READ THIS FIRST

Model G0604Z

******IMPORTANT UPDATE******

For Machines Mfd. Since 12/24
and Owner's Manual Printed 02/24

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

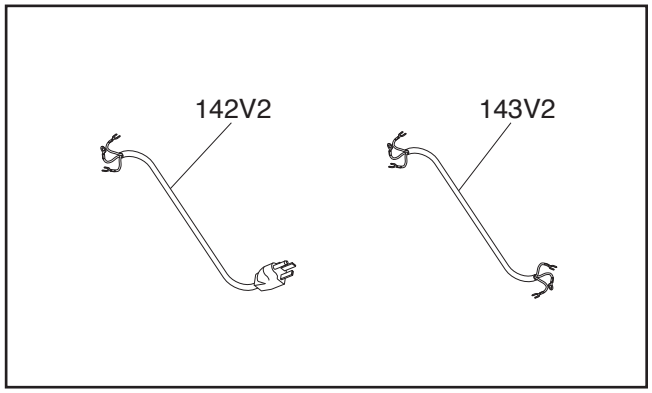
The following changes were recently made since the owner's manual was printed:

- Parts have changed.
- Specifications have changed.

Aside from this information, all other content in the owner's manual applies and MUST be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Parts



REF	PART #	DESCRIPTION
142V2	P0604Z142V2	POWER CORD 12G 3W 98" 5-20P V2.12.24
143V2	P0604Z143V2	MOTOR CORD 12G 3W 31" V2.12.24

Revised Specifications

Electrical:

Power Cord Gauge .....12 AWG

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#KS23496 PRINTED IN CHINA

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Model G0604Z

IMPORTANT UPDATE

For Machines Mfd. Since 02/24
and Owner's Manual Printed 02/24

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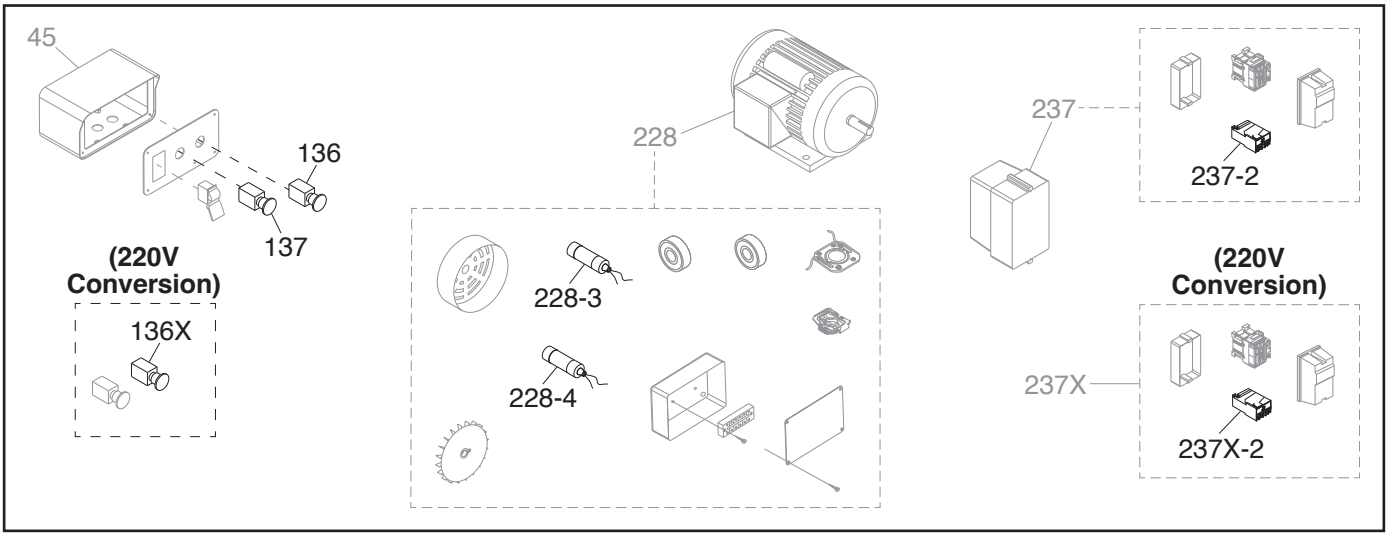
The following changes were recently made since the owner's manual was printed:

- Parts have been revised.
- **Converting Voltage to 220V** has been updated.
- **Wiring Diagram 110V** and **Wiring Diagram 220V** have been revised.

Aside from this information, all other content in the owner's manual applies and MUST be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Parts



REF	PART #	DESCRIPTION
136	P0604Z136	STOP BUTTON NHD NLB22-F11RE AC110V RED
136X	P0604Z136X	STOP BUTTON NHD NLB22-F11RI AC220V RED
137	P0604Z137	START BUTTON NHD NLB22-F10GE AC110V GRN
228-3	P0604Z228-3	S CAPACITOR 200M 300V 2 X 3-1/2

REF	PART #	DESCRIPTION
228-4	P0604Z228-4	R CAPACITOR 40M 450V 1-3/4 X 3-5/8
237-2	P0604Z237-2	OL RELAY NHD NTH-32 17-21A
237X-2	P0604Z237X-2	OL RELAY NHD NTH-32 8-11A

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Converting Voltage to 220V



⚠WARNING

Electrocution, shock, fire, or damage may occur if machine is ungrounded, incorrectly connected to power, or NOT connected to a proper power supply. Only an electrician or qualified service personnel should connect this machine to power. Damage from an improper connection or power supply will NOT be covered under warranty!

The voltage conversion MUST be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of replacing the START and STOP buttons, replacing the power cord, replacing the magnetic switch assembly, and rewiring the motor. Wiring diagrams are provided on **Pages 4–5** of this update.

IMPORTANT: *If the diagram included on the motor conflicts with those on **Pages 4–5**, the motor may have changed since this update was printed. Use the diagram included on the motor instead.*

Items Needed	**Qty**
Electrical Tape	As Needed
Phillips Head Screwdriver #2	1
Wire Cutters/Stripper	1
START Button 220V (P0604Z137X)	1
STOP Button 220V (P0604Z136X)	1
Mag Switch Assembly 220V (P0604Z237X)	1
Power Cord 220V w/6-15P (P0604Z142X)	1

To convert machine to 220V:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen strain relief on rear of control panel (see **Figure 1**).

3. Open control panel and replace pre-installed 110V START and STOP buttons with 220V buttons (see **Figure 1**).

Note: *Write terminal numbers on masking tape and attach to each wire for easier installation later on.*

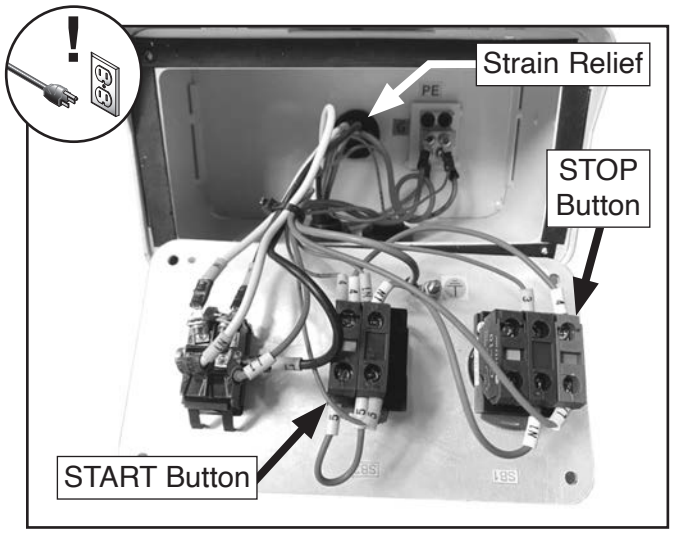


Figure 1. Location of START and STOP buttons in control panel.

4. Remove 110V power cord w/5-15 plug and replace with 220V power cord w/6-15 plug (P0604Z142X).

5. Tighten strain relief, close and secure control panel, then remove rear panel on machine.

6. Loosen (2) Phillips head screws on magnetic switch cover (see **Figure 2**), then remove cover.

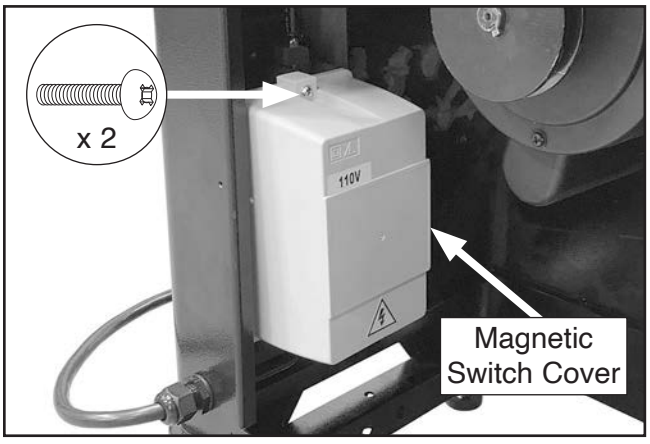


Figure 2. Example of mag switch cover fasteners.

7. Loosen strain reliefs on top and bottom of magnetic switch assembly, then disconnect and remove control panel wiring, motor cord wiring, and power connection wiring (see **Figure 3**).

   Note: *Write terminal numbers on masking tape and attach to each wire for easier installation later on.*

8. Remove (2) Phillips head screws, then remove magnetic switch assembly (see **Figure 3**).

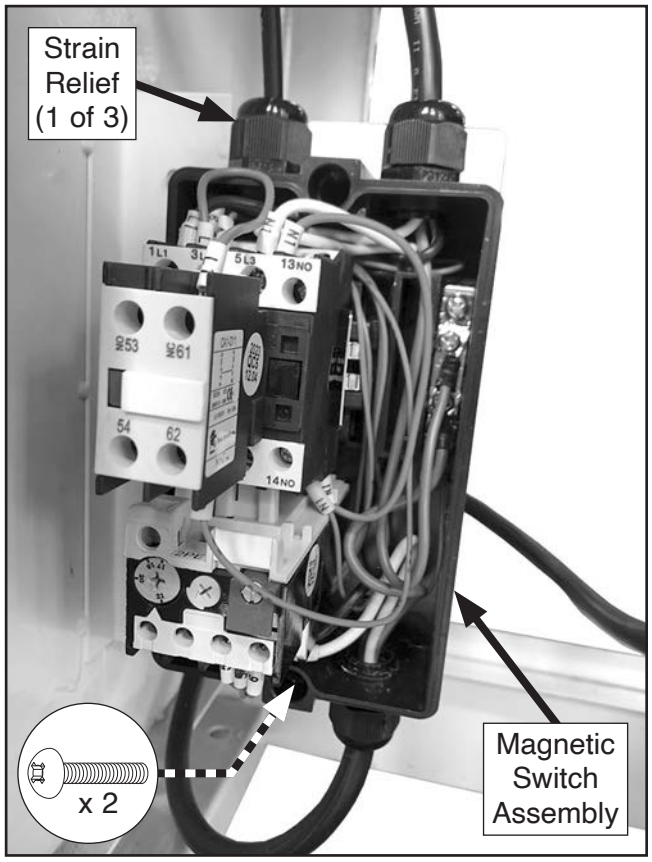


Figure 3. Magnetic switch assembly.

9. Remove cover from 220V magnetic switch assembly (P0604Z237X).

10. Install 220V magnetic switch assembly using (2) Phillips head screws removed in **Step 8** and secure.

11. Connect control panel wiring and motor cord wiring as shown in **Wiring Diagram 220V** on **Page 5**.

12. Open motor junction box and disconnect wires from terminal block (see **Figure 4**).

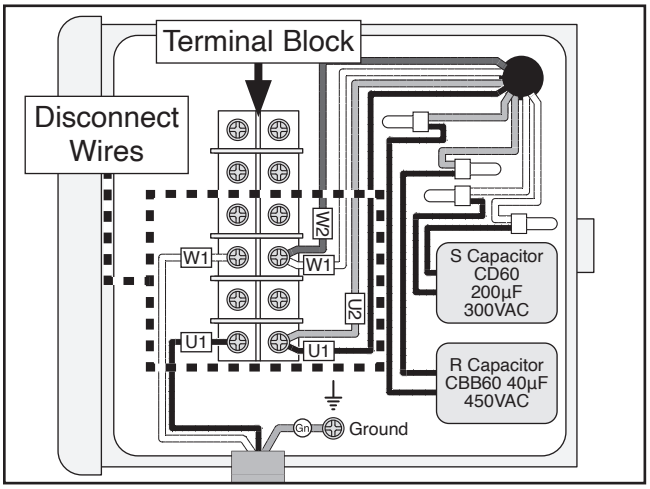


Figure 4. Inside motor junction box (motor prewired to 110V).

13. Connect wires as shown in **Figure 5**, then secure terminals.

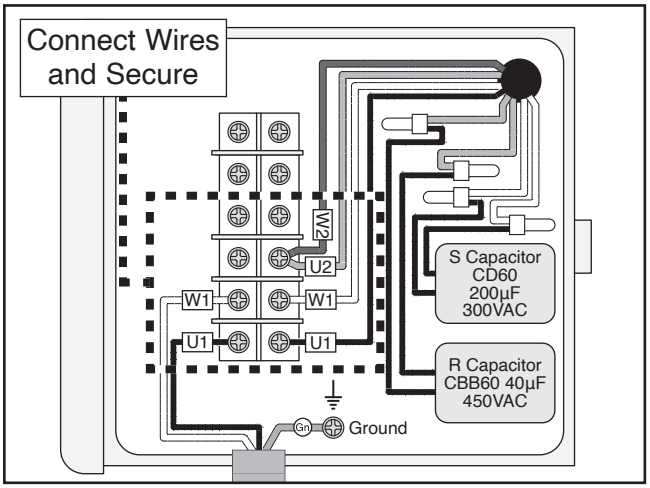


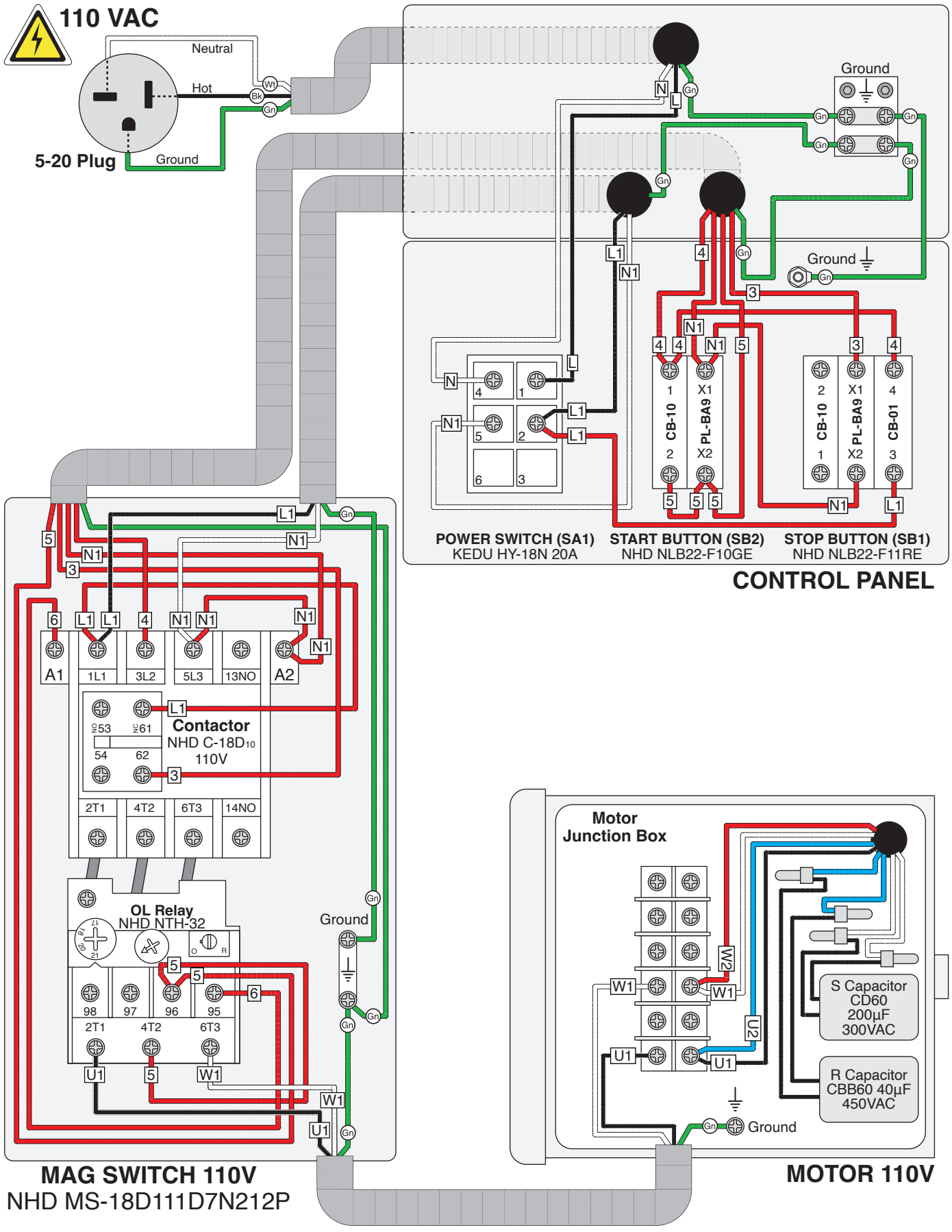
Figure 5. Motor rewired to 220V.

14. Install motor junction box cover and magnetic switch assembly cover, then secure.

15. Install rear panel and secure.

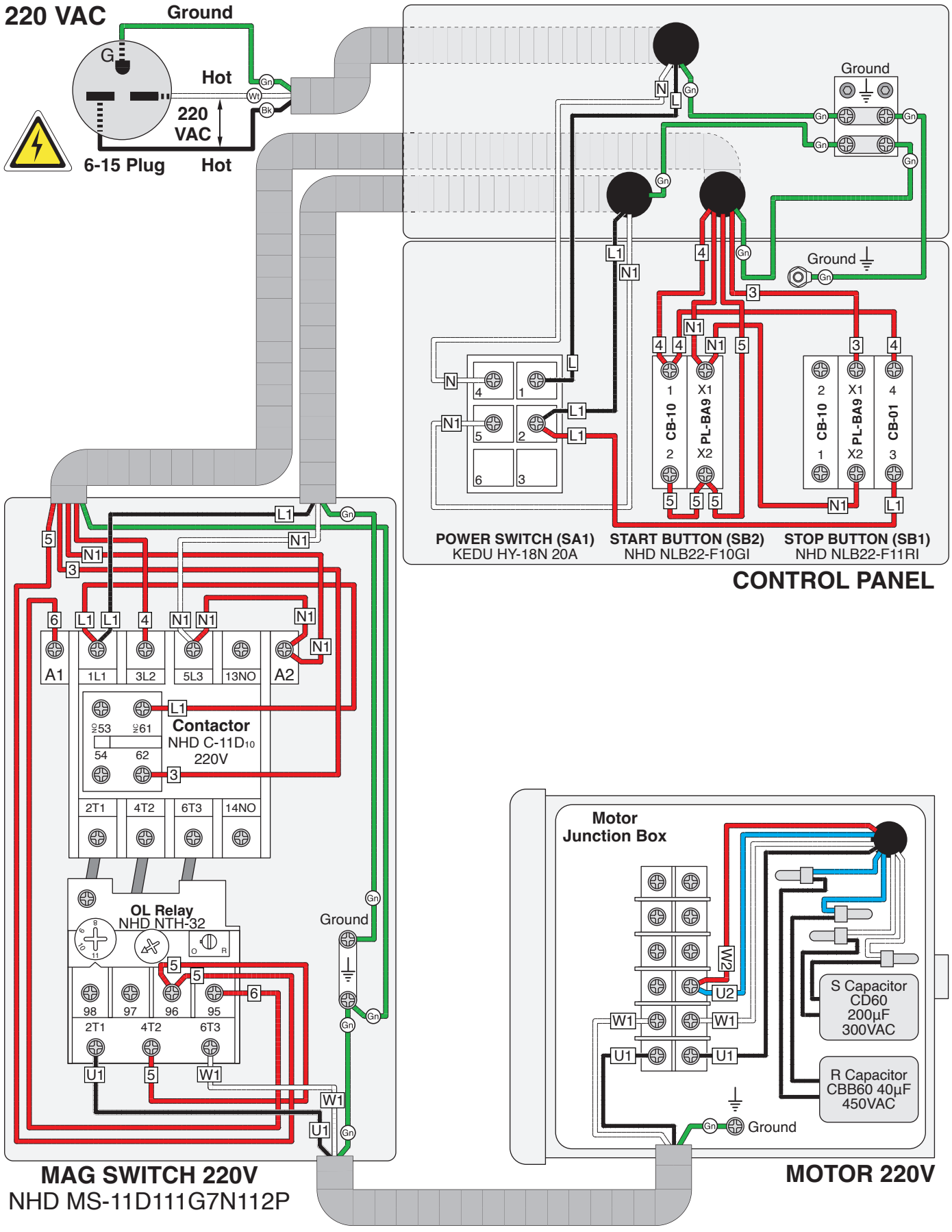
16. Perform **Test Run** on **Page 23** of owner's manual.

Wiring Diagram 110V



STOP ***READ ELECTRICAL SAFETY ON PAGE 51 OF MANUAL!***

Wiring Diagram 220V



STOP *READ ELECTRICAL SAFETY ON PAGE 51 OF MANUAL!*

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MODEL G0604Z
6" JOINTER w/SPIRAL CUTTERHEAD
OWNER'S MANUAL
(For models manufactured since 02/24)



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******Keep for Future Reference******

⚠ 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

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
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

⚠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.

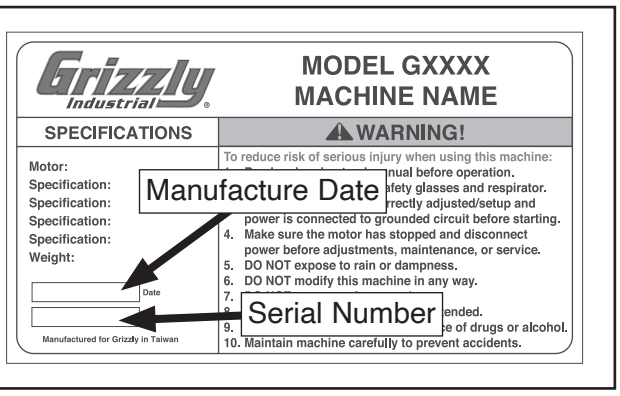
Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual**.

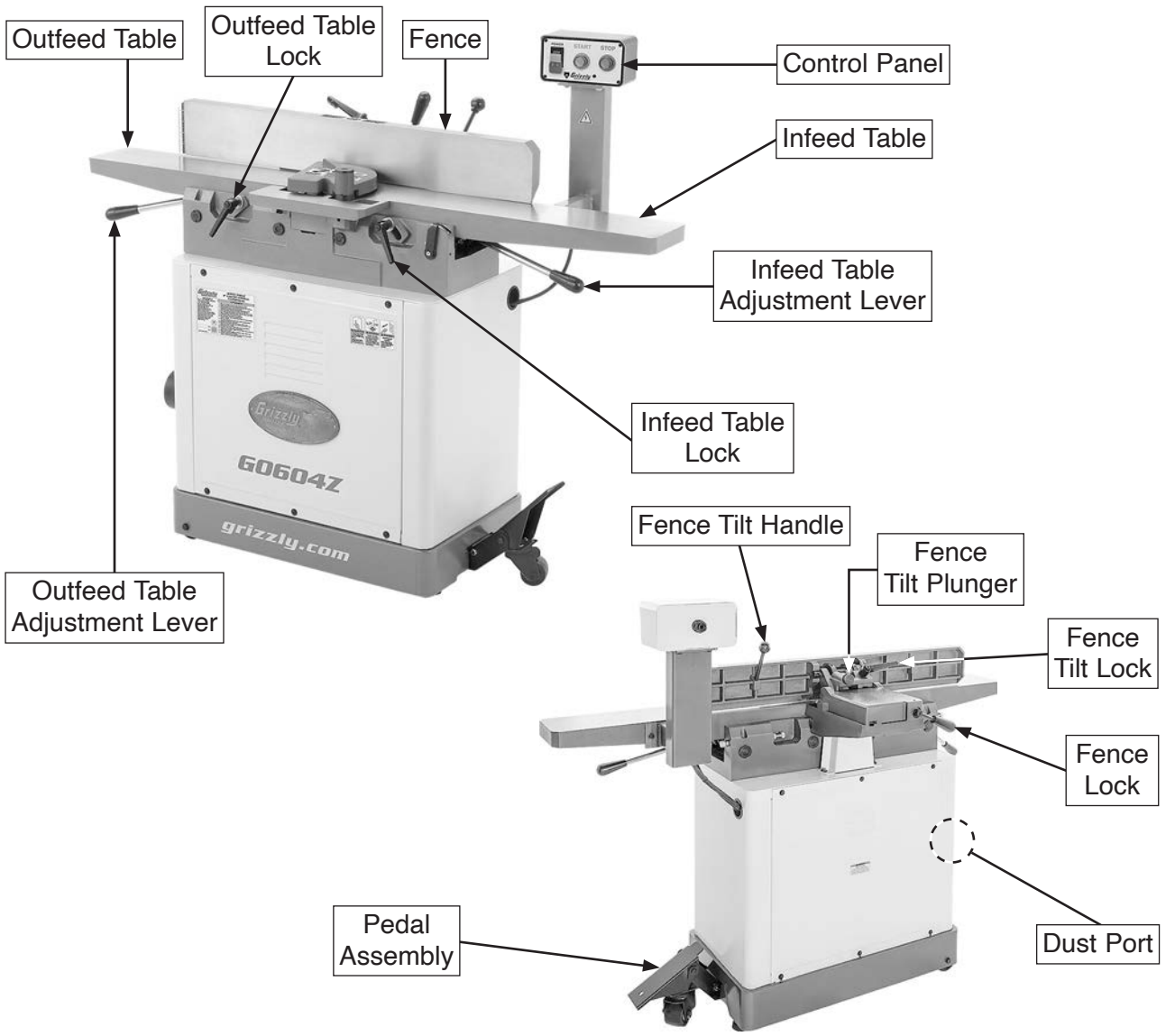
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.

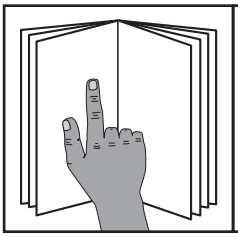


⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

a) Wear eye protection.
b) Always keep cutterhead and drive guards in place and in proper operating condition. ALWAYS replace cutterhead guard after rabbeting operations.
c) Never make jointing or rabbeting cuts deeper than ⅛" or planing cuts deeper than 1/16".
d) Always use hold-down or push blocks when jointing material narrower than 3" or surface planing material thinner than 3".
e) Never perform jointing, planing, or rabbeting cuts on pieces shorter than 8" in length.

Controls & Components



⚠WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

Refer to **Figures 1–4** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

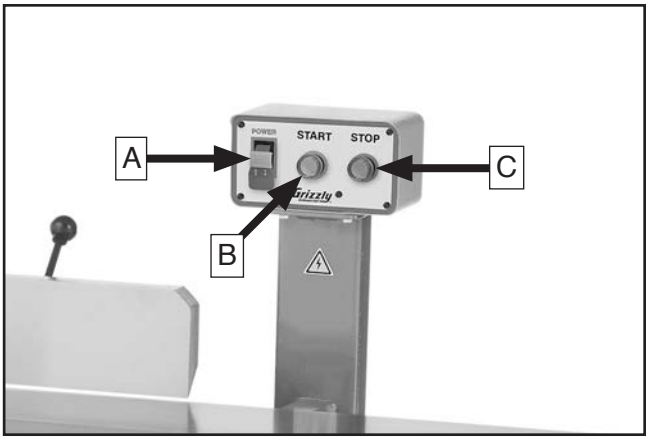


Figure 1. Power controls.

A. POWER Switch w/Disabling Key: Turns power to machine ***ON*** or ***OFF***. Remove orange key to disable switch.

B. START Button: Turns motor ***ON***.

C. STOP Button: Turns motor ***OFF***.

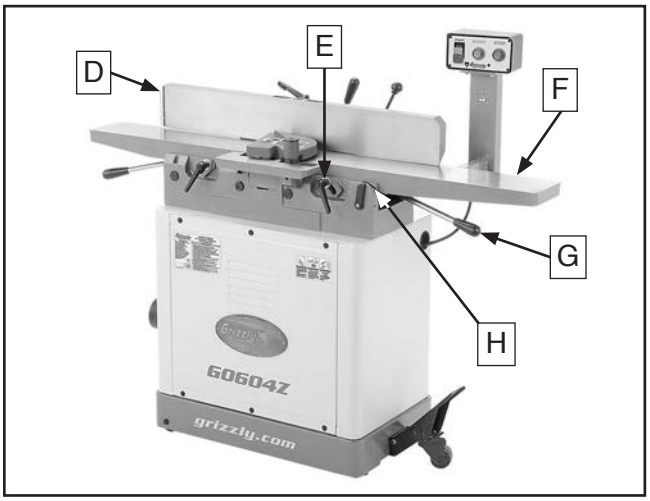


Figure 2. Fence, infeed table controls, and depth-of-cut scale.

D. Fence: Guides workpiece as it moves across cutterhead and determines angle of cut.

E. Infeed Table Lock: Loosens to allow adjustment of infeed table height; tightens to secure infeed table.

F. Infeed Table: Supports workpiece before it reaches cutterhead. Position of infeed table relative to cutterhead determines depth of cut.

G. Infeed Table Adjustment Lever: Adjusts height of infeed table (when infeed table lock is loosened).

H. Depth-of-Cut Scale: Indicates cutting depth of a single pass.

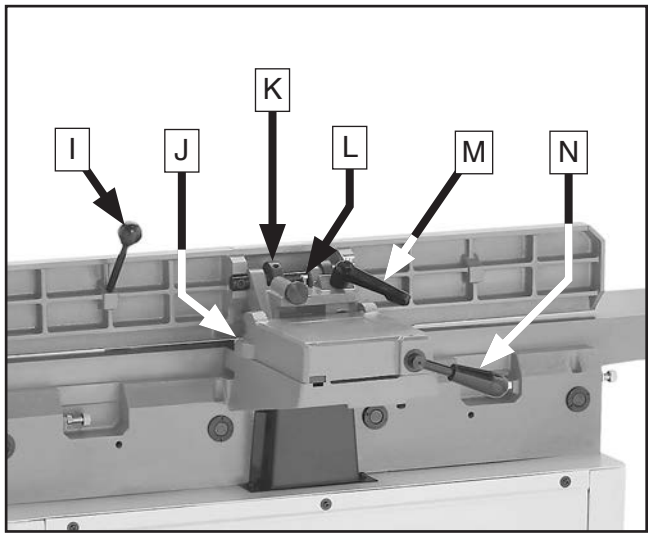


Figure 3. Fence controls.

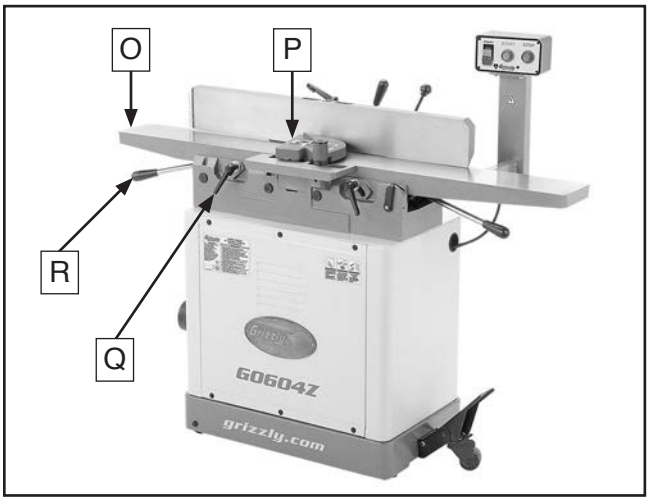


Figure 4. Cutterhead guard and outfeed table controls.

I. Fence Tilt Handle: Tilts fence throughout its range of motion from 45°–135° (45° outward).

J. 45° Fence Stop: Stops fence at 45°.

K. 90° Fence Stop: When engaged, stops fence at 90°.

L. 135° Fence Stop: Stops fence at 135° (45° outward).

M. Fence Tilt Lock: Secures fence tilt setting at desired angle.

Note: *Even when fence is resting against fence stops, tilt lock must be tightened before starting machine.*

N. Fence Lock: Loosens to allow adjustment of fence position along width of tables; tightens to secure fence.

O. Outfeed Table: Supports workpiece after it passes over cutterhead. For safety and best results, outfeed table must be properly adjusted relative to cutterhead inserts before ANY operations (see **Page 48** for additional details).

P. Cutterhead Guard: Covers cutterhead until pushed out of the way by workpiece during operation. When workpiece leaves cutterhead, guard springs back to its starting position.

Q. Outfeed Table Lock: Loosens to allow adjustment of outfeed table height; tightens to secure outfeed table.

R. Outfeed Table Adjustment Lever: Adjusts height of outfeed table. Typically only used when setting outfeed table even with cutterhead inserts or when servicing cutterhead.

MACHINE DATA SHEET

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

MODEL G0604Z 6" JOINTER WITH SPIRAL CUTTERHEAD

Product Dimensions:

Weight..... 397 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 56 x 23-1/2 x 47 in.
Footprint (Length x Width)..... 27 x 20-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
Content..... Machine
Weight..... 308 lbs.
Length x Width x Height..... 67 x 22 x 13 in.
Must Ship Upright..... Yes

Carton #2

Type..... Wood Crate
Content..... Stand
Weight..... 165 lbs.
Length x Width x Height..... 31 x 18 x 31 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 17A at 110V, 7.6A at 220V
Minimum Circuit Size..... 20A at 110V, 15A at 220V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 90 in.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-20 for 110V
Recommended Plug Type..... 6-15 for 220V
Switch Type..... Control Panel w/Magnetic Switch Protection

Motors:

Main

Horsepower..... 1.7 HP
Phase..... Single-Phase
Amps..... 17A/7.6A
Speed..... 3400 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer ..... Belt
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications

Jointer Size	6 in.
Bevel Jointing	0 - 45 deg. L/R
Maximum Width of Cut	6 in.
Maximum Depth of Cut	1/8 in.
Minimum Workpiece Length	8 in.
Minimum Workpiece Thickness	1/2 in.
Maximum Rabbeting Depth	1/2 in.
Number of Cuts Per Minute	22668

Fence Information

Fence Length	36 in.
Fence Width	1-1/4 in.
Fence Height	5 in.
Fence Stops	45, 90, 135 deg.

Cutterhead Information

Cutterhead Type	Spiral
Cutterhead Diameter	3 in.
Number of Cutter Rows	4
Number of Indexable Cutters	30
Cutterhead Speed	5667 RPM

Cutter Insert Information

Cutter Insert Type	Indexable Carbide
Cutter Insert Length	14mm
Cutter Insert Width	14mm
Cutter Insert Thickness	2mm

Table Information

Table Length	55-1/2 in.
Table Width	6 in.
Table Thickness	1-1/2 in.
Floor to Table Height	32-1/2 in.
Table Adjustment Type	Lever Action
Table Movement Type	Parallelogram

Construction

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

Other Information

Number of Dust Ports	1
Dust Port Size	4 in.
Mobile Base	Built-In

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	2 Hours
Serial Number Location	ID Label
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

SECTION 1: SAFETY

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. Always use common sense and good judgment.

⚠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 **Alerts the user to useful information about proper operation of the machine to avoid machine damage.**

Safety Instructions for Machinery

⚠WARNING

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

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.

⚠WARNING

WEARING PROPER APPAREL. Do not wear loose clothing, gloves, neckties, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

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.

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

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

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

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

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

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

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine ***OFF*** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

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 experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

Additional Safety for Jointers

⚠WARNING

Serious cuts, amputation, entanglement, or death can occur from contact with rotating cutterhead or other moving components! Flying chips from cutting operations can cause eye injuries or blindness. Workpieces or inserts/knives thrown by cutterhead (kickback) can strike nearby operator or bystanders with deadly force. To reduce the risk of serious personal injury from these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

KICKBACK. Occurs when workpiece is ejected from machine at a high rate of speed. Kickback injuries occur from getting struck by workpiece or hands being pulled into cutterhead. To reduce the risk of kickback, only use proper workpieces, safe feeding techniques, and proper machine setup or maintenance.

GUARD REMOVAL. Operating jointer without guards unnecessarily exposes operator to knives/inserts and other hazardous moving parts. Except when rabbeting, never operate jointer or allow it to be connected to power if any guards are removed. Turn jointer ***OFF*** and disconnect power before clearing any shavings or sawdust from around cutterhead. After rabbeting or maintenance is complete, immediately replace all guards and ensure they are properly installed/adjusted before resuming regular operations.

DULL OR DAMAGED KNIVES/INSERTS. Dull or damaged knives/inserts increase risk of kickback and cause poor workpiece finish. Only use sharp, undamaged knives/inserts.

OUTFEED TABLE ALIGNMENT. Setting outfeed table too high can cause workpiece to hit table or get stuck while feeding. Setting outfeed table too low may cause workpiece to rock or shift while feeding. Both of these results will increase risk of kickback. Always keep outfeed table even with knives/inserts at highest point during rotation.

INSPECTING STOCK. Impact injuries or kickback may result from using improper workpieces. Thoroughly inspect and prepare workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or other foreign material. Always joint warped workpieces with cupped side facing down.

MAXIMUM CUTTING DEPTH. To reduce risk of kickback, never cut deeper than ⅛" per pass.

GRAIN DIRECTION. Jointing against the grain or end grain can increase risk of kickback. It also requires more cutting force, which produces chatter or excessive chip out. Always joint or surface plane WITH the grain.

CUTTING LIMITATIONS. Cutting workpieces that do not meet minimum dimension requirements can result in kickback or accidental contact with cutterhead. Never perform jointing, planing, or rabbeting cuts on pieces smaller than specified in machine data sheet.

PUSH BLOCKS. Push blocks reduce risk of accidental cutterhead contact with hands. Always use push blocks when planing materials less than 3" high or wide. Never pass your hands directly over cutterhead without a push block.

WORKPIECE SUPPORT. Poor workpiece support or loss of workpiece control while feeding will increase risk of kickback or accidental contact with cutterhead. Support workpiece with fence continuously during operation. Support long stock with auxiliary tables if necessary.

FEED WORKPIECE PROPERLY. Kickback or accidental cutterhead contact may result if workpiece is fed into cutterhead the wrong way. Allow cutterhead to reach full speed before feeding. Never start jointer with workpiece touching cutterhead. Always feed workpiece from infeed side to outfeed side without stopping until cut is complete. Never move workpiece backwards while feeding.

SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can be thrown from cutterhead with dangerous force. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than ⅛" (0.125") from cutterhead body.

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 an electrician or qualified service personnel in accordance with all applicable codes and standards.



⚠WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

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 ..... 17 Amps
Full-Load Current Rating at 220V .... 7.6 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 specified circuit requirements.

Circuit Information

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 an electrician if you are unsure about wiring practices or electrical codes in your area.

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

Circuit Requirements for 110V

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

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 5-20

Circuit Requirements for 220V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 208V, 220V, 230V, 240V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 15 Amps
Plug/Receptacle ..... NEMA 6-15

Grounding 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.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). 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.

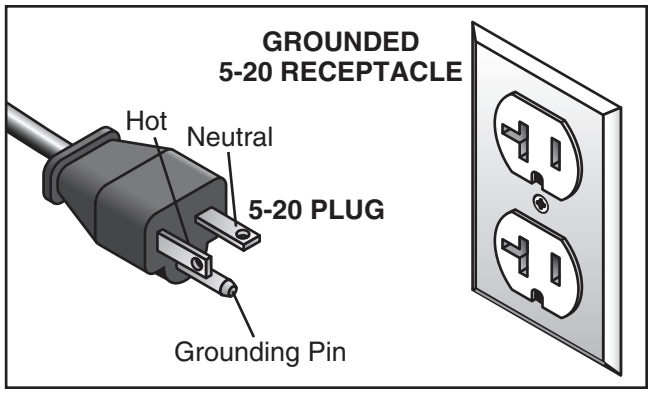
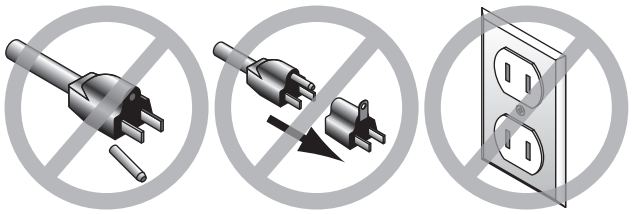


Figure 5. Typical 5-20 plug and receptacle.

⚠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.

For 220V operation: The plug specified under "Circuit Requirements for 220V" on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

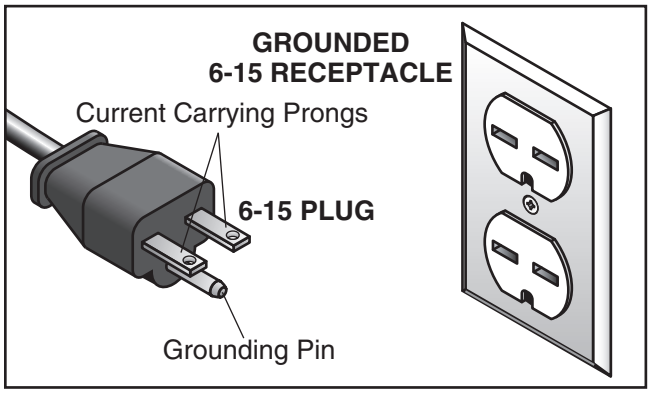


Figure 6. Typical 6-15 plug and receptacle.

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 can 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 be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size.....12 AWG
Maximum Length (Shorter is Better).....25 ft.

Converting Voltage to 220V

NOTICE

Voltage conversion MUST be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the motor and installing the correct plug. Wiring diagrams are provided for your reference on **Pages 52–53**.

IMPORTANT: *If the diagram included on the motor conflicts with the wiring diagrams in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor junction box instead.*

Item(s) Needed	Qty
Phillips Head Screwdriver #2	1
6-15 Plug	1
Wire Cutters/Stripper	1

To convert voltage to 220V:

1. DISCONNECT MACHINE FROM POWER!

2. Cut off existing 5-20 plug.

3. Open motor junction box and disconnect wires from terminal block (see **Figure 7**).

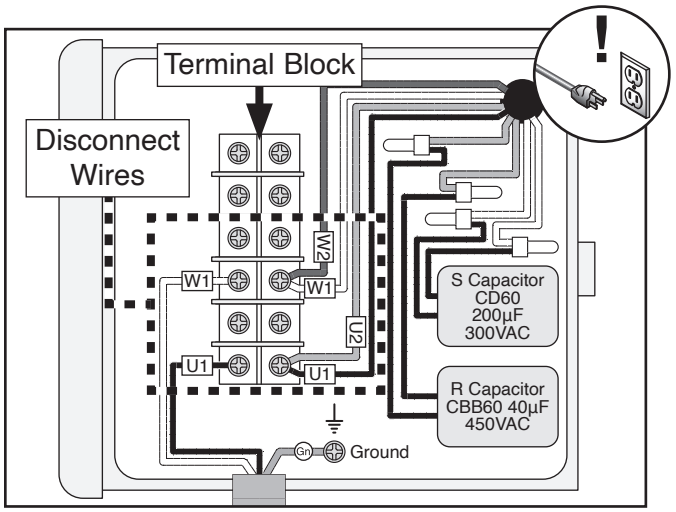


Figure 7. Inside motor junction box (motor pre-wired to 110V).

4. Connect wires as shown in **Figure 8**, then secure terminals.

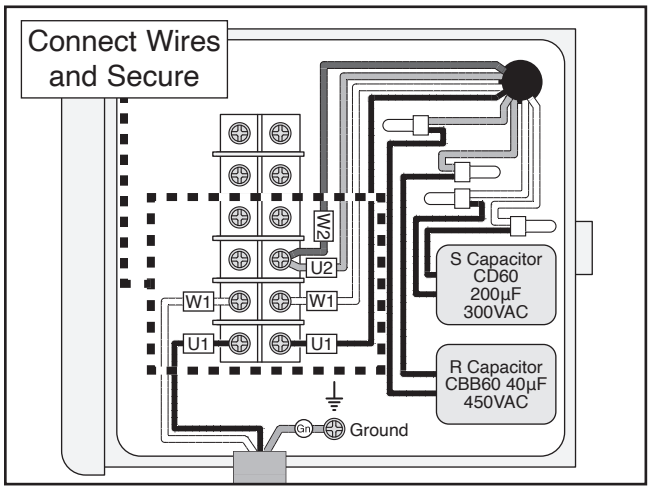


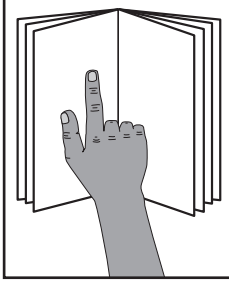
Figure 8. Motor rewired to 220V.

5. Close and secure motor junction box.

6. Install a 6-15 plug according to manufacturer's instructions. If plug manufacturer's instructions are not available, NEMA standard 6-15 plug wiring is provided in the **Wiring Diagram 220V** on **Page 53**.

   IMPORTANT: Additional components are required for 220V conversion. See **SECTION 9: PARTS** beginning on **Page 55** for a complete list of electrical components.

SECTION 3: SETUP



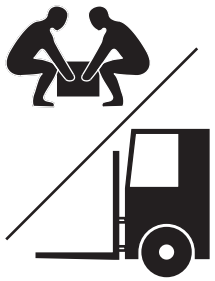
⚠WARNING

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

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Additional Person	1
• Safety Glasses (for each person)	1
• Forklift or Hoist w/Lifting Straps (rated for at least 400 lbs.)	1
• Phillips Head Screwdriver #2	1
• Flat Head Screwdriver ¼"	1
• Straightedge (12" Minimum Length)	1
• Prybar	1
• Power Drill w/Phillips Bit #2	1
• Dust Collection System	1
• Dust Hose 4"	1
• Hose Clamps 4"	2
• Cleaner/Degreaser (**Page 16**)	As Needed
• Disposable Shop Rags	As Needed
• Disposable Gloves	As Needed

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. *You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.*

Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and 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.

Inventory (Figures 9–10) **Qty**

A. Table 1
B. Fence Carriage 1
C. Fence 1
D. Cutterhead Guard 1
E. Fence Tilt Handle 1
F. Loose Tools:
—Wrench 8/10mm 1
—Wrench 12/14mm 1
—Hex Wrenches 2.5, 4, 5, 6, 8mm ..... 1 Ea.
G. Push Blocks 2
H. Cabinet w/Motor 1
I. Control Panel Pedestal (Inside Cabinet) 1
J. Pedal Assembly 1
K. Belt Guard 1
L. V-Belt A1120LI 1
M. Dust Port 1

Hardware Bag (Not Shown)

- Hex Bolt M8-1.25 x 50 (Pedal/Cabinet) 1
- Flat Washer 8mm (Pedal/Cabinet) 1
- Hex Bolts M10-1.5 x 55 (Pedal/Cabinet) 2
- Flat Washers 10mm (Pedal/Cabinet) 2
- Hex Nuts M10-1.5 (Wheel/Cabinet) 2
- Cap Screws M8-1.25 x 25 (Table/Cabinet) . 4
- Lock Washers 8mm (Table/Cabinet) 4
- Flat Washers 8mm (Table/Cabinet) 4
- Flange Bolts M6-1 x 12 (Belt Guard) 2
- Flat Washers 6mm (Belt Guard) 2
- Hex Nuts M6-1 (Belt Guard) 2
- Driver Bits Torx T20 2
- L-Wrenches Torx T20 2
- Flat Hd Torx Screws T20 M6-1 x 15 3
- Indexable Carbide Inserts 14 x 14 x 2mm .. 3

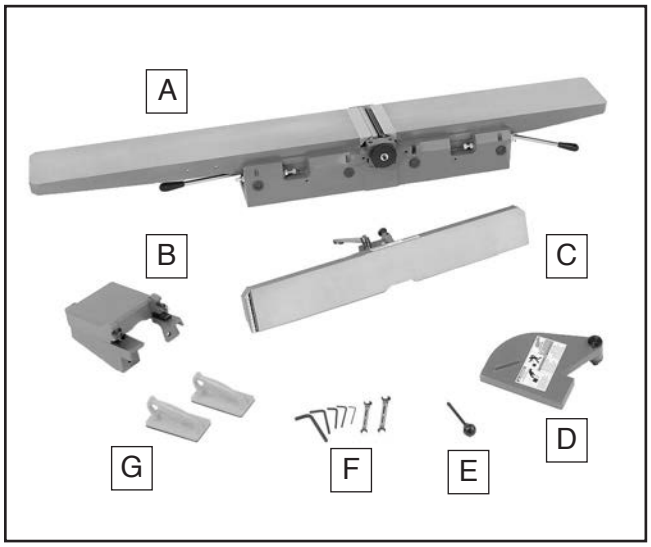


Figure 9. Crate 1 inventory.

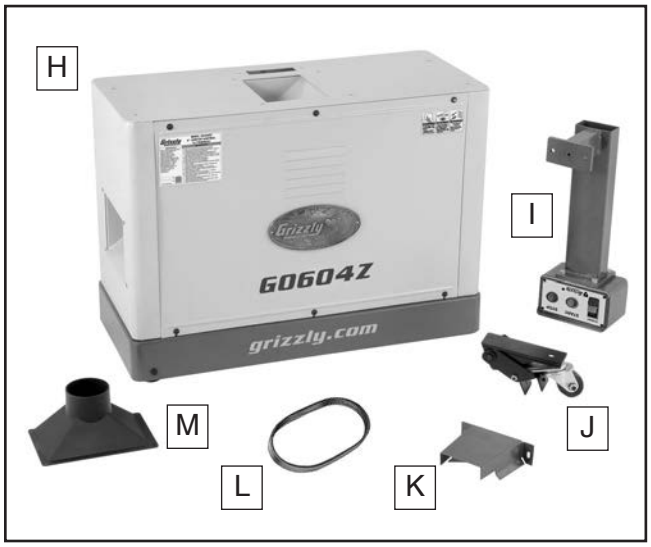


Figure 10. Crate 2 inventory.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

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.



⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Order online at www.grizzly.com OR Call 1-800-523-4777



Figure 11. T23692 Orange Power Degreaser.

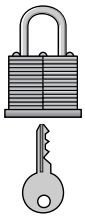
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

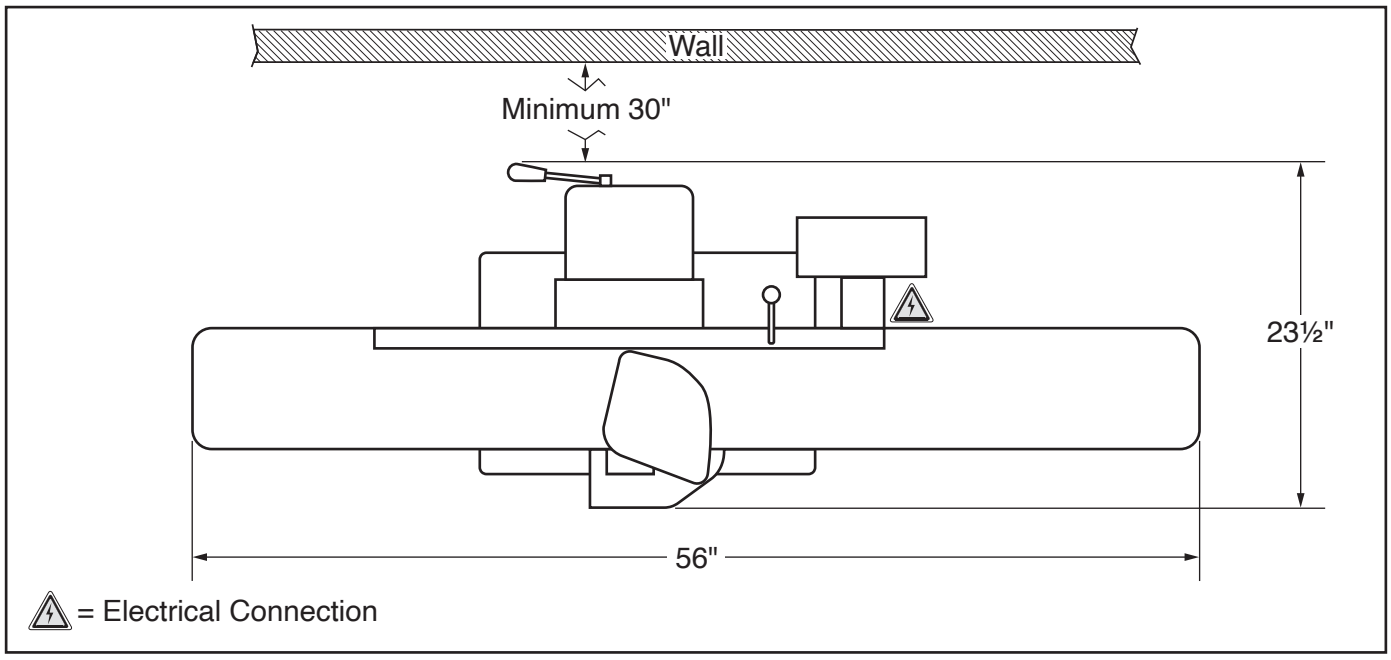


Figure 12. Minimum working clearances.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

To assemble machine:

1. Move each crate separately to desired machine location.

2. Remove crate top and sides, any blocks around machine base, and any loose items inside crate.

3. Remove all fasteners and shipping brackets securing machine to shipping pallet.

4. Remove rear cabinet panel.

5. Reach inside cabinet and remove accessories box, V-belt, and dust port.

6. Remove control panel pedestal and fasteners from inside cabinet and set aside.

7. With help from another person, place a piece of cardboard on floor, tip cabinet over so cabinet top is on cardboard, then remove plastic from cabinet.

8. Attach pedal assembly to right side of cabinet with (1) M8-1.25 x 50 hex bolt, 8mm flat washer, and (2) M10-1.5 x 55 hex bolts, 10mm flat washers, and M10-1.5 hex nuts (see **Figure 13**).

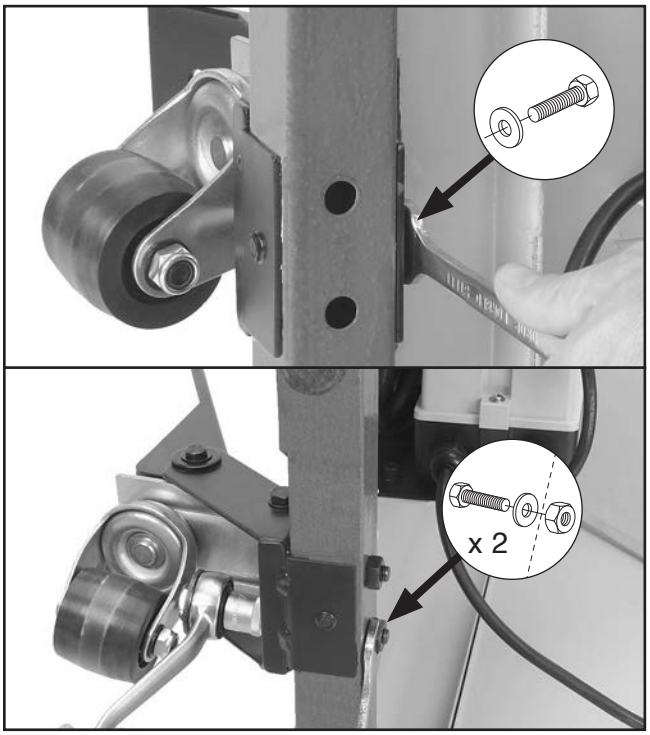


Figure 13. Installing pedal assembly.

9. From inside cabinet, insert power cord plug through same hole in cabinet that control panel pedestal cord is in.

10. With help from another person, place cabinet upright.

11. Attach dust port to cabinet with pre-installed Phillips head screws and flat washers, as shown in **Figure 14**.

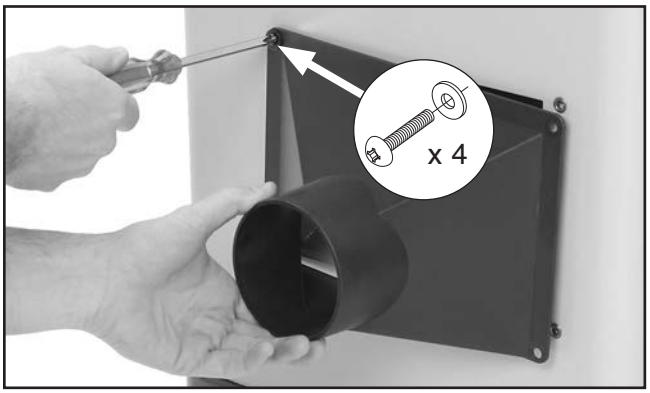


Figure 14. Installing dust port.

12. Remove (2) hex nuts and flat washers from underneath shipping crate that hold table to crate.

13. Wrap lifting straps around infeed and outfeed table, as illustrated in **Figure 15**, then attach them to forklift or hoist.

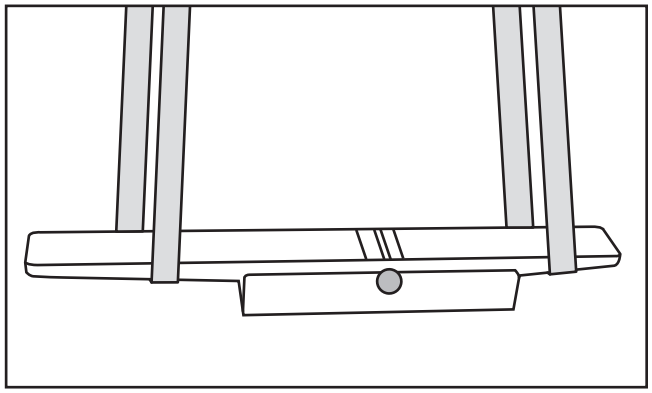


Figure 15. Using lifting straps to lift table.

14. With another person to steady load, carefully lift table over cabinet and align eight mounting holes in cabinet with holes in bottom of table.

Note: *Make sure cutterhead pulley is facing rear of cabinet.*

15. Attach table to cabinet with (4) M8-1.25 x 25 cap screws, 8mm lock washers, and 8mm flat washers (see **Figure 16**).

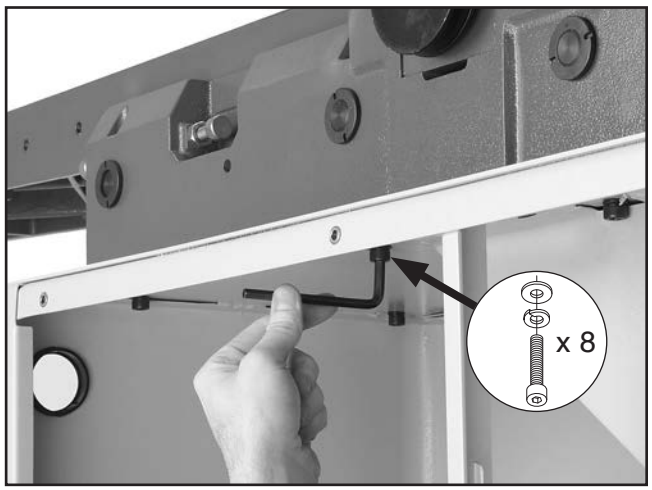


Figure 16. Securing table to cabinet.

16. Attach control panel pedestal to back of infeed table with (2) M8-1.25 x 25 cap screws, 8mm lock washers, and 8mm flat washers pre-installed on infeed table (see **Figure 17**).

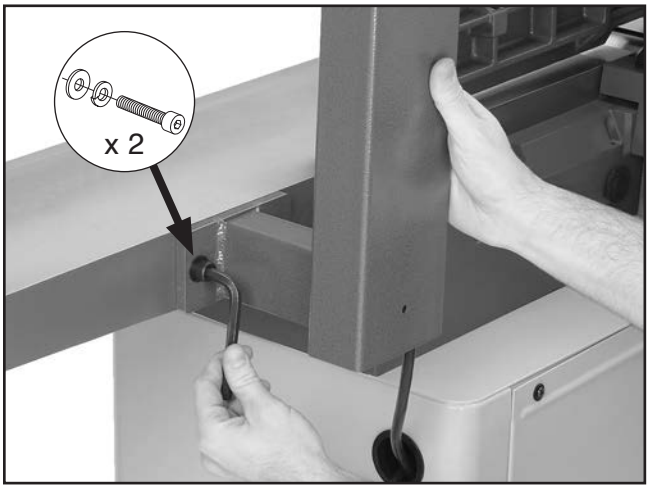


Figure 17. Installing control panel pedestal.

17. Use a straightedge to check alignment of cutterhead and motor pulleys, as shown in **Figure 18**.

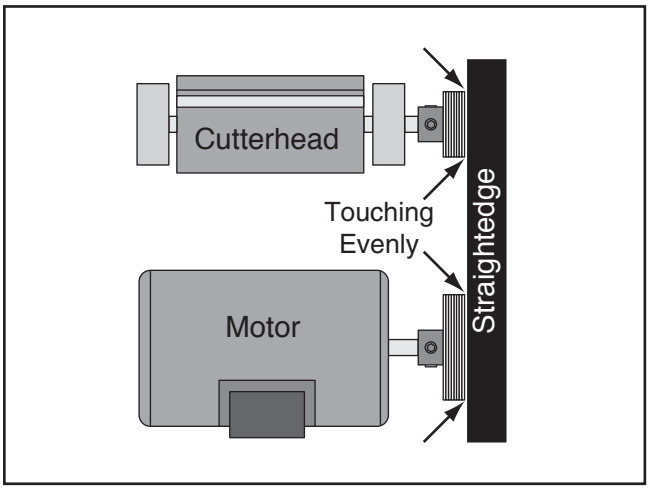


Figure 18. Pulleys aligned.

— If pulleys *are not* aligned, loosen (4) hex nuts on carriage bolts shown in **Figure 19**, shift motor horizontally to align pulleys, then secure carriage bolts.



Figure 19. Motor adjustment.

18. Use (2) pre-installed cap screws and flat washers to install fence carriage to rear of table, as shown in **Figure 20**.

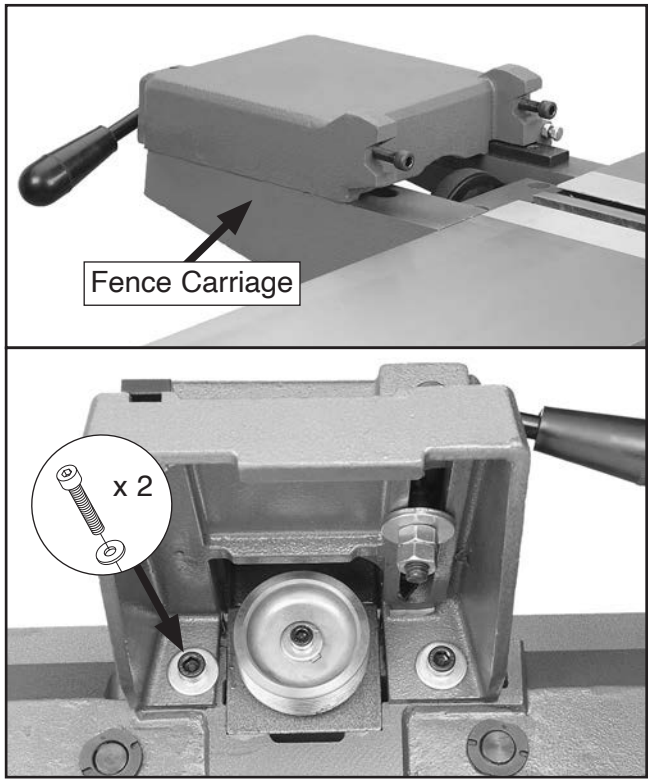


Figure 20. Fence carriage installed.

19. Wrap V-belt around cutterhead and motor pulleys (see **Figure 21**). Make sure ribs of V-belt are seated in pulley grooves.

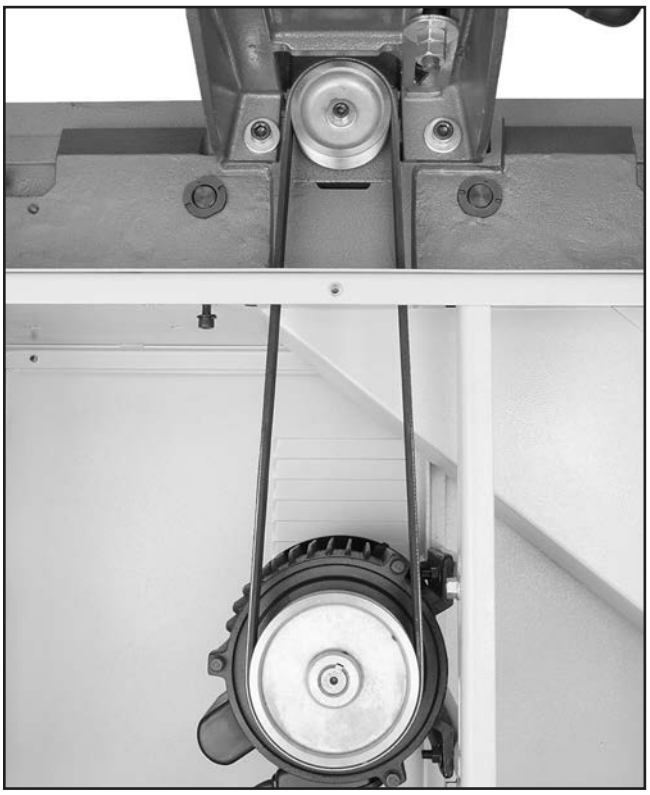


Figure 21. V-belt installed.

20. Loosen flange nuts on carriage bolts securing motor mounting brackets, let motor slide down to place tension on V-belt, then tighten flange nuts (see **Figure 22**).



Figure 22. Motor mount flange nuts and carriage bolts.

Note: *When properly tensioned, there is approximately ¼" deflection of V-belt as moderate pressure is applied midway between pulleys, as illustrated in* ***Figure 23****. If necessary, apply downward pressure on motor to attain proper V-belt tension.*

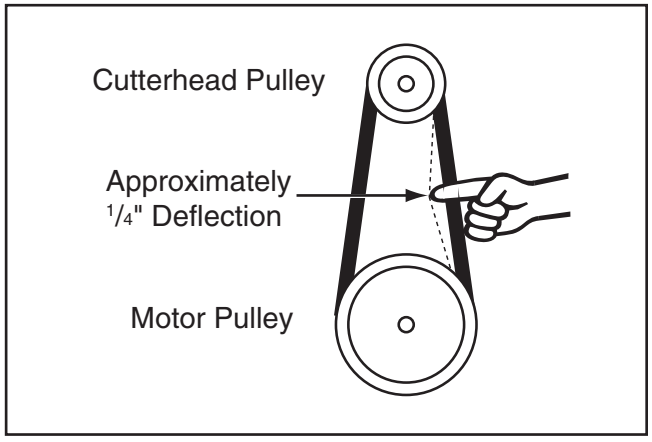


Figure 23. Correct V-belt deflection when properly tensioned.

21. Verify outfeed table height is set correctly with inserts at top dead center (TDC) (see **Setting Outfeed Table Height** on **Page 48**) and all inserts are securely tightened in cutterhead.

22. Use (2) pre-installed cap screws on fence carriage to install fence (see **Figure 24**).

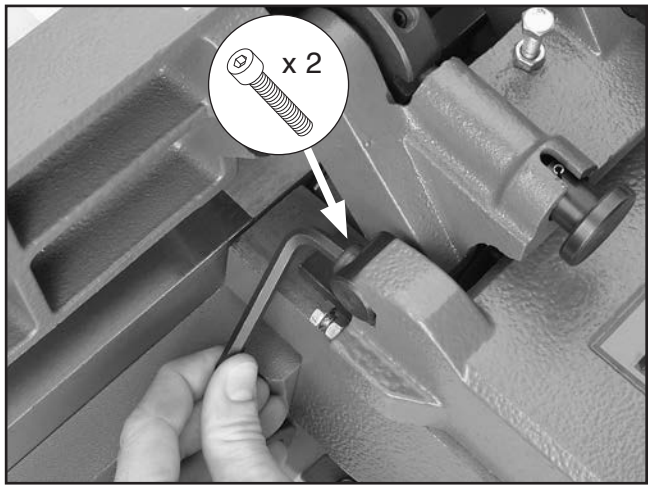


Figure 24. Installing fence.

23. Install fence tilt handle (see **Figure 25**).

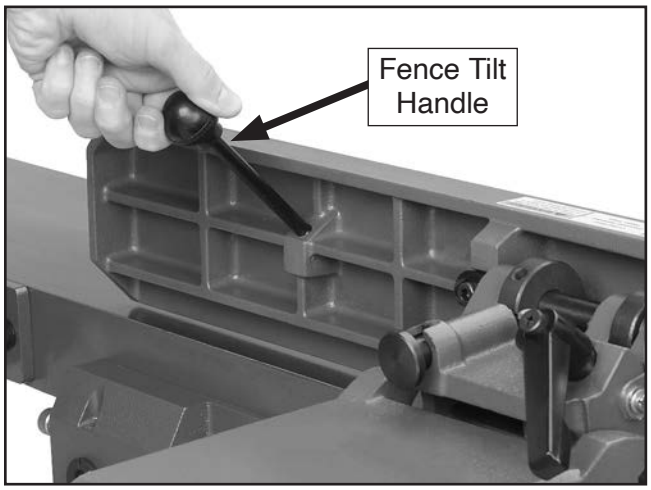


Figure 25. Installing fence tilt handle.

24. Use (2) M6-1 x 12 flange bolts, 6mm flat washers, and M6-1 hex nuts to install belt guard under fence carriage (see **Figure 26**).

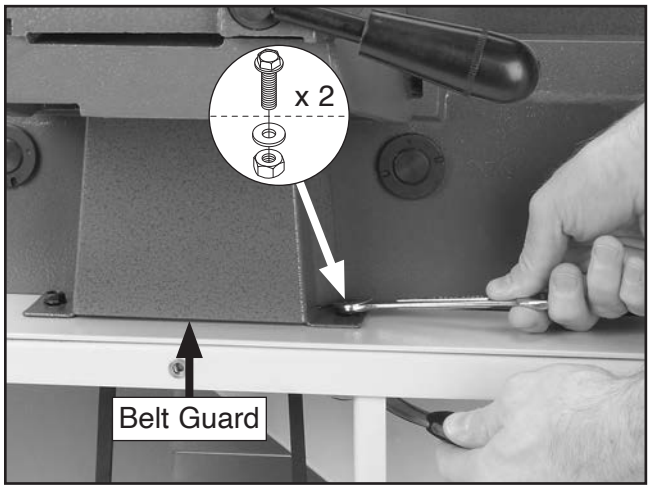


Figure 26. Installing belt guard.

25. Install rear cabinet panel.

26. Set fence to 90º and move it all the way back.

27. Insert cutterhead guard shaft into extension fence, as shown in **Figure 27**, so shaft flat is facing set screw, then tighten set screw against shaft.

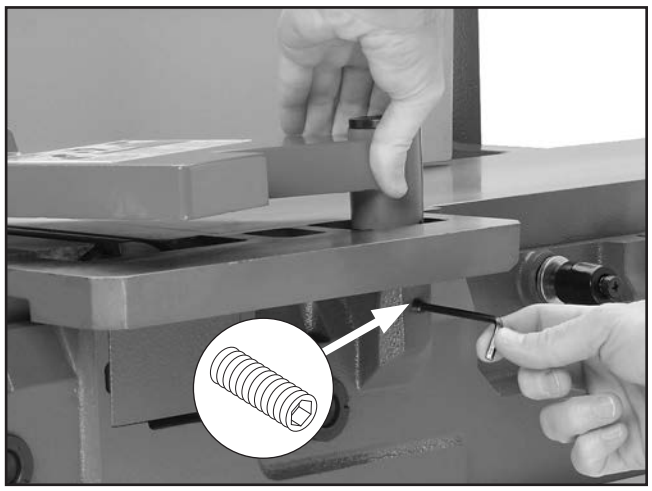


Figure 27. Installing cutterhead guard.

⚠WARNING

The cutterhead guard is a critical safety feature of this jointer. You MUST verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

28. Verify proper operation of cutterhead guard by setting fence to 90°, moving fence to rear of table, then pulling cutterhead guard back and letting it go. It should spring back over cutterhead and contact fence without dragging across outfeed table.

— If cutterhead guard DOES NOT spring back over cutterhead and contact fence, or if it drags across outfeed table, then it must be adjusted (see **Checking/ Adjusting Cutterhead Guard** on **Page 39** for complete instructions).

Dust Collection

⚠CAUTION

DO NOT operate Model G0604Z without an adequate dust collection system. This jointer 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: 400 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 connect a dust collection hose:

1. Fit 4" dust hose over dust port on left side of cabinet and secure in place with a hose clamp (see **Figure 28**).

2. Tug hose to make sure it does not come off.

Note: *A tight fit is necessary for proper performance.*

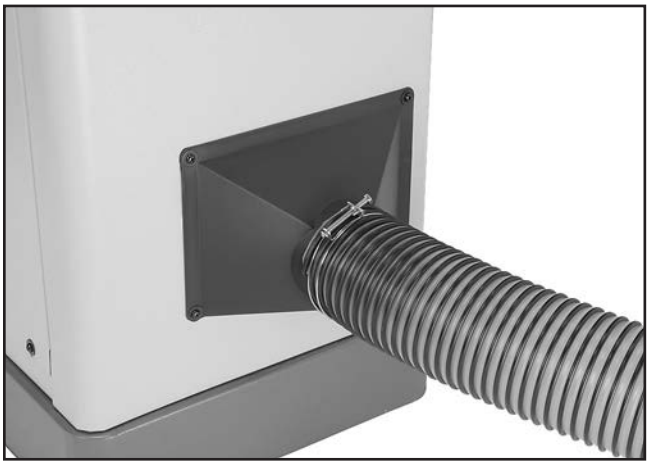


Figure 28. Example of dust hose connected to dust port.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the switch disabling key disables the switch properly.

⚠WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

⚠WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.
2. Ensure POWER switch is in down position.
3. Connect machine to power supply.
4. Move POWER switch to up position to turn machine ***ON***.
5. Press START button to start motor. Verify motor operation, then press STOP button to stop motor.

   The motor should run smoothly and without unusual problems or noises.
6. Move POWER switch to OFF position and remove switch disabling key (see **Figure 29**).

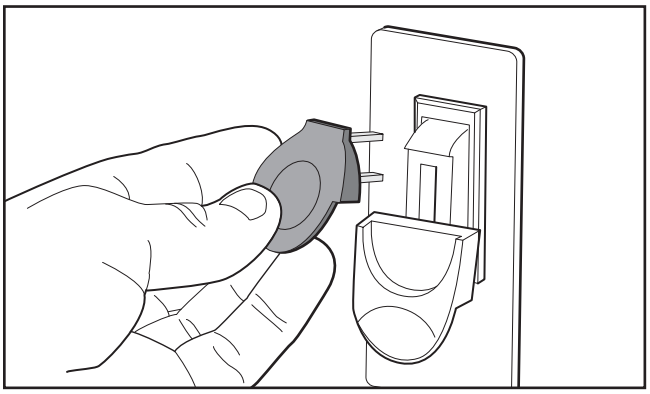


Figure 29. Removing switch disabling key from paddle switch.

7. Try to start machine with paddle switch disabling key removed. Machine should not start.

   — If machine *does not* start, switch disabling feature is working correctly.

   — If machine *does start*, immediately stop machine. Switch disabling feature is not working correctly. This safety feature must work properly before proceeding with operations. Call Tech Support for help.

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.

Factory adjustments that should be verified:

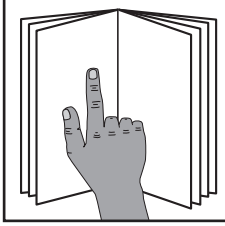
- Table Parallelism (**Page 44**).
- Calibrating Depth Scale (**Page 49**).
- Setting Fence Stops (**Page 50**).

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, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



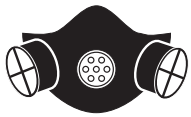
⚠WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

⚠WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.







NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/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 workpiece to verify it is safe and suitable for jointing.
2. Adjusts fence for width of workpiece and locks it in place.
3. Adjusts fence tilt, if necessary.
4. Adjusts infeed table height to set depth of cut per pass.
5. Ensures cutterhead guard position and operation are functioning properly.
6. Puts on safety glasses, respirator, hearing protection, and any other required protective equipment.
7. Starts dust collection and jointer.
8. Using push blocks as needed, holds workpiece firmly against infeed table and fence, and feeds workpiece into cutterhead at a steady and controlled rate until entire length of workpiece has been cut and it clears the cutterhead on the outfeed table side.
9. Repeats cutting process described above until desired results are achieved.
10. Stops jointer and dust collection.

Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

- **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 a knot becomes dislodged during the cutting operation.

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

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

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

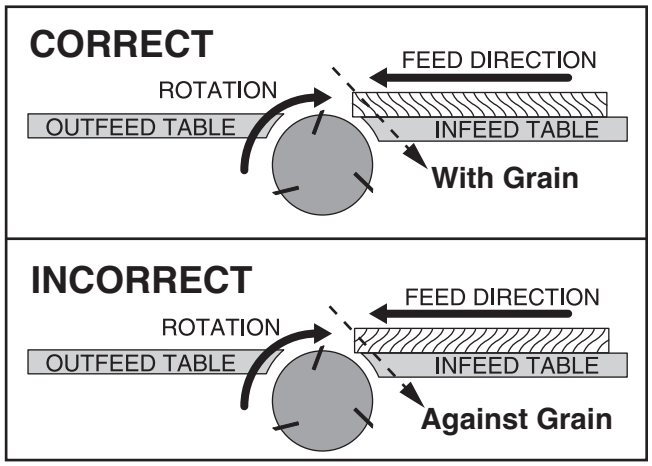


Figure 30. Proper grain alignment with cutterhead.

- **Only cut natural wood.** This jointer is only designed for cutting natural wood stock. Never use it to cut MDF, particle board, plywood, laminates, drywall, backer board, metals, glass, stone, tile, products with lead-based paint, or products that contain asbestos. Cutting these may lead to injury or machine damage.

- **Scrape all glue off the workpiece before jointing.** Glue deposits on the workpiece, hard or soft, will gum up the cutterhead and produce poor results.

- **Remove foreign objects from the workpiece.** Make sure that any stock you process with the jointer is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects that could damage the cutterhead. These particles could also cause a spark as they strike the cutterhead and create a fire hazard.

  IMPORTANT: Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.

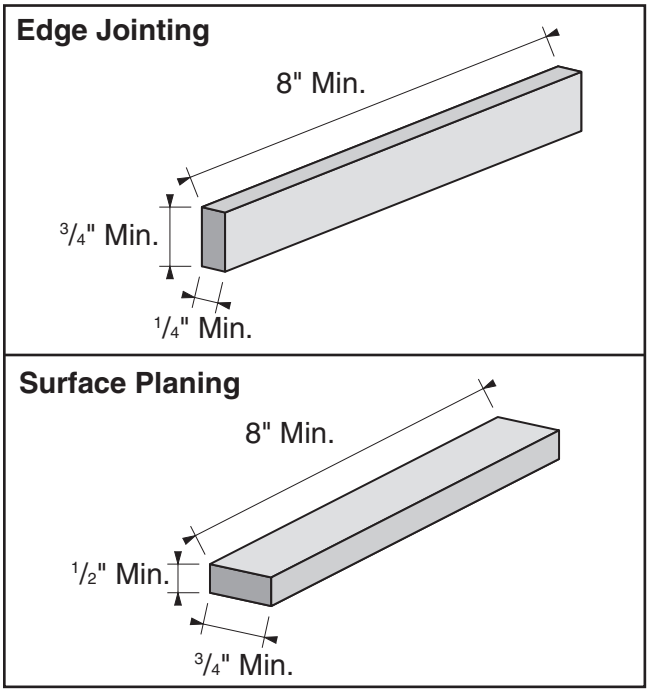


Figure 31. Minimum stock dimensions for jointer.

Setting Depth of Cut

The depth of cut on a jointer is the amount of material removed from the bottom of the workpiece as it passes over the cutterhead.

The depth of cut is set by adjusting the height of the infeed table relative to the carbide inserts at TDC (top dead center).

⚠CAUTION

DO NOT exceed 1/8" depth of cut per pass when edge jointing and 1/16" depth of cut per pass when surface planing on this machine or kickback and serious injury may occur!

Adjusting Infeed Table Height

To adjust the infeed table height, loosen the infeed table lock, use the infeed table adjustment lever to raise or lower the table, then tighten the lock to secure the setting (see **Figure 32**).

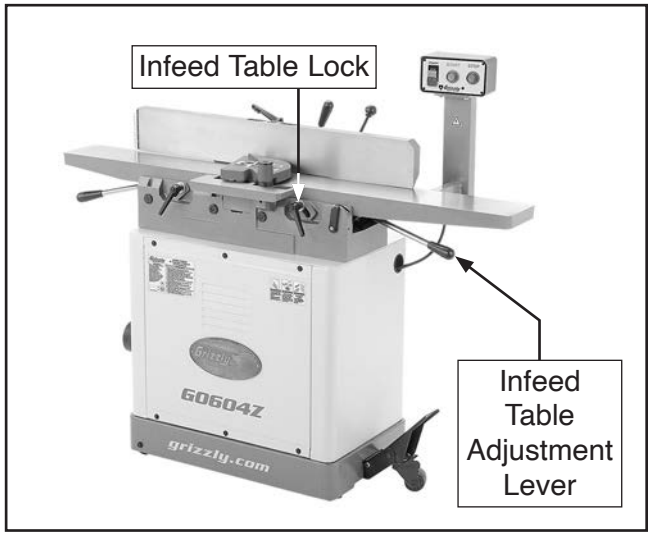


Figure 32. Infeed table controls.

Depth-of-Cut Scale

The depth of cut can be referenced directly from the depth scale located on the front of the jointer (see figures below).

Note: *The depth scale can be calibrated or "zeroed" if it is not correct. Refer to* ***Calibrating Depth Scale*** *on* ***Page 49*** *for more information.*



Figure 33. Location of depth-of-cut scale.

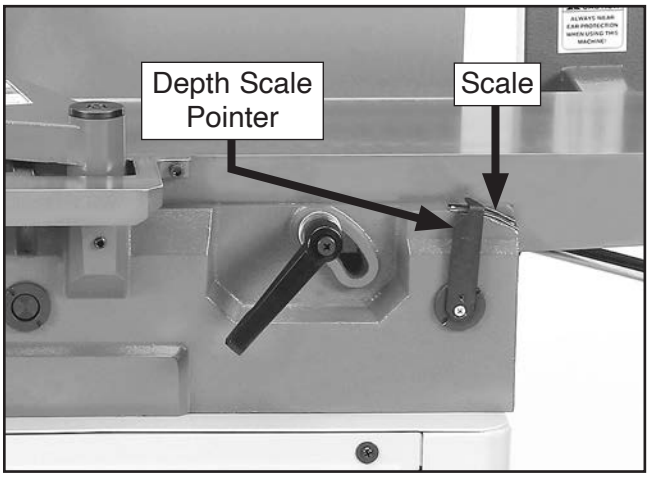
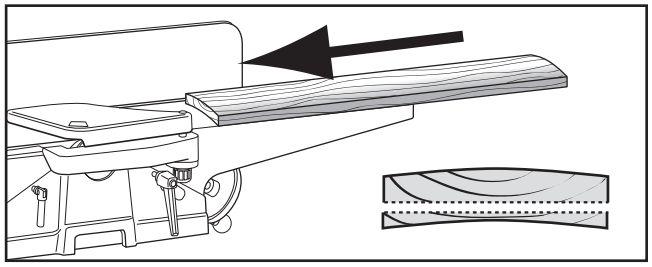


Figure 34. Location of depth-of-cut components.

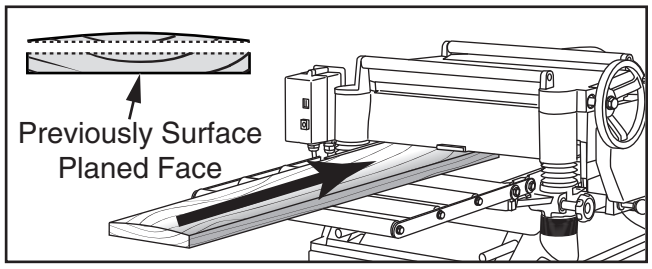
Squaring Stock

Squaring stock involves four steps performed in the order below:

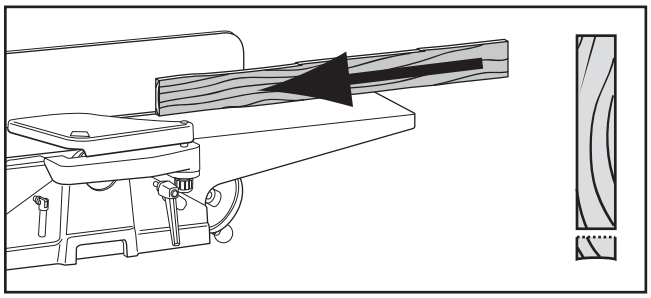
1. **Surface Plane on Jointer**—Concave face of workpiece is surface planed flat with jointer.



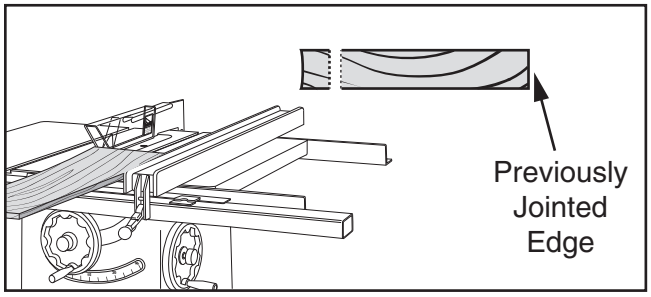
2. **Surface Plane on a Thickness Planer**—Opposite face of workpiece is surface planed flat with a thickness planer.



3. **Edge Joint on Jointer**—Concave edge of workpiece is jointed flat with jointer.



4. **Rip Cut on a Table Saw**—Jointed edge of workpiece is placed against a table saw fence and opposite edge cut off.



Surface Planing

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

⚠WARNING

Failure to use push blocks when surface planing could result in your hands contacting rotating cutterhead, which will cause serious personal injury. ALWAYS use push blocks when surface planing on jointer!



Figure 35. Example of surface planing operation.

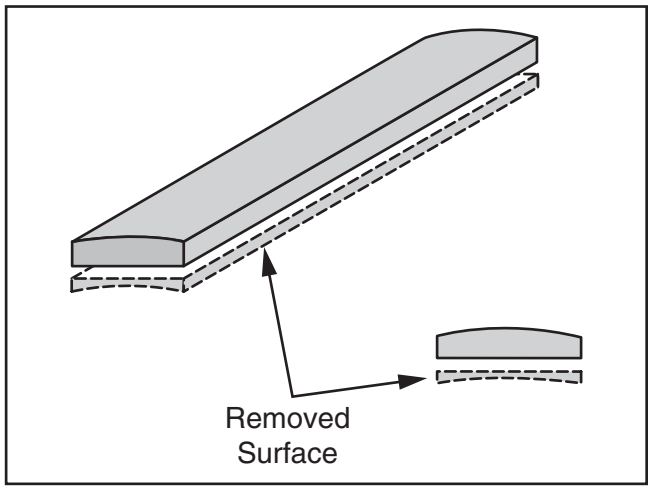


Figure 36. Illustration of surface planing results.

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Set infeed table height to desired cutting depth for each pass.

   ⚠ **CAUTION:** To minimize risk of kickback, do not exceed a cutting depth of 1/16" per pass when surface planing.

3. Set fence to 90°.

4. Start jointer.

5. Place workpiece firmly against fence and infeed table.

   ⚠ **CAUTION:** To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

6. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during the entire cut.

   ⚠ **CAUTION:** Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

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

   Tip: *When squaring up stock, cut opposite side of workpiece with a planer instead of the jointer to ensure both sides are parallel.*

Edge Jointing

Edge jointing (see example **Figures** below) produces a flat and true surface along the side of a workpiece by removing uneven areas. It is an essential step for squaring up warped or rough stock and when preparing a workpiece for joinery or finishing.

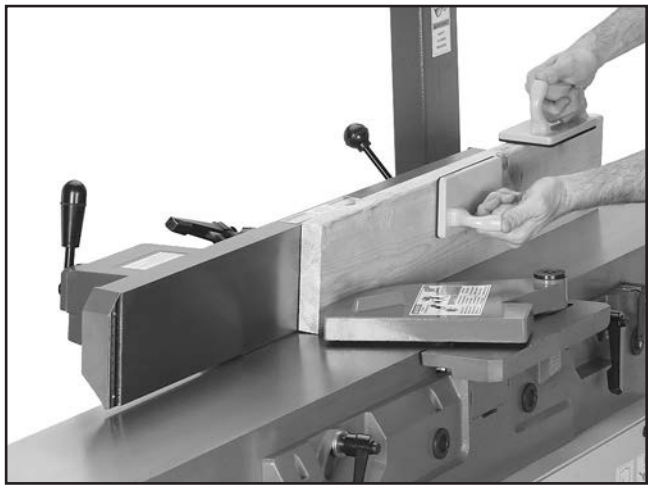


Figure 37. Example of edge jointing operation.

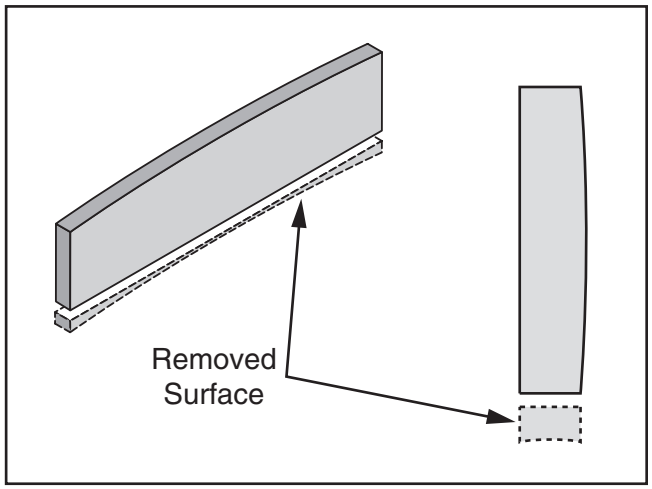


Figure 38. Illustration of edge jointing results.

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Surface plane workpiece (see **Surface Planing** section).

3. Set infeed table height to desired cutting depth for each pass.

   ⚠ **CAUTION:** To minimize risk of kickback, do not exceed a cutting depth of ⅛" per pass.

4. Set fence to 90°.

5. Start jointer.

6. Place workpiece firmly against fence and infeed table with concave side facing down.

   ⚠ **CAUTION:** To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

7. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during the entire cut.

   ⚠ **CAUTION:** Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

8. Repeat **Step 6** until the entire edge is flat.

   Tip: *When squaring up stock, cut opposite edge of workpiece with a table saw instead of the jointer—otherwise, both edges of workpiece will not be parallel with each other.*

Bevel Cutting

Bevel cuts (see example **Figures** below) can be made by setting the fence at the desired angle and feeding the workpiece firmly along the fence face, with the bottom inside corner firmly against the table. The cutting process typically requires multiple passes or cuts to bevel the entire edge of a workpiece.



Figure 39. Fence setup for a bevel cut of 45°.

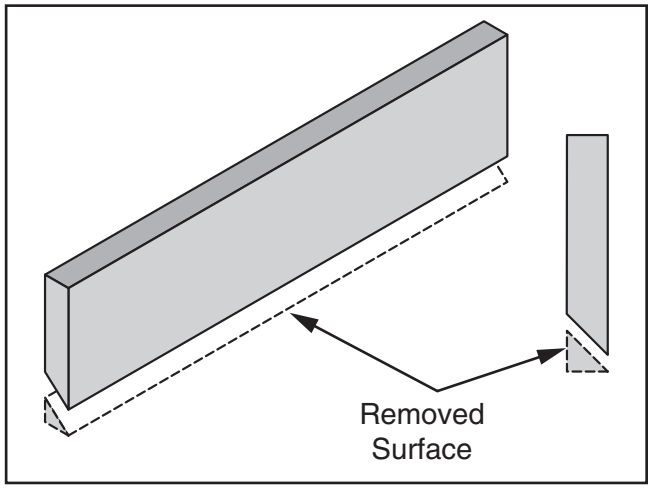


Figure 40. Illustration of bevel cutting results.

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).

2. Surface plane workpiece (see **Surface Planing** section).

3. Edge joint workpiece (see **Edge Jointing** section).

4. Set infeed table height to cutting depth desired for each pass.

   ⚠ **CAUTION:** Cutting depth for bevel cuts is typically between 1/16" and 1/8", depending on hardness and width of stock.

5. Set fence tilt to desired angle of cut.

6. Place workpiece against fence and infeed table with concave side face down.

7. Start jointer.

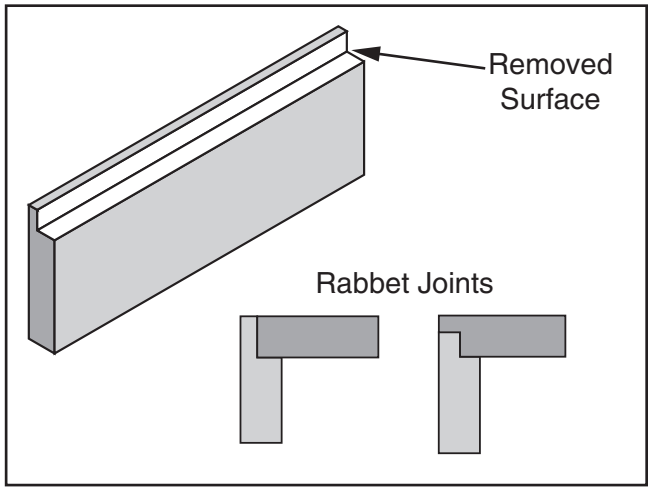
8. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

   ⚠ **CAUTION:** When your leading hand gets within 4" of the cutterhead, lift it up and over cutterhead, and place push block on portion of the workpiece once it is 4" past cutterhead. Now, focus your pressure on outfeed end of the workpiece while feeding, and repeat same action with your trailing hand when it gets within 4" of cutterhead. To help keep your hands safe, DO NOT let them get closer than 4" from moving cutterhead at any time during operation!

9. Repeat cutting process, as necessary, until you are satisfied with the results.

Rabbet Cutting

A rabbet cut removes a portion of a workpiece edge, so it fits together with an opposing, equally sized rabbet cut on another workpiece (see example **Figure** below). This is a classic method of joining two workpieces that is simple, yet strong.



This jointer can be used to make high-quality rabbet cuts, but there are some situations—whether it is due to an excessively large/small workpiece size or rabbet cutting width/depth—when it will not be safe or appropriate for making the rabbet cut on this jointer. In these cases, you need to use another tool or method for rabbet cutting that will be a safer alternative.

A rabbet cut can alternatively be made using a table saw, router, or even a hand saw. As with any type of cutting operation, always consider your safety first and use good judgement!

Typically, rabbet cutting with a jointer requires the cutterhead guard to be removed first, so the workpiece can slide along the rabbeting ledge during the cut. However, it is possible to make rabbet cuts with workpieces up to 1" thick without removing the cutterhead guard. This is done by performing the rabbet cut with the workpiece on end (similar to when you are edge jointing).

To rabbet cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** on **Page 25**).

2. Set infeed table height to desired cutting depth for each pass.

   ⚠CAUTION: For safety reasons, cutting depth should never exceed ⅛" per pass.

3. Remove cutterhead guard if necessary to perform operation (see **Figure 41**).

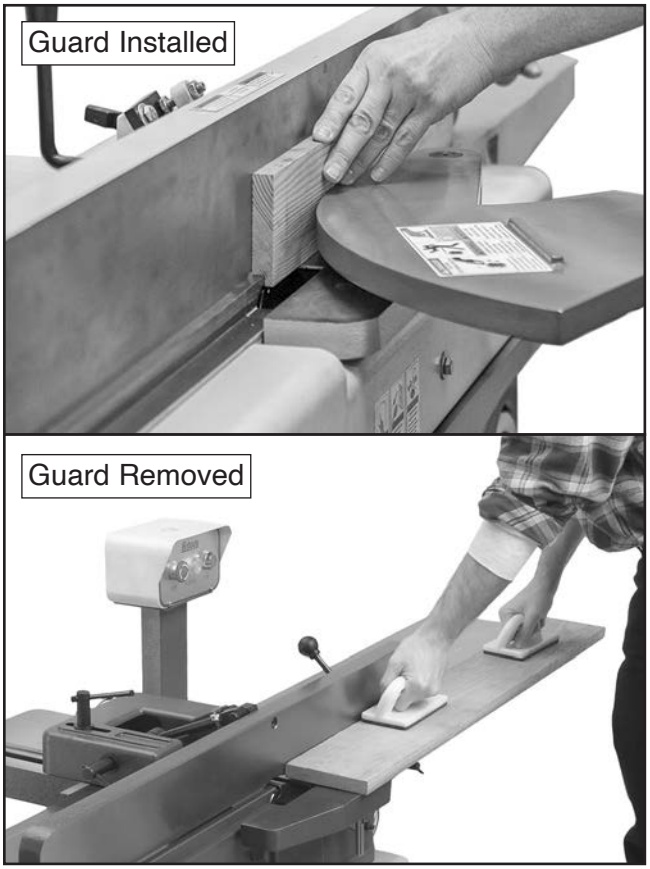


Figure 41. Examples of typical rabbet cutting operations.

⚠WARNING

When cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes operator to moving cutterhead. To minimize risk of injury and unnecessary exposure to cutterhead, always keep cutterhead guard installed when possible, and ALWAYS immediately replace it after performing rabbet cuts.

4. Set fence to 90° and near front of jointer, so amount of exposed cutterhead in front of fence matches size of desired rabbet.

5. Start jointer.

6. Place workpiece firmly against fence and infeed table.

   ⚠**CAUTION:** To ensure workpiece remains stable during cut, concave sides of workpiece must face toward table and fence.

7. Feed workpiece completely across cutterhead while keeping it firmly against fence and tables during entire cut.

   ⚠**CAUTION:** Keep hands at least 4" away from cutterhead during the entire cut. Instead of allowing a hand to pass directly over cutterhead, lift it up and over cutterhead, and safely reposition it on the outfeed side to continue supporting workpiece. Use push blocks whenever practical to further reduce risk of accidental hand contact with cutterhead.

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

9. Re-install cutterhead guard if removed in **Step 3** (see **Checking/Adjusting Cutterhead Guard** on **Page 39**).

SECTION 5: ACCESSORIES

⚠WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

G0862—3 HP Portable Cyclone Dust Collector
The capstone of our line of affordable, high-quality cyclones, the G0862 features a 3 HP motor, a whopping 1941 CFM of airflow capacity, and a 45-gallon collection capacity. It's packed with features like a quick-release collection drum, latching system, high-efficiency, two-stage separation driven by a 16" aluminum impeller, durable powder coated finish, and a heavy-duty steel frame and housing.



Figure 42. Model G0862 3 HP Portable Cyclone Dust Collector.

H7319—Indexable Carbide Inserts (10-Pack)
These indexable carbide inserts can be rotated to provide four factory sharp edges before replacement. Inserts measure 14 x 14 x 2mm.

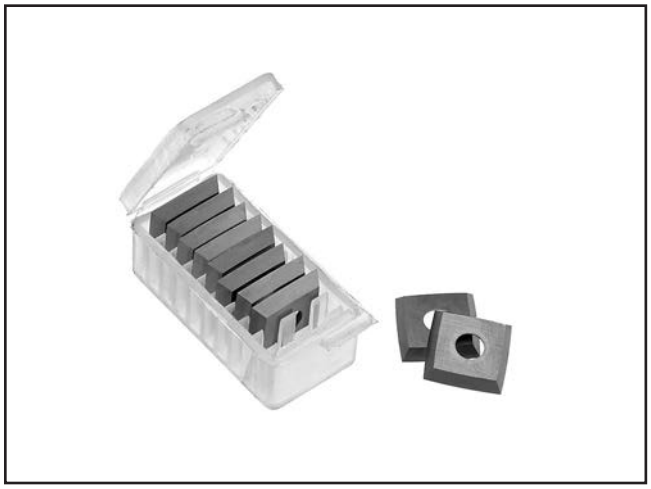


Figure 43. Replacement carbide inserts for Model G0604Z.

T21578—12" Beveled Straight Edges w/Scale
T21579—24" Beveled Straight Edges w/Scale
T21580—36" Beveled Straight Edges w/Scale
These bevel straight edges are made from hardened steel and feature a satin chrome finish and are ground and lapped for straightness and parallelism. Each straightedge offers true right angles for all edges, along with a beveled edge with scale in US standard. 1/64" graduations.

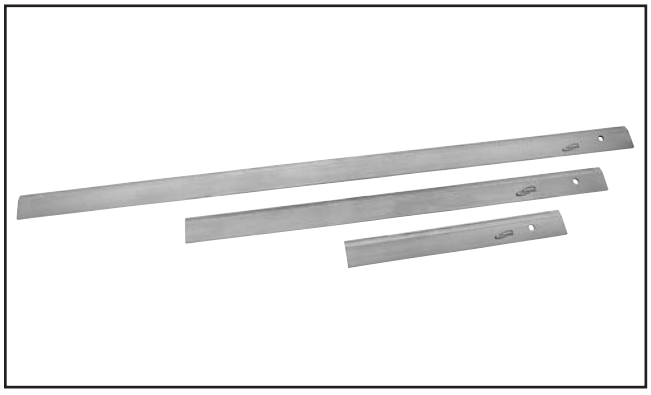
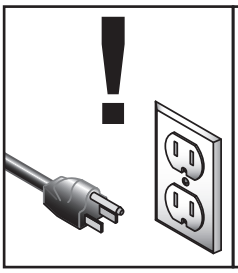


Figure 44. T21578, T21579, and T21580 straightedges.

SECTION 6: MAINTENANCE



⚠WARNING
To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing
To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Dust or debris on and around machine.
- Dull or damaged cutterhead inserts.
- Unprotected cast-iron surfaces.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check
- V-belt tension, damage, or wear (**Page 41**).
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning & Protecting

The cleaning process for this machine is simple. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

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

Keep tables rust-free with regular applications of quality lubricants.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 11 Oz. Spray



Figure 45. Recommended products for protecting unpainted cast-iron and steel.

Lubrication

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

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more grease to them will not yield smooth moving components.

Clean the components below with mineral spirits or other oil/grease solvent cleaner and shop rags.

SB1365—South Bend Way Oil-ISO 68



Figure 46. Recommended product for machine lubrication.

Infeed/Outfeed Table Controls

Oil Type .....SB1365 or ISO 68 Equivalent
Oil Amount.....Thin Coat
Frequency..... As Needed

Lubricate the infeed/outfeed table adjustment lever components with light machine oil as needed (see **Figure 47**). Wipe off excess oil and sawdust with a cloth.

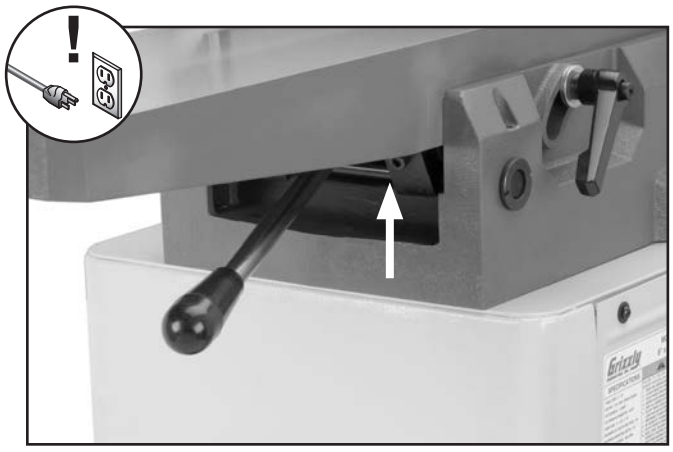


Figure 47. Adjustment lever lubrication location.

Fence

Oil Type .....SB1365 or ISO 68 Equivalent
Oil Amount.....1–2 Drops
Lubrication Frequency..... As Needed

Place one or two drops of light machine oil on fence pivot points (see **Figure 48**) as needed.

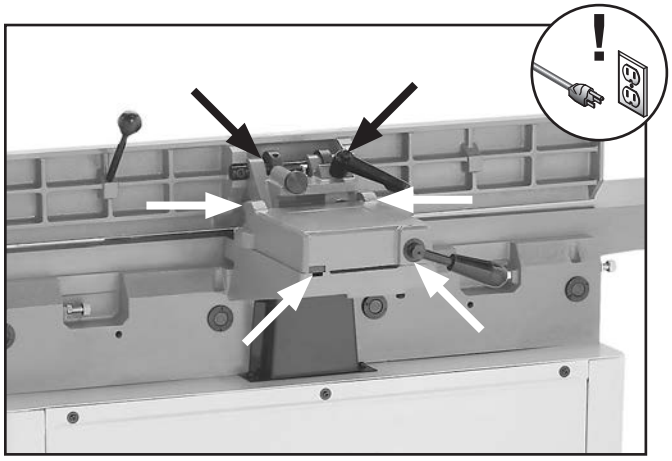
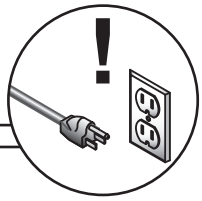


Figure 48. Fence lubrication locations.

SECTION 7: SERVICE

Review the troubleshooting 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. **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 power supply breaker immediately trips after startup.	1. POWER switch in OFF position. 2. POWER switch disabling key removed. 3. Incorrect power supply voltage or circuit size. 4. Plug/receptacle at fault/wired incorrectly. 5. Power supply circuit breaker tripped or fuse blown. 6. Motor wires connected incorrectly. 7. Thermal overload relay has tripped/at fault. 8. Start capacitor at fault. 9. Centrifugal switch adjustment/contact points at fault. 10. Contactor not energized/at fault. 11. Wiring broken, disconnected, or corroded. 12. ON/OFF button(s) at fault. 13. Motor or motor bearings at fault.	1. Move POWER switch to ON position. 2. Install POWER switch disabling key. 3. Ensure correct power supply voltage and circuit size. 4. Test for good contacts; correct wiring. 5. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 6. Correct motor wiring connections (**Page 51**). 7. Reset. Adjust or replace if at fault. 8. Test/replace if at fault. 9. Adjust centrifugal switch/clean contact points. Replace either if at fault. 10. Test all legs for power; replace if necessary. 11. Fix broken wires or disconnected/corroded connections. 12. Replace button(s). 13. Replace motor.
Machine stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Feed rate/cutting speed too fast. 3. Machine undersized for task. 4. Belt slipping/pulleys misaligned. 5. Motor wires connected incorrectly. 6. Plug/receptacle at fault/wired incorrectly. 7. Pulley slipping on shaft. 8. Motor overheated. 9. Run capacitor at fault. 10. Extension cord too long. 11. Contactor not energized/at fault. 12. Centrifugal switch/contact points at fault. 13. Motor or motor bearings at fault.	1. Only cut wood/ensure moisture is below 20% (**Page 25**). 2. Decrease feed rate/cutting speed. 3. Use sharp inserts; reduce feed rate/depth of cut (**Page 26**). 4. Clean/tension/replace belt (**Page 41**); ensure pulleys are aligned (**Page 42**). 5. Correct motor wiring connections (**Page 51**). 6. Test for good contacts; correct wiring. 7. Tighten/replace loose pulley/shaft. 8. Clean motor, let cool, and reduce workload. 9. Test/repair/replace. 10. Move machine closer to power supply; use shorter extension cord (**Page 12**). 11. Test all legs for power; repair/replace if at fault. 12. Adjust centrifugal switch/clean contact points. Replace either if at fault. 13. Replace motor.

Motor & Electrical (Cont.)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Mobile cabinet feet not adjusted properly. 3. V-belt worn, loose, pulleys misaligned or belt slapping cover. 4. Insert(s) at fault. 5. Pulley loose. 6. Motor mount loose/broken. 7. Cutterhead bearings at fault. 8. Motor fan rubbing on fan cover. 9. Centrifugal switch needs adjustment/at fault. 10. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts; tighten if loose. 2. Adjust mobile cabinet feet to stabilize machine. 3. Inspect/replace belt (**Page 41**). Re-align pulleys if necessary (**Page 42**). 4. Rotate/replace insert(s) (**Page 43**). 5. Secure pulley on shaft (**Page 42**). 6. Tighten/replace. 7. Replace bearing(s)/re-align cutterhead. 8. Fix/replace fan cover; replace loose/damaged fan. 9. Adjust/replace if at fault. 10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operation

Symptom	Possible Cause	Possible Solution
Table(s) hard to adjust.	1. Table lock(s) engaged/partially engaged. 2. Table stop(s) blocking movement.	1. Completely loosen table lock(s) (**Page 4**). 2. Loosen/reset table stop(s) (**Page 49**).
Excessive snipe (gouge in end of board that is uneven with rest of cut); back of workpiece is concave.	1. Outfeed table set too low. 2. Operator pushing down on trailing end (infeed side) of workpiece as it leaves cutterhead.	1. Align outfeed table with cutterhead inserts at top dead center (**Page 48**). 2. Focus most of the workpiece pressure against outfeed table while cutting.
Workpiece stops in middle of cut; front of workpiece is concave.	1. Outfeed table set too high.	1. Align outfeed table with cutterhead inserts at top dead center (**Page 48**).
Workpiece chipping, tear-out, indentations, or overall rough cuts.	1. Workpiece is rough or has loose knots/surface flaws; not suitable for jointing. 2. Not feeding workpiece to cut "with" the grain. 3. Dull inserts. 4. Nicked or chipped insert(s). 5. Feeding workpiece too fast. 6. Excessive depth of cut. 7. Lack of proper dust collection or clogged dust port.	1. Inspect workpiece. Use smooth stock without loose knots/surface flaws (**Page 25**). 2. Flip workpiece 180° before feeding again. 3. Rotate/replace inserts (**Page 43**). 4. Rotate/replace inserts (**Page 43**). 5. Reduce feed rate. 6. Reduce depth of cut (**Page 26**). 7. Clear blockages, ensure dust collection is operating efficiently; upgrade dust collector.
Fuzzy grain left in workpiece.	1. Wood has high moisture content. 2. Dull inserts.	1. Ensure wood moisture content is less than 20%. Allow to dry if necessary (**Page 25**). 2. Rotate/replace inserts (**Page 43**).
Long lines or ridges that run along length of workpiece.	1. Nicked or chipped inserts. 2. Loose or incorrectly installed insert(s). 3. Dirt or debris under insert(s).	1. Rotate/replace inserts (**Page 43**). 2. Remove/replace insert(s) and install properly (**Page 43**). 3. Remove insert(s), clean bottom of insert/cutterhead mounting pocket and re-install (**Page 43**).

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Uneven cutter marks, wavy surface, or chatter marks across face of workpiece.	1. Feeding workpiece too fast. 2. Insert(s) not properly adjusted or dirt or debris under insert(s).	1. Reduce feed rate. 2. Remove, clean bottom of insert/cutterhead mounting pocket, and re-install any inserts that are "raised" in cutterhead (**Page 43**).
Glossy surface; scorching or burn marks on workpiece.	1. Dull inserts. 2. Feed rate too slow.	1. Rotate/replace inserts (**Page 43**). 2. Increase feed rate.
Workpiece is concave or convex along its length after jointing.	1. Workpiece not held with even pressure against outfeed table during cut. 2. Workpiece too uneven at start of operation. 3. Tables not parallel with cutterhead and each other.	1. Apply even, downward pressure against workpiece throughout entire travel along outfeed side during cut. 2. Take partial cuts to remove extreme high spots before doing a full pass. 3. Verify/adjust table parallelism (**Page 44**).
Workpiece edges not square; tapered cut produced.	1. Fence not square to table(s); fence tilt unlocked. 2. Insert(s) not adjusted at even heights in cutterhead. 3. Warped infeed or outfeed table.	1. Square fence to table(s) (**Page 50**); lock fence. 2. Remove, clean bottom of insert/cutterhead mounting pocket, and re-install any inserts that are "raised" in cutterhead (**Page 43**). 3. Regrind/replace table.

Checking/Adjusting Cutterhead Guard

⚠WARNING

The cutterhead guard is a critical safety feature of this jointer. You MUST verify its operation before using the jointer! Failure to properly install this guard will greatly increase risk of serious personal injury.

The cutterhead guard is designed to reduce the risk of accidental contact with hands or fingers with the spinning cutterhead. When properly installed and functioning correctly, the guard automatically rotates clear of the cutterhead during the cutting operation and then springs back over the cutterhead as soon as the operation is complete.

In order to function as intended, the guard must be installed as low as possible over the infeed table without actually touching it (approximately 1/16" above infeed table), and it must have enough spring tension at the mounting shaft to quickly reposition itself against the fence after it is rotated away from the cutterhead and released. Before performing rabbeting operations, adjust guard height to just clear outfeed table.

Items Needed	**Qty**
Work Gloves	1 Pr.
Hex Wrenches 4, 6mm	1 Ea.
Straight Jaw Pliers 10"	1

To check/adjust cutterhead guard:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence lock, move fence all the way back, then tighten fence lock.

3. Pull cutterhead guard back and let it go. It should spring back over cutterhead and rest against fence (see **Figure 49**).

   — If cutterhead guard *does* spring back over cutterhead and rest against fence, cutterhead guard is properly tensioned. Proceed to **Step 7**.

   — If cutterhead guard *does not* spring back over cutterhead and rest against fence, proceed to **Step 4**.

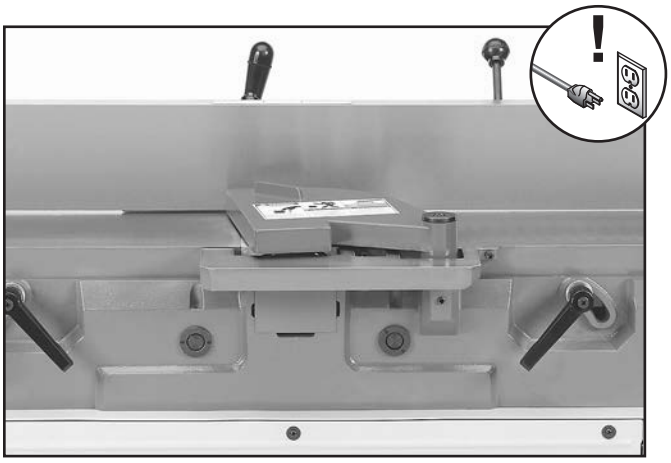


Figure 49. Cutterhead guard against fence.

4. Put on work gloves and loosen cap screw securing cutterhead guard clamp just enough so cutterhead guard moves freely (see **Figure 50**). DO NOT remove cap screw.

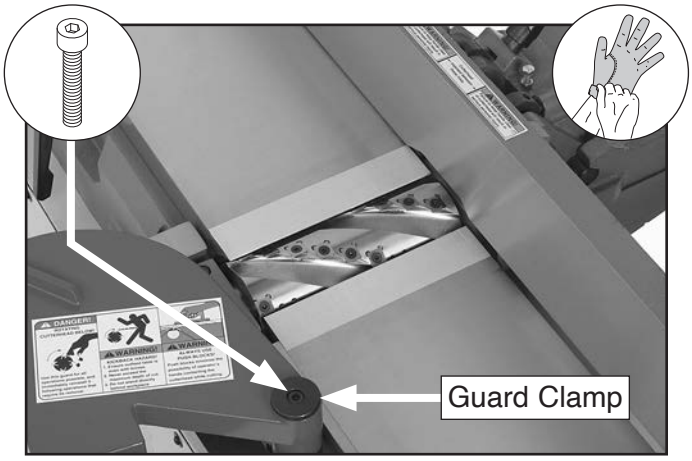


Figure 50. Location of cutterhead guard clamp and cap screw.

5. With cutterhead guard resting against fence, use straight-jaw pliers to rotate cutterhead guard clamp a ¼ turn clockwise, then tighten cap screw to secure guard clamp, as shown in **Figure 51**.

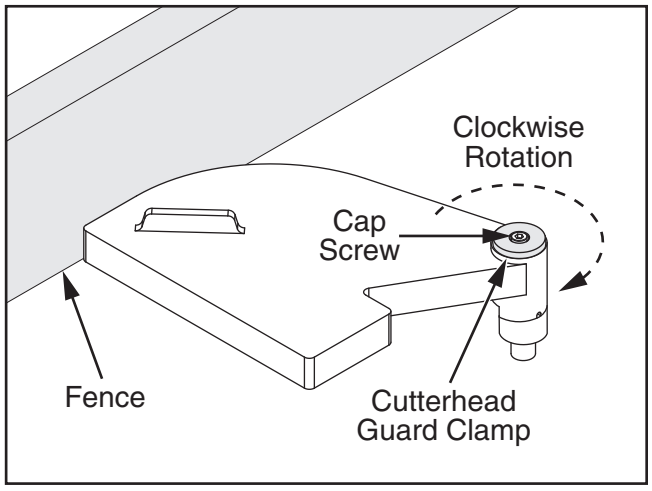


Figure 51. Rotating cutterhead guard clamp (tables removed for clarity).

6. Pull cutterhead guard back and let it go. It should spring back over cutterhead and rest against fence.

   — If cutterhead guard *does* spring back over cutterhead and rest against fence, cutterhead guard is properly tensioned. Proceed to **Step 7**.

   — If cutterhead guard *does not* spring back over cutterhead and rest against fence, repeat **Steps 4–5** until properly adjusted, then proceed to **Step 7**.

7. Verify cutterhead guard height is as low as possible (approximately ⅛" above infeed table) without dragging on infeed table/rabbeting extension.

   — If cutterhead guard *is* as low as possible without dragging on infeed table/rabbeting extension, cutterhead guard height is correct. No further adjustment is required.

   — If cutterhead guard *is not* as low as possible or drags on infeed table/rabbeting extension, loosen set screw securing cutterhead guard shaft, position cutterhead guard until it is approximately ⅛" above infeed table, then tighten set screw (see **Figure 52**).

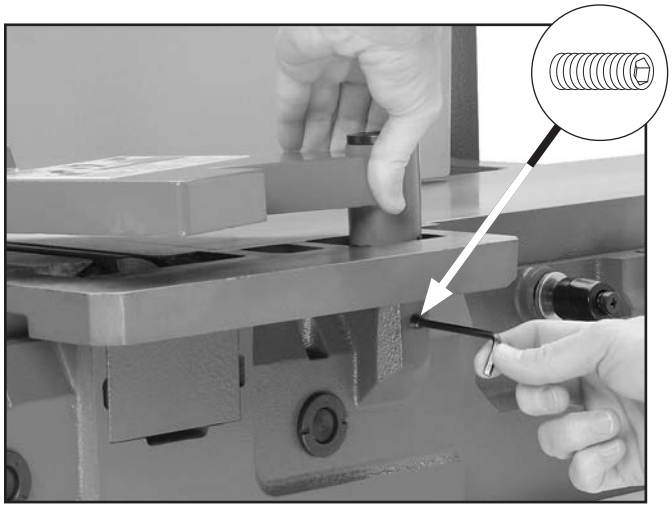


Figure 52. Location of cutterhead guard shaft set screw.

Tensioning/ Replacing V-Belt

To ensure optimum power transmission from the motor to the cutterhead, the V-belt must be in good condition (free from cracks, fraying and wear) and properly aligned and tensioned.

NOTICE

After approximately 16 hours of operation, belt will stretch and seat into pulley grooves. The belt needs to be re-tensioned after this initial break-in period to ensure optimum power transfer and maximum overall life of the belt.

Items Needed	Qty
Additional Person	1
Replacement V-Belt (P0604Z224)	1
Phillips Head Screwdriver #2	1
Wrenches or Sockets 12, 13mm	1 Ea.

Tensioning V-Belt

1. DISCONNECT MACHINE FROM POWER!

2. Remove cabinet rear panel and belt guard.

3. Loosen hex nuts on carriage bolts securing motor (see **Figure 53**). DO NOT completely remove hex nuts.

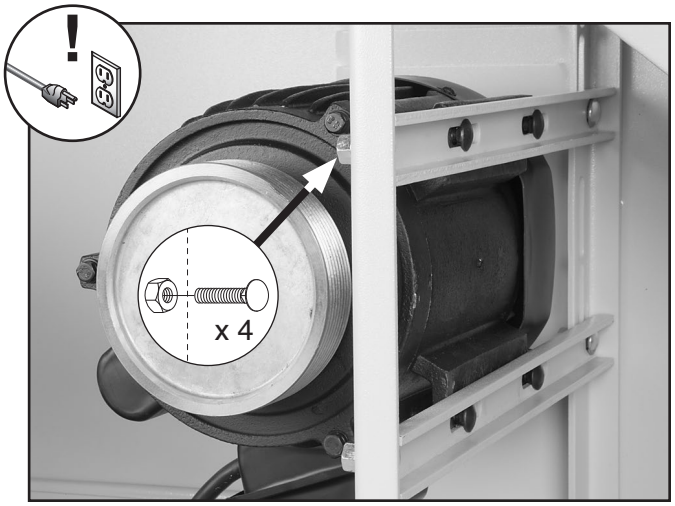


Figure 53. Motor adjustment location.

4. Press down on motor to keep tension on belt.

⚠CAUTION

Belt and pulleys will be hot after operation. Allow them to cool before handling.

5. Press belt with moderate pressure in center to check belt tension. Belt is correctly tensioned when there is approximately ¼" deflection when pushed (see **Figure 54**).

   — If there is more than ¼" deflection when you check belt tension, repeat the tensioning procedure until it is correct.

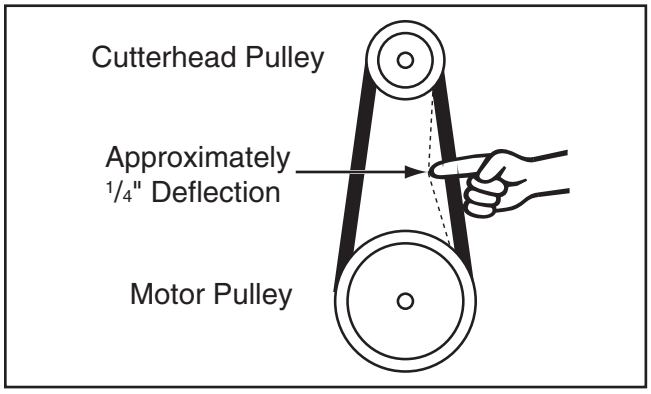


Figure 54. Correct belt deflection when properly tensioned.

6. Tighten motor mount hex nuts (see **Figure 53**), and install cabinet rear panel and belt guard.

Replacing V-Belt

1. DISCONNECT MACHINE FROM POWER!

2. Remove cabinet rear panel and belt guard.

3. Loosen hex nuts on carriage bolts securing motor (see **Figure 53**).

4. Have another person lift motor as you remove belt and replace it with a new one. Make sure ribs of belt are seated in pulley grooves.

5. Follow **Steps 4–5** in **Tensioning Belt** procedure to set correct belt tension.

6. Tighten motor mount hex nuts (see **Figure 53**), and install cabinet rear panel and belt guard.

Aligning Pulleys

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

The pulleys can be adjusted by loosening the pulley set screws, aligning the pulleys, and retightening the set screws.

Tools Needed	**Qty**
Hex Wrench 3mm	1
Straightedge 4'	1
Phillips Head Screwdriver #2	1
Wrenches or Sockets 12, 13mm	1 Ea.

To align pulleys:

1. DISCONNECT MACHINE FROM POWER!

2. Remove cabinet rear panel and belt guard, then move fence all the way back.

3. Place straightedge against pulleys to check their alignment (see **Figure 55**).

Note: *This can also be done visually (without a straightedge) if you do not have a straightedge available that will fit; however, the most accurate results will come from using a straightedge.*

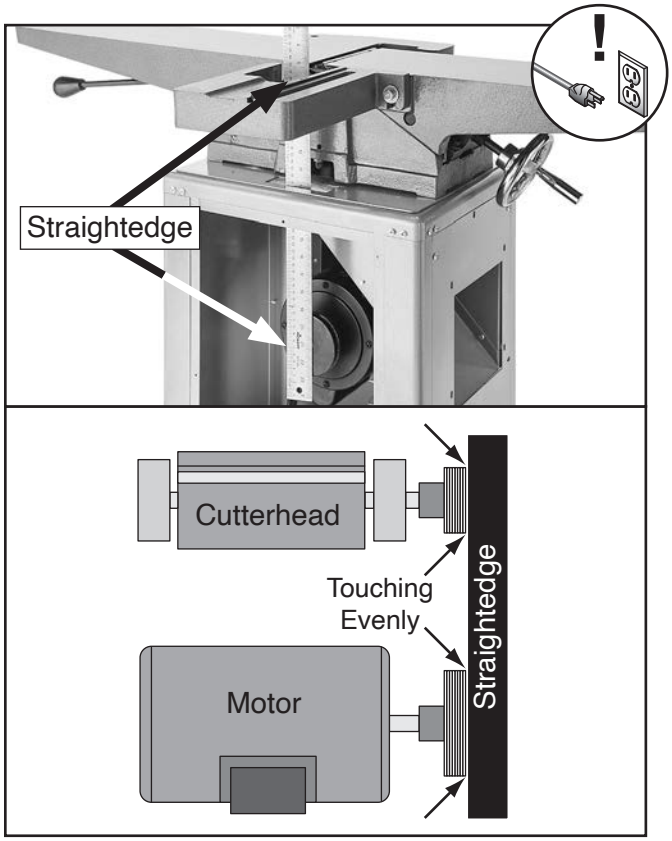


Figure 55. Example of checking pulley alignment.

— If they *are not* aligned, loosen set screws on motor pulley as needed to align pulleys, then tighten set screws, as shown in **Figure 56**.

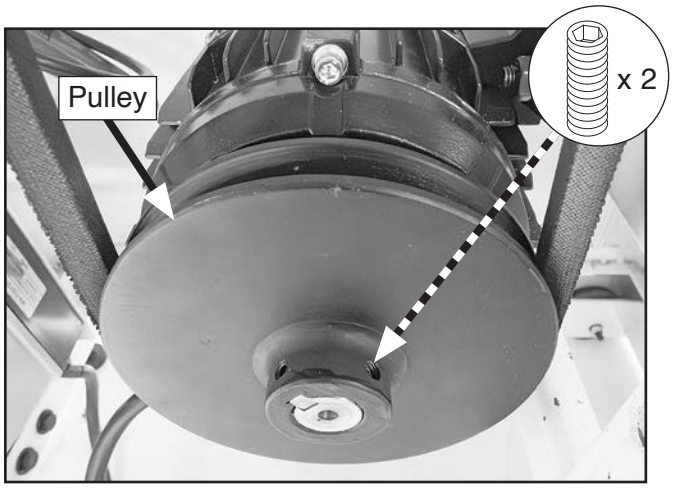


Figure 56. Motor pulley set screw locations.

4. Replace cabinet rear panel and belt guard, then move fence to desired position.

Rotating/Replacing Indexable Inserts

The Model G0604Z spiral cutterhead is equipped with 4-sided indexable carbide inserts. Each insert can be removed, rotated, and re-installed to use any of its four cutting edges. If one cutting edge becomes dull or damaged, simply rotate it 90º (see **Figure 57**) to use a sharp cutting edge.

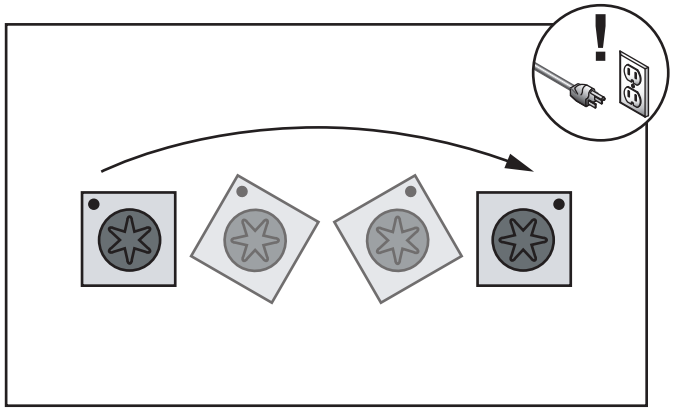


Figure 57. Rotating indexable carbide inserts.

Each insert has a reference dot on one corner. As the insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. Replace insert when the reference dot has been used and rotated back to its starting position.

Items Needed

- Work Gloves ..... 1 Pair
- Safety Glasses (per person) 1
- Flat Hd Torx Screws T20 M6-1 x 15 ..... As Needed
- Indexable Carbide Inserts 14 x 14 x 2mm ..... As Needed
- Torx Bit T-20 ¼" Shank 1
- T-Handle Bit Driver ¼" 1
- Wrench or Socket 10mm 1
- Hex Wrench 4mm 1
- Torque Wrench 0–50 in.-lb. 1
- Clean Shop Rags ..... As Needed
- Degreaser ..... As Needed
- Light Machine Oil ..... As Needed

⚠WARNING

Cutterhead inserts are extremely sharp. Wear work gloves to avoid the risk of serious personal injury during the following steps in this section.

To replace or rotate indexable insert:

1. DISCONNECT MACHINE FROM POWER!
2. Set fence to 90° and move it all the way back.
3. Remove cutterhead guard, and lower infeed table as far down as it will go.
4. Remove belt guard to expose cutterhead pulley.
5. Rotate pulley as needed to make inserts accessible for removal or rotation.
6. Remove any sawdust from head of carbide insert Torx screw.
7. Put on work gloves to protect fingers and hands.
8. Remove Torx screw and indexable insert (see **Figure 58**).

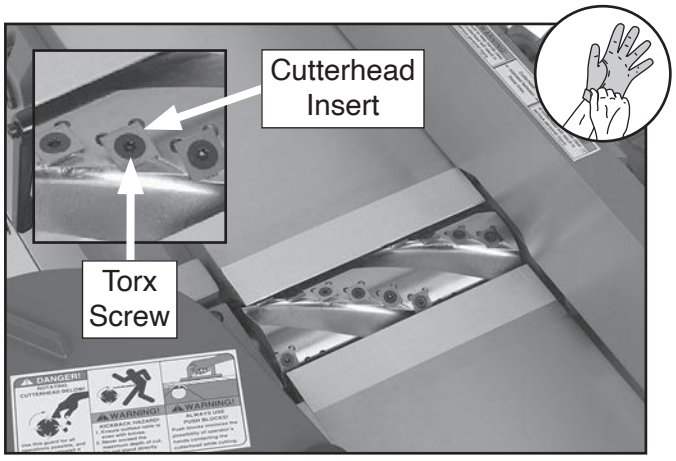


Figure 58. Example of cutterhead inserts and Torx screws.

9. Clean all dust and dirt off insert and cutterhead pocket from which insert was removed, and replace insert so a fresh, sharp edge is facing outward.

   — If all four insert cutting edges have been used, replace insert with a new one. Always position reference dot in same position when installing a new insert to aid in rotational sequencing.

   Note: *Proper cleaning is critical to achieving a smooth finish. Dirt or dust trapped between insert and cutterhead will slightly raise insert, and make noticeable marks on your workpieces the next time you cut.*

10. Lubricate Torx screw threads with a light machine oil, wipe excess oil off threads, and torque Torx screw to 48–50 inch pounds.

    Note: *Excess oil may squeeze between insert and cutterhead or in screw hole, thereby lifting insert or screw slightly and affecting workpiece finishes.*

11. Install belt guard and raise infeed table.

12. Install cutterhead guard back over cutterhead, making sure that spring tension in guard is properly set so guard springs back over cutterhead when it is pulled back and released, as shown in **Checking/Adjusting Cutterhead Guard** on **Page 39**.

Checking/Adjusting Table Parallelism

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

Tools Needed	Qty
Straightedge 4'	1
Hex Wrench 4mm	1
Hammer	As Needed
Center Punch	As Needed

Checking Outfeed Table

1. DISCONNECT MACHINE FROM POWER!

2. Remove cutterhead guard, fence, and rear cabinet panel.

3. Loosen outfeed table lock, and loosen jam nuts and positive stop bolts located on the rear of machine just behind outfeed table (see **Figure 59**).

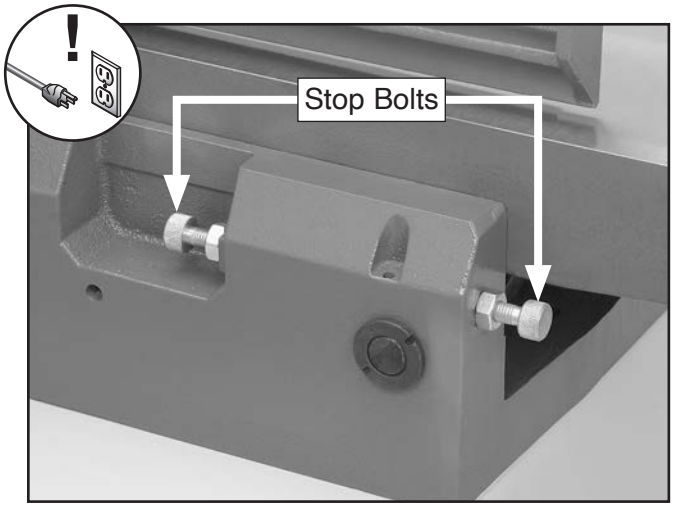


Figure 59. Outfeed table positive stop bolts.

4. Rotate motor pulley so that you can access cutterhead body with straightedge between insert rows (see **Figure 60**).

5. Place straightedge on outfeed table so it hangs over cutterhead, then lower outfeed table until straightedge just touches cutterhead body (see **Figure 60**).

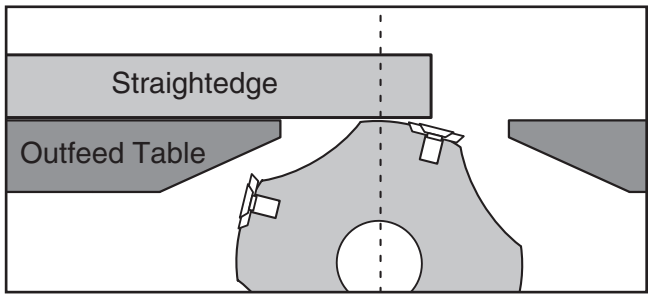


Figure 60. Adjusting outfeed table even with cutterhead body.

6. Place straightedge in positions shown in **Figure 61**. In each position, straightedge should touch cutterhead and sit flat on outfeed table.

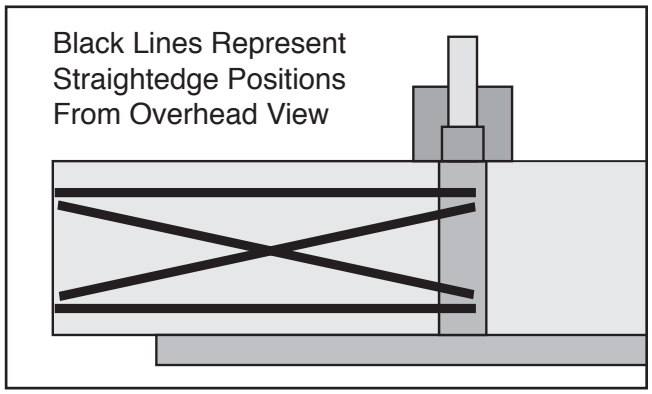


Figure 61. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

— If straightedge touches cutterhead body and sits flat across outfeed table in each position, then outfeed table is already parallel with cutterhead. Follow **Checking Infeed Table** instructions on this page.

— If straightedge *does not* touch cutterhead and sit flat on outfeed table in any of the positions, then outfeed table is not parallel with cutterhead. Perform **Adjusting Table Parallelism** procedure on **Page 46**.

Checking Infeed Table

1. Follow all steps in **Checking Outfeed Table** on **Page 44** to first make sure that outfeed table is parallel with cutterhead.

2. Set outfeed table height (see **Setting Outfeed Table Height** on **Page 48**).

3. Rotate cutterhead so inserts will not interfere, then place straightedge across infeed/outfeed tables and adjust infeed table even with outfeed table (see **Figure 62**).

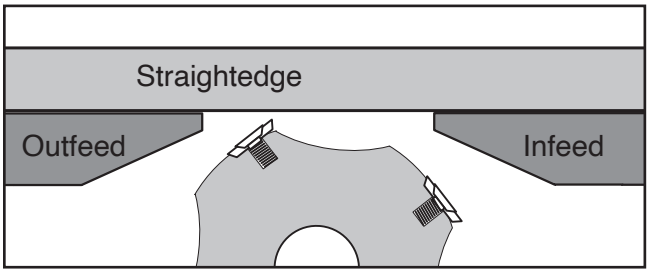


Figure 62. Infeed and outfeed tables set evenly.

4. Place straightedge in positions shown in **Figure 63**. In each position, the straightedge should sit flat against both outfeed table and infeed table.

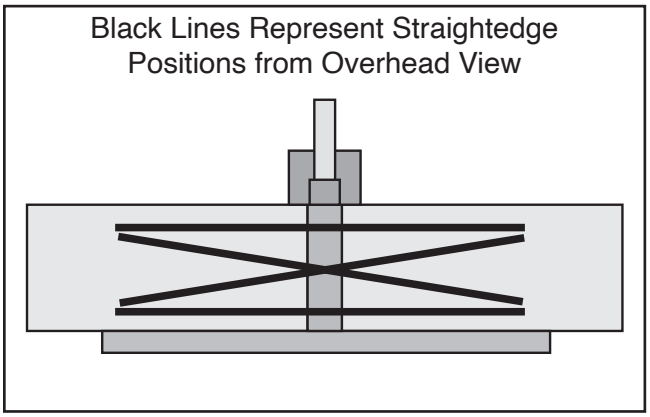


Figure 63. Straightedge positions for checking infeed/outfeed table parallelism.

— If straightedge sits flat against both infeed and outfeed tables, then tables are parallel. Install cutterhead guard, fence, and rear cabinet panel.

— If straightedge *does not* sit flat against both infeed and outfeed tables in any of positions, proceed to **Adjusting Table Parallelism** on **Page 46**.

Adjusting Table Parallelism

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

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

The tables have four eccentric bushings under each corner that allow the tables to be adjusted parallel. These eccentric bushings are locked in place by set screws and adjust when rotated.

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

When setting the outfeed table, all measurements must be made from the cutterhead body—NOT the inserts.

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

To adjust table parallelism:

1. Place straightedge on outfeed table so it hangs over cutterhead, and lower outfeed table until straightedge just touches cutterhead body (see **Figure 64**).

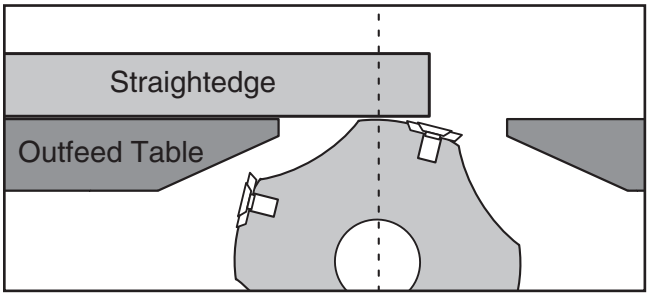


Figure 64. Adjusting outfeed table even with cutterhead body.

2. Remove top set screw from (4) eccentric bushings under outfeed table, and loosen set screws underneath removed set screws (see **Figure 65**).

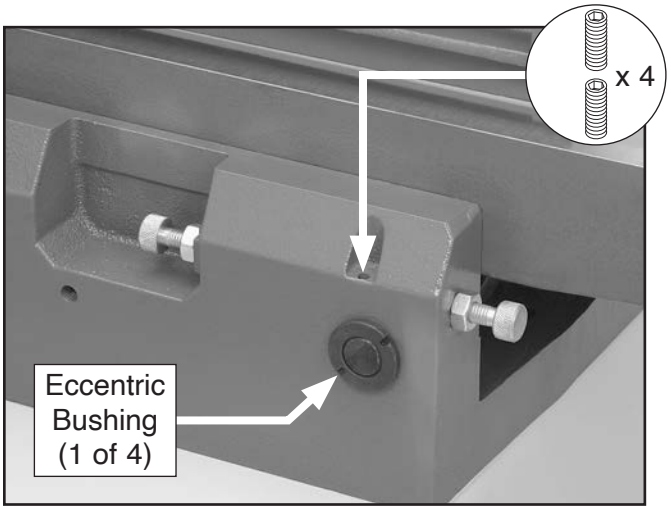


Figure 65. Eccentric bushing and set screw location.

3. Place straightedge in one of the positions shown in **Figure 66**, and adjust table by turning eccentric bushings as needed so that straightedge touches cutterhead while lying flat across outfeed table. Repeat this step with each remaining straightedge position as many times as necessary until outfeed table is parallel with cutterhead to within 0.010"–0.012".

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

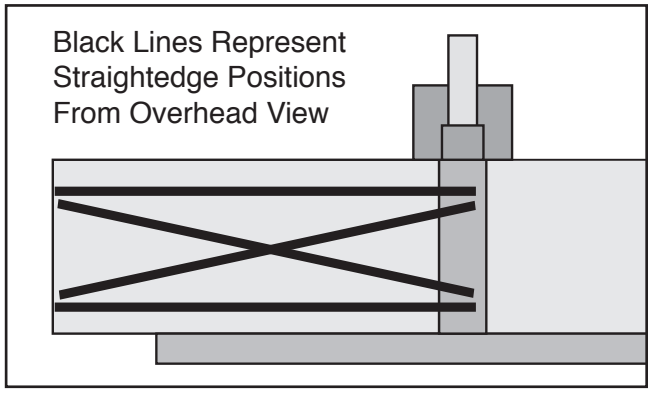


Figure 66. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

4. Repeat **Step 3** with each remaining straightedge position as many times as necessary until outfeed table is parallel with cutterhead.

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

6. Remove set screw from each of the (4) eccentric bushings under infeed table, and loosen set screws underneath those removed set screws.

7. Rotate cutterhead so inserts will not interfere, then place straightedge across infeed/outfeed tables and adjust infeed table even with outfeed table (see **Figure 67**).

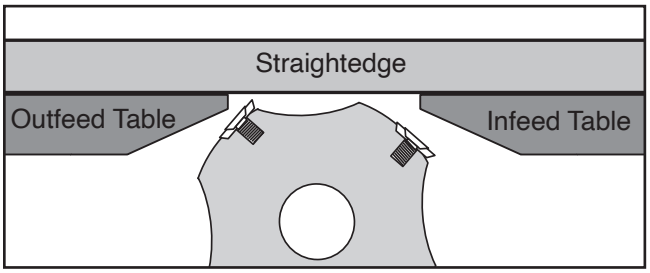


Figure 67. Infeed and outfeed tables set evenly.

8. Place straightedge in one of the positions shown in **Figure 68**, and adjust eccentric bushings under infeed table so straightedge lies flat against both tables.

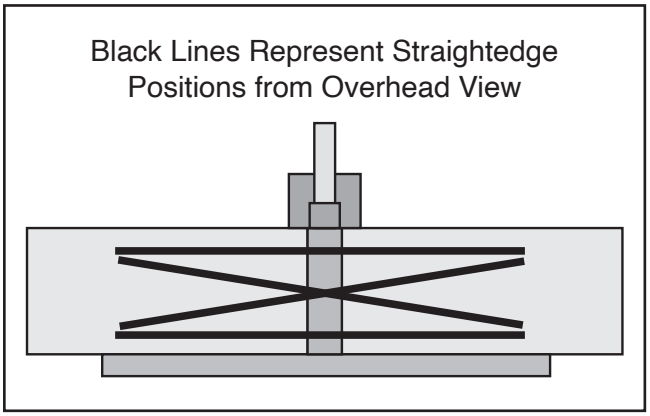


Figure 68. Straightedge positions for checking infeed/outfeed table parallelism.

9. Repeat **Step 8** with each remaining straightedge position as many times as necessary until infeed table is parallel with outfeed table.

10. Tighten/install set screws in eccentric bushings on infeed table.

11. Perform **Setting Outfeed Table Height** on **Page 48**.

Setting Outfeed Table Height

To help ensure safe operation and the best cutting results, set the outfeed table height level with the inserts when they are at top-dead-center (TDC). If the outfeed table is set too low, the workpiece will be tapered from front to back or there will be snipe (a gouge in the end of the board that is uneven with the rest of the cut). If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

Tools Needed	**Qty**
Straightedge 4'	1
Open-End Wrench 17mm	1
Hex Wrenches 3, 4, 8mm	1
Phillips Head Screwdriver #2	1
Pliers	1

To set outfeed table height:

1. DISCONNECT MACHINE FROM POWER!

2. Remove cutterhead guard, fence, and rear cabinet panel.

3. Loosen outfeed table lock, then loosen jam nuts and positive stop bolts located at rear of machine just behind outfeed table (see **Figure 69**).

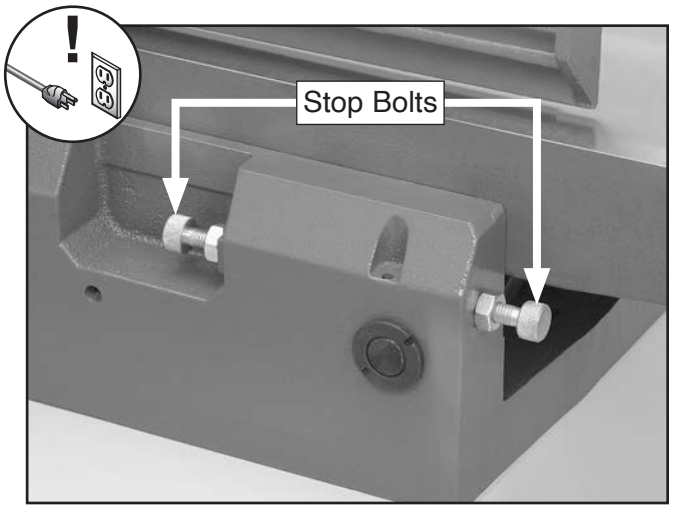


Figure 69. Outfeed table positive stop bolts.

4. Place straightedge on outfeed table so it hangs over cutterhead, then use motor pulley to rotate cutterhead until one insert is at TDC (its highest point during rotation), as shown in **Figures 70**–**71**.

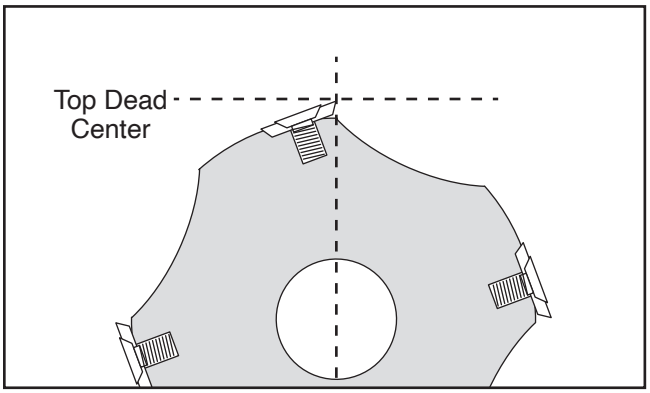


Figure 70. Cutterhead insert at TDC.

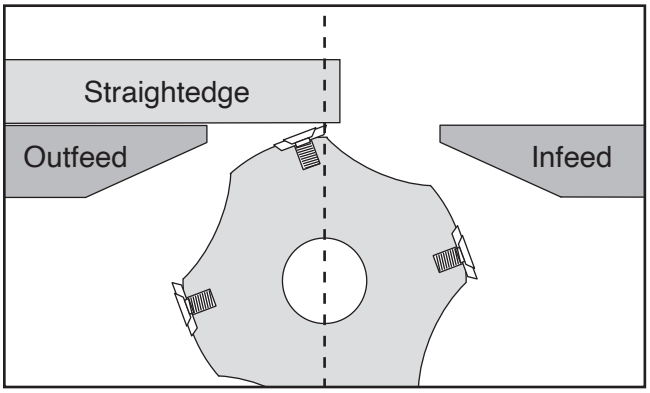


Figure 71. Using straightedge to check outfeed table height.

5. Use outfeed table adjustment lever to set outfeed table so insert barely touches straightedge, as shown in **Figure 71**.

6. Tighten outfeed table lock so outfeed table will not move during operation.

7. Tighten positive stop bolts, then jam nuts.

8. Install cutterhead guard, fence, and rear cabinet panel.

Adjusting Infeed Table Stop Bolts

The infeed table on the Model G0604Z has positive stop bolts that, when properly set up, allow the operator to quickly adjust the infeed table between finish/final cuts and shaping/heavy cuts.

\We recommend setting the minimum depth of cut to 1/32" and the maximum depth of cut to 1/8" for most operations.

⚠WARNING

DO NOT exceed 1/8" cut per pass on this machine or the risk of kickback and serious injury will be greatly increased!

Each positive stop bolt controls top or bottom range of table movement (see **Figure 72**). Jam nuts lock positive stop bolts in position so they will not move during operation.

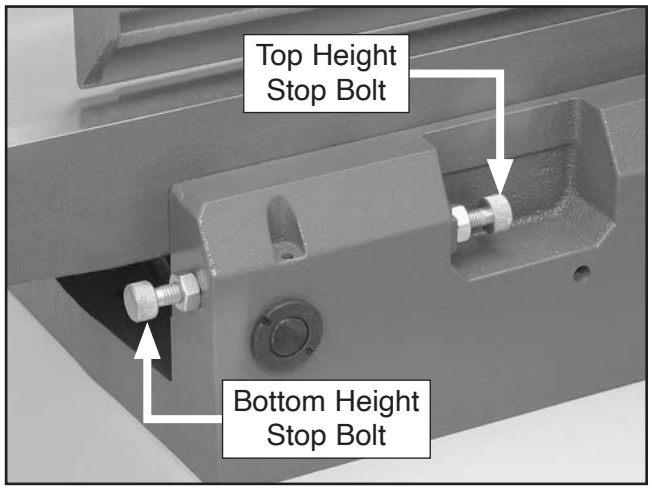


Figure 72. Positive stop bolts for infeed table.

Tools Needed	Qty
Open-End Wrench 17mm	1
Slip-Joint Pliers	1

Calibrating Depth Scale

The depth scale can be calibrated or "zeroed" to make sure the cutting depth shown on the scale matches the actual cutting depth (per pass).

Tools Needed	Qty
Straightedge 4'	1
Hex Wrench 2.5mm	1

To calibrate depth scale:

1. DISCONNECT MACHINE FROM POWER!

2. Set outfeed table height (see **Setting Outfeed Table Height** on **Page 48**).

3. Rotate cutterhead until insert is no longer at TDC, extend straightedge over both tables, then raise infeed table even with outfeed table, as shown in **Figure 73**.

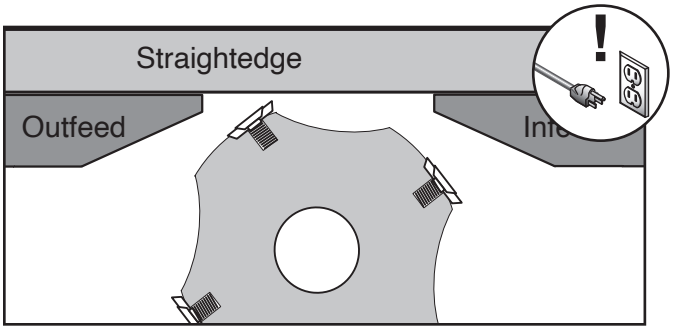


Figure 73. Infeed table even with outfeed table.

4. Loosen flat head cap screw on depth scale pointer, adjust scale pointer to zero, then secure (see **Figure 74**).

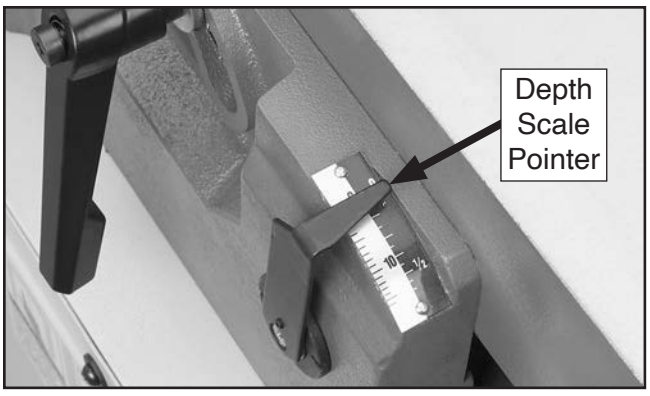


Figure 74. Depth scale pointer adjusted to zero.

Setting Fence Stops

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

Tools Needed	Qty
Square 45º, 90°	1 Ea.
Phillips Head Screwdriver #2	1
Sliding Bevel	1
Open-End Wrenches 10mm	2
Hex Wrench 4mm	1

Setting 45° Fence Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock knob and tilt fence approximately 45° onto stop bolt, then place 45° square against fence and table (see **Figure 75**).

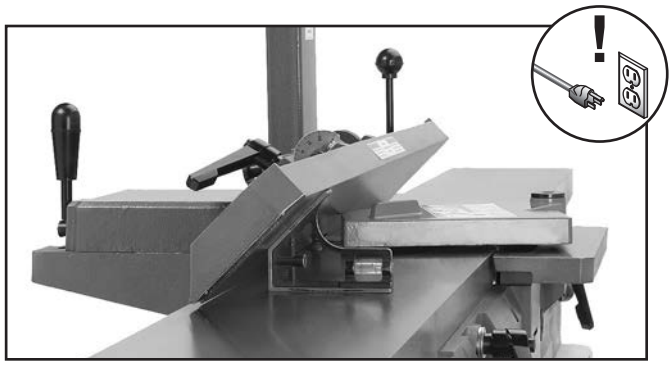


Figure 75. Fence adjusted 45˚.

3. Loosen jam nut on 45° positive stop bolt shown in **Figure 76**.

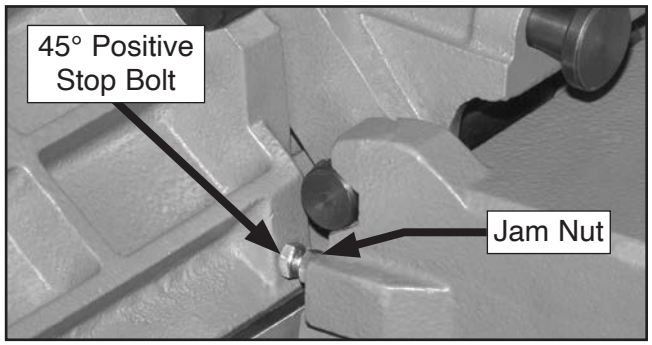


Figure 76. 45° positive stop bolt location.

4. Adjust stop bolt until fence is exactly 45° while resting on bolt (verify angle with 45° square), then tighten jam nut loosened in **Step 3**.

Setting 90° Fence Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen set screw in plunger lock collar, then loosen fence tilt lock (see **Figure 77**).

3. Using a 90° square, adjust fence to 90° position, then tighten set screw in plunger lock collar.

4. If required, loosen Phillips head screw on fence tilt scale, adjust fence tilt scale indicator to 0°, then secure (see **Figure 77**).

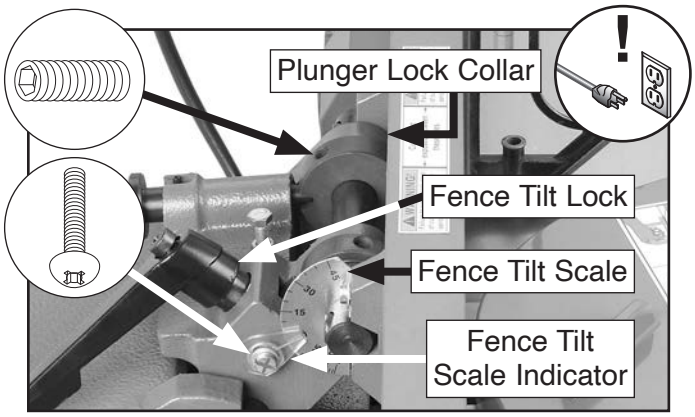


Figure 77. Adjusting fence to 90˚.

Setting 135° Fence Stop

1. DISCONNECT MACHINE FROM POWER!

2. Loosen fence tilt lock, and position fence against 135° stop bolt.

3. Loosen jam nut on 135˚ positive stop bolt (see **Figure 78**).

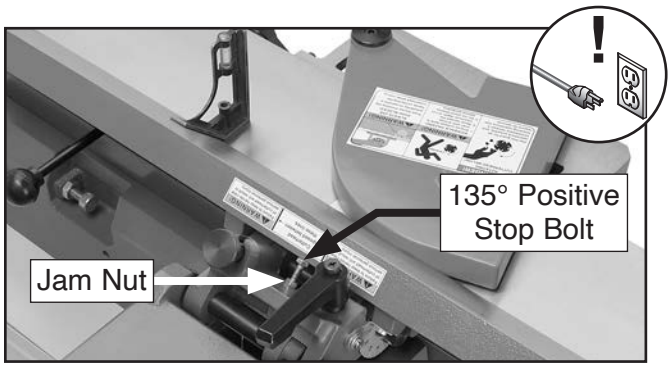


Figure 78. Adjusting fence 135˚.

4. Adjust 135˚ positive stop bolt until fence is 135° while resting on bolt (check angle with a 45º square set to 135°), then tighten jam nut loosened in **Step 3**.

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 aftermarket 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.

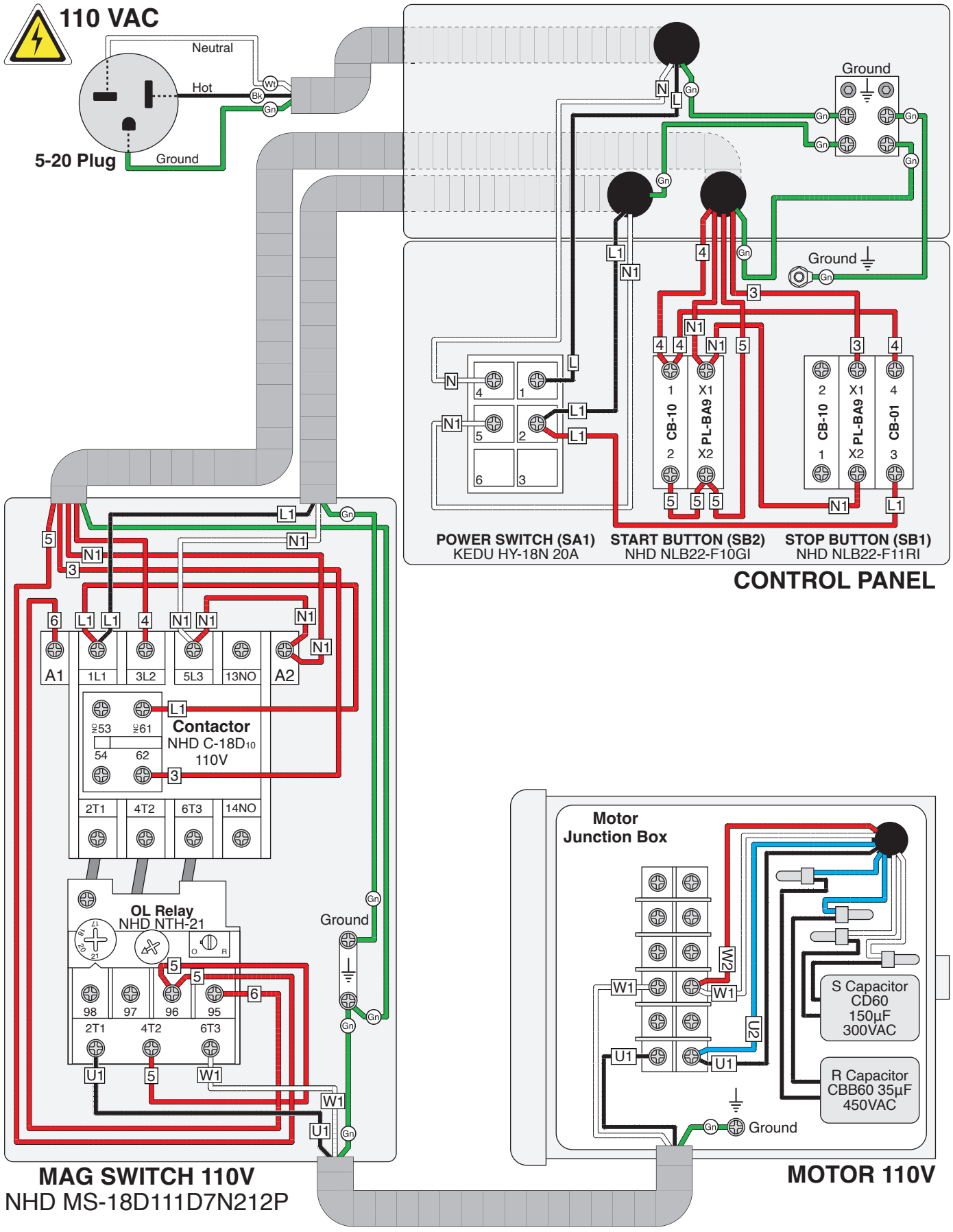
NOTICE

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

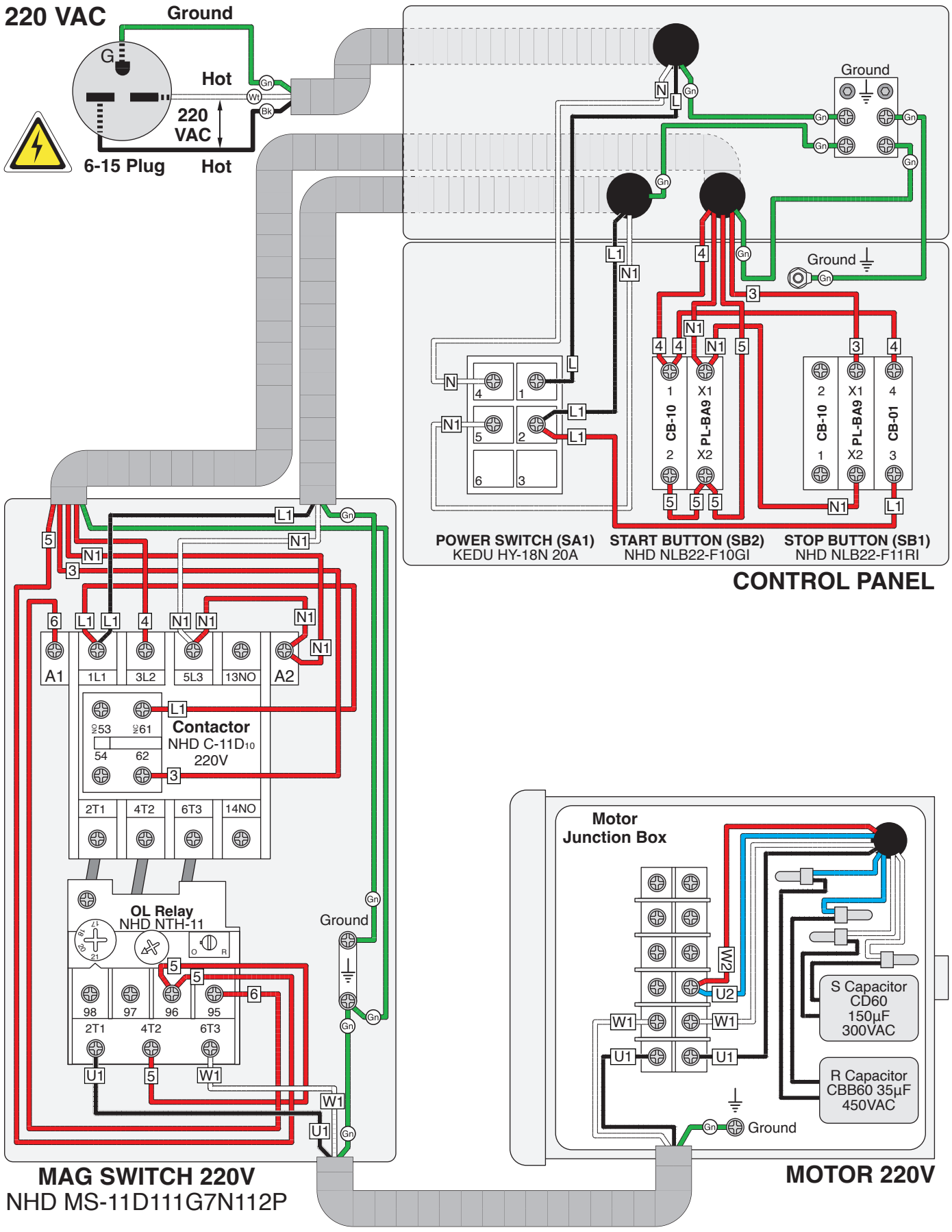
BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu		
RED	Rd	ORANGE	Or	PINK	Pk	TURQUOISE	Tu

Wiring Diagram 110V



READ ELECTRICAL SAFETY ON PAGE 51!

Wiring Diagram 220V



Electrical Components

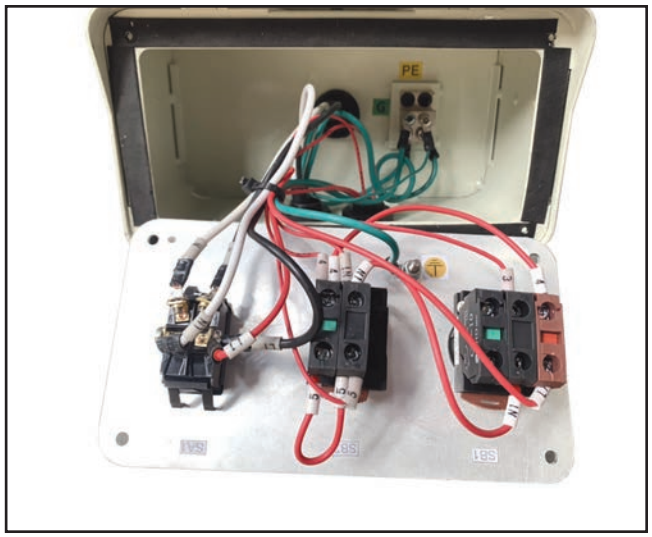


Figure 79. Control panel wiring.

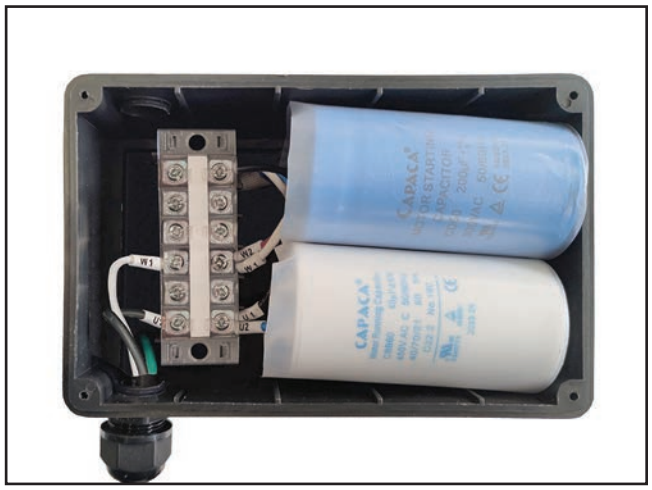


Figure 80. Motor junction box (110V).

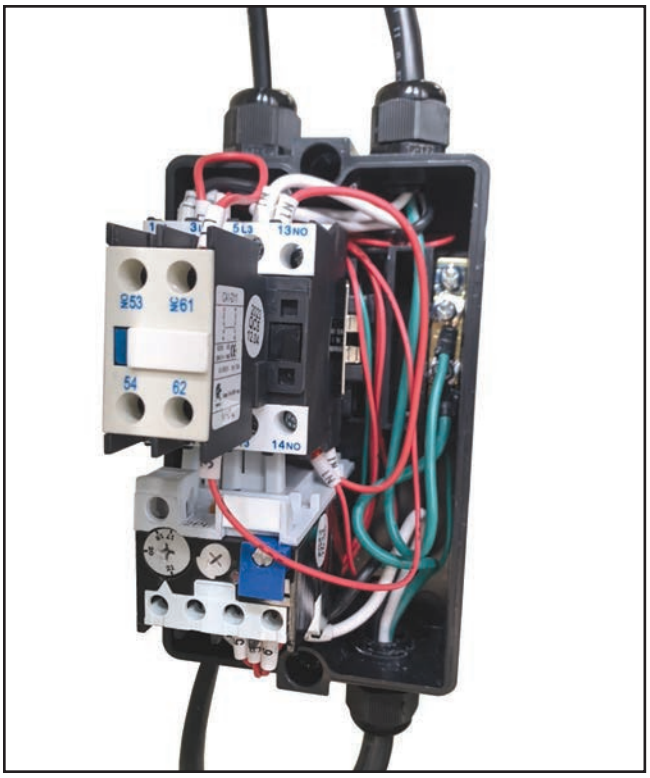
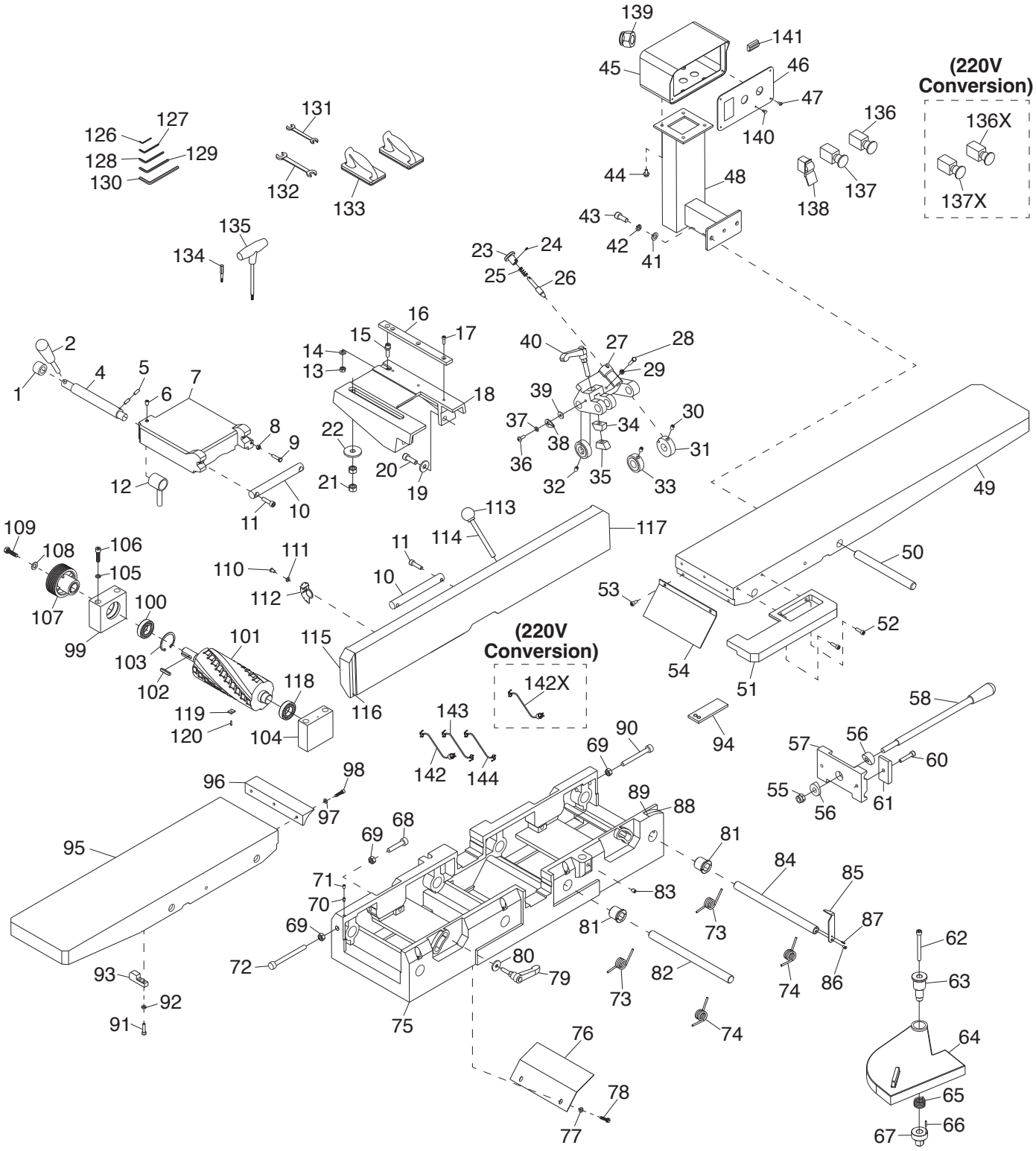


Figure 81. Magnetic switch wiring (110V).

SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call **(800) 523-4777** or visit **www.grizzly.com/parts** to check for availability.

Main



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Main Parts List

REF	PART #	DESCRIPTION
1	P0604Z001	BUSHING
2	P0604Z002	LEVER HANDLE M10-1.5 X 80, 66L
4	P0604Z004	ECCENTRIC SHAFT
5	P0604Z005	SET SCREW M6-1 X 16
6	P0604Z006	SET SCREW M8-1.25 X 12
7	P0604Z007	FENCE CARRIAGE
8	P0604Z008	HEX NUT M6-1
9	P0604Z009	HEX BOLT M6-1 X 25
10	P0604Z010	SHAFT W/HOLES
11	P0604Z011	CAP SCREW M8-1.25 X 30
12	P0604Z012	COLLAR
13	P0604Z013	HEX NUT M8-1.25
14	P0604Z014	FLAT WASHER 8MM
15	P0604Z015	ECCENTRIC SHAFT
16	P0604Z016	FENCE GIB
17	P0604Z017	CAP SCREW M5-.8 X 16
18	P0604Z018	FENCE SUPPPORT
19	P0604Z019	FLAT WASHER 10MM
20	P0604Z020	CAP SCREW M10-1.5 X 30
21	P0604Z021	HEX NUT M12-1.75
22	P0604Z022	FLAT WASHER 14 X 38 X 5MM
23	P0604Z023	INDEX PIN KNOB
24	P0604Z024	ROLL PIN 3 X 30
25	P0604Z025	COMPRESSION SPRING 1 X 10 X 24
26	P0604Z026	INDEX PIN SHAFT
27	P0604Z027	SWIVEL
28	P0604Z028	HEX BOLT M6-1 X 25
29	P0604Z029	HEX NUT M6-1
30	P0604Z030	SET SCREW M8-1.25 X 12
31	P0604Z031	LOCK COLLAR
32	P0604Z032	SET SCREW M8-1.25 X 12
33	P0604Z033	LOCK COLLAR
34	P0604Z034	CLAMP
35	P0604Z035	THREADED CLAMP
36	P0604Z036	PHLP HD SCR M6-1 X 16
37	P0604Z037	FLAT WASHER 6MM
38	P0604Z038	POINTER
39	P0604Z039	FLAT WASHER 6.5 X 16 X 3
40	P0604Z040	ADJUSTABLE HANDLE M10-1.5 X 40, 111L
41	P0604Z041	FLAT WASHER 8MM
42	P0604Z042	LOCK WASHER 8MM
43	P0604Z043	CAP SCREW M8-1.25 X 25
44	P0604Z044	FLANGE BOLT M6-1 X 12
45	P0604Z045	CONTROL PANEL BOX
46	P0604Z046	CONTROL PANEL
47	P0604Z047	PHLP HD SCR M4-.7 X 8
48	P0604Z048	CONTROL PANEL PEDESTAL
49	P0604Z049	INFEED TABLE
50	P0604Z050	TABLE SHAFT 20 X 151MM
51	P0604Z051	RABBETING TABLE
52	P0604Z052	CAP SCREW M6-1 X 20
53	P0604Z053	CAP SCREW M5-.8 X 12
54	P0604Z054	CHIP DEFLECTOR

REF	PART #	DESCRIPTION
55	P0604Z055	LOCK NUT M12-1.75
56	P0604Z056	ADJUSTABLE BLOCK
57	P0604Z057	PIVOT BRACKET
58	P0604Z058	LEVER HANDLE M12-1.75 X 25, 329L
60	P0604Z060	CAP SCREW M8-1.25 X 40
61	P0604Z061	CLAMP PLATE
62	P0604Z062	CAP SCREW M8-1.25 X 80
63	P0604Z063	GUARD CLAMP
64	P0604Z064	CUTTERHEAD GUARD
65	P0604Z065	TORSION SPRING
66	P0604Z066	ROLL PIN 3 X 16
67	P0604Z067	SPRING RETAINER
68	P0604Z068	MEDIUM ADJUSTMENT SCREW M10-1.5 X 50
69	P0604Z069	HEX NUT M10-1.5
70	P0604Z070	SET SCREW M6-1 X 10 CONE-PT
71	P0604Z071	SET SCREW M6-1 X 10
72	P0604Z072	MEDIUM ADJUSTMENT SCREW M10-1.5 X 110
73	P0604Z073	TORSION SPRING
74	P0604Z074	TORSION SPRING
75	P0604Z075	TABLE BASE
76	P0604Z076	CHIP BREAKER
77	P0604Z077	FLAT WASHER 6MM
78	P0604Z078	HEX BOLT M6-1 X 12
79	P0604Z079	ADJUSTABLE HANDLE M8-1.25 X 30, 106L
80	P0604Z080	FLAT WASHER 9 X 30 X 5MM
81	P0604Z081	ECCENTRIC BUSHING
82	P0604Z082	TABLE SHAFT 20 X 234MM
83	P0604Z083	SET SCREW M8-1.25 X 10
84	P0604Z084	TABLE SHAFT W/HOLES 20 X 234MM
85	P0604Z085	POINTER
86	P0604Z086	FLAT HD SCR M5-.8 X 10
87	P0604Z087	ROLL PIN 3 X 10
88	P0604Z088	HEIGHT SCALE
89	P0604Z089	RIVET 2 X 4 NAMEPLATE, STEEL
90	P0604Z090	MEDIUM ADJUSTMENT SCREW M10-1.5 X 90
91	P0604Z091	HEX BOLT M6-1 X 25
92	P0604Z092	LOCK WASHER 6MM
93	P0604Z093	BUMPER
94	P0604Z094	SPRING PLATE
95	P0604Z095	OUTFEED TABLE
96	P0604Z096	OUTFEED TABLE LIP
97	P0604Z097	FLAT WASHER 5MM
98	P0604Z098	CAP SCREW M5-.8 X 16
99	P0604Z099	REAR BEARING PILLOW BLOCK
100	P0604Z100	BALL BEARING 6004-2RS
101	P0604Z101	SPIRAL CUTTERHEAD 6"
102	P0604Z102	KEY 6 X 6 X 32
103	P0604Z103	INT RETAINING RING 42MM
104	P0604Z104	FRONT BEARING PILLOW BLOCK
105	P0604Z105	LOCK WASHER 8MM
106	P0604Z106	CAP SCREW M8-1.25 X 80
107	P0604Z107	CUTTERHEAD PULLEY
108	P0604Z108	CUTTERHEAD PULLEY WASHER

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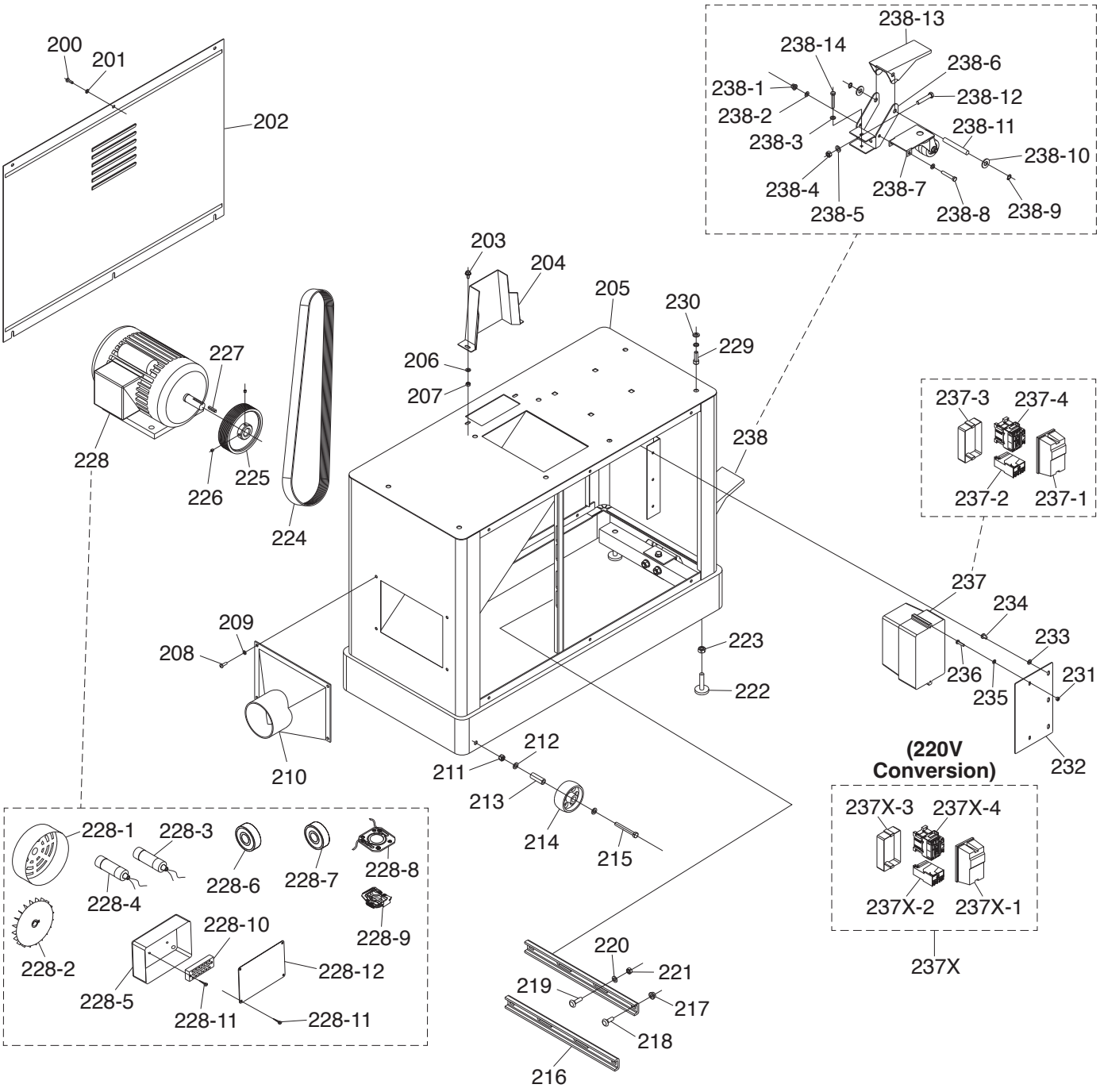
Main Parts List (Cont.)

REF	PART #	DESCRIPTION
109	P0604Z109	HEX BOLT M8-1.25 X 25
110	P0604Z110	PHLP HD SCR M6-1 X 10
111	P0604Z111	FLAT WASHER 6MM
112	P0604Z112	TILT SCALE
113	P0604Z113	KNOB M10-1.5, D32, BALL
114	P0604Z114	STUD-UDE M10-1.5 X 130, 15, 18
115	P0604Z115	SCALE
116	P0604Z116	RIVET 2 X 4 NAMEPLATE, STEEL
117	P0604Z117	FENCE
118	P0604Z118	BALL BEARING 6004-2RS
119	P0604Z119	INDEXABLE INSERT 14 X 14 X 2
120	P0604Z120	FLAT HD TORX T20 M6-1 X 12
126	P0604Z126	HEX WRENCH 2.5MM
127	P0604Z127	HEX WRENCH 4MM
128	P0604Z128	HEX WRENCH 5MM
129	P0604Z129	HEX WRENCH 6MM
130	P0604Z130	HEX WRENCH 8MM

REF	PART #	DESCRIPTION
131	P0604Z131	WRENCH 8 X 10MM OPEN-ENDS
132	P0604Z132	WRENCH 12 X 14MM OPEN-ENDS
133	P0604Z133	PUSH BLOCK
134	P0604Z134	DRIVER BIT TORX T20
135	P0604Z135	T-HANDLE TORX T20
136	P0604Z136	STOP BUTTON NHD NLB22-F10GI AC110V RED
136X	P0604Z136X	STOP BUTTON NHD NLB22-F10GI AC220V RED
137	P0604Z137	START BUTTON NHD NLB22-F10GI AC110V GRN
137X	P0604Z137X	START BUTTON NHD NLB22-F10GI AC220V GRN
138	P0604Z138	PADDLE SWITCH KEDU HY18
139	P0604Z139	STRAIN RELIEF TYPE 3 M20-2.5 X 1.5
140	P0604Z140	CARRIAGE BOLT M4-.7 X 20
141	P0604Z141	GROUND PLATE
142	P0604Z142	POWER CORD 14G 3W 98" 5-20P
142X	P0604Z142X	POWER CORD 16G 3W 98" 6-15P
143	P0604Z143	MOTOR CORD 14G 3W 31"
144	P0604Z144	CONTROL PANEL CORD 18G 5W 94"

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Cabinet



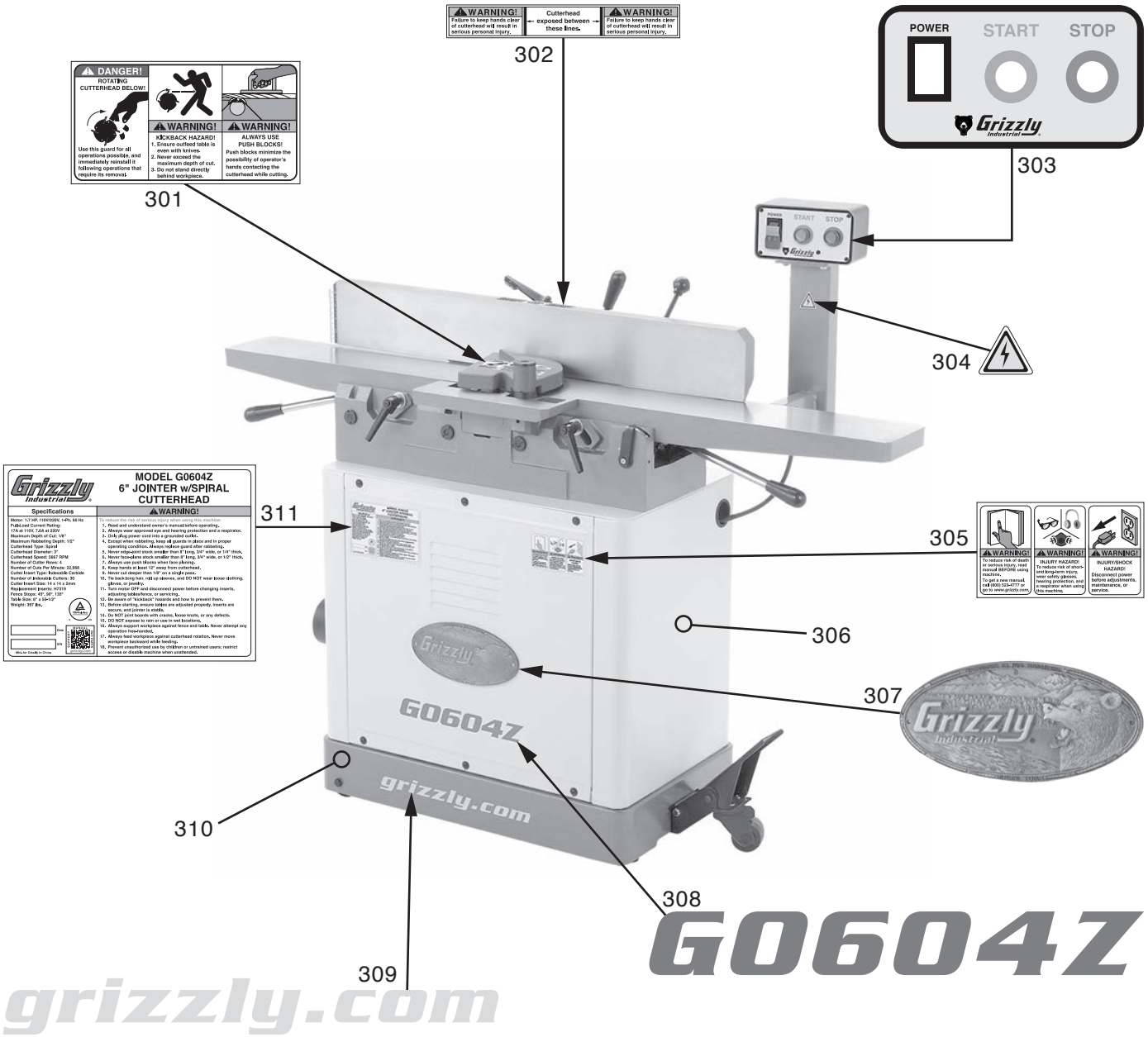
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Cabinet Parts List

REF	PART #	DESCRIPTION
200	P0604Z200	PHLP HD SCR M5-.8 X 16
201	P0604Z201	FLAT WASHER 5MM
202	P0604Z202	REAR PANEL
203	P0604Z203	FLANGE SCREW M6-1 X 12
204	P0604Z204	BELT GUARD
205	P0604Z205	CABINET
206	P0604Z206	FLAT WASHER 6MM
207	P0604Z207	HEX NUT M6-1
208	P0604Z208	PHLP HD SCR M5-.8 X 16
209	P0604Z209	FLAT WASHER 5MM
210	P0604Z210	DUST CHUTE 4"
211	P0604Z211	HEX NUT M8-1.25
212	P0604Z212	FLAT WASHER 8MM
213	P0604Z213	SLEEVE
214	P0604Z214	WHEEL 13 X 76 X 30MM
215	P0604Z215	HEX BOLT M8-1.25 X 65
216	P0604Z216	MOTOR BRACKET
217	P0604Z217	FLANGE NUT M8-1.25
218	P0604Z218	CARRIAGE BOLT M8-1.25 X 25
219	P0604Z219	CARRIAGE BOLT M8-1.25 X 30
220	P0604Z220	FLAT WASHER 8MM
221	P0604Z221	HEX NUT M8-1.25
222	P0604Z222	ADJUSTABLE FOOT M10-1.5 X 45
223	P0604Z223	HEX NUT M10-1.5
224	P0604Z224	POLY V-BELT A1120LI
225	P0604Z225	MOTOR PULLEY
226	P0604Z226	SET SCREW M6-1 X 6
227	P0604Z227	KEY 6 X 6 X 25
228	P0604Z228	MOTOR 1HP 110/220V 1-PH
228-1	P0604Z228-1	MOTOR FAN COVER
228-2	P0604Z228-2	MOTOR FAN
228-3	P0604Z228-3	S CAPACITOR 150M 300V 2 X 3-1/2
228-4	P0604Z228-4	R CAPACITOR 35M 450V 1-3/4 X 3-5/8
228-5	P0604Z228-5	JUNCTION BOX
228-6	P0604Z228-6	BALL BEARING 6024-2RS FRONT
228-7	P0604Z228-7	BALL BEARING 6023-2RS REAR
228-8	P0604Z228-8	CENTRIFUGAL SWITCH CONTACT
228-9	P0604Z228-9	CENTRIFUGAL SWITCH
228-10	P0604Z228-10	TERMINAL BAR 6P
228-11	P0604Z228-11	TAP SCREW M4 X 16
228-12	P0604Z228-12	JUNCTION BOX COVER
229	P0604Z229	CAP SCREW M8-1.25 X 25
230	P0604Z230	FLAT WASHER 8MM
231	P0604Z231	HEX NUT M5-.8
232	P0604Z232	SWITCH MOUNTING PLATE
233	P0604Z233	FLAT WASHER 6MM
234	P0604Z234	PHLP HD SCR M6-1 X 10
235	P0604Z235	FLAT WASHER 5MM
236	P0604Z236	PHLP HD SCR M5-.8 X 12
237	P0604Z237	MAG SWITCH ASSY 110V
237-1	P0604Z237-1	FRONT MAG SWITCH COVER
237-2	P0604Z237-2	OL RELAY NHD NTH-21 17-21A
237-3	P0604Z237-3	REAR MAG SWITCH COVER
237-4	P0604Z237-4	CONTACTOR NHD NTH C-18D +CA1-D11
237X	P0604Z237X	MAG SWITCH ASSY 220V
237X-1	P0604Z237X-1	FRONT MAG SWITCH COVER
237X-2	P0604Z237X-2	OL RELAY NHD NTH-11 8-11A
237X-3	P0604Z237X-3	REAR MAG SWITCH COVER
237X-4	P0604Z237X-4	CONTACTOR NHD NTH C-11D +CA1-D11
238	P0604Z238	PEDAL ASSEMBLY
238-1	P0604Z238-1	HEX NUT M8-1.25
238-2	P0604Z238-2	FLAT WASHER 8MM
238-3	P0604Z238-3	FLAT WASHER 8MM
238-4	P0604Z238-4	HEX NUT M10-1.5
238-5	P0604Z238-5	FLAT WASHER 10MM
238-6	P0604Z238-6	PEDAL BRACKET
238-7	P0604Z238-7	TROLLEY BRACKET
238-8	P0604Z238-8	HEX BOLT M8-1.25 X 100
238-9	P0604Z238-9	EXT RETAINING RING 13MM
238-10	P0604Z238-10	FLAT WASHER 14 X 30 X 3
238-11	P0604Z238-11	CAPTIVE PIN
238-12	P0604Z238-12	HEX BOLT M10-1.5 X 55
238-13	P0604Z238-13	PEDAL
238-14	P0604Z238-14	HEX BOLT M8-1.25 X 50

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Labels & Cosmetics



REF	PART #	DESCRIPTION
301	P0604Z301	CUTTERHEAD GUARD LABEL
302	P0604Z302	FENCE/CUTTERHEAD LABEL
303	P0604Z303	CONTROL PANEL FACE LABEL
304	P0604Z304	ELECTRICITY LABEL
305	P0604Z305	COMBO WARNING LABEL
306	P0604Z306	TOUCH UP PAINT, GRIZZLY BEIGE

REF	PART #	DESCRIPTION
307	P0604Z307	GRIZZLY NAMEPLATE - SMALL
308	P0604Z308	MODEL NUMBER LABEL
309	P0604Z309	GRIZZLY.COM LABEL
310	P0604Z310	TOUCH UP PAINT, GRIZZLY GREEN
311	P0604Z311	MACHINE ID LABEL

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Please feel free to write or call us if you have any questions about the machine or the manual.

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