Grizzly Industrial, Inc.®

6" JOINTER

MODEL G0526

INSTRUCTION MANUAL

#5503 PRINTED IN TAIWAN

ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE . CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

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

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

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 equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
4. **NEVER USE IN DANGEROUS ENVIRONMENT**. DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY**. All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **NEVER FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

⚠WARNING
Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DO NOT OVER-REACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

18. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** DO NOT leave tool until it comes to a complete stop.

19. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

20. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

21. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

Additional Safety Instructions For Jointers

1. **JOINTING SAFETY BEGINS** with your lumber. Inspect your stock carefully before you feed it over the cutterhead. If you have any doubts about the stability or structural integrity of your stock, **DO NOT JOINT IT!**

2. **MAINTAIN PROPER RELATIONSHIPS** of infeed and outfeed table surfaces and cutterhead knife path.

3. **ALWAYS USE A PUSH PADDLE** when jointing. Never place your hands directly over the cutterhead.

4. **SUPPORT THE WORKPIECE** adequately at all times during operation, and maintain control over the work at all times.

5. **WHEN JOINTING**, DO NOT stand directly at the end of either table. Position yourself just to the side of the infeed table to protect yourself from possible kickbacks**.**

6. **NEVER MAKE JOINTING CUTS** deeper than ⅛".

7. **NEVER JOINT A BOARD** that has loose knots. All defects should be cut out of the board before it is planed or jointed.

8. **NEVER JOINT** end grain.

9. **JOINT WITH THE GRAIN**. Jointing against the grain is dangerous and could produce chatter or excessive chip out, which could lead to loss of control over the workpiece.

10. **WITH THE EXCEPTION OF RABBETING**, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

11. **NEVER BACK THE WORK** toward the infeed table. If a cut must be interrupted, lift the workpiece clear of the cutterhead.

12. **HABITS — GOOD AND BAD** — are hard to break. Develop good habits in your shop and safety will become second-nature to you.

13. **"KICKBACK"** is when the workpiece is thrown off the jointer table by the force of the cutterhead. Always use push paddles 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.

14. **PROLONGED EXPOSURE TO WOOD DUST IS KNOWN TO CAUSE CANCER IN HUMANS.** Always wear an OSHA-approved respirator when working in an environment that could contain wood dust.

⚠WARNING

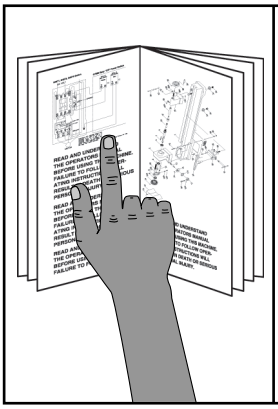
Like all machines there is danger associated with the Model G0526. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious 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: INTRODUCTION

Commentary



⚠WARNING

Lack of familiarity with this manual could cause serious personal injury. Become familiar with the contents of this manual, including all the safety warnings.

We are proud to offer the Model G0526 6" 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 G0526. 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. If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, 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

The specifications, drawings, and photographs illustrated in this manual represent the Model G0526 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!

SECTION 3: CIRCUIT REQUIREMENTS

Amperage Draw

The Model G0526 features a 110V/220V motor that is prewired at 110V.

Amperage Draw
110V (prewired) ..... 18 Amps
220V ..... 9 Amps

Circuit Breaker

Use the following guidelines when choosing a circuit breaker (circuit breakers rated any higher are not adequate to protect the circuit):

Circuit Breaker
110V (prewired) .....20 Amp, 1 Pole
220V .....10 Amp, 2 Pole

Plug-Type

The cord set enclosed is equipped with a NEMA 5-15 plug (**Figure 1a**).

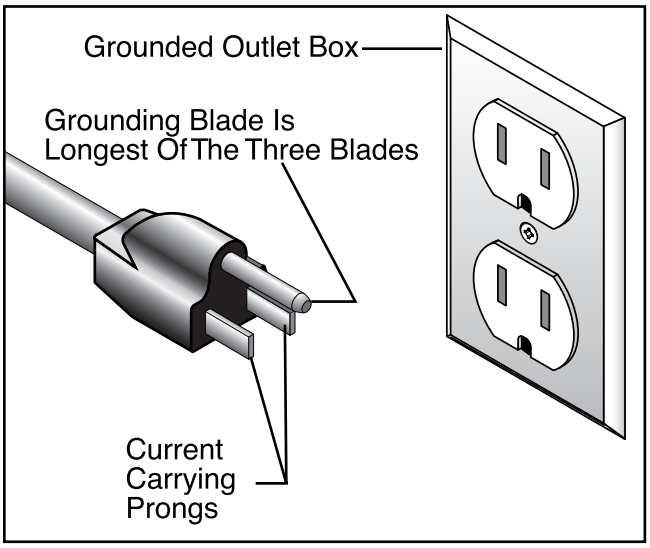


Figure 1a. NEMA 5-15 plug and receptacle.

If the jointer is rewired to operate on a 220V power source, the plug must be replaced with a NEMA 6-15 plug (**Figure 1b**).

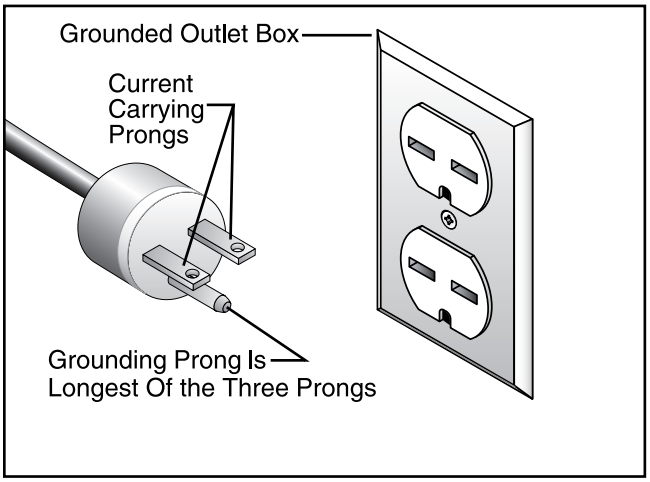


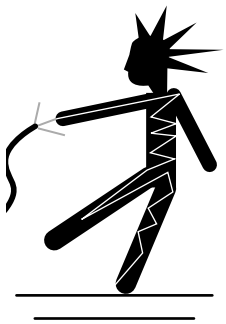
Figure 1b. NEMA 6-15 plug and receptacle.

Circuit Capacity

Always check to see if the wires 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.

If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified electrician.

Grounding



WARNING

Electrocution or a fire can result if the machine is not grounded correctly. Make sure all electrical circuits are grounded. DO NOT use the machine if it is not grounded.

NOTICE

The wire on the power cord with green or green and yellow striped insulation is the grounding conductor.

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with a power cord that has an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.

Extension Cords

Because of the high amperage draw from this machine, we do not recommend the use of extension cords. Instead, position your equipment near installed wiring to eliminate the need for extension cords.

Rewiring To 220V

The Model G0526 can be rewired to operate on a 220V power source; however, the MA-15 Magnetic Overload Switch (18-26A) must be replaced with an MA-9 Magnetic Overload Switch (8-12A). To order the MA-9, call our customer service number at (800) 523-4777 and purchase part # P0526349.

The motor must also be rewired to handle the 220V power source. The correct wiring configuration can be found on the inside of the motor wire cover, as well as on **page 48**.

This procedure takes moderate electrical skill and the rewiring job should be inspected by a licensed electrician before turning the machine *ON*.

SECTION 4: MACHINE FEATURES

External Features

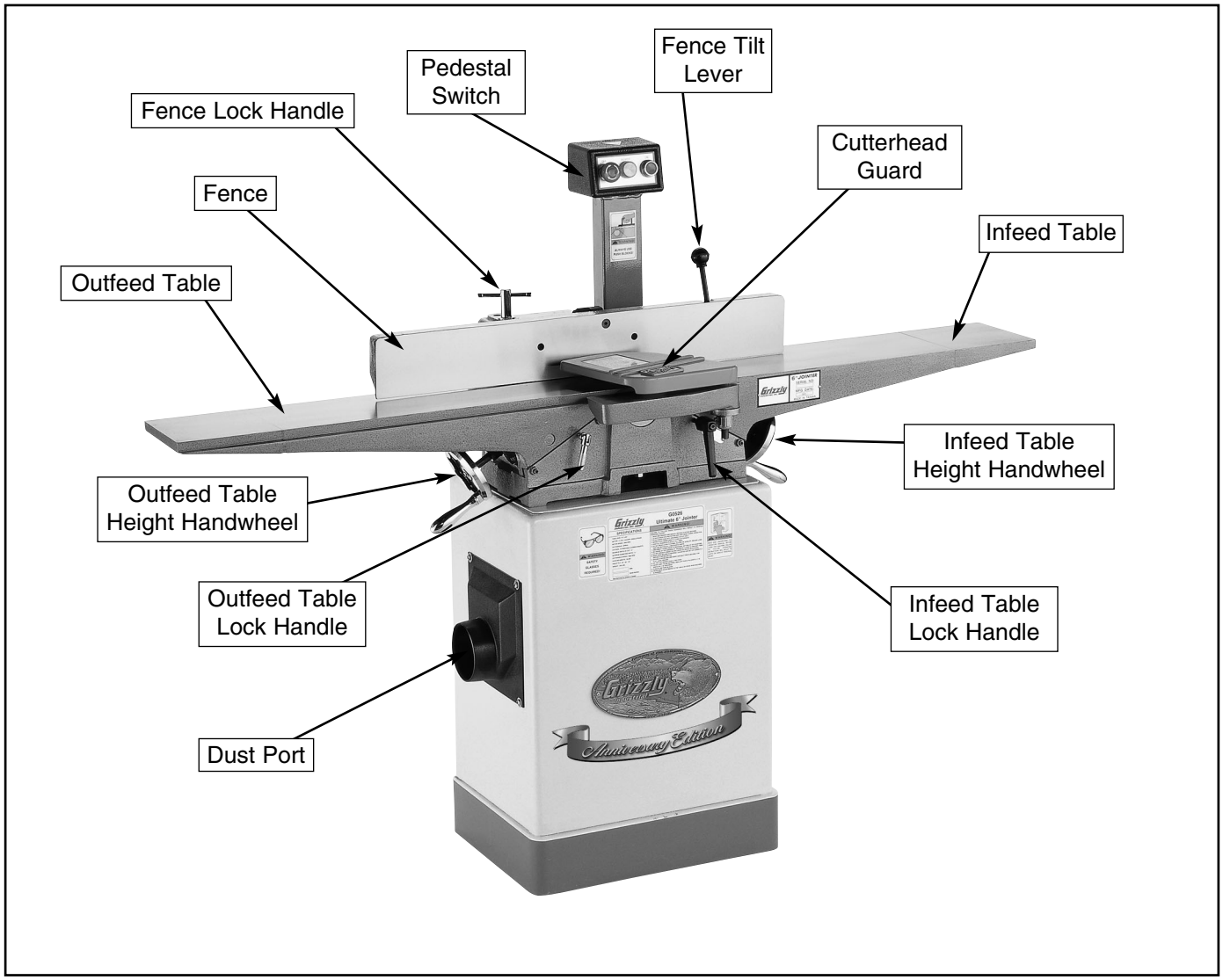


Figure 2. External features.

Common Terms & Definitions

Infeed Table: The infeed table is where the cutting operation begins. When facing the front of the jointer, it is on the right-hand side. The wood travels right to left; from the infeed table, across the cutterhead, and onto the outfeed table.

Outfeed Table: The outfeed table is where the cutting operation ends. When facing the front of the jointer, it is on the left-hand side.

Cutterhead: The cutterhead is the cylindrical assembly that holds each of the carbide cutters. It spins on a horizontal axis between the infeed and outfeed table, and is covered by the cutterhead guard.

Fence: The jointer fence is the adjustable cast iron surface that the wood stock runs along when jointing and surface planing. The fence is adjustable from 45°-90° to the infeed and outfeed tables.

Adjustment Handwheels: Controls the height of the infeed and outfeed tables.

Table Lock Handles: The threaded handles that must be loosened before the height of the tables can be adjusted. They are then tightened after the height is properly set.

Rabbet Cut: A rabbet cut is a groove cut along the long edge of the wood stock, usually used for making simple joints. The cutterhead guard must be removed for this operation, so great care is needed for safe operation.

Surface Planing: Surface planing is running the face of the wood stock over the jointer. This provides one flat side that is ready to be run through a dedicated planing machine.

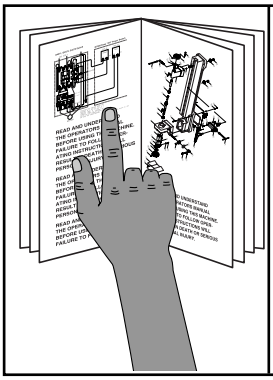
Edge Jointing: Edge jointing is running the long edge of the wood stock over the jointer. This provides one flat edge that is ready to be run against the table saw rip fence or edge glued.

Cutterhead Guard: The metal guard that covers the cutterhead and automatically moves out of the way during operation, then automatically moves back into place after the operation.

SECTION 5: SET UP

About This Section

The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.



⚠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!

Unpacking

The Model G0526 is shipped from the manufacturer in carefully packed boxes. 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 parts.

Parts Inventory

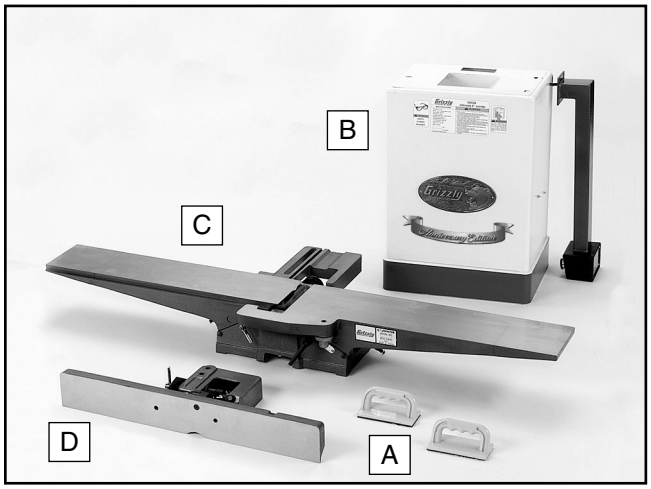


Figure 3. Loose components.

A. Push Paddles 2
B. Jointer Stand 1
C. Jointer 1
D. Fence (Ship Attached To Jointer) 1

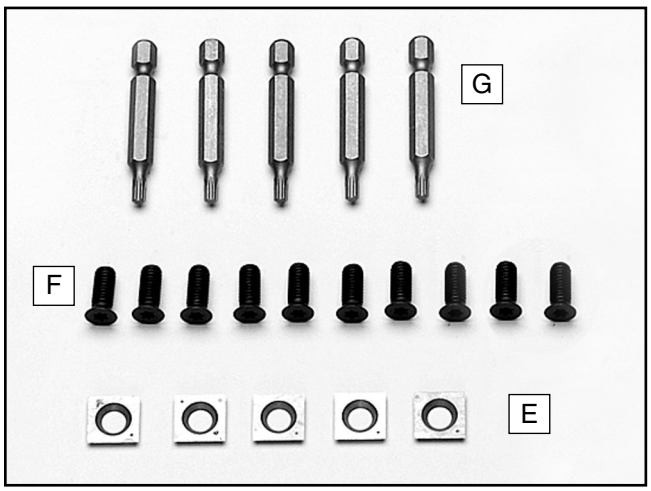


Figure 4. Spiral cutterhead bag contents.

E. Indexable Cutters 5
F. Flat Hd Torx Screws M6-1.0 x 15 10
G. Torx Bits 5
H. Torx T-Handle Driver 6mm (Not Shown) ..1

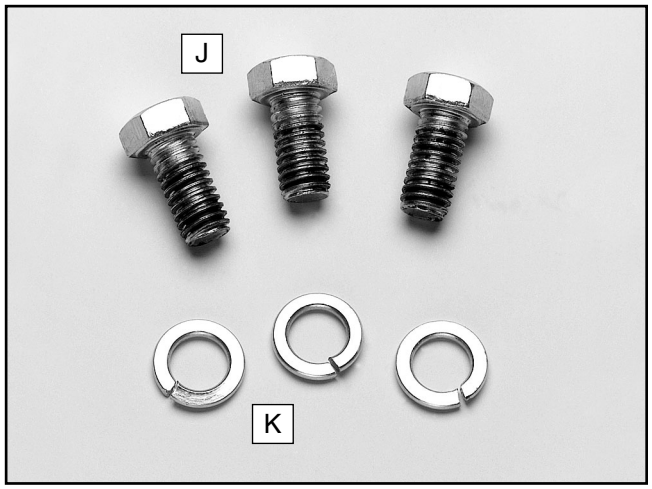


Figure 5. Jointer mounting hardware bag contents.

J. Hex Bolts ⅜"-16 x ¾" 3
K. Lock Washers ⅜" 3

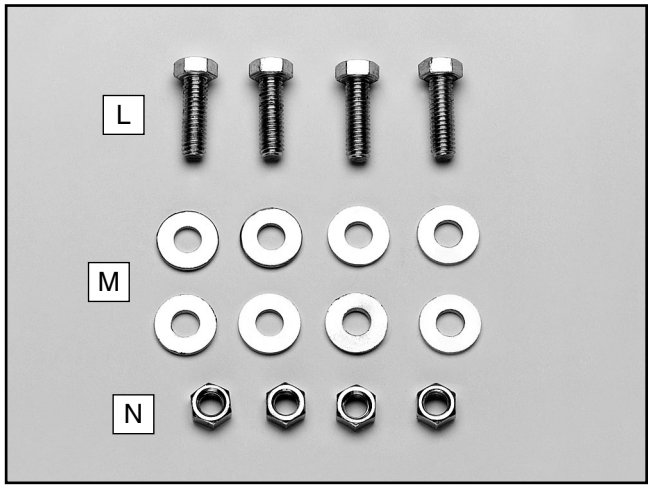


Figure 6. Pedestal switch hardware bag contents.

L. Hex Bolts 5⁄16"-18 x 1" 4
M. Flat Washers 5⁄16" 8
N. Hex Nuts 5⁄16"-18 4

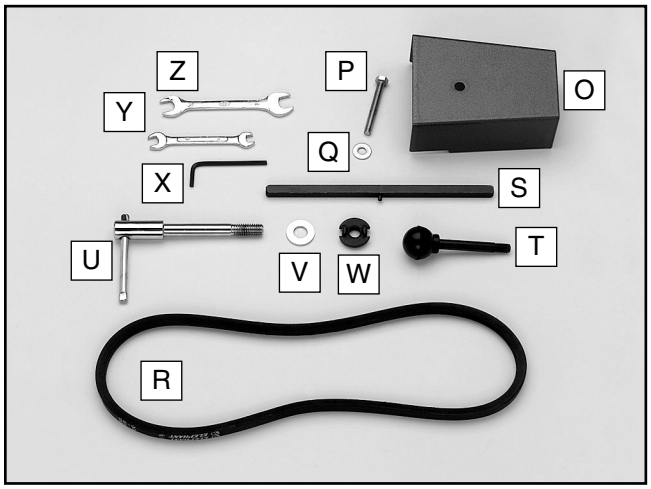


Figure 7. Large hardware bag contents.

O. V-Belt Belt Guard 1
P. Hex Bolt 5⁄16"-18 x 2½" 1
Q. Flat Washer 5⁄16" 1
R. V-Belt A-54 1
S. Fence Support Key W/Pin 1
T. Tilt Lever W/Knob 1
U. Lock Handle ½"-12 x 1¼" 1
V. Flat Washer ½" 1
W. Special Nut ½"-12 1
X. 3mm Allen Wrench 1
Y. 8 X 10mm Wrench 1
Z. 12 X 14mm Wrench 1

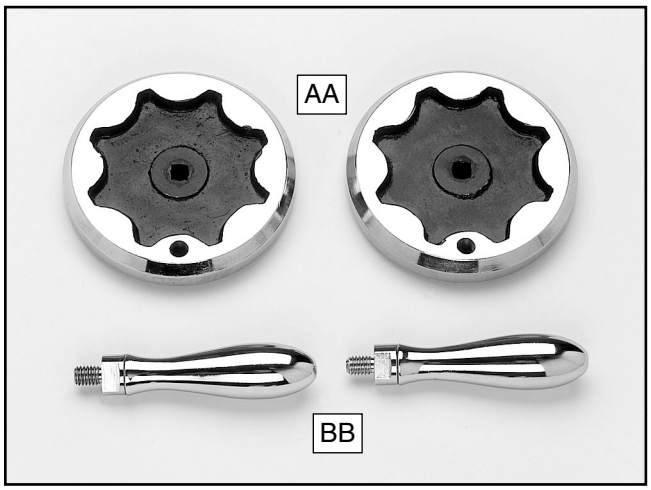


Figure 8. Handwheel bag contents.

AA. Handwheels 2
BB. Handwheel Handles 2

Figure 9. Cutterhead guard bag contents.

CC. Cutterhead Guard 1

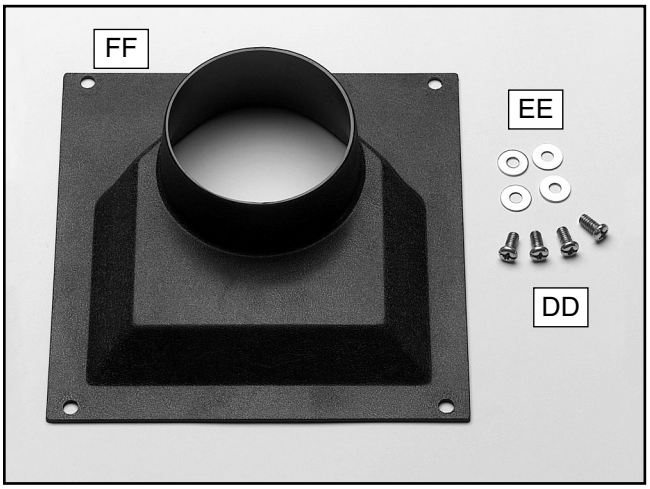
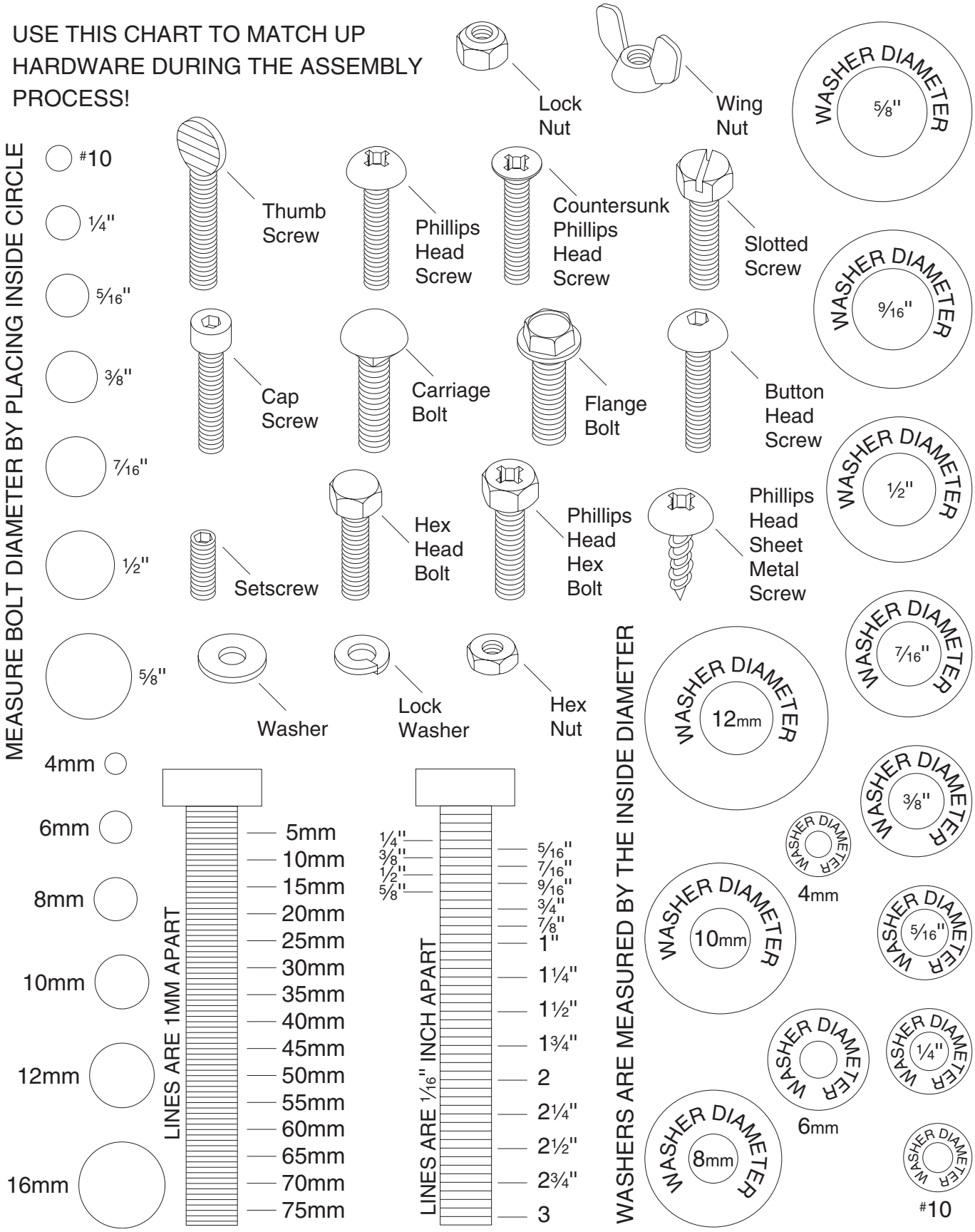


Figure 10. Dust port bag contents.

DD. Phillips Head Screws ¼"-20 x ½" 4
EE. Flat Washers ¼" 4
FF. Dust Port 1

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 as they may damage painted surfaces should they come in contact.

To access the sliding surfaces, remove the fence lock nut (**Figure 11**) and handle, and remove the fence from the jointer unit.

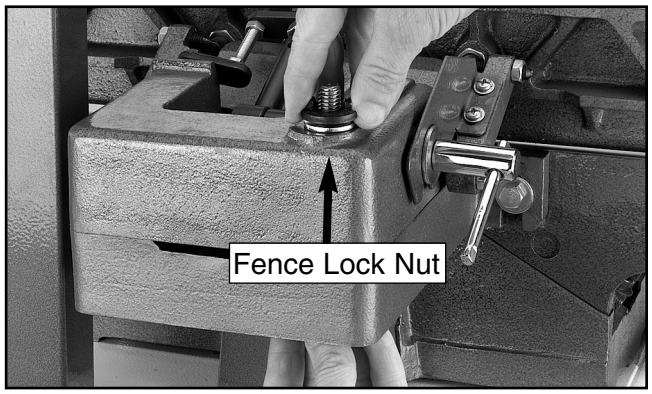


Figure 11. Removing the fence lock nut so the sliding surfaces can be cleaned.

Once the sliding surfaces are clean, reassemble the fence to the jointer with the lock handle on the top and the fence lock nut below the fence support assembly.

⚠WARNING

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

Site Considerations

Floor Load

The Model G0526 weighs 247 lbs and has a base footprint of 20" x 60". Most commercial floors are suitable for the 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 the machine. See **Figure 12** for the overall dimensions of the Model G0526.

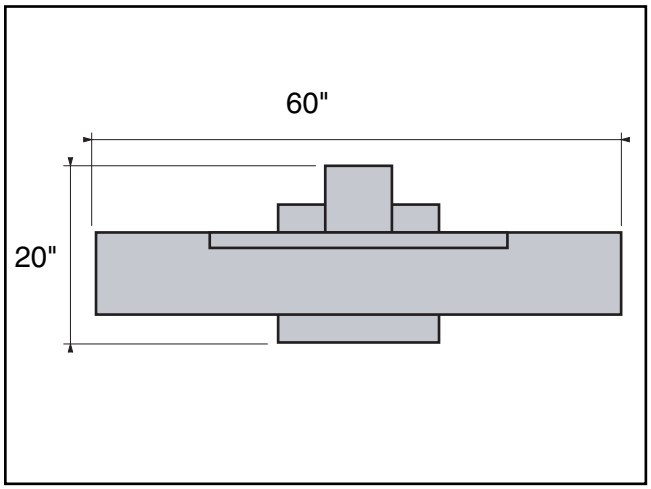
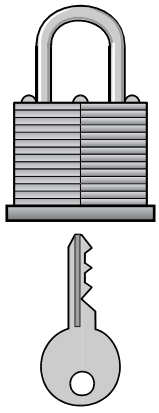


Figure 12. Overall machine dimensions.



⚠WARNING

Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.

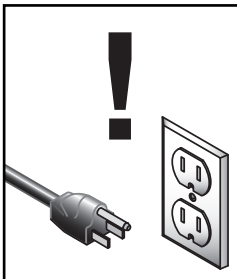
Beginning Assembly

This section covers the basic assembly and adjustment instructions needed to begin operation. Complete the assembly in the order provided in this manual and then read the remaining portion of the manual before attempting any type of operation.

Your safety is important! Please follow the warnings below during this entire section:

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

Disconnect power to the machine during the entire assembly process. Failure to do this may result in serious personal injury.

CAUTION

Sharp edges on metal parts may cause personal injury. Examine the edges of all metal parts before handling.

Jointer To Stand

Components and Hardware Needed: **Qty**
Jointer 1
Jointer Stand.....1
Hex Bolts ⅜"-16 x ¾" 3
Lock Washers ⅜" 3

Tools Needed:
14mm Wrench or Socket 1

CAUTION

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

To mount the jointer to the stand:

1. With the help of an assistant, lift the jointer onto the stand.

2. Align the three bolt holes on the jointer with the three holes on the stand (**Figure 13**).

Figure 13. Mounting holes.

3. Using a 14mm wrench, secure the jointer to the stand with the hex bolts and lock washers.

V-Belt

Components and Hardware Needed: **Qty**
V-Belt A-54 1

Tools Needed:
12mm Wrench or Socket 1
Straightedge 1

To install the V-belt:

1. Remove the back access panel from the jointer stand.

2. Using a 12mm wrench, loosen the motor mount bolts. Note—*DO NOT completely remove the motor mount bolts.*

3. Slide the motor upward far enough to allow the V-belt to be placed around the cutterhead pulley and the motor pulley.

4. Carefully allow the motor to slide downward, tensioning the V-belt with the weight of the motor.

5. Using a straightedge, check the alignment of the V-belt and the two pulleys (**Figure 14**).

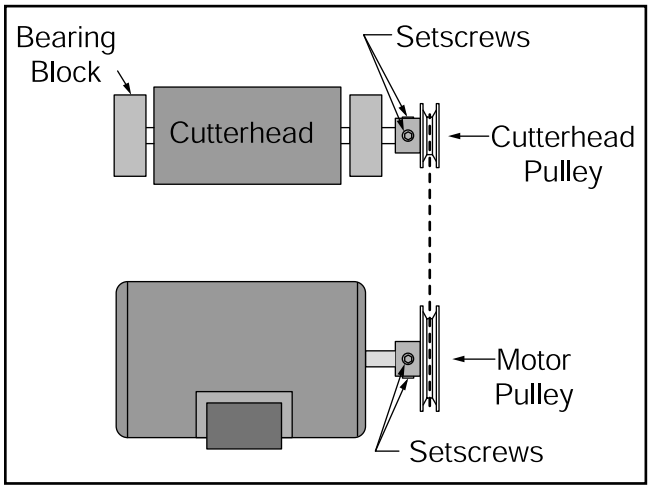


Figure 14. The V-belt should be in alignment with the two pulleys.

— If the V-belt is aligned between the pulleys, continue on to **step 7**.

— If the V-belt is NOT aligned between the pulleys, continue with the next step.

6. Adjust the motor until the V-belt is aligned between the pulleys. Note—*The pulleys can also be adjusted in and out along the motor shaft and cutterhead shaft by loosening the pulley setscrews.*

7. Tighten the motor mount bolts loosened in **step 1**

Dust Port

Components and Hardware Needed: **Qty**
Dust Port 1
Phillips Screws ¼"-20 x ½" 4
Flat Washers ¼" 4

Tools Needed:
Phillips Head Screwdriver 1

To install the dust port:

Using a Phillips head screwdriver, secure the dust port to the dust chute opening with the Phillips screws and flat washers (**Figure 15**). Note—*Make sure the dust port hose hook-up is positioned over the lower portion of the dust chute opening.*

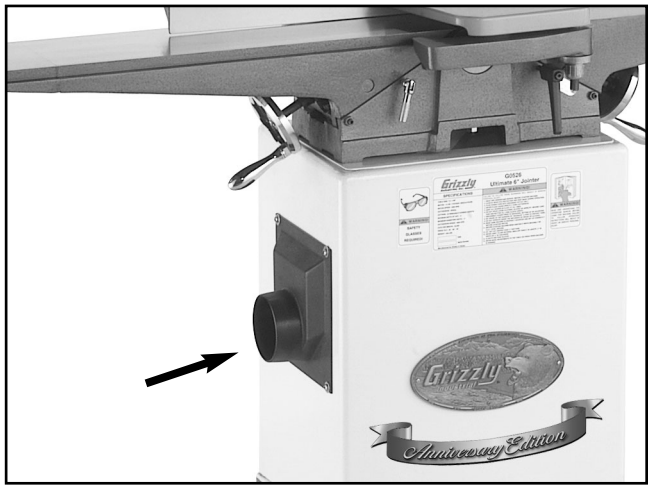


Figure 15. Correctly installed dust port.

Fence

Components and Hardware Needed: **Qty**
Fence Assembly 1
Lock Handle ½"-12 x 1¼" 1
Special Nut ½"-12 1
Flat Washer ½" 1
Tilt Lever W/Knob 1

To attach the fence assembly:

1. Place the fence assembly on the jointer as it was before removing it for cleaning (see **page 15**), making sure the key and keyways align with one another.

2. Secure the fence assembly to the jointer with the lock handle, the flat washer, and the special nut (**Figure 16**). Note—*Make sure the flanges on the special nut protrude upward and into the slot on the underside of the fence support.*

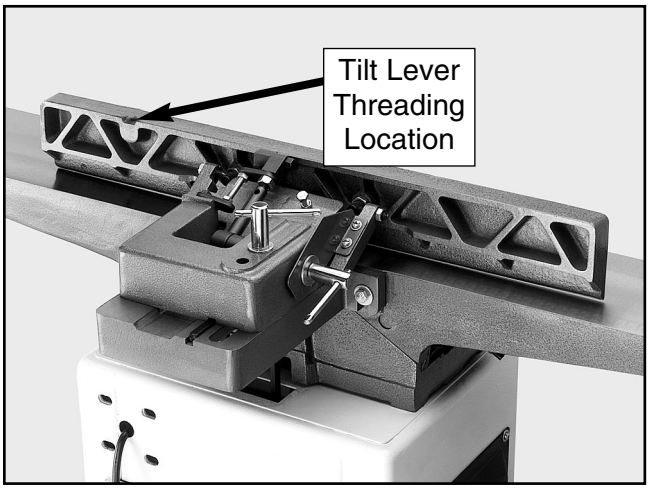


Figure 16. Correctly installed fence assembly.

3. Thread the tilt lever into the fence casting.

Cutterhead Guard

Components and Hardware Needed: **Qty**
Cutterhead Guard 1

Tools Needed:
2.5mm Allen Wrench.....1

To install the cutterhead guard:

1. Slide the cutterhead guard shaft down through the mounting hole on the table. Note—*The guard may not fully seat in the hole initially; however, rotating the guard will allow the shaft to fully seat in the hole.*

2. Using a 2.5mm Allen wrench, thread the setscrew through the hole in the forked end of the cutterhead guard shaft (**Figure 17**). Note—*Thread the setscrew far enough to prevent the guard from being pulled out.*

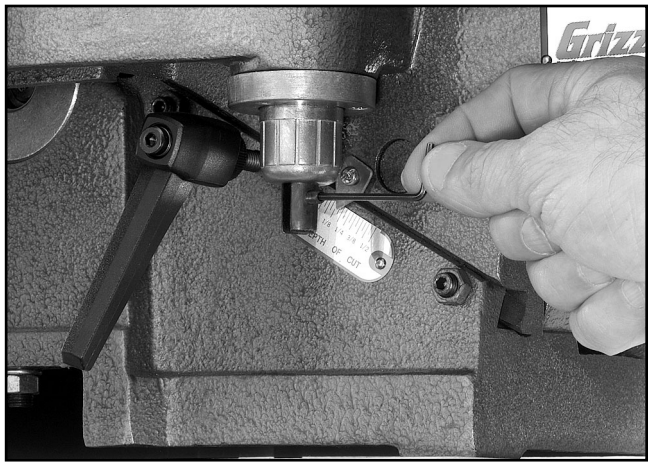


Figure 17. Cutterhead guard setscrew.

3. Raise the fence and rotate the guard one revolution counter-clockwise as it appears from the top. Hold the guard in position.

4. Lower the fence and allow the guard to swing back against the fence.

NOTICE

The cutterhead guard must always return to the closed position whenever it is moved. Repeat steps 1-3 until this occurs.

V-Belt Guard

Components and Hardware Needed: **Qty**
V-Belt Guard 1
Hex Bolt 5/16"-18 x 2½".....1
Flat Washer 5/16" 1

Tools Needed:
12mm Wrench or Socket 1

To install the V-belt guard:

Using a 12mm wrench, secure the V-belt guard over the cutterhead pulley and V-belt with the hex bolt and flat washer (**Figure 18**).

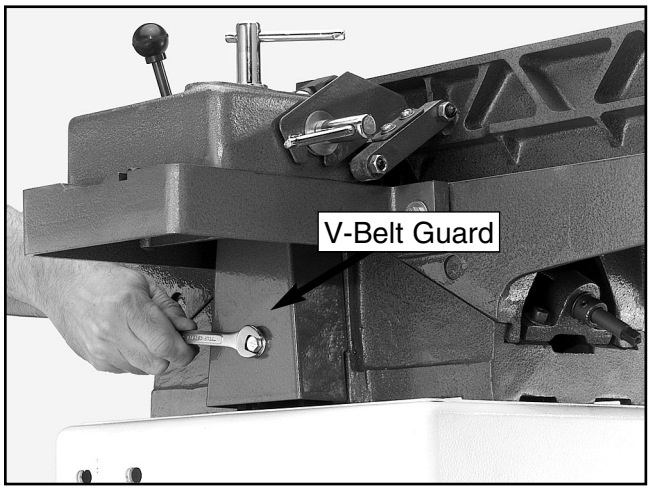


Figure 18. Correctly installed V-belt guard.

Pedestal Switch

Components and Hardware Needed: **Qty**
Pedestal Switch 1
Hex Bolts 5/16"-18 x 1" 4
Hex Nuts 5/16"-18 4
Flat Washers 5/16" 8

Tools Needed:
12mm Wrench or Socket 2

To install the pedestal switch:

Using two 12mm wrenches, secure the pedestal switch to the jointer stand with the hex bolts, the flat washers, and the hex nuts (**Figure 19**).

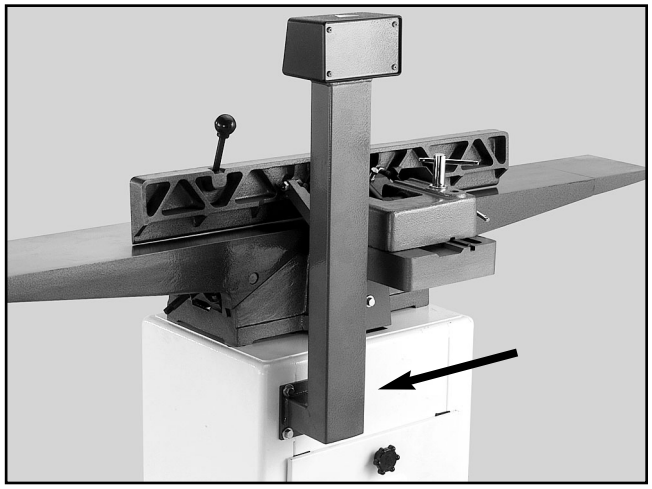


Figure 19. Correctly installed pedestal switch.

Handwheels

Components and Hardware Needed: **Qty**
Handwheels 2
Handwheel Handles 2

Tools Needed:
Phillips Head Screwdriver.....1
14mm Wrench.....1

To install the handwheels:

1. Using a 14mm wrench, secure the handwheel handles to the handwheels (**Figure 20**).

Figure 20. Securing the handwheel handle.

2. Using a Phillips head screwdriver, remove the two Phillips head screws and flat washers from the end of the leadscrews under each table.

3. Secure the handwheel assemblies to the end of the leadscrews with the Phillips head screws and flat washers that were removed in **step 2**.

Start Up

⚠WARNING

Loose hair and clothing could get caught in machinery causing 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 3: Circuit Requirements* (**Page 7**).
5. Keep your finger on the *STOP* button at all times during the test run.

Starting the machine:
Press the *START* button to turn the machine *ON*. The machine should run smoothly with little or no vibration.

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 on verifying these adjustments can be found in *Section 8: Service Adjustments*.

Factory adjustments that should be verified:

1. Outfeed Table Height (**page 31**)

2. Depth-of-Cut Scale (**page 32**)

3. Fence Stops (**page 32**)

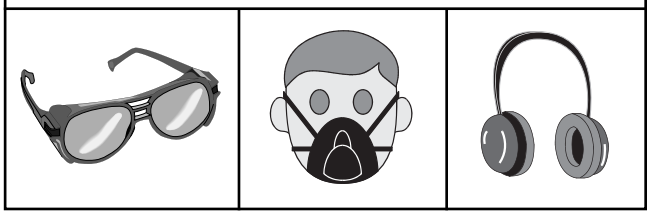
SECTION 6: OPERATIONS

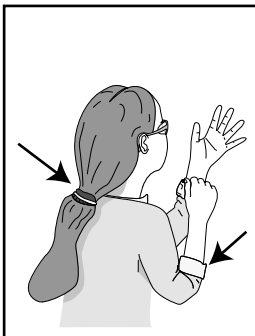
General

Your safety is important! Please follow the warnings below during this entire section:

⚠WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a dust mask, and hearing protection while using this machine.





⚠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.

Stock Inspection & 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 (See **Warning #13** on **page 5**), 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 21**). Note—*If the grain changes direction along the edge of the board, your best bet for improving cut quality is to decrease the cutting depth and make additional passes.*

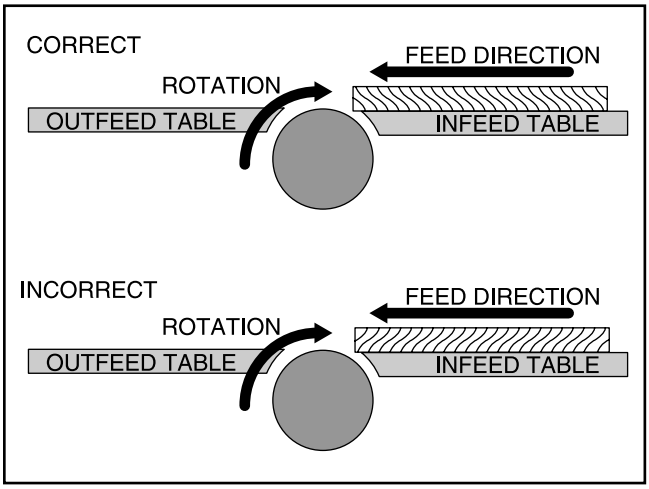


Figure 21. Correct and incorrect grain alignment to cutterhead.

- **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 will produce undesirable results.

- **Make sure the stock meets the minimum dimension requirement (Figures 22 and 23) before edge jointing or surface planing.**

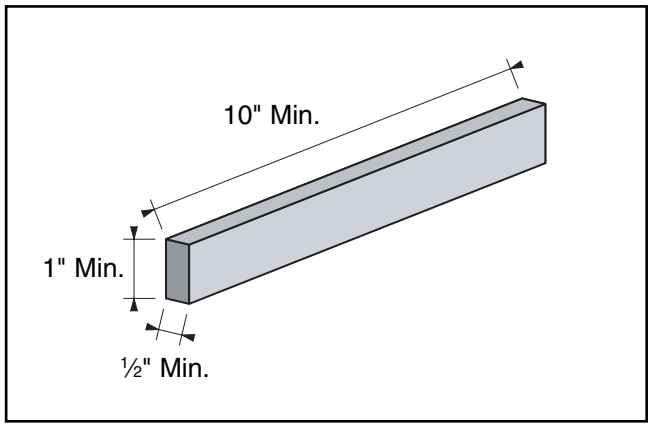


Figure 22. Minimum dimensions for edge jointing.

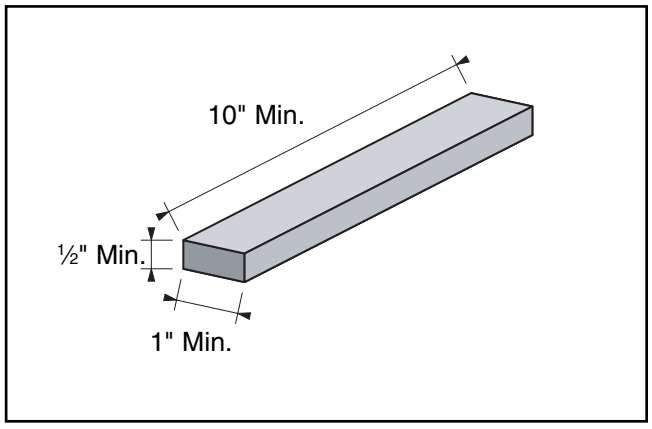
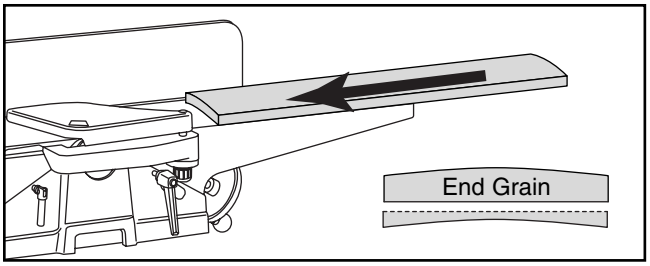


Figure 23. Minimum dimensions for surface planing.

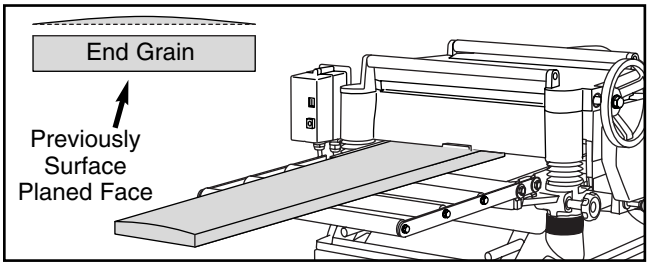
Squaring Stock

Squaring stock involves four steps that should be performed in the order below. The following pages will go into more detail.

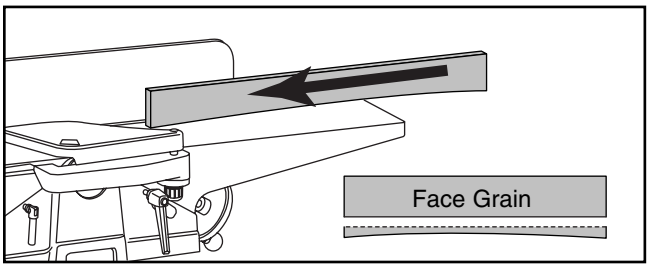
1. Surface Plane On The Jointer—The concave face of the workpiece is surface planed flat with the jointer.



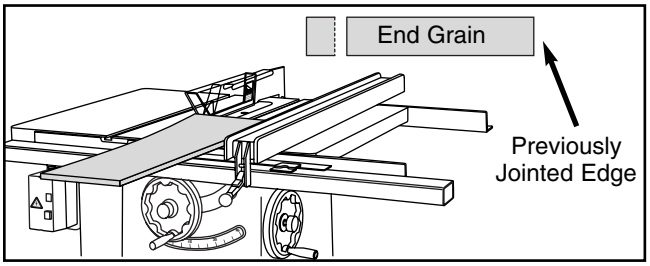
2. Surface Plane On A Thickness Planer—The opposite face of the workpiece is surface planed flat with a thickness planer.



3. Edge Joint On The Jointer—The concave edge (viewed from end-to-end) of the workpiece is edge jointed flat with the jointer.



4. Rip Cut On A Table Saw—Place the jointed edge of the workpiece against a table saw fence and rip the opposite edge off.



Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (**Figure 24**) to prepare it for surface planing on a thickness planer.

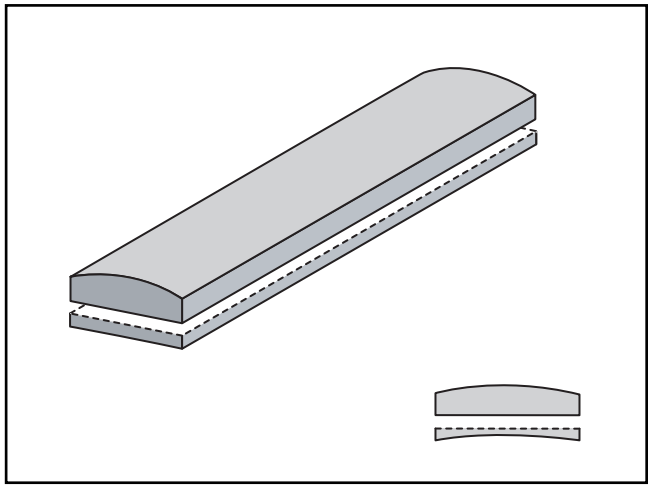


Figure 24. Illustration of surface planing results.

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.

To surface plane on the jointer:

1. Read and understand *Section 1: Safety,* beginning on **page 3**.

2. Make sure your stock has been inspected for dangerous conditions as described in the "Stock Inspection" instructions, beginning on **page 22**.

3. Set the cutting depth for your operation. (We suggest 1/32" for surface planing, using a more shallow depth for harder wood species or for wider 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 on the surface of the infeed table.

6. Start the jointer.

7. With a push paddle in each hand, press the workpiece against the table and fence with firm pressure.

⚠WARNING

Failure to use push paddles when surface planing could result in the operator's hands coming into contact with the cutterhead, causing serious personal injury. Always use push paddles when surface planing on the jointer.

8. Feed the workpiece over the cutterhead. Note—*When your leading hand (with push paddle) gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push paddle on the portion of the workpiece that is over the outfeed table. At this point, 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!*

9. Repeat **steps 7-8** until the entire surface is flat.

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface (**Figure 25**) that is suitable for joinery or finishing. It is also a necessary step in the squaring process of rough or warped stock.

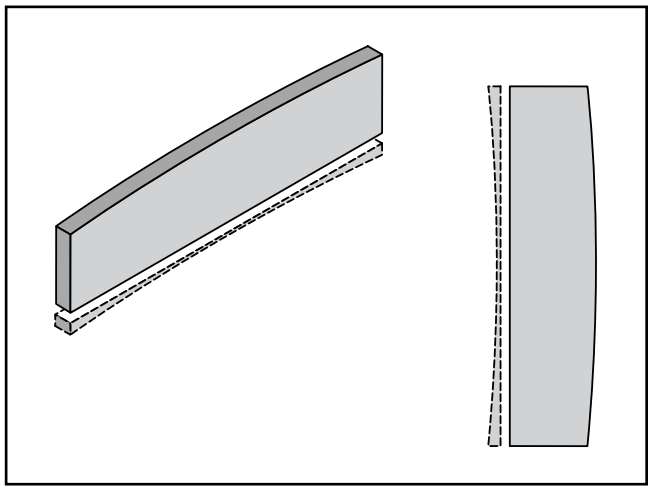


Figure 25. Illustration of edge jointing results.

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.

To edge joint on the jointer:

1. Read and understand *Section 1: Safety,* beginning on **page 3**.
2. Make sure your stock has been inspected for dangerous conditions as described in the "Stock Inspection" instructions, beginning on **page 22**.
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 harder wood species or for wider 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 on the surface of the infeed table.
6. Start the jointer.
7. Press the workpiece against the table and fence with firm pressure. Use your trailing hand to guide the workpiece through the cut.
8. Feed the workpiece over the cutterhead. Note—*If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place it on the portion of the workpiece that is over the outfeed table. At this point, 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!*
9. Repeat **steps 7-8** until the entire edge is flat.

Bevel Cutting

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

The Model G0526 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.

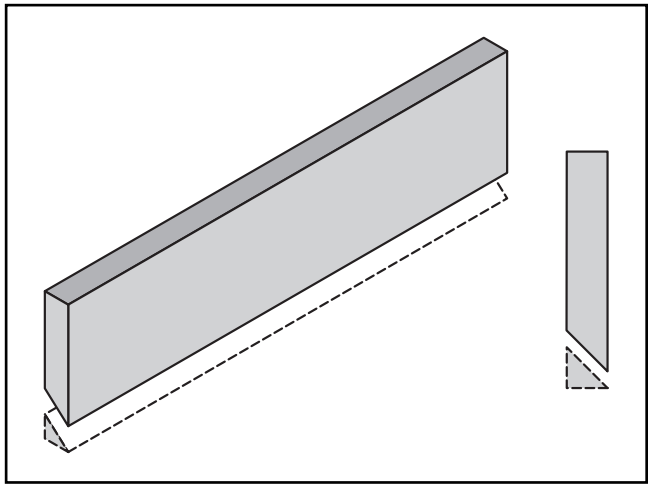


Figure 26. Illustration of bevel cutting results.

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.

To bevel cut on the jointer:

1. Read and understand *Section 1: Safety,* beginning on **page 3**.
2. Make sure your stock has been inspected for dangerous conditions as described in the "Stock Inspection" instructions, beginning on **page 22**.
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 harder wood species or for wider 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 paddle in your leading hand, press the workpiece against the table and fence with firm pressure.
8. Feed the workpiece over the cutterhead. Note—*If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push paddle on the portion of the workpiece that is over the outfeed table. At this point, 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!*
9. Repeat **steps 7-8** 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. When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock. See **Figure 27.**

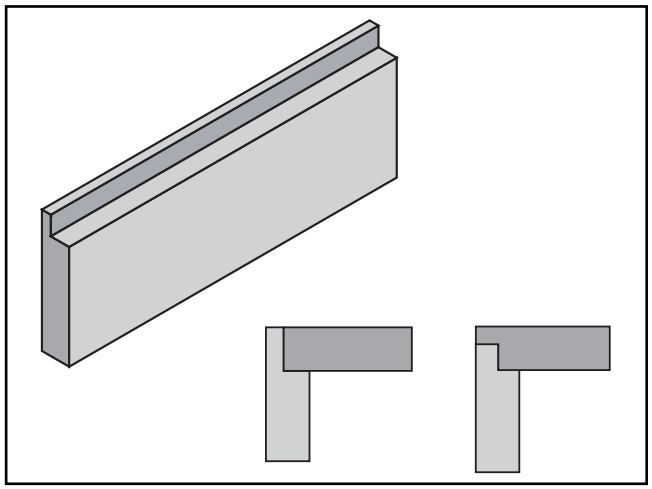


Figure 27. Illustration of rabbet cutting effects and a few sample joints.

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.

To rabbet cut on the jointer:

1. Read and understand *Section 1: Safety,* beginning on **page 3**.

2. Make sure your stock has been inspected for dangerous conditions as described in the "Stock Inspection" instructions, beginning on **page 22**.

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 harder wood species or for wider stock.)

4. 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°

5. Start the jointer.

6. With a push paddle in each hand, press the workpiece against the table and fence with firm pressure.

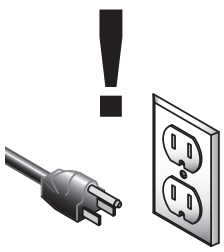
7. Feed the workpiece over the cutterhead. Note—*When your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push paddle on the portion of the workpiece that is over the outfeed table. At this point, focus your pressure on the outfeed end of the workpiece 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 **steps 7-8** until the your rabbet is cut to depth.

SECTION 7: MAINTENANCE

Maintenance Safety

Your safety is important! Please follow the warnings below during this entire section:



⚠WARNING

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

⚠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 from the machine could cause serious eye injury. Wear safety glasses at all times.

General

Regular periodic maintenance on the Model G0526 will ensure optimum performance. Make a habit of inspecting the machine each time you use it.

Before each use, look for the following conditions:

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Damaged V-belt.
5. Any other condition that could hamper the safe operation of this machine.

Table

The table and other non-painted surfaces on your machine should be protected against rust and pitting. Wiping the table clean after every use ensures that moisture from wood dust does not remain on bare metal surfaces.

Tables can be kept rust-free with regular applications of products like SLIPIT® or Boeshield® T-9. For long term storage you may want to consider products like Kleen Bore's Rust Guardit™.

V-Belts

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). Check the V-belt at least every 3 months; more often if the jointer is used daily.

Carbide Cutters

The carbide cutters are typically rotated at the same time when they become dull; however, the cutters can also be rotated individually when one becomes nicked or damaged. Refer to *Section 8: Service Adjustments* for instructions on rotating or replacing the carbide cutters.

Lubrication

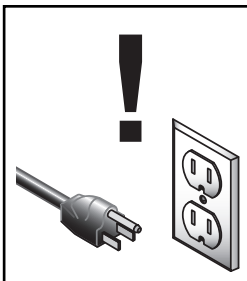
Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

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 8: SERVICE ADJUSTMENTS



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, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Outfeed Table Height

The outfeed table must be level with the carbide cutters when they are at top-dead-center.

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 carbide cutters is at top-dead-center.
3. Raise or lower the outfeed table until the carbide cutter just touches the straightedge (**Figure 28**).

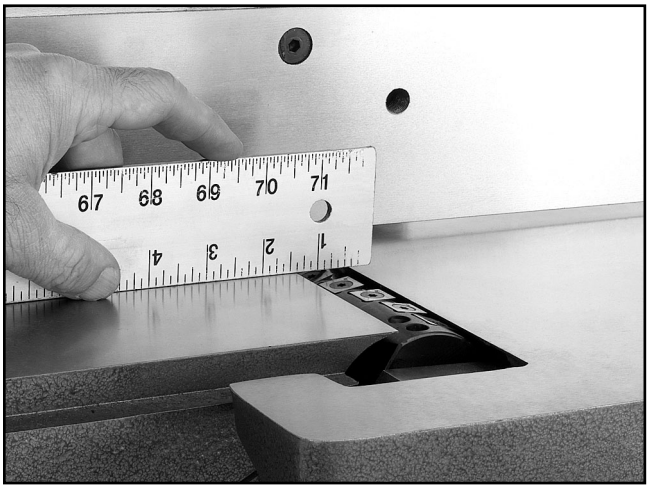


Figure 28. Setting the outfeed table height.

Depth-Of-Cut Scale

To set the depth-of-cut scale:

1. Set the outfeed table height as described in the “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.

4. Adjust the depth-of-cut pointer to read “0” (**Figure 29**).

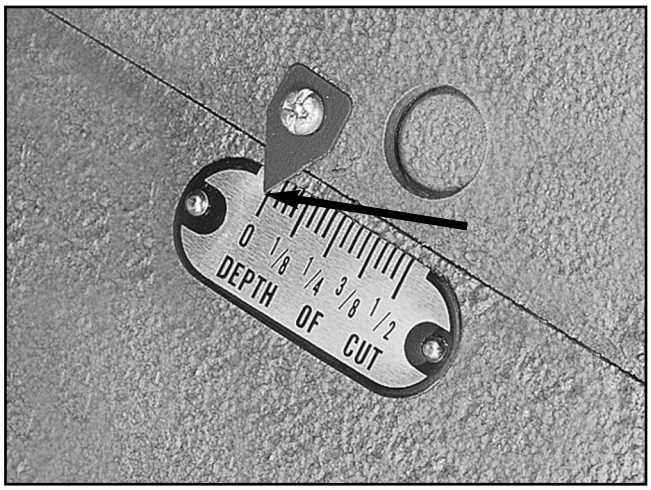


Figure 29. Depth-of-cut pointer adjusted to “0” position.

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.

2. Loosen the jam nut shown in **Figure 30**.

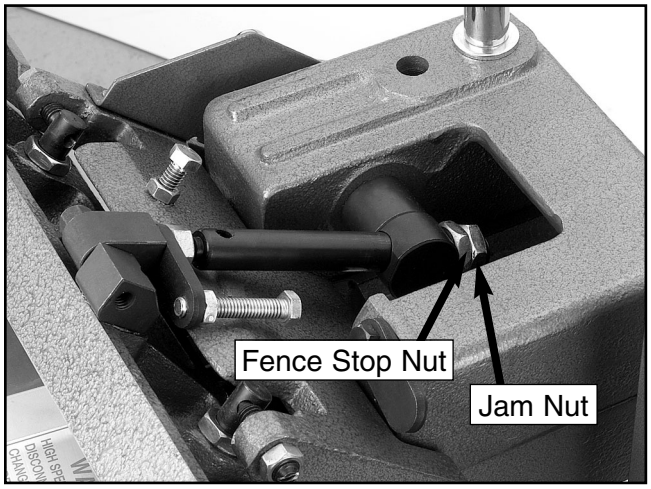


Figure 30. 45˚ inward fence stop jam nut.

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**.

To set the 90˚ fence stop:

1. Using a 90˚ square, adjust the fence to the 90˚ position.

2. Flip the 90˚ swing stop into the position shown in **Figure 31**.

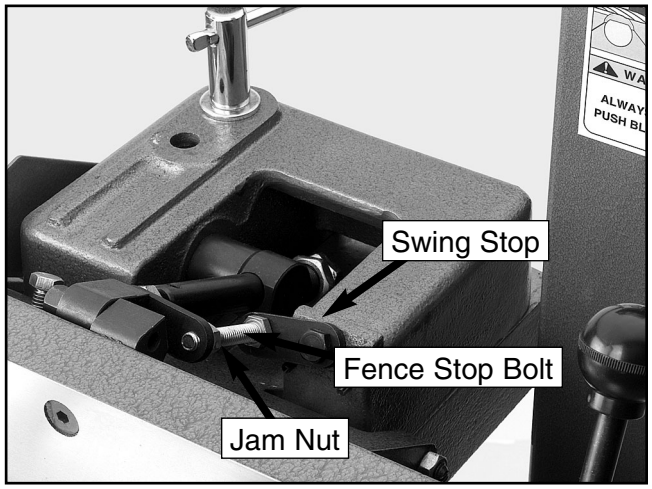


Figure 31. 90˚ swing stop engaged.

3. Loosen the jam nut on the 90˚ fence stop bolt (**Figure 31**).

4. Adjust the 90˚ fence stop bolt until it makes contact with the 90˚ swing stop.

5. Retighten the jam nut loosened in **step 3**.

To set the 45˚ outward fence stop:

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

2. Loosen the jam nut on the 45˚ outward fence stop bolt (**Figure 32**).

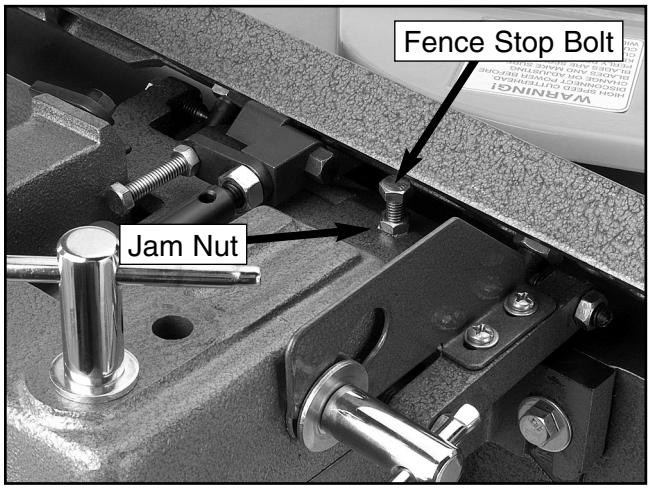


Figure 32. 45˚ outward fence stop jam nut.

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

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

Adjusting Gibs

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

To set the table gibs:

1. Using a 12mm wrench, loosen the two outfeed table gib nuts on the side of the jointer base (**Figure 33**).

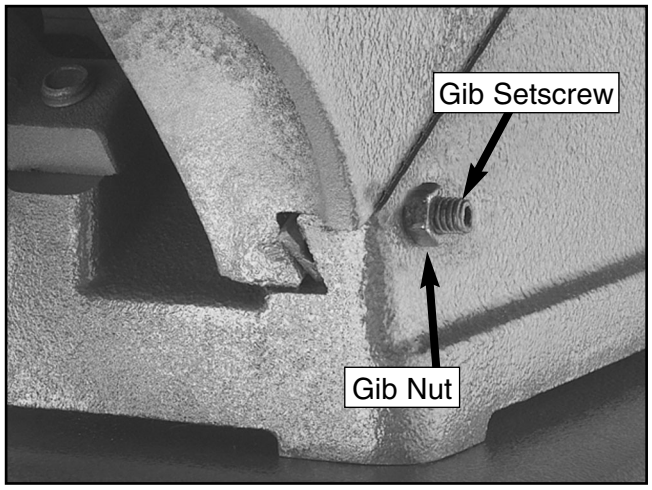


Figure 33. Outfeed table gib nuts.

2. Using a 4mm Allen wrench, evenly tighten both 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 the "Outfeed Table Height" sub-section.

Carbide Cutters

The cutterhead is equipped with 24 indexable carbide cutters. Each cutter can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90˚ to reveal a fresh cutting edge (**Figure 34**).

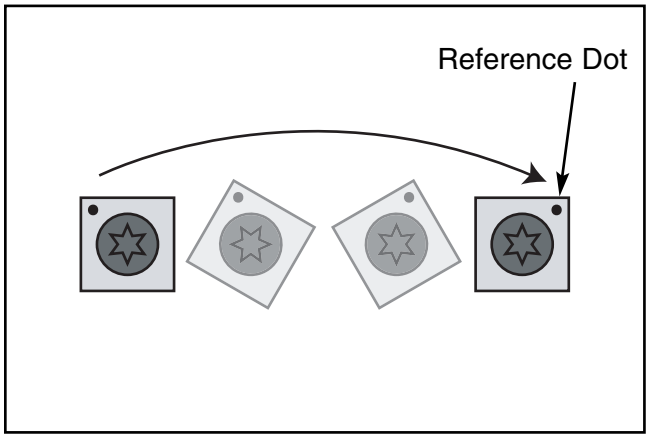


Figure 34. Always rotate carbide cutters clockwise to keep track of the dull or damaged edges.

In addition, each cutter has a reference dot on its corner. As the cutter is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. When the reference dot revolves back around to its starting position, the cutter must be replaced.

Installing or adjusting a carbide cutter:

1. Remove any sawdust from the head of the carbide cutter Torx screw.

2. Remove the Torx screw, rotate or replace the carbide cutter, lubricate the Torx screw threads with a light machine oil, and torque the Torx screw to 48-50 inch/pounds.

SECTION 9: REFERENCE INFO

General

This section contains the following subsections for the Model G0526: aftermarket accessories, data sheets, wiring diagrams, parts diagrams and list, troubleshooting, and warranty/return information.

If you need parts or help in assembling your machine, or if you need operational information, call the service department at (570) 546-9663. Trained service technicians will be glad to help you.

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

Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department at the location listed below.

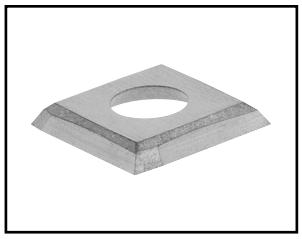
Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com.

Aftermarket Accessories

To order any of the aftermarket accessories below, find the model number in bold and call our customer service line 24 hours a day at 1-800-523-4777.

Push Paddles
Small Push Paddle.....**G2405**
Large Push Paddle **G2406**

Replacement Carbide Inserts - H2334
These indexable carbide inserts can be rotated to provide four factory sharp edges before they need to be replaced.



Heavy-Duty SHOP FOX® Mobile Base - G8683
Make your jointer mobile with this popular patented mobile base.

MACHINE DATA SHEET

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

MODEL G0526 6" SPIRAL CUTTERHEAD JOINTER

Design Type .....Floor Model

Capacities:
- Maximum Depth of Cut.....⅛"
- Maximum Width of Cut .....6"
- Maximum Rabbet Depth.....½"
- Cutterhead Speed .....4800 RPM
- Cuts Per Minute (Effective) 19,200

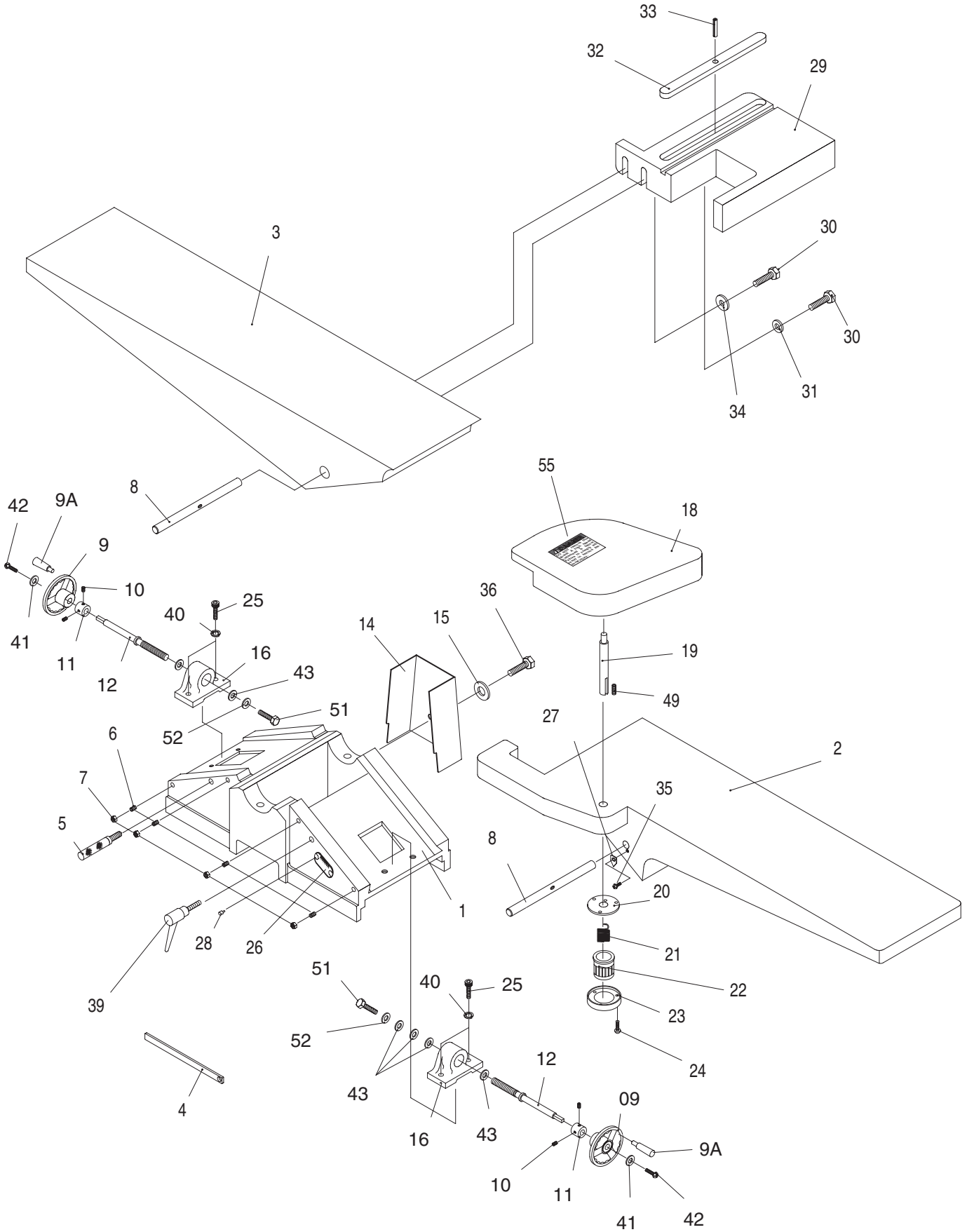
Overall Dimensions:
- Table Size .....7¼" W x 60" L
- Height From Floor To Table .....31⅞"
- Overall Length .....60"
- Overall Width .....20"
- Footprint .....18" W x 14" D
- Box 1 of 2 .....60⅞" L x 20⅞" W x 11⅞" H
- Box 2 of 2 .....27½" L x 22" W x 20⅝" H
- Net Weight .....247 lbs.
- Shipping Weight .....280 lbs.

Construction:
- Table.....Cast Iron
- Fence Assembly.....Cast Iron
- Body Assembly.....Cast Iron
- Base .....One-Piece Heavy-Duty Metal Cabinet - Powder Coated
- Cutterhead .....4 Spiral, Sealed & Lubricated Ball Bearings
- Guard .....Die Cast Metal
- Carbide Inserts .....14 x 14 x 2mm, 30˚ Bevel

Motor:
- Type .....TEFC Capacitor Start Induction
- Horsepower .....1½ HP
- Phase Type / Voltage .....Single Phase; 110V/220V
- Pre-Wired 110V
- Amps 18/9
- Cycle/RPM .....60 Hertz/3450 RPM
- Switch .....Magnetic Contactor - 110V Only
- Power Transfer..... V-Belt Drive
- Bearings.....Sealed & Permanently Lubricated Ball

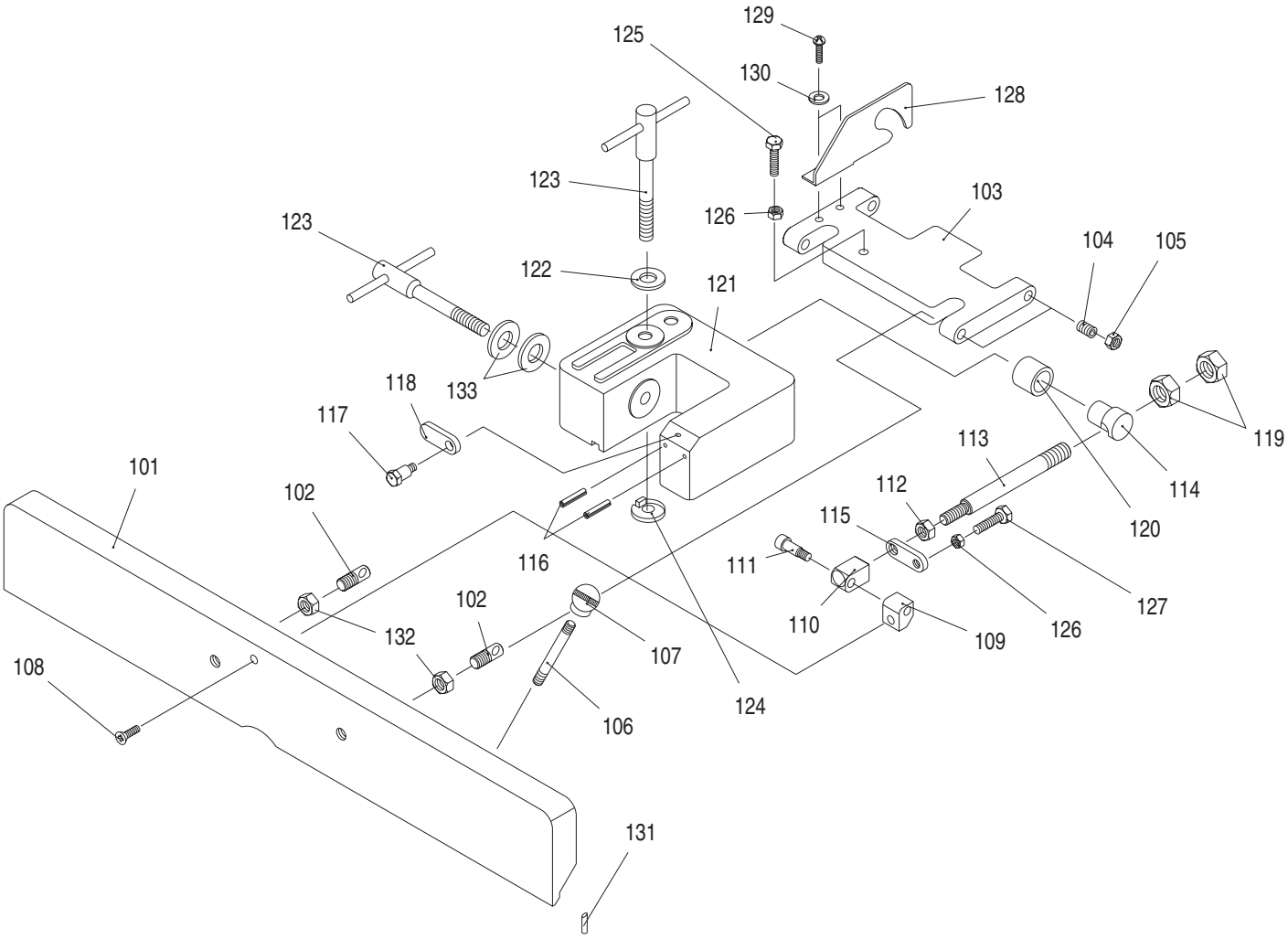
Features:
- .....Positive Fence Stops at ± 45° and 90°
- .....Precision Table Height Handwheels
- .....Built-In Rabbeting Capability
- .....Extra-Long Infeed & Outfeed Tables
- .....Post-Mounted Power Switch
- .....Built-In Chip Chute and Dust Hood

Specifications, while deemed accurate, are not guaranteed.
9/2003



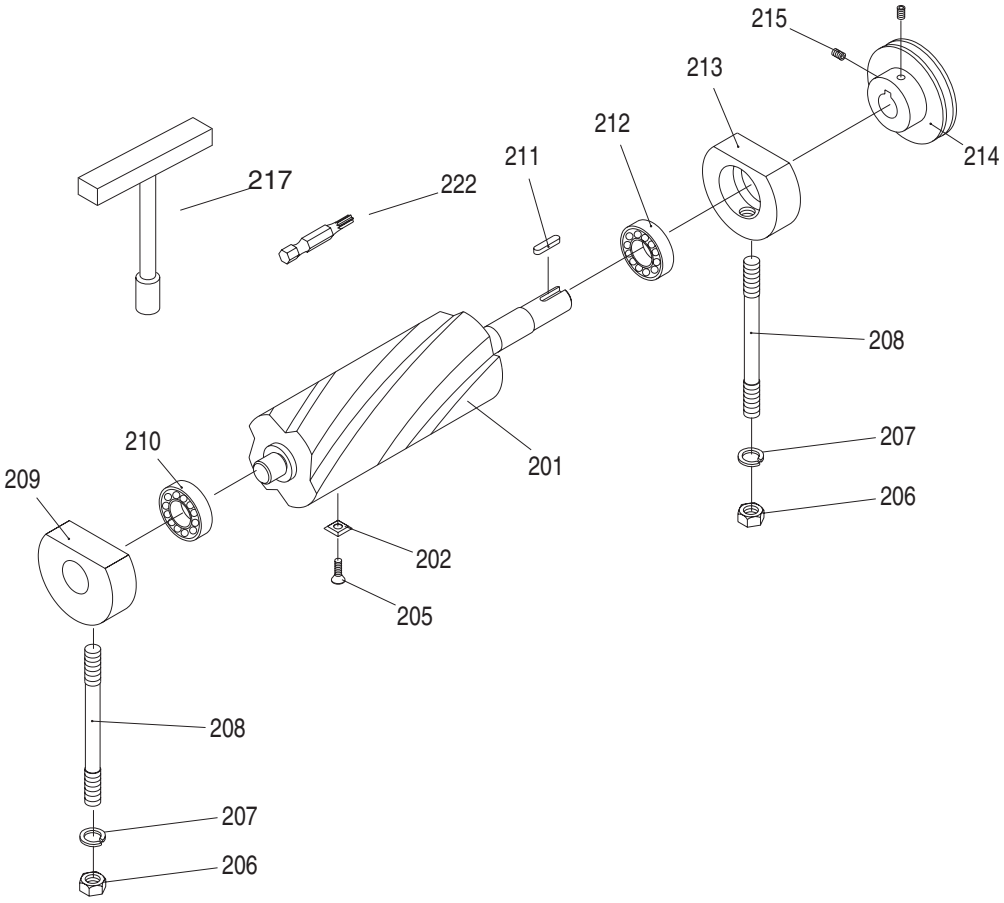
REF	PART #	DESCRIPTION
001	P0526001	BASE
002	P0526002	INFEED TABLE
003	P0526003	OUTFEED TABLE
004	P0526004	GIB
005	P0526005	TABLE LOCK HANDLE
006	PSS01	SETSCREW 5/16-18 X 1
007	PN02	HEX NUT 5/16-18
008	P0526008	TABLE ADJUST ROD
009	P0526009	HANDWHEEL
09A	P0526009A	HANDWHEEL HANDLE
010	PSS11	SETSCREW 1/4-20 X 1/4
011	P0526011	LOCK COLLAR
012	P0526012	TABLE ADJUST LEVER
014	P0526014	BELT GUARD
015	PW07	FLAT WASHER 5/16
016	P0526016	LEAD SCREW BRACKET
018	P0526018	CUTTERHEAD GUARD
019	P0526019	STUD
020	P0526020	SPRING PLATE
021	P0526021	SPRING
022	P0526022	SPRING HOUSING
023	P0526023	HOUSING MOUNT
024	PS25	PHLP HD SCR 8-32 X 5/8
025	PSB03	CAP SCREW 5/16-18 X 1

REF	PART #	DESCRIPTION
026	P0526026	SCALE
027	P0526027	POINTER
028	P0526028	RIVET
029	P0526029	FENCE SUPPORT
030	PB24	HEX BOLT 3/8-16 X 1 1/4
031	P0526031	SPACER
032	PK16	KEY 3/8 X 3/8 X 9"
033	PRP18M	ROLL PIN 4 X 12
034	PW02	FLAT WASHER 3/8
035	PS23	PHLP HD SCR 8-32 X 1/4
036	PB23	HEX BOLT 5/16-18 X 2 1/2
039	P0526039	LOCK HANDLE 5/16 (MALE)
040	PW07	FLAT WASHER 5/16
041	PW03	FLAT WASHER #10
042	PS01	PHLP HD SCR 10-24 X 1/2
043	PW01	FLAT WASHER 1/2
049	PSS31M	SETSCREW M5-.8 X 8
051	PB19	HEX BOLT 1/4-20 X 1/2
052	PW06	FLAT WASHER 1/4
053	P0526053	DUST PORT
055	PLABEL-29	CUTTERHEAD LABEL



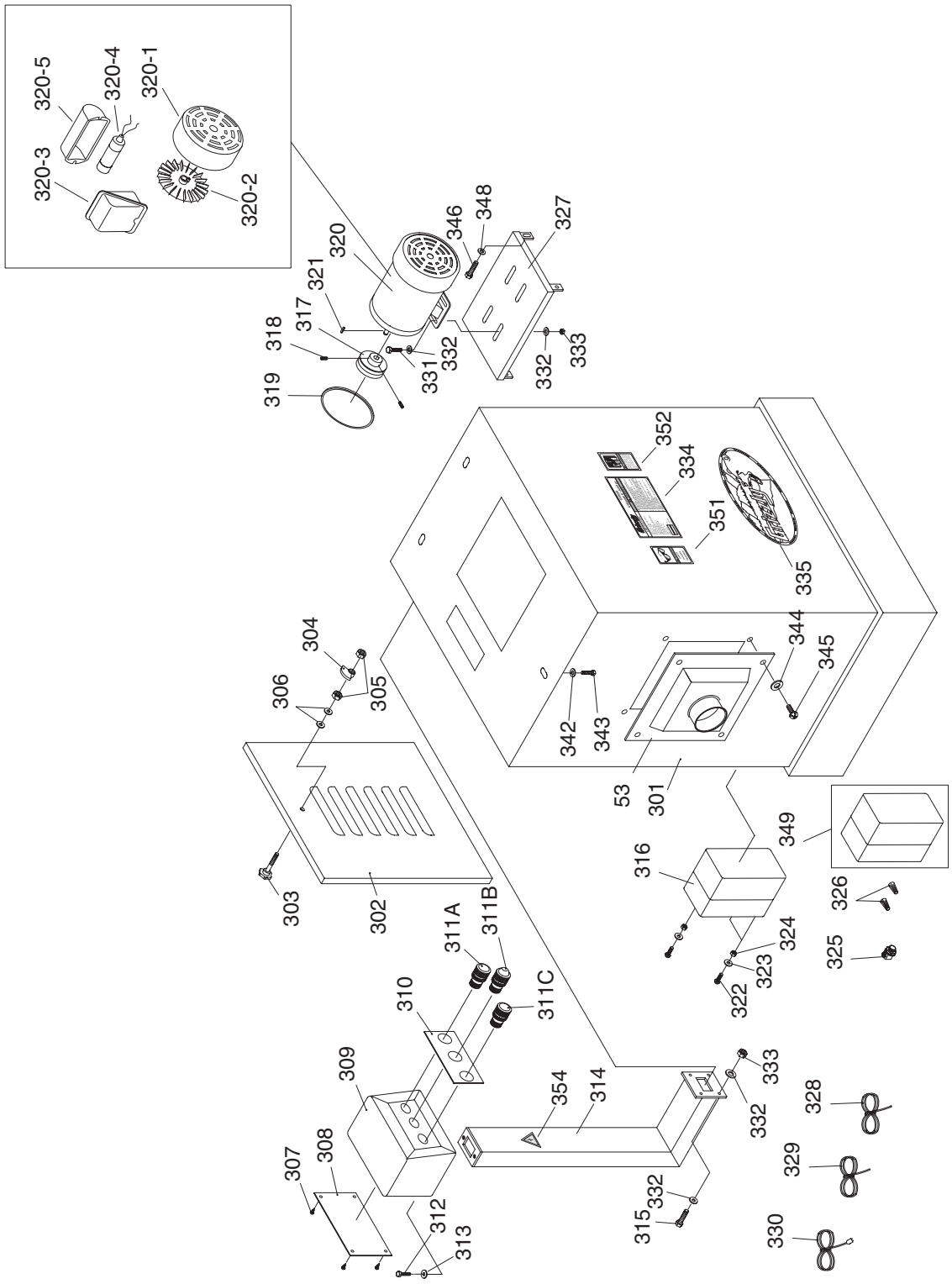
REF	PART #	DESCRIPTION
101	P0526101	FENCE
102	P0526102	PIVOT STUD
103	P0526103	FENCE HINGE
104	P0526104	STUD 3/8-16 X 1 1/2
105	PN08	HEX NUT 3/8-16
106	P0526106	TILT LEVER
107	P0526107	KNOB 3/8-16 (FEMALE)
108	PFH30	FLAT HD ALLEN SCR 1/4-20 X 1 3/4
109	P0526109	FENCE BRACKET
110	P0526110	FENCE STOP BRACKET
111	P0526111	SPECIAL HEX HD BOLT 1/4-20 X 1/2
112	PN19	HEX NUT 7/16-14
113	P0526113	FENCE ADJUSTMENT ROD
114	P0526114	FENCE TILT CLAMP
115	P0526115	90° STOP TAB
116	PRP18M	ROLL PIN 4 X 12
117	P0526117	SPECIAL HEX HD BOLT 1/4-20 X 3/8

REF	PART #	DESCRIPTION
118	P0526118	STOP TAB
119	P0526119	JAM NUT 5/8-18
120	P0526120	FENCE TILT SLEEVE
121	P0526121	FENCE BASE
122	PW01	FLAT WASHER 1/2
123	P0526123	LOCK HANDLE 1/2-12 X 1 1/4
124	P0526124	SPECIAL NUT 1/2-12
125	PB03	HEX BOLT 5/16-18 X 1
126	PN02	HEX NUT 5/16-18
127	PB22	HEX BOLT 5/16-18 X 1 3/4
128	P0526128	FENCE LOCK BRACKET
129	PS04	PHLP HD SCR 1/4-20 X 1/2
130	PW06	FLAT WASHER 1/4
131	P0526131	POST
132	PN01	HEX NUT 1/2-20
133	PW01	FLAT WASHER 1/2



REF	PART #	DESCRIPTION
201	P0526201	SPIRAL CUTTERHEAD
202	P0526202	INDEXABLE CUTTER
205	PFH35M	FLAT HD TRX T-20 M6-1.0 X 15
206	PN11	HEX NUT 3/8-24
207	PLW06M	LOCK WASHER 10MM
208	P0526208	STUD
209	P0526209	BALL BEARING BLOCK
210	P6202	BALL BEARING 6202

REF	PART #	DESCRIPTION
211	PK15	KEY 3/16 X 3/16 X 1 1/4
212	P6203	BALL BEARING 6203
213	P0526213	BALL BEARING BLOCK
214	P0526214	PULLEY
215	PSS03	SETSCREW 1/4-20 X 3/8
217	P0526217	TORX T-HANDLE DRIVER 6MM
222	P9740Z1722	T-20 TORX BIT



REF	PART #	DESCRIPTION
301	P0526301	CABINET STAND
302	P0526302	CABINET DOOR
303	P0526303	KNOB ⅜-16
304	P0526304	LATCH
305	PN08	HEX NUT ⅜-16
306	PW02	FLAT WASHER ⅜
307	PHTEK27	TAP SCREW #8 X ½
308	P0526308	BACK SWITCH PLATE
309	P0526309	SWITCH BOX
310	P0526310	PEDESTAL
311A	P0526311A	“OFF” SWITCH ASSEMBLY
311B	P0526311B	LIGHT INDICATOR
311C	P0526311C	“ON” SWITCH ASSEMBLY
312	PB02	HEX BOLT ¼-20 X ⅝
313	PW06	FLAT WASHER ¼
314	P0526314	PEDESTAL MOUNT
315	PB03	HEX BOLT 5⁄16-18 X 1
316	P0526316	MA-15 MAG SWITCH (110V)
317	P0526317	MOTOR PULLEY
318	PSS03	SETSCREW ¼-20 X ⅜
319	PVA54	V-BELT A-54 4L540
320	P0526320	MOTOR 1½ HP
320-1	P0526320-1	FAN COVER
320-2	P0526320-2	FAN
320-3	P0526320-3	WIRING COVER
320-4	PC300B	START CAP. 300MF 125V
320-5	P0526320-5	CAPACITOR COVER
321	PK04	KEY 3⁄16 X 3⁄16 X 1¾"

REF	PART #	DESCRIPTION
322	PS01	PHLP HD SCR 10-24 X ½
323	PW03	FLAT WASHER #10
324	PN07	HEX NUT 10-24
325	P0526325	STRAIN RELIEF
327	P0526327	MOTOR BRACKET
328	P0526110S	POWER CORD 110V, SHORT
329	P0526110L	PWR CRD 110V, LONG
330	P0526330	CONTROL CORD
331	PB07	HEX BOLT 5⁄16-18 X ¾
332	PW07	FLAT WASHER 5⁄16
333	PN02	HEX NUT 5⁄16-18
334	P0526334	ID/WARNING LABEL
335	G8588	GRIZZLY LOGO PLATE
338	PWR810	8 X 10 WRENCH
339	PWR1214	12 X 14 WRENCH
340	PAW03M	ALLEN WRENCH 3MM
341	P0526341	PUSH PADDLE
342	PLW04	LOCK WASHER ⅜
343	PB21	HEX BOLT ⅜-16 X ¾
344	PW06	FLAT WASHER ¼
345	PS04	PHLP HD SCR ¼-20 X ½
346	PB65	HEX BOLT ⅜-16 X ⅝
348	PW02	FLAT WASHER ⅜
349	P0526349	MA-9 MAG SWITCH (220V)
351	PLABEL-11	SAFETY GLASSES LABEL
352	PLABEL-12	READ MANUAL LABEL
354	PLABEL-14	ELECTRICITY LABEL

Troubleshooting Guide

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.	1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2 Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows when operating.	1. Applying too much pressure to workpiece. 2. V-belts loose.	1. Feed workpiece slower. 2. Adjust V-belts.
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 defective.	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Tighten fan or shim cover. 3. Replace V-belts.
Snipe (gouge in the end of the board that is uneven with the rest of the cut).	1. Outfeed table is set too low.	1. Align outfeed table with cutterhead knife at top dead center.
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.
Chipping.	1. Knots or conflicting grain direction in wood. 2. Nicked or chipped carbide cutters. 3. Feeding too fast. 4. Taking too deep of a cut.	1. Inspect stock for knots and grain. 2. Inspect and replace or rotate the carbide cutters. 3. Slow down the rate that you feed the wood into the cutterhead. 4. Raise the infeed table to take a smaller depth of cut. Never exceed ⅛" per pass when edge jointing or 1/32" when surface planing. Reduce cutting depth for harder woods.
Fuzzy grain.	1. Wood may have high moisture content or surface wetness. 2. Nicked or chipped carbide cutters.	1. Check moisture content and allow to dry if moisture is too high. 2. Inspect and replace or rotate the carbide cutters.

Troubleshooting Guide

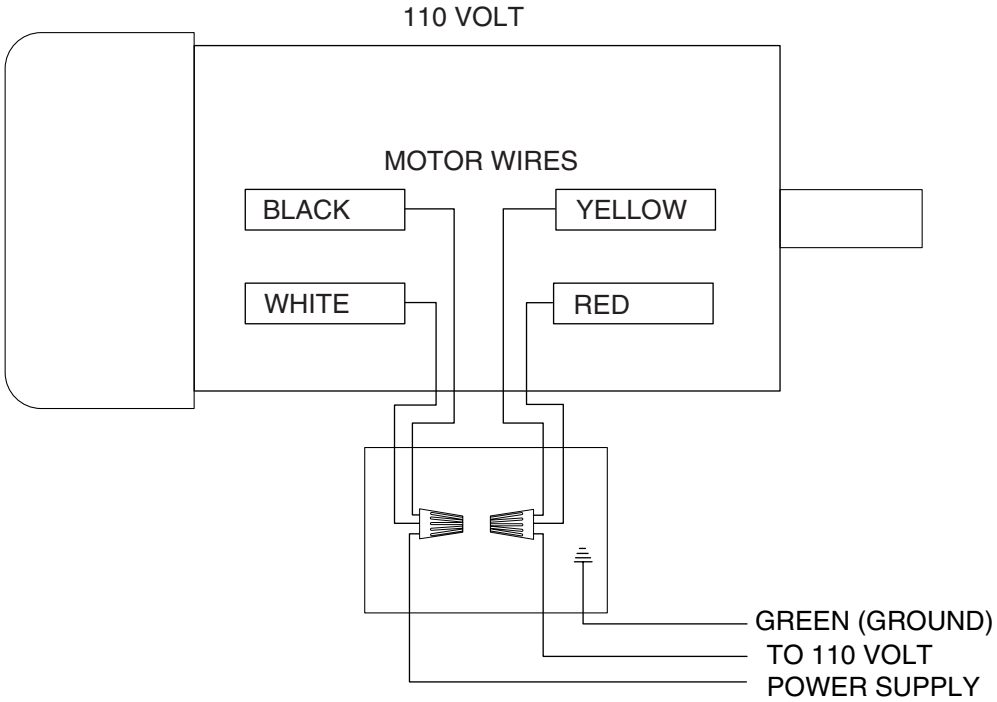
SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Lines or ridges on board.	1. Nicked or chipped carbide cutters.	1. Inspect and replace or rotate the carbide cutters.
Uneven cutter marks on board.	1. Nicked or chipped carbide cutters.	1. Inspect and replace or rotate the carbide cutters.
Wavy surface or chatter marks on board.	1. Board being fed too fast.	1. Slow down the feed rate and feed consistently. DO NOT stop or hesitate during feeding.
Board edge is concave or convex after jointing.	1. Board not held with even pressure on infeed and outfeed table. 2. Board was too uneven start. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.	1. Hold board with even pressure as it moves through 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. Nicked or chipped carbide cutters.	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. Inspect and replace or rotate the carbide cutters.
Tables are hard to adjust.	1. Table lock is partially engaged. 2. Table gibs are too tight.	1. Completely loosen the table lock. 2. Re-adjust the table gibs.
Excessive play in table movement.	1. Table gibs are too loose.	1. Re-adjust the table gibs.

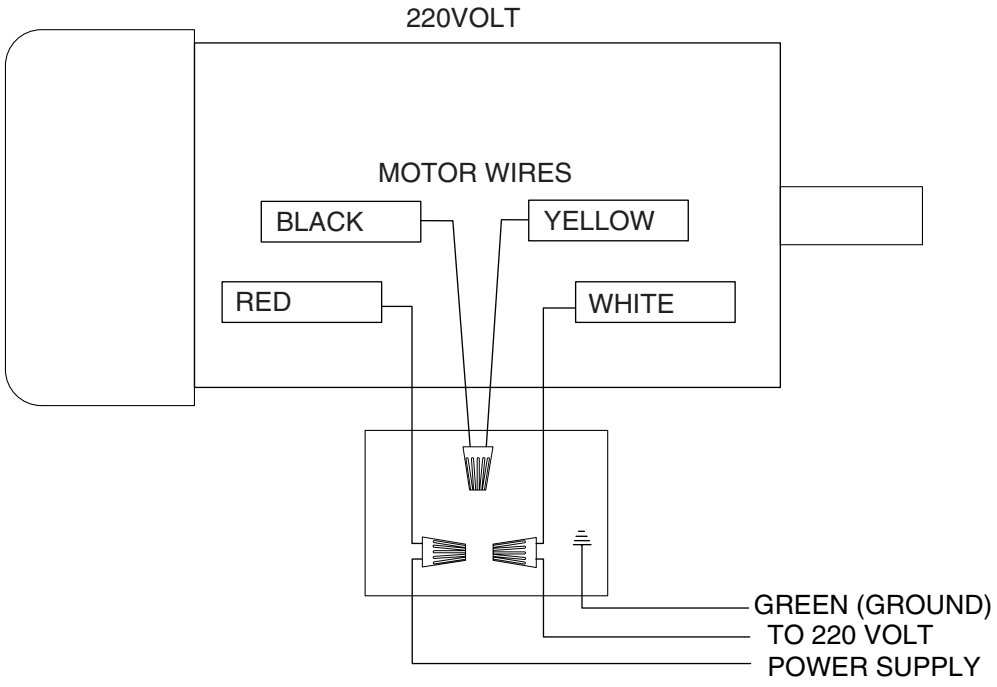
G0526 Wiring Diagram

⚠DANGER

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard, leading to injury or death.

NOTE: THE WIRES FROM THE POWER SUPPLY, EXCEPT THE GREEN GROUND WIRE, ARE INTERCHANGABLE, THEREFORE COLORS ARE NOT SPECIFIED.





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.

WARRANTY CARD

Name _____

Street _____

City _____State_____Zip_____

Phone Number_____E-Mail_____FAX_____

MODEL #_____**Serial #** _____ Order #_____

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
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other_____

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

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other_____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Bandsaw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___jointer
___Vacuum Veneer Press
___Wide Belt Sander

___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" jointer
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander

___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other_____

13. What machines/supplies would you like Grizzly Industrial to carry?

_____

_____

14. What new accessories would you like Grizzly Industrial to carry?

_____

_____

15. What other companies do you purchase your tools and supplies from?

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes ___No

19. 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