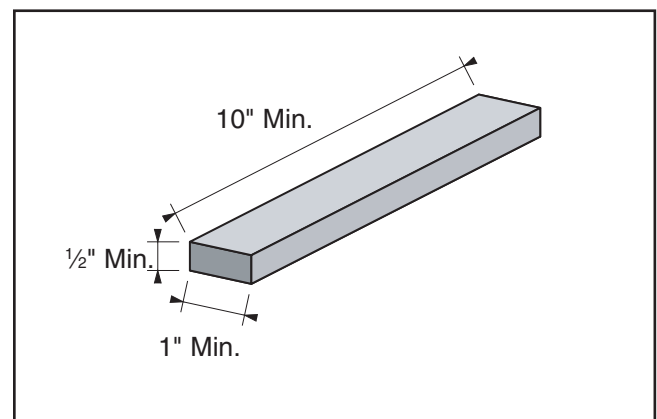


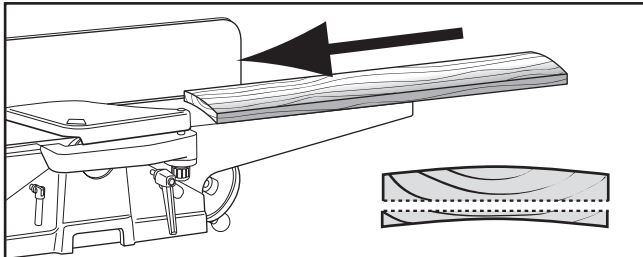
Figure 34. Illustration showing minimum workpiece dimensions for surface planing.



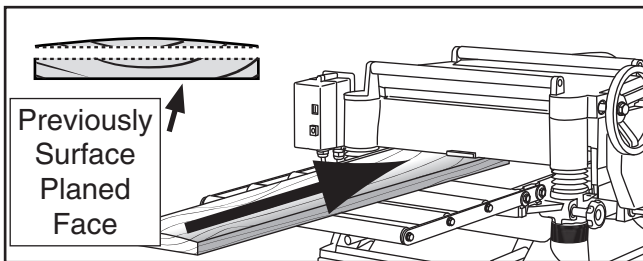
Squaring Stock

Squaring stock involves four steps performed in the order below:

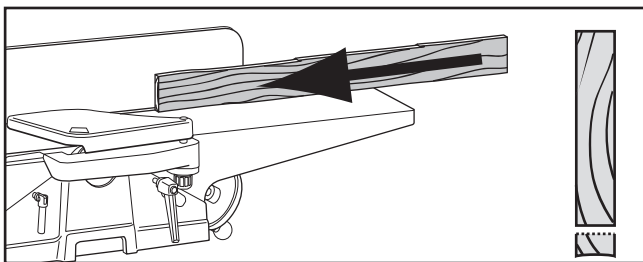
1. Surface Plane on the Jointer—The concave face of the workpiece is surface planed flat with the jointer.



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 the workpiece (see **Figures 35–36**) 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 zero and practice feeding the workpiece across the tables as described. This procedure will better prepare you for the actual operation.

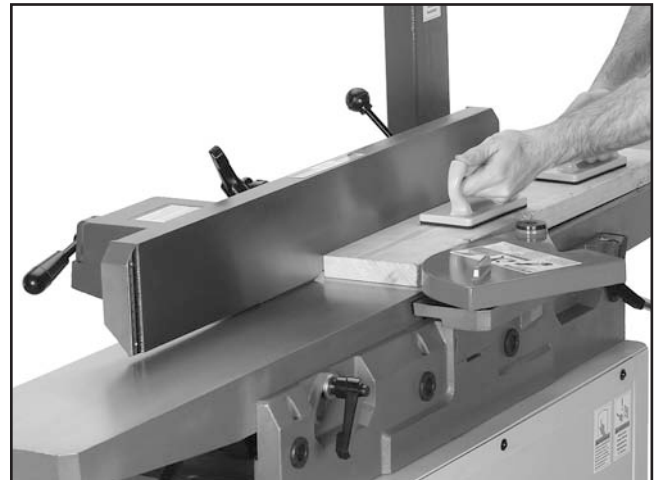


Figure 35. Example photo of a typical surface planing operation.

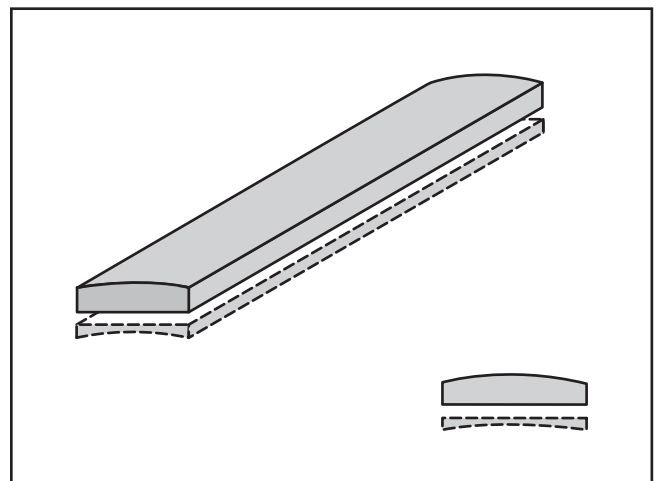


Figure 36. Illustration of surface planing results.



To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**.
2. Make sure you inspect your workpiece for dangerous conditions as described in the **Choosing and Jointing Stock** on **Page 26**.
3. Set the cutting depth for your operation. (We suggest $\frac{1}{32}$ " for surface planing.)
4. Make sure your fence is set to 90°.
5. If your workpiece is cupped (warped), place the concave side (see **Figure 35** on **Page 27**) 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 with your hands, 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 down on the infeed table and against the fence with firm pressure, then feed the workpiece over the cutterhead, as shown in **Figure 37**.

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 resting 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. **DO NOT** place either hand closer than 4" from the cutterhead! Failure to heed this warning could result in serious personal injury.

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 **Figure 37**) 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 zero, and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.



Figure 37. Example photo of a typical jointing operation.

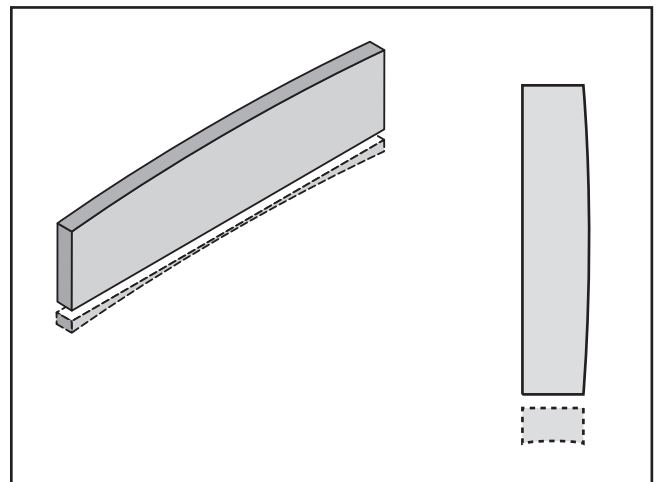


Figure 38. Illustration of edge jointing results.



To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Choosing and Jointing Stock** instructions on **Page 26**.
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° .
5. If your workpiece is cupped (warped), square the stock before edge jointing by surface planing the workpiece until it is flat on both sides.
6. Start the jointer.
7. Press the workpiece against the infeed table and fence with firm pressure. Use your trailing hand to guide the workpiece through the cut, and feed the workpiece over the cutterhead, as shown in **Figure 37**.

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! Failure to heed this warning could result in serious personal injury.*

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

Bevel Cutting

The purpose of bevel cutting is to cut the edge of a workpiece at a specific angle (see **Figure 40**).

This jointer has fence stops you can set at 90° , 45° inward, and 45° outward (135°). If your situation requires a different angle, the fence can be locked anywhere between these angles.

NOTICE

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

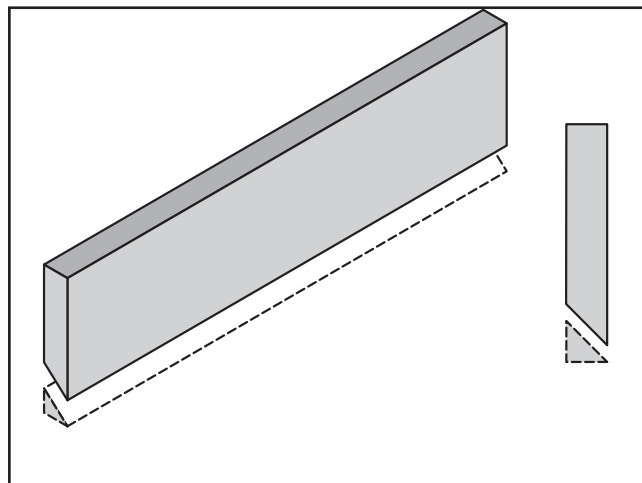


Figure 40. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**.
2. Make sure your stock has been inspected for dangerous conditions as described on **Page 26**.
3. Set the cutting depth for your operation. We suggest between $\frac{1}{16}$ " and $\frac{1}{8}$ " for bevel cutting; but use a more shallow depth when cutting hardwoods or wide surfaces.
4. Make sure your fence is set to the angle desired and securely locked.



5. If your workpiece is cupped (warped), square the stock before edge jointing by surface planing the workpiece until it is flat on both sides.
6. Start the jointer.
7. With a push block in your leading hand, press the workpiece against the infeed table and fence with firm pressure, and feed the workpiece over the cutterhead, as shown in **Figure 41**.



Figure 41. Example photo of a typical bevel cutting operation.

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 angled cut is satisfactory to your needs.



SECTION 5: ACCESSORIES

⚠️ WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

**H9837—6" Replacement Jointer Knives
(Set of 2)**

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 42. G3631 Jointer/Planer Knife Hone.

**G9643—8" Precision Straightedge
G9644—12" Precision Straightedge
H2675—16" Precision Straightedge**

These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.



Figure 43. Straightedges.

H7828—Shop Fox Tool Table Plus

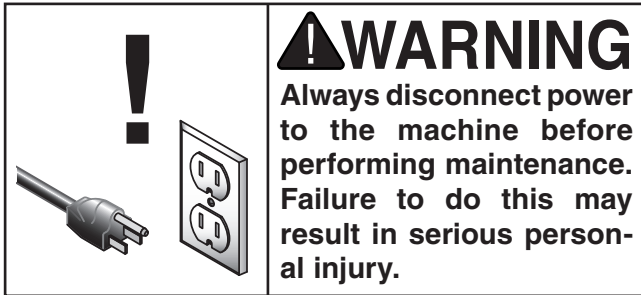
This new, tool table plus was designed to answer customer requests for a slightly wider and taller table than our G7313 to accommodate a variety of bench-top machines including the G0725 Jointer.



Figure 44. H7828 Shop Fox Tool Table Plus.



SECTION 6: MAINTENANCE



Schedule

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

Daily Check

- Vacuum all dust on and around the machine.
- Empty debris from the dust collection bag. DO NOT use the jointer if debris obstructs the flow of material into the bag. Using the jointer when the chute is obstructed can lead to jointer malfunction and, possibly, fire. Failure to heed this warning can result in serious personal injury.
- Wipe down tables and all other unpainted cast iron with a metal protectant.

Monthly Check

- Cutterhead knife alignment and fence angle stops (see **Page 17** and **Page 23**).
- Belt tension, damage, or wear (see **Page 36**).
- Clean/vacuum dust from inside the cabinet and around the motor.

Cleaning

Cleaning the Model G0725 is easy and should be done often. Vacuum excess wood chips and sawdust, and wipe off the remaining dust away 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 will help prevent moisture from wood dust accumulating on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Figure 45**).

Recommended Metal Protectants

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

Lubrication

All bearings are sealed and permanently lubricated. Do not lubricate them; leave them alone until they need to be replaced.

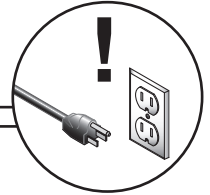


SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

Note: Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting

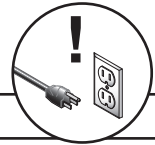


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Safety key removed from ON/OFF switch, 2. Plug/receptacle is at fault or wired incorrectly. 3. Power supply is at fault/switched OFF. 4. Lockout key is at fault. 5. Motor brushes are at fault. 6. Motor ON/OFF switch is at fault. 7. Wiring is open/has high resistance. 8. Motor is at fault. 	<ol style="list-style-type: none"> 1. Replace safety key. 2. Test for good contacts; correct the wiring. 3. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 4. Install/replace lockout key; replace switch. 5. Remove/replace brushes. 6. Replace faulty ON/OFF switch. 7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 8. Test/repair/replace.
Machine stalls or is overloaded.	<ol style="list-style-type: none"> 1. Wrong workpiece material. 2. Cutterhead belt slipping. 3. Plug/receptacle is at fault. 4. Motor brushes are at fault. 5. Motor bearings are at fault. 6. Machine is undersized for the task. 7. Knives dull, feed rate is too fast, depth of cut too great. 8. Motor has overheated. 9. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use wood with correct moisture content, without glues, and little pitch/resins. 2. Re-tension or replace cutterhead belt. 3. Test for good contacts; correct the wiring. 4. Remove/replace brushes. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Stop operation and ensure stock is properly sized for safe machine operation. 7. Use sharp knives; reduce feed rate/depth of cut. 8. Clean off motor, let cool, and reduce workload. 9. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. Knife blades, clamp or jack screws are at fault. 3. Belts worn or loose. 4. Motor fan is rubbing on fan cover. 5. Loose mounting bolts. 6. Blade is at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Resharpen/replace knives as required; set knife alignment correctly. 3. Inspect/replace belts with a new ones. 4. Replace dented fan cover; replace loose/damaged fan. 5. Replace/tighten as required. 6. Replace warped, bent, or twisted blade; resharpen dull blade.



Cutting Operations



Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	<ol style="list-style-type: none"> 1. Outfeed table is out of alignment with the cutterhead. 2. Operator is pushing down on trailing edge of the workpiece 	<ol style="list-style-type: none"> 1. Align cutterhead with outfeed table. 2. Reduce/eliminate downward pressure on that end of the workpiece.
Cutterhead stops during operation.	<ol style="list-style-type: none"> 1. Cutterhead belt is damaged/broken. 	<ol style="list-style-type: none"> 1. Replace cutterhead belt.
Workpiece stops in the middle of the cut.	<ol style="list-style-type: none"> 1. Cutterhead is set lower than the outfeed table. 	<ol style="list-style-type: none"> 1. Align the cutterhead knives with the outfeed table at top dead center.
Chipping.	<ol style="list-style-type: none"> 1. Knots or conflicting grain direction in wood. 2. Nicked or chipped knives. 3. Feeding workpiece too fast. 4. Taking too deep of a cut. 	<ol style="list-style-type: none"> 1. Inspect workpiece for knots and grain; only use clean stock. 2. Adjust one of the nicked knives sideways; sharpen or replace blade. 3. Slow down the feed rate. 4. Take a smaller depth of cut. Never exceed 1/8" per pass. Reduce cutting depth when working with hard woods.
Long lines or ridges that run along the length of the board.	<ol style="list-style-type: none"> 1. Nicked or chipped knives. 	<ol style="list-style-type: none"> 1. Adjust one of the nicked knives sideways; sharpen or replace blade.
Uneven cutter marks, wavy surface, or chatter marks across the face of the board.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. Knives not adjusted evenly with each other in the cutterhead. 	<ol style="list-style-type: none"> 1. Slow down the feed rate. 2. Adjust the knives so they are set up evenly with the cutterhead.
Board edge is concave or convex after jointing.	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 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.
Overall, cut quality is poor; inconsistent snipe problems; or consistent difficulty feeding workpiece.	<ol style="list-style-type: none"> 1. Knives are out of alignment or cutterhead height is not even with the outfeed table. 2. Fence stops are set incorrectly. 3. Fence bracket parts are loose or parts are misaligned. 	<ol style="list-style-type: none"> 1. Reset the knives to correct height and alignment with cutterhead assembly. 2. Recalibrate the fence stops. 3. Check/tighten the fence bracket fasteners.



Adjusting/Replacing Belts

The Model G0725 uses belts to drive both the cutterhead and the dust collection fan. When these belts are misaligned, damaged, or not tensioned correctly, the jointer will not function properly.

This sub-section describes how to service these belts. You can order replacement belts from Grizzly. The part number for the drive belt is P0612070; the part number for the fan belt is P0612092.

Tools Needed	Qty
Phillips Head Screwdriver.....	1
Hex Wrench 6mm.....	1

To realign or replace the cutterhead belt:

1. DISCONNECT JOINTER FROM POWER!
2. While facing the rear of the jointer, tip it away from you until it rests on the fence assembly.
3. Remove the Phillips screws fastening the motor cover to the jointer base. Lift the cover off and set it aside.
4. Remove all dust and debris from the motor and belt areas.
5. Inspect the cutterhead belt for proper tension, alignment and condition.

Note: The belt is properly tensioned if it deflects no more than $\frac{3}{8}$ " when you press down on middle of the belt with moderate pressure from your thumb or forefinger.

The belt is properly aligned if it lies flat and straight on the motor shaft and drive pulley.

Belt damage will be evident on inspection.

6. Loosen the four motor mounting cap screws (see **Figure 46**), but do not remove them. This will release the belt tension.

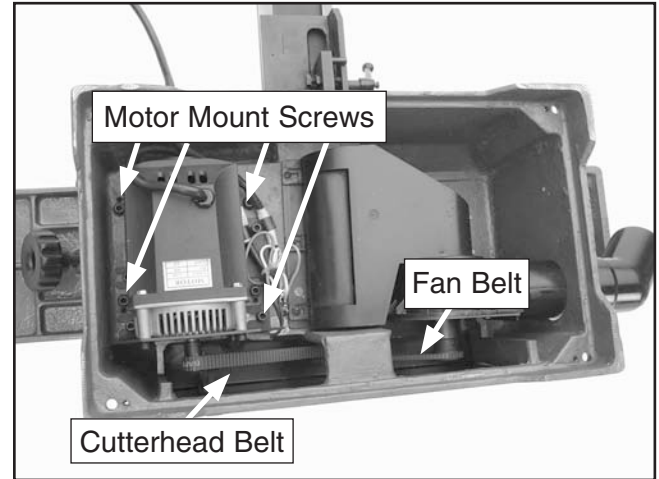


Figure 46. Motor mounting screws and belt locations.

7. Replace a damaged belt with a new one. Realign and re-tension the belt by tightening the four motor mounting cap screws.
8. Tighten the motor mounting cap screws and replace the motor cover.
9. Test run the jointer. Repeat this procedure if necessary. If repeating this procedure does not solve the problem, call Grizzly Tech Support.

To replace the fan belt:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the motor cover and check the belt for damage.
—If the belt shows no wear or damage, precede to **Step 4**.
3. Remove the belt. Put one end of the new belt on the fan pulley, then fit the other end onto the drive pulley.

Note: It is highly unlikely that this belt will ever be misaligned or out of tension. If it is, the jointer needs to be serviced by a qualified technician. Call our Tech Support.

4. Re-install the motor cover.



Replacing Motor Brushes

The jointer has a universal motor that uses carbon brushes that normally wear out over time. If you are having trouble with the performance of the motor, refer to **Troubleshooting (Page 34)** to determine if the motor brushes must be replaced.

You can order a new brush kit (two brush assemblies) from Grizzly. The part number for the brush kit is P0612024-1.

Tools Needed	Qty
Phillips Head Screwdriver.....	1
Dime	1

To replace motor brushes:

1. DISCONNECT JOINTER FROM POWER.
2. While facing the rear of the jointer, tip it away from you until it rests on the fence assembly.
3. Remove the four Phillips screws fastening the motor cover to the jointer base. Lift the cover and set it aside.
4. Take this opportunity to clear dust and debris from inside the jointer.
5. Use a dime to unscrew the brush caps. (See **Figure 47** to locate the brush caps.)

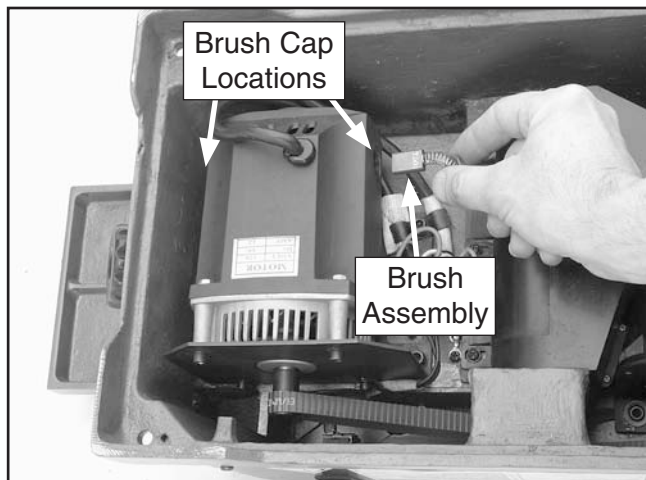


Figure 47. Removing a motor brush.

Note: When you remove the brush caps, a spring will pop out of the socket; the carbon brush is firmly attached to this spring. When you buy a new brush kit, you will get a pair of brush/spring assemblies. Do not separate the brush from the spring.

6. Check the brushes for wear. If a brush is worn to less than $\frac{3}{32}$ " in length, replace both brushes.
7. Insert the brush assemblies, positioning them so they slide into the slots built into the sockets.
8. Individually, press each brush cap against its spring, pushing it into the socket and turning the brush cap to lock it in the motor housing.
9. Re-install the motor cover.
10. Test run the jointer.

—If the jointer runs properly, you are done.

—If the motor does not start, either the brushes are not correctly aligned in the sockets or there is another problem with the motor or wiring. Double check all wire connections first, then refer to the **Troubleshooting** on **Page 34** for assistance.



Replacing Cutterhead Knives

The Model G0725 jointer has a dual-knife cutterhead. Under normal operation these knives will become dull and need to be sharpened or replaced. Refer to **Troubleshooting (Page 35)** to determine if the knives may be dull.

You can order new knives or a knife hone from Grizzly, see **Accessories on Page 31**.

To replace cutterhead knives:

1. DISCONNECT JOINTER FROM POWER.
2. Carefully rotate the cutterhead until clamp screws are accessible.

CAUTION

Cutterhead knives are sharp. Use caution when handling cutterhead knives. Use gloves to reduce the risk of injury.

3. Remove the four cutterhead clamp screws fastening the knife to cutterhead (see **Figure 48**). Carefully remove the knife and clamp from cutterhead.

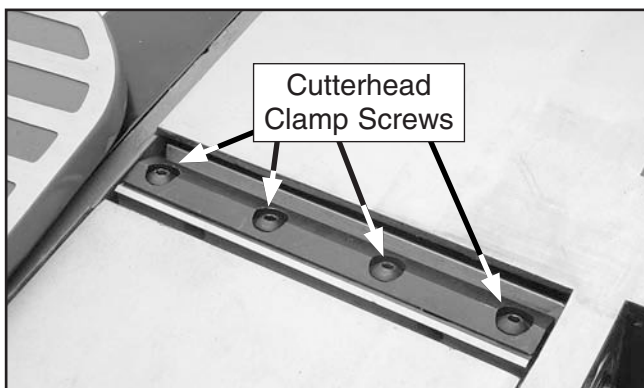


Figure 48. Cutterhead knife clamp screws.

4. Repeat **Steps 1–3** for the second cutterhead knife.
5. Clean the cutterhead thoroughly before installing new knives or re-installing sharpened knives.

6. Install the knife and clamp in the cutterhead and slightly tighten each of the clamp screws in sequence, as shown in **Figure 49**.

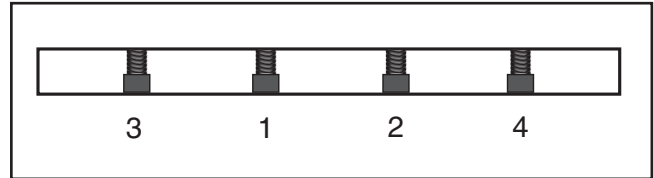


Figure 49. Clamp screw tightening sequence.

Note: By tightening the clamp screws out of sequence, the shape of the knife may be affected, hampering the jointing capabilities of the machine. Following the tightening sequence reduces that possibility.

7. Repeat **Steps 6** for the second cutterhead knife.
8. Check the alignment of the knives to the outfeed table. They must be parallel. If the knife is not parallel to the outfeed table, use the knife adjustment jack screws (see **Figure 50**) to fine tune the position of the knife. Refer to **Checking Outfeed Table Alignment on Page 17** for detailed instructions for adjusting the position of the knife.

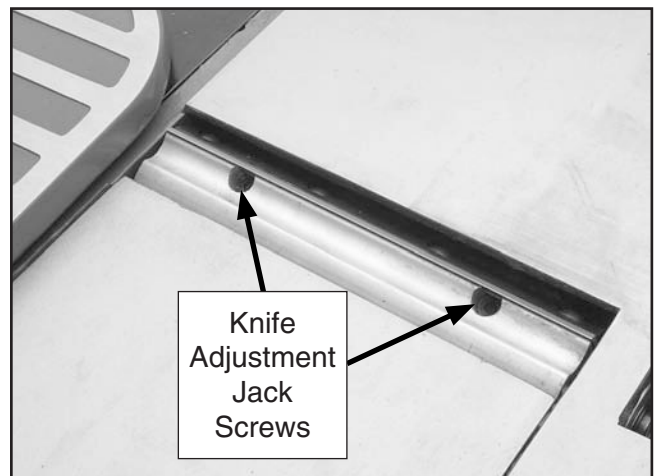


Figure 50. Knife adjustment jack screws.

9. Following the tightening sequence (**Figure 51**), final tighten each of the clamp screws.
10. Return the cutterhead guard to the operating position and ensure it is working properly. Re-align the fence and tables as needed. Test the jointer on a piece of scrap material.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.











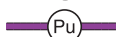



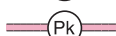
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

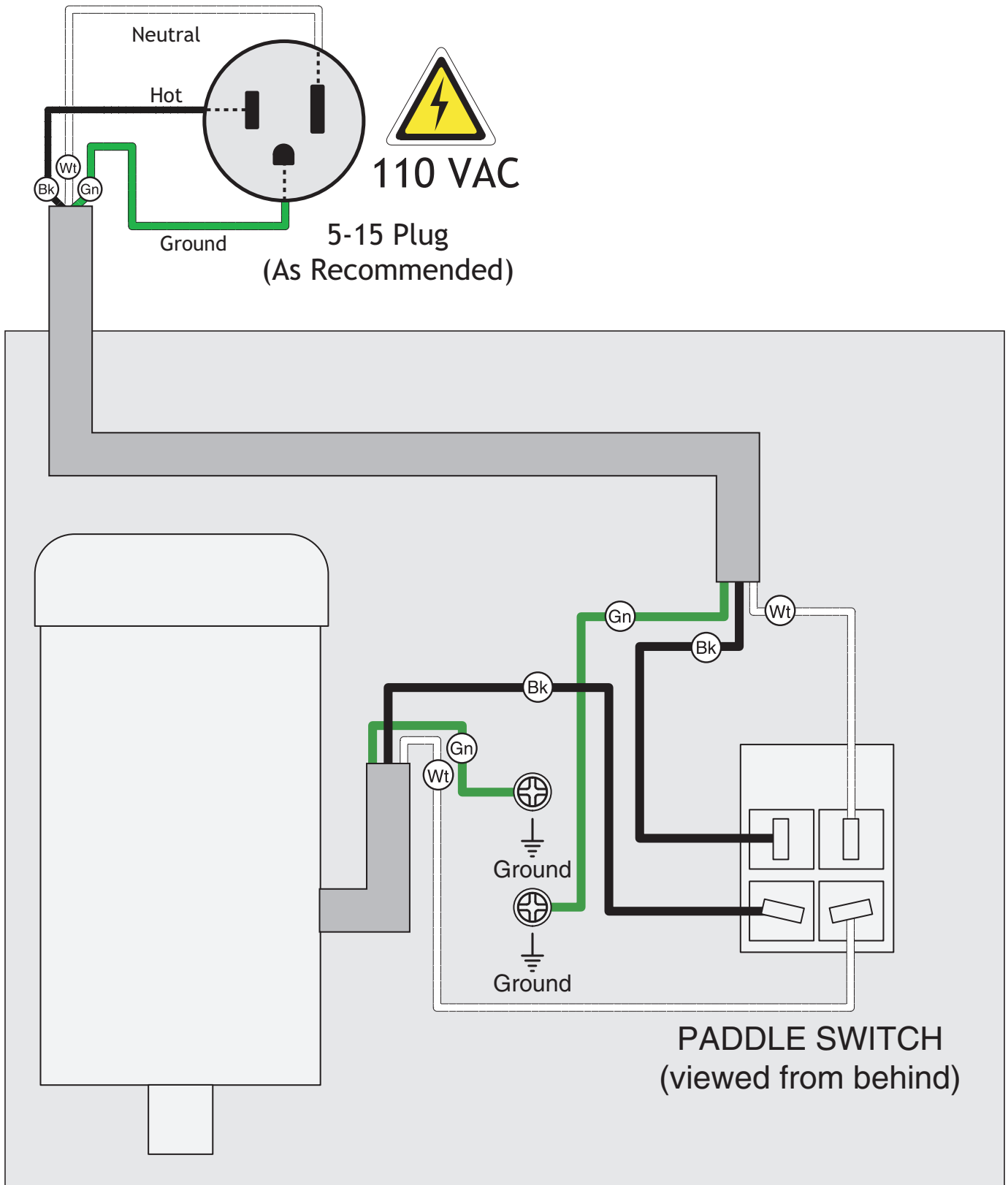
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK		BLUE		YELLOW		LIGHT BLUE	
WHITE		BROWN		YELLOW GREEN		BLUE WHITE	
GREEN		GRAY		PURPLE		TURQUOISE	
RED		ORANGE		PINK			

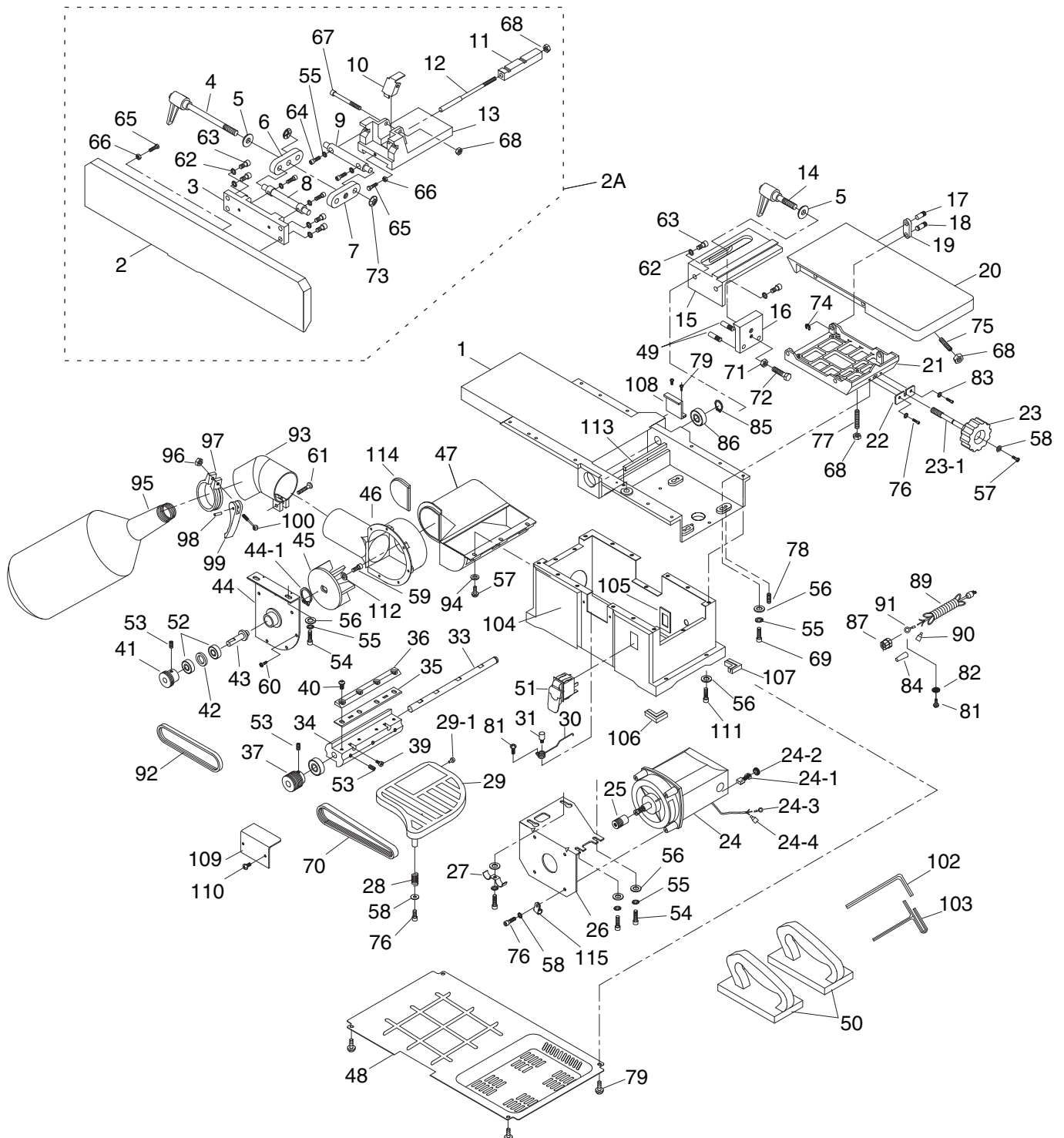


Wiring Diagram



SECTION 9: PARTS

Main Breakdown



Main Parts List

REF	PART #	DESCRIPTION
1	P0725001	TABLE
2	P0725002	FENCE
2A	P0725002A	FENCE ASSEMBLY
3	P0725003	FENCE PLATE
4	P0725004	FENCE TILTING HANDLE
5	PW01M	FLAT WASHER 8MM
6	P0725006	RIGHT LINK
7	P0725007	LEFT LINK
8	P0725008	PLATE SHAFT
9	P0725009	BRACKET SHAFT
10	P0725010	LIMIT PLATE
11	P0725011	BLOCK
12	P0725012	SHAFT
13	P0725013	FENCE BRACKET
14	P0725014	FENCE SLIDING HANDLE
15	P0725015	FENCE SUPPORT
16	P0725016	LOCKING PLATE
17	P0725017	TABLE PIN
18	P0725018	FRAME PIN
19	P0725019	BRACKET
20	P0725020	INFEED TABLE
21	P0725021	TABLE FRAME
22	P0725022	SUPPORT PLATE
23	P0725023	KNOB
23-1	P0725023	KNOB BOLT
24	P0725024	MOTOR 2 HP UNIVERSAL
24-1	P0725024-1	CARBON BRUSH SET
24-2	P0725024-2	BRUSH COVER
24-3	P0725024-3	RING TERMINAL
24-4	P0725024-4	SPADE TERMINAL
25	P0725025	MOTOR PULLEY
26	P0725026	MOTOR MOUNTING PLATE
27	P0725027	CORD CLAMP
28	P0725028	COMPRESSION SPRING
29	P0725029	BLADE GUARD
29-1	P0725029-1	RUBBER BUMPER
30	P0725030	TORSION SPRING
31	P0725031	PIN
33	P0725033	SHAFT
34	P0725034	CUTTERHEAD
35	P0725035	KNIVES 2-PC SET 6" x 7/8" x 3/32"
36	P0725036	KNIFE CLAMP
37	P0725037	DRIVE PULLEY
39	P0725039	JACK SCREW M4-.7 X 10
40	PCAP115M	BUTTON HD CAP SCR M6-1 X 16
41	P0725041	FAN PULLEY
42	P0725042	SPACER
43	P0725043	FAN SHAFT
44	P0725044	CHIP BLOWER MOUNTING PLATE
44-1	PR17M	EXT RETAINING RING 26MM
45	P0725045	IMPELLER
46	P0725046	CHIP EXHAUST
47	P0725047	CHIP COLLECTOR
48	P0725048	BASE BOTTOM

REF	PART #	DESCRIPTION
49	P0725049	ALIGNMENT PIN
50	P0725050	PUSH BLOCKS
51	G8988	PADDLE SWITCH
52	P6000ZZ	BALL BEARING 6000ZZ
53	PSS01M	SET SCREW M6-1 X 10
54	PCAP26M	CAP SCREW M6-1 X 12
55	PLW03M	LOCK WASHER 6MM
56	PW03M	FLAT WASHER 6MM
57	PS09M	PHLP HD SCR M5-.8 X 10
58	PW02M	FLAT WASHER 5MM
59	PCAP17M	CAP SCREW M4-.7 X 10
60	PHTEK47M	TAP SCREW M6 X 12
61	PS107M	PHLP HD SCR M6-1 X 20
62	PLW04M	LOCK WASHER 8MM
63	PCAP14M	CAP SCREW M8-1.25 X 20
64	PCAP02M	CAP SCREW M6-1 X 20
65	PB149M	HEX BOLT M5-.8 X 25
66	PN06M	HEX NUT M5-.8
67	PCAP83M	CAP SCREW M6-1 X 55
68	PN01M	HEX NUT M6-1
69	PCAP07M	CAP SCREW M6-1 X 30
70	P0725070	RIBBED V-BELT 171J5 NK
71	PN03M	HEX NUT M8-1.25
72	PB20M	HEX BOLT M8-1.25 X 35
73	P0725073	SHAFT RETAINER M10
74	PEC09M	E-CLIP 6MM
75	PSS28M	SET SCREW M6-1 X 30
76	PCAP07M	CAP SCREW M6-1 X 30
77	PSS29M	SET SCREW M6-1 X 35
78	PSS11M	SET SCREW M6-1 X 16
79	PS05M	PHLP HD SCR M5-.8 X 8
81	PS38M	PHLP HD SCR M4-.7 X 10
82	PTLW01M	EXT TOOTHED WASHER 4MM
83	PLW01M	LOCK WASHER 5MM
84	P0725084	WIRE NUT
85	PR03M	EXT RETAINING RING 12MM
86	P6201ZZ	BALL BEARING 6201ZZ
87	P0725087	STR SNAP-IN STRAIN RELIEF 5/8"
89	P0725089	POWER CORD 16 AWG 3C 5-15
90	P0725090	SPADE TERMINAL
91	P0725091	RING TERMINAL
92	P0725092	FAN RIBBED V-BELT V1.25-7A
93	P0725093	DUST CHUTE
94	PW02M	FLAT WASHER 5MM
95	P0725095	DUST COLLECTION BAG
96	PN01M	HEX NUT M6-1
97	P0725097	CLAMP 60MM
98	P0725098	SOLID PIN 4.5 X 20MM
99	P0725099	CLAMP HANDLE
100	P0725100	SWING BOLT M6-1 X 50
102	PAW06M	HEX WRENCH 6MM
103	PAW04M	HEX WRENCH 4MM
104	P0725104	BASE
105	P0725105	SWITCH MOUNTING PLATE



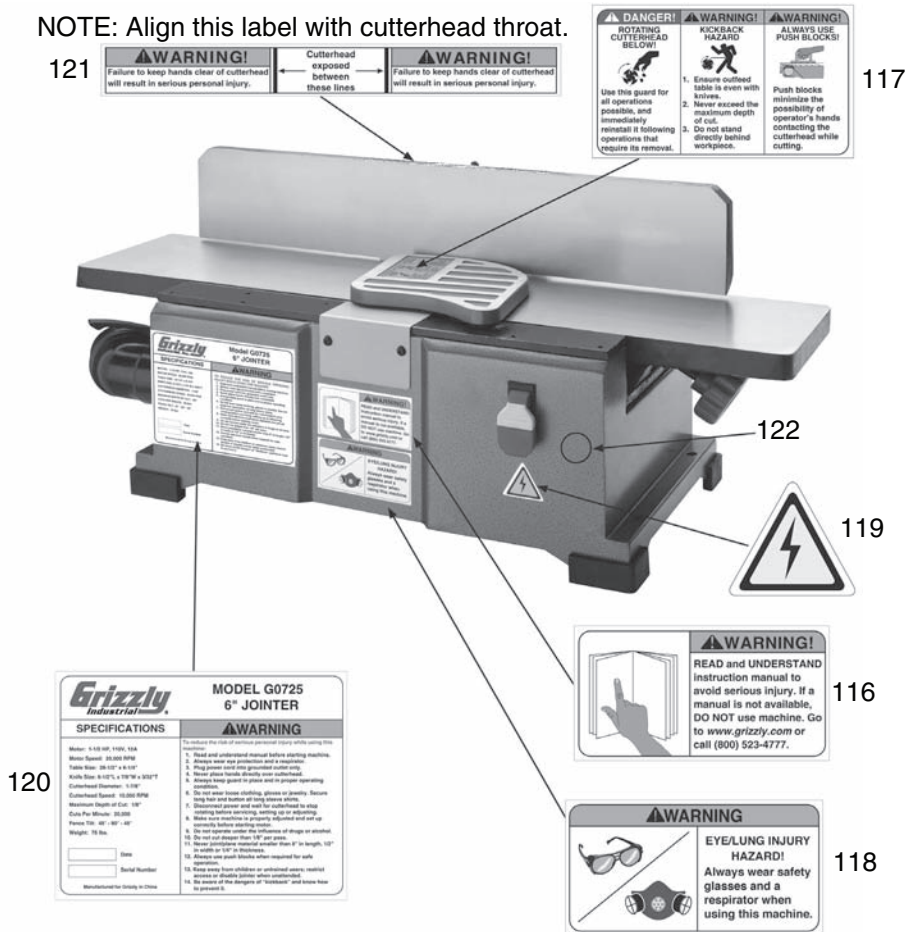
Main Parts List

REF	PART #	DESCRIPTION
106	P0725106	RIGHT RUBBER FOOT
107	P0725107	LEFT RUBBER FOOT
108	P0725108	GUARD PLATE
109	P0725109	CUTTERHEAD COVER
110	PS19M	PHLP HD SCR M5-.8 X 6

REF	PART #	DESCRIPTION
111	PCAP68M	CAP SCREW M6-1 X 8
112	PWF05M	FENDER WASHER 5MM
113	P0725113	INFEED TABLE SUPPORT ARM
114	P0725114	CHIP COLLECTOR COVER PLATE
115	P0725115	WIRE RESTRAINT

Machine Labels

NOTE: Align this label with cutterhead throat.



REF	PART #	DESCRIPTION
116	PLABEL-12B	READ MANUAL LABEL
117	P0725116	CUTTERHEAD GUARD LABEL
118	PLABEL-57B	EYE/LUNG HAZARD LABEL
119	PLABEL-14	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
120	P0725119	MACHINE ID LABEL
121	P0725120	CUTTERHEAD EXPOSURE LABEL
122	PPAINT-01	GRIZZLY GREEN TOUCH UP PAINT

! WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

0-2 3-5 6-9 10+

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

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

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times. Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



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



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

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.

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