Grizzly Industrial, Inc.®

MODEL G0633/G0634
JOINTER/PLANER
COMBINATION MACHINE
OWNER'S MANUAL

#BL8977 PRINTED IN TAIWAN

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

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

The owner of this machine/equipment 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, blade/cutter 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

Foreword

We are proud to offer the Model G0633/G0634 Jointer/Planer Combination Machine. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0633/G0634 when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

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

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

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

MACHINE DATA SHEET

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

MODEL G0633
JOINTER/PLANER COMBINATION MACHINE

Product Dimensions:

Weight	672 lbs.
Length/Width/Height	41-1/4 x 59-5/8 x 45 in.
Foot Print (Length/Width)	19-1/2 x 26 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	767 lbs.
Length/Width/Height	34-1/4 x 62-1/2 x 44-3/8 in.

Electrical:

Switch	Magnetic with Thermal Overload Protection
Switch Voltage	220V
Cord Length	10 ft.
Cord Gauge	12 gauge
Recommended Breaker Size	30 amp
Plug	No

Motors:

Main

Type	TEFC Capacitor Start Induction
Horsepower	5 HP
Voltage	220V
Phase	Single
Amps	25A
Speed	3450 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Twin V-Belts
Bearings	Shielded and Lubricated

Main Specifications:

Fence Information

Fence Length	39-3/8 in.
Fence Height	5-7/8 in.
Fence Stops	45 and 90 deg.

Cutting Capacities (Jointer)

Bevel Jointing	0-45 deg.
Maximum Width of Cut	12 in.
Maximum Depth of Cut	1/8 in.
Number of Cuts Per Minute	15102
Minimum Stock Length	5-5/8 in.

Cutting Capacities (Planer)

Maximum Width of Cut	12 in.
Maximum Depth of Cut Planing Full Width	1/8 in.
Maximum Depth of Cut Planing 6" Wide Board	5/32 in.
Number of Cuts Per Minute	15102
Number of Cuts Per Inch	57
Feed Speeds	22 FPM
Minimum Stock Length	5-5/8 in.
Maximum Stock Thickness	8 in.

Knife Information (Jointer)

Number of Knives	3
Knife Type	HSS
Knife Length.	12 in.
Knife Width.	1 in.
Knife Thickness.	1/8 in.
Knife Adjustment.	Springs and Jack Screws

Cutterhead Information

Cutterhead Type	3 HSS Knives
Cutterhead Diameter	3-1/8 in.
Cutterhead Speed	5034 RPM

Table Information (Jointer)

Table Length	59-1/2 in.
Table Width	14 in.
Floor To Table Height	35-1/2 in.

Table Information (Planer)

Table Length	23-1/8 in.
Table Width	12-1/4 in.
Table Thickness	1-5/8 in.
Floor To Table Height	32-1/2 in.

Construction

Body Assembly Construction	Cast Iron
Cutterhead Assembly Construction	Steel
Infeed Roller Construction	Steel
Outfeed Roller Construction	Steel
Stand Construction	Heavy Gauge Sheet Metal
Table Construction	Cast Iron
Paint.	Powder Coated

Other Infomation

Dust Port Size	4 in.
Number of Dust Ports	2
Measurement Scale (Jointer)	Inch
Measurement Scale (Planer)	Inch/Metric

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label on Front of the Stand

Features:

Quick Release Fence
Flip Up Tables and Change Lever Simplify Jointer-Planer Conversion
Jointer Tables Lock Into Raised Position for Planer Operation; Hand Knobs Release Tables
Cast Iron Infeed and Outfeed Tables

MACHINE DATA SHEET

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

MODEL G0634 JOINTER/PLANER COMBINATION MACHINE W/SPIRAL CUTTERHEAD

Product Dimensions:

Weight	672 lbs.
Length/Width/Height	41-1/4 x 59-5/8 x 45 in.
Foot Print (Length/Width)	19-1/2 x 26 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	767 lbs.
Length/Width/Height	34-1/4 x 62-1/2 x 44-3/8 in.

Electrical:

Switch	Magnetic with Thermal Overload Protection
Switch Voltage	220V
Cord Length	10 ft.
Cord Gauge	12 gauge
Recommended Breaker Size	30 amp
Plug	No

Motors:

Main

Type	TEFC Capacitor Start Induction
Horsepower	5 HP
Voltage	220V
Phase	Single
Amps	25A
Speed	3450 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Twin V-Belts
Bearings	Shielded and Lubricated

Main Specifications:

Fence Information

Fence Length	39-3/8 in.
Fence Height	5-7/8 in.
Fence Stops	45 and 90 deg.

Cutting Capacities (Jointer)

Bevel Jointing	0-45 deg.
Maximum Width of Cut	12 in.
Maximum Depth of Cut	1/8 in.
Number of Cuts Per Minute	20136
Minimum Stock Length	5-5/8 in.

Cutting Capacities (Planer)

Maximum Width of Cut	12 in.
Maximum Depth of Cut Planing Full Width	1/8 in.
Maximum Depth of Cut Planing 6" Wide Board	5/32 in.
Number of Cuts Per Minute	20136
Number of Cuts Per Inch	76
Feed Speeds	22 FPM
Minimum Stock Length	5-5/8 in.
Maximum Stock Thickness	8 in.

Cutterhead Information

Cutterhead Type	Spiral
Cutterhead Diameter	3-1/8 in.
Number of Cutter Spirals	4
Number of Indexable Cutters	56
Cutter Insert Type	4 Sided Indexable Carbide
Cutter Insert Length	14 mm
Cutter Insert Width	14 mm
Cutter Insert Thickness	2 mm
Cutterhead Speed	5034 RPM

Table Information (Jointer)

Table Length	59-1/2 in.
Table Width	14 in.
Floor To Table Height	35-1/2 in.

Table Information (Planer)

Table Length	23-1/8 in.
Table Width	12-1/4 in.
Table Thickness	1-5/8 in.
Floor To Table Height	32-1/2 in.

Construction

Body Assembly Construction	Cast Iron
Cutterhead Assembly Construction	Steel
Infeed Roller Construction	Steel
Outfeed Roller Construction	Steel
Stand Construction	Heavy Gauge Sheet Metal
Table Construction	Cast Iron
Paint.	Powder Coated

Other Infomation

Dust Port Size	4 in.
Number of Dust Ports	2
Measurement Scale (Jointer)	Inch
Measurement Scale (Planer)	Inch/Metric

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label on Front of the Stand

Features:

Quick Release Fence
Flip Up Tables and Change Lever Simplify Jointer-Planer Conversion
Jointer Tables Lock Into Raised Position for Planer Operation; Hand Knobs Release Tables
Cast Iron Infeed and Outfeed Tables
Dual 4" Dust Ports
Includes Knife Setting Gauge

Identification

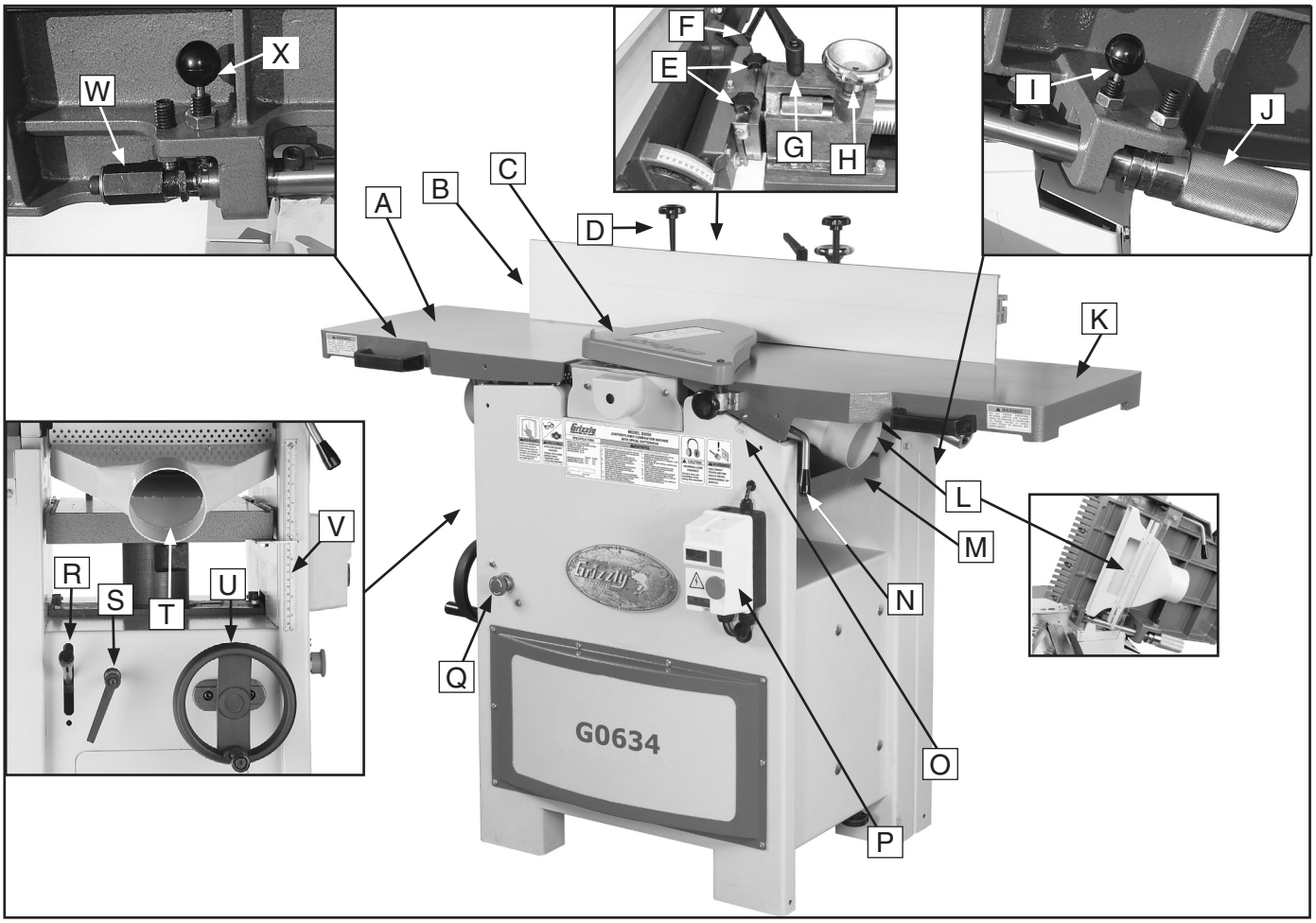


Figure 1. G0634 identification and controls.

A. Outfeed Table
B. Fence
C. Cutterhead Guard
D. Fence Height Knobs
E. Quick Release Knobs
F. Tilt Lock
G. Fence Lock Lever
H. Fence Adjustment Knob
I. Infeed Table Lock Knob
J. Infeed Handgrip
K. Infeed Table
L. Jointer Dust Port
M. Planer Table
N. Infeed Table Lock Lever
O. Jointer Depth Scale
P. Magnetic Switch
Q. Emergency Off Button
R. Change Lever
S. Planer Table Lock
T. Planer Dust Port
U. Planer Table Height Handwheel
V. Planer Table Height Scale
W Outfeed Table Adjustment Knob
X. Outfeed Table Lock Knob

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

1. **READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust can cause severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

⚠WARNING
Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.

8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.

9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power ***OFF*** and allow all moving parts to come to a complete stop before leaving machine unattended.

11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.

12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.

13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.

14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY**. Make sure switch is in OFF position before reconnecting.

15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**

17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ***ON***.

18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.

19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.

20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.

21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.

22. **DO NOT OVERREACH.** Maintain stability and balance at all times.

23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."

24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY**.

25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.

⚠WARNING
Additional Safety Instructions for Jointers

1. **JOINTER KICKBACK.** "Kickback" is when the workpiece is thrown off the jointer table by the force of the cutterhead. Always use push blocks and safety glasses to reduce the likelihood of injury from “kickback.” If you do not understand what kickback is, or how it occurs, **DO NOT** operate this machine.

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

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

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

5. **KICKBACK ZONE.** The "kickback zone" is the path directly through the end of the infeed table. Never stand or allow others to stand in this area during operation.

6. **MAXIMUM CUTTING DEPTH.** The maximum cutting depth for one pass is ⅛". Never attempt any single cut deeper than this!

7. **JOINTING WITH THE GRAIN**. Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

8. **KEEPING GUARDS IN PLACE.** With the exception of rabbeting, all operations must be performed with the cutterhead guard in place. After rabbeting, be sure to replace the guard.

9. **PROPER CUTTING.** When cutting, always keep the workpiece moving toward the outfeed table until the workpiece has passed completely over the cutterhead. Never back the work toward the infeed table.

10. **USING GOOD STOCK.** Jointing safety begins with your lumber. Inspect your stock carefully before you feed it over the cutterhead. Never joint a board that has loose knots, nails, or staples. If you have any doubts about the stability or structural integrity of your stock, DO NOT joint it!

⚠WARNING

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

⚠CAUTION

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

⚠WARNING
Additional Safety Instructions for Planers

1. **INSTRUCTION MANUAL.** This machine presents significant safety hazards to untrained users. Read/understand this entire manual before starting the planer.

2. **REACHING INSIDE PLANER.** Never reach inside planer or remove covers when the planer is connected to power.

3. **INFEED CLEARANCE SAFETY.** The infeed roller is designed to pull material into the cutterhead. Always keep hands, clothing, and long hair away from the infeed roller during operation to prevent serious injury.

4. **BODY POSITION WHILE OPERATING.** The workpiece may kick out during operation. To avoid getting hit, stand to the side of the planer during the entire operation.

5. **PLANING CORRECT MATERIAL.** Only plane natural wood stock with this planer. DO NOT plane MDF, plywood, laminates, or other synthetic products.

6. **GRAIN DIRECTION.** Planing across the grain is hard on the planer and may cause the workpiece to kick out. Always plane in the same direction or at a slight angle with the wood grain.

7. **LOOKING INSIDE PLANER.** Wood chips fly around inside the planer at a high rate of speed. DO NOT look inside the planer or remove guards/covers when the planer is connected to power or during operation.

8. **CUTTING LIMITATIONS.** The planer may kick out a workpiece at the operator or be damaged if pushed beyond these limits.
   - Maximum Depth of Cut ..... 1/8"
   - Maximum Width of Cut ..... 12"
   - Minimum Board Length..... 12"
   - Maximum Board Thickness ..... 8"

9. **CLEAN STOCK.** Only plane clean stock. Planing stock with nails, staples, or imbedded stone will damage your inserts/knives, and may cause a fire hazard if the dust collector captures sparks or hot particles that have contacted the inserts/knives. Always thoroughly inspect and prepare stock to avoid these hazards.

10. **REMOVING JAMMED WORKPIECES.** To avoid serious injury, always stop the planer and disconnect power before removing jammed workpieces.

11. **DULL/DAMAGED INSERTS/KNIVES.** The planer may kick out a workpiece at the operator or give poor finish results if it is operated with dull or damaged inserts/knives.

12. **UNPLUGGING DURING ADJUSTMENTS.** When connected to power, the planer can be accidentally turned ***ON***. Always disconnect power when servicing or adjusting the components of the planer.

13. **WORKPIECE CLEARANCE.** Always verify workpiece has enough room to exit the planer before starting.

⚠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 lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

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

SECTION 2: CIRCUIT REQUIREMENTS

220V Operation

⚠WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. DO NOT connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0633/G0634 motor draws the following amps under maximum load:

Motor Draw at 220V .....25 Amps

Circuit Requirements

We recommend connecting your machine to a dedicated and grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

220V Circuit.....30 Amps

Plug/Receptacle Type

Recommended Plug/Receptacle....NEMA L6-30

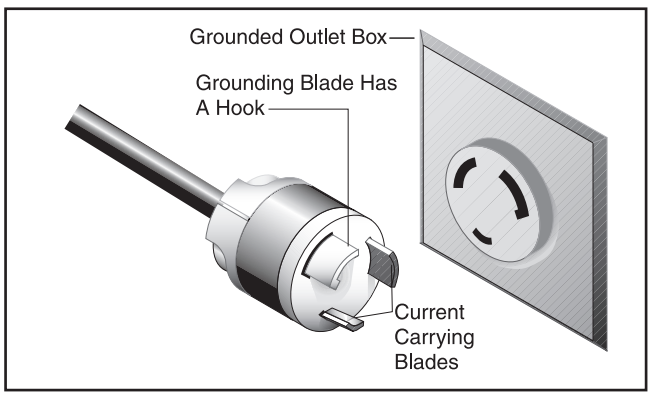
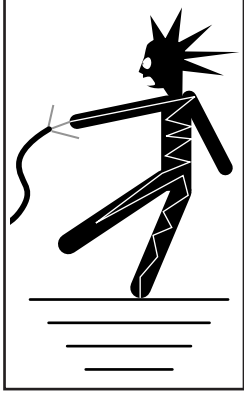


Figure 2. NEMA L6-30 plug and receptacle.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



⚠WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!

Extension Cords

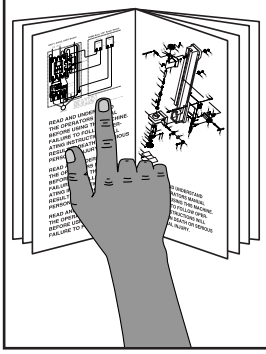
We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

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

- Use at least a 10 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician MUST size cords over 50 feet long to prevent motor damage.

SECTION 3: SET UP

Set Up Safety



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire set up process!

⚠WARNING

The Model G0633/G0634 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Setup

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

Description	Qty
• Safety Glasses (for each person)	1
• Power Lifting Equipment	1
• Lifting Straps (800 lb. Capacity, Optional)	1
• Dust Collection System	1
• 4" Dust Hose (length as needed)	1
• 4" Hose Clamp	1
• Shop Rags for Cleaning	As needed
• Solvent Cleaner	As needed

Unpacking

The Model G0633/G0634 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

Inventory

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

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Common Components (Figure 3 & 3) Qty

A. Jointer/Planer Assembly (Not shown) 1
B. Push Blocks 2
C. Cutterhead Guard Assembly 1
D. Hardware and Tools (Not Shown)
— Wrench 12/14 1
— Hex Wrench 3mm 1
— Spare Chain 1
— Extension Spring 1
— Rubber Strip for Cutterhead Guard 1

G0633 ONLY (Figure 4)

E. Knife Setting Jig Hardware
— Knife Setting Gauge Feet 2
— Knife Setting Gauge Rod 1
— E-Clips 9mm 2
F. Tools (Not Shown)
— Wrench 8/10mm 1

G0634 ONLY (Figure 5)

G. Spiral Cutterhead Hardware
— Indexable Carbide Inserts 5
— Flat Head Torx Screws M6-1 x 15 10
—Torx Drivers T20 5
—T-Handle Wrench 1/4" 1

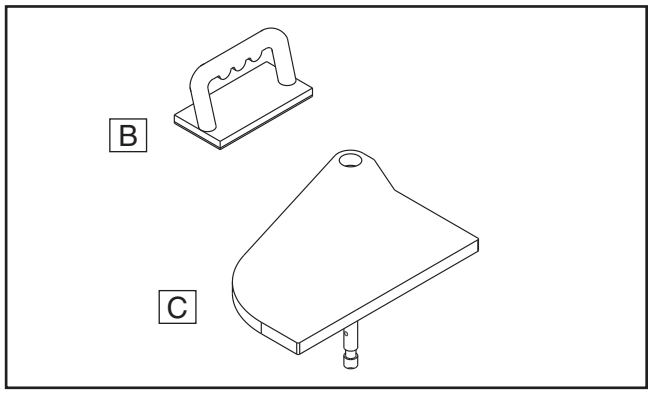


Figure 3. Common components.

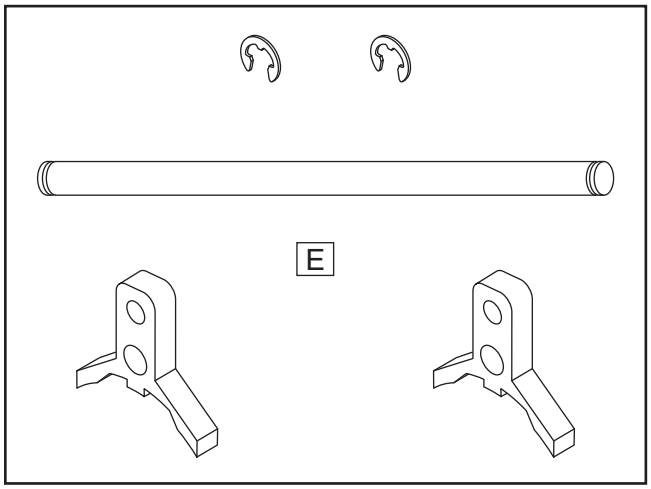


Figure 4. Knife gauge hardware.

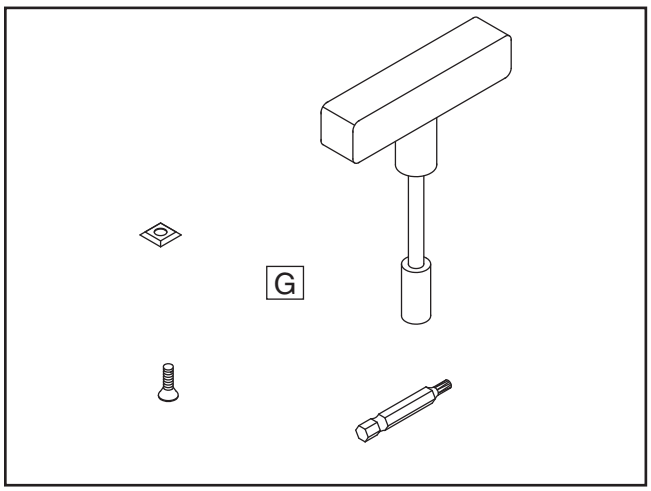
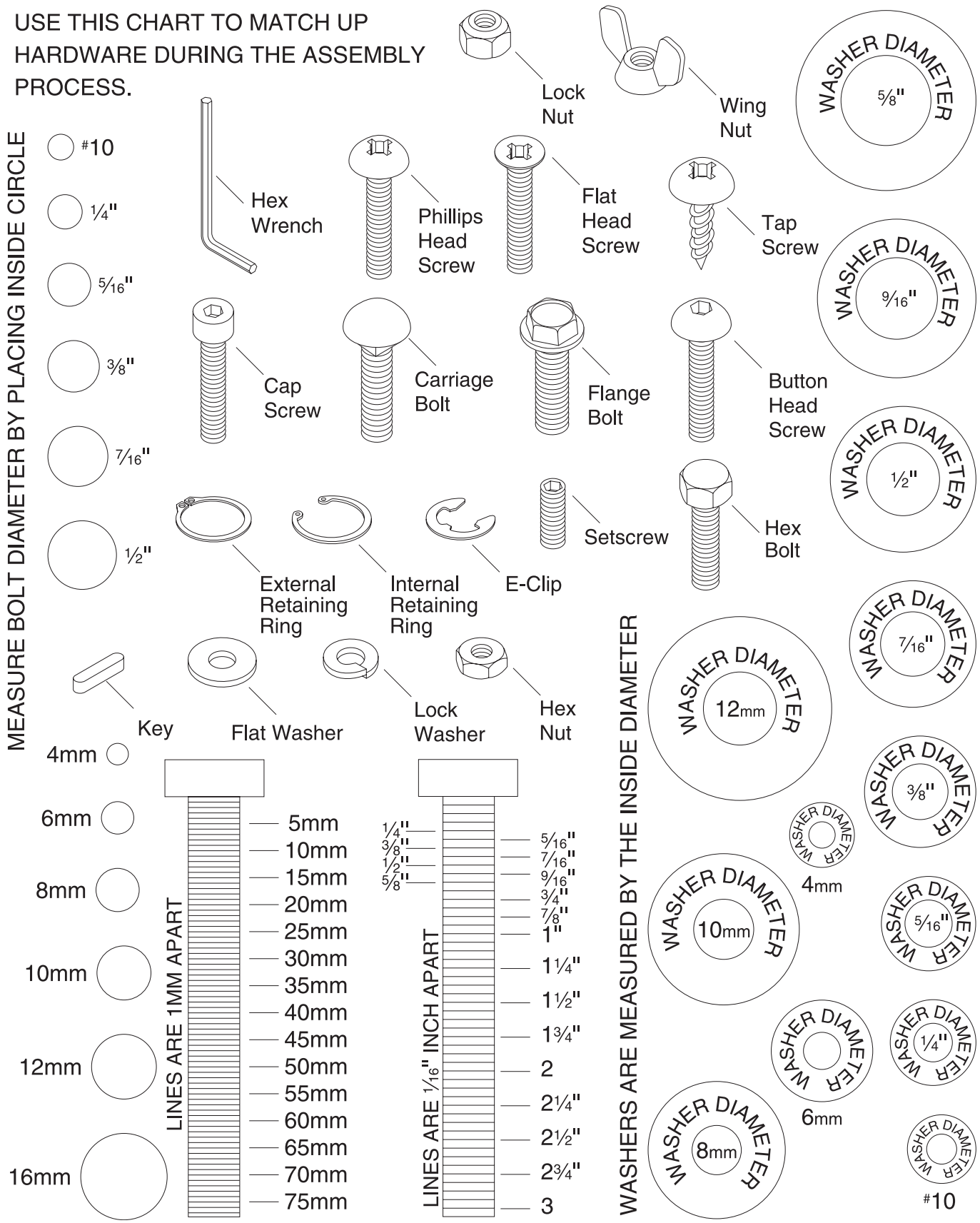


Figure 5. Spiral cutterhead hardware.

If any nonproprietary 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.

Hardware Recognition Chart

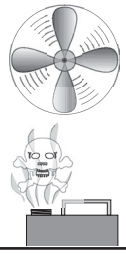


Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Citrus Degreaser. To clean thoroughly, some parts must be removed. **For optimum performance from your machine, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. DO NOT use these products to clean the machinery.



⚠CAUTION

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

G7895—Grizzly Citrus Degreaser

This natural, citrus-based degreaser is a great solution for removing export grease, and it's much safer to work around than nasty solvents.

Figure 6. Grizzly citrus degreaser.

Site Considerations

Floor Load

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

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 7** for the minimum working clearances.

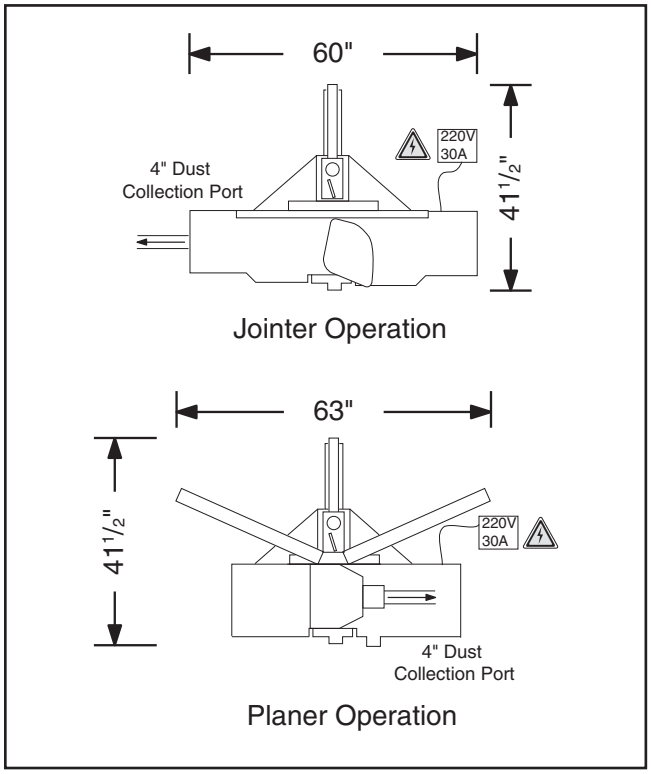
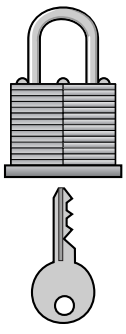


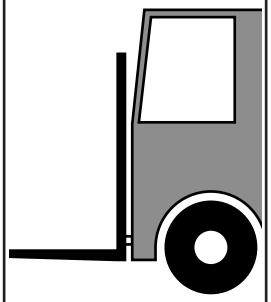
Figure 7. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.

Moving & Placing Base Unit



⚠WARNING

The Model G0633/G0634 is a heavy machine. Serious personal injury may occur if safe moving methods are not used. To be safe, get assistance and use power equipment to move the shipping crate and remove the machine from the crate.

Unbolt the jointer/planer from the pallet, and use a forklift to lift the machine off the pallet and onto a suitable location as shown in **Figure 8**. Only lift the machine enough to clear the floor.

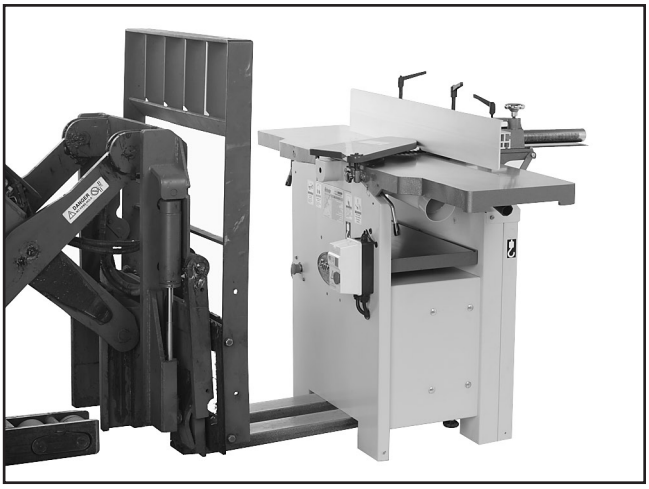


Figure 8. Lifting model G0633 with a forklift.

You can also attach hooks and lifting straps to the machine using the three lifting holes shown in **Figures 9 & 10** with a forklift, hoist, or boom crane. If you choose this alternative, you must punch out the lifting strap holes—this will permanently alter your machine.

If you are unsure how to lift this machine, consult a qualified professional.

After setting the machine in place, remove the shipping brackets on both sides (**Figure 9**).

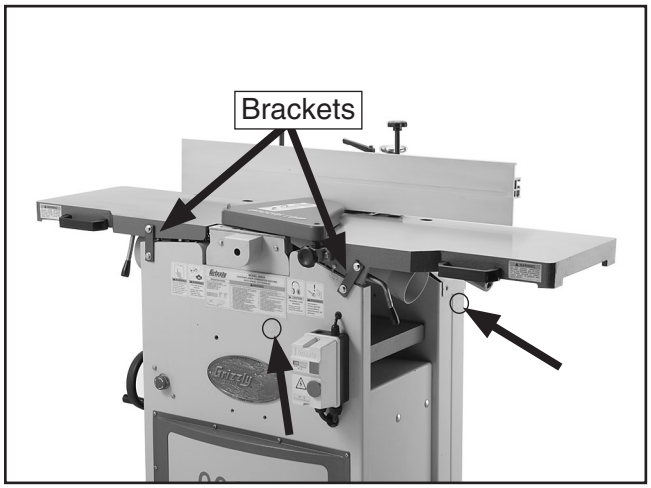


Figure 9. Front and right rear lifting hole locations.

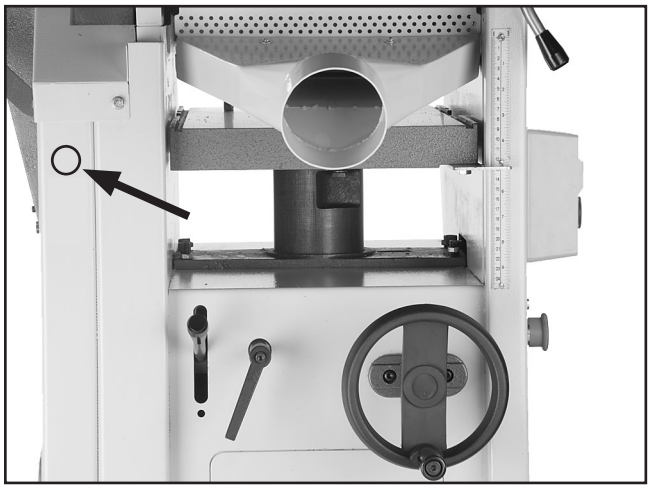


Figure 10. Left rear lifting hole location.

Setting Outfeed Table Height

The outfeed table height MUST be level with the knives or carbide inserts when they are at top-dead-center. If the outfeed table is set too low, the workpiece will be tapered from front to back. 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.

To set the outfeed table height:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Place a straightedge on the outfeed table so it extends over the cutterhead.

3. Open the motor access panel and rotate the cutterhead pulley until one of the knives (or carbide inserts) is at top-dead-center (TDC), as illustrated in **Figure 11**.

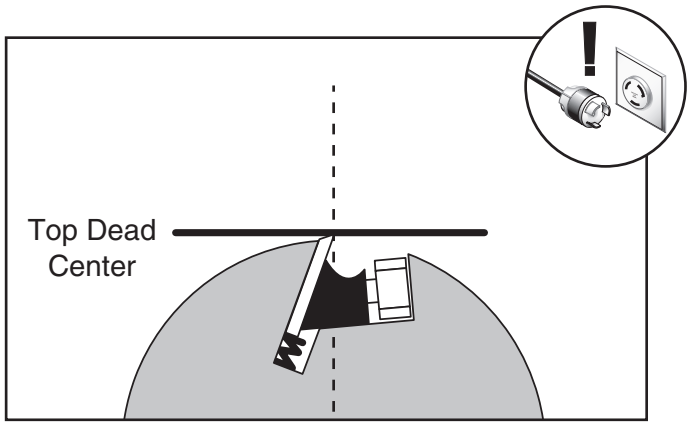


Figure 11. Cutterhead knife at top-dead-center.

4. Raise or lower the outfeed table until the knife (or carbide insert) just touches the straightedge (**Figure 12**).

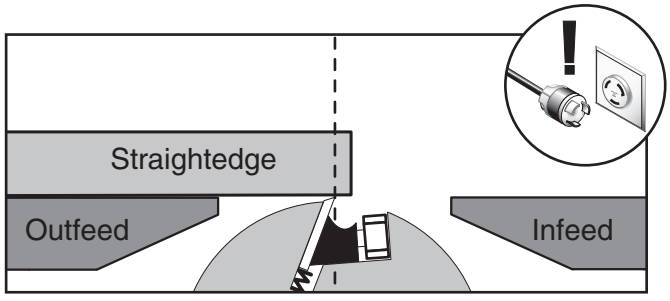


Figure 12. Using a straightedge to align outfeed table height with knife at TDC.

Cutterhead Guard

To install the cutterhead guard:

1. Remove the shaft lock knob and insert the cutterhead guard shaft into the bracket hole as shown in **Figure 13**.

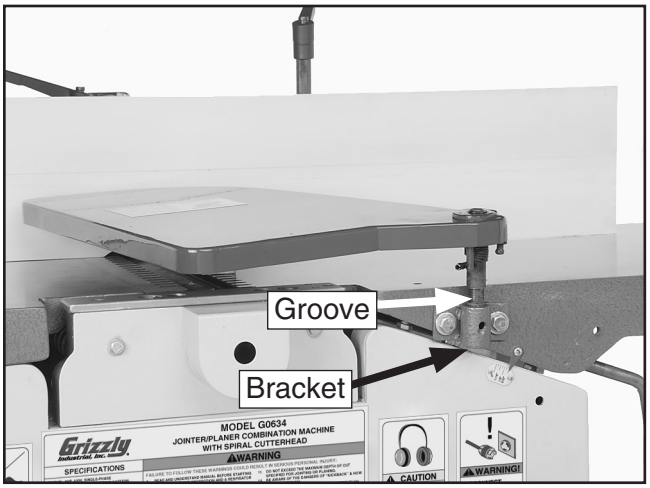


Figure 13. Installing cutterhead guard.

3. Move the fence forward until it touches the cutterhead guard.

4. Thread the lock knob into the bracket so the threads fit into the shaft groove (**Figure 13**), and secure the guard into place. Adjust the guard and lock knob as needed so the guard fully covers the cutterhead.

5. Test the guard by pulling it back and letting go. The rubber dot on the guard should hit the fence when the guard comes back.

   —The guard should snap back over the cutterhead without dragging across the table.

   —If the guard drags across the table, raise it until it won't drag, then tighten the shaft lock.

   —If the guard does not snap back, remove it and repeat **Steps 1–3**.

Knife Setting Gauge

Assemble the knife setting gauge using the knife setting gauge rod, feet and 9mm e-clips as shown in **Figure 14**.

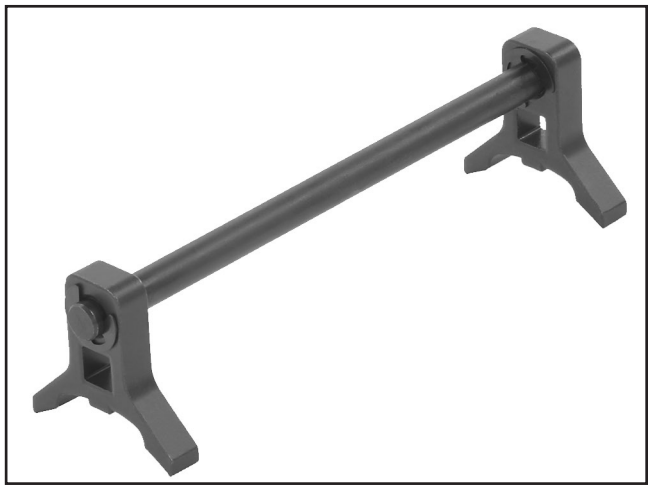


Figure 14. Knife setting gauge assembly.

Dust Collection

⚠CAUTION

DO NOT operate the Model G0633/G0634 without an adequate dust collection system. This machine creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Each Dust Port: 400
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 the 4" dust hose over the jointer dust port, (see **Figure 15)**, or over the planer dust port (see **Figure 16**), depending upon which operation mode is setup, and secure in place with a hose clamp.

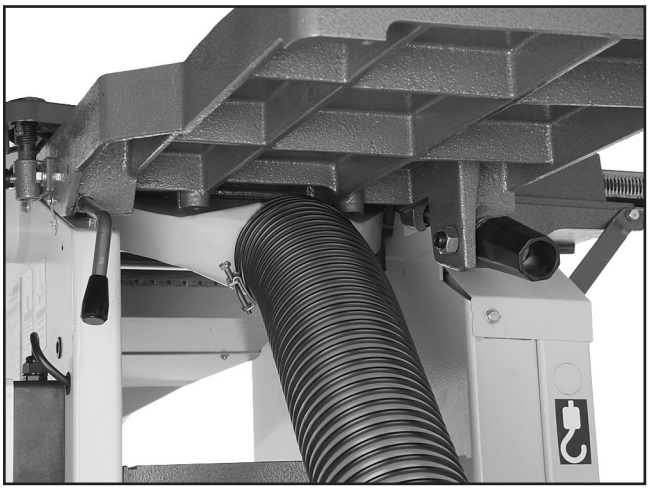


Figure 15. Dust hose attached to jointer dust port.

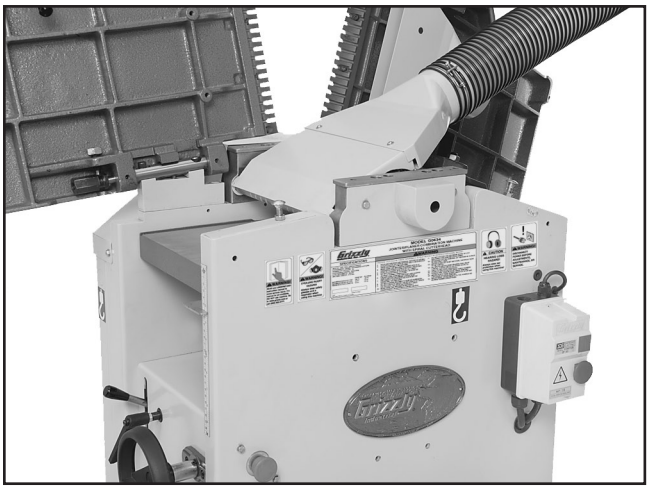


Figure 16. Dust hose attached to planer dust port.

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

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

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation. The test run consists of verifying the following: 1) The motor powers up and runs smoothly and without vibration and 2) the stop button safety feature works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 37**.

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

⚠WARNING

Before starting the jointer/planer, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety features on this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the machine:

1. Make sure you understand the safety instructions at the beginning of the manual and that the machine is setup properly.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Make sure the jointer tables are folded down and locked in place (see **Page 25**).

4. Connect the machine to the power source.

5. Push the EMERGENCY OFF button in, then twist it clockwise so it pops out. See **Figure 1, Page 7** for location of the EMERGENCY OFF button. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 17**).

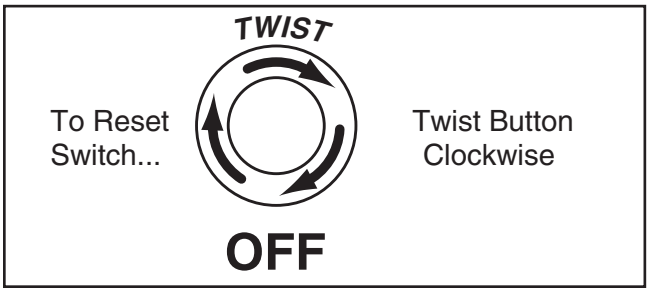


Figure 17. Resetting the Emergency Off switch.

6. Verify that the machine is operating correctly by pushing the green ON button.

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

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

7. Press the EMERGENCY OFF button to stop the machine.

8. WITHOUT resetting the switch, press the ON button. The machine should not start.

   —If the machine does not start, the EMERGENCY OFF button safety feature is working correctly.

   —If the machine does start (with the EMERGENCY OFF button pushed in), immediately disconnect power to the machine. The EMERGENCY OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

9. Press the ON button, then immediately press the OFF button on the magnetic box (**Figure 1, Page 7**).

   —If the machine turns off, the OFF button is working correctly. The Test Run is complete.

   —If the machine does not stop, disconnect power to the machine. The OFF button is not working correctly. This feature must work properly before proceeding with regular 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 and storage, some of these adjustments may need to be repeated to ensure optimum cutting results. Keep this in mind as you start to use your new jointer/planer.

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

1. Jointer Table Parallelism (**Page 39**)
2. Depth Scale Calibration (**Page 46**)
3. Fence Stop Accuracy (**Page 47**)
4. Planer Table Parallelism (**Page 50**)
5. Feed Roller Spring Tension (**Page 51**)

Tighten V-Belts

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the V-belts will stretch and seat into the pulley grooves. After this 16 hours, you must retension the V-belts to avoid slippage and burn out. Refer to **Page 34** when you are ready to perform this important adjustment.

Note: *Pulleys and belts can get hot. This is a normal condition. Allow them to cool before making adjustments.*

A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate premature belt failure is in progress.

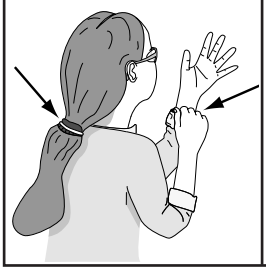
SECTION 4: OPERATIONS

Operation Safety

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.





⚠WARNING

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

NOTICE

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

Basic Jointer Controls

This section covers the basic controls used during routine jointer operations. To use the machine as a planer, you must perform a changeover (see **Jointer-Planer Conversion**, **Page 24**)

START Button: Starts motor only if the EMERGENCY OFF button is in the out position.

OFF Button: Stops motor when pushed in.

EMERGENCY OFF Button: Disables the START button. Enable the START button by twisting the EMERGENCY OFF button until it pops out.

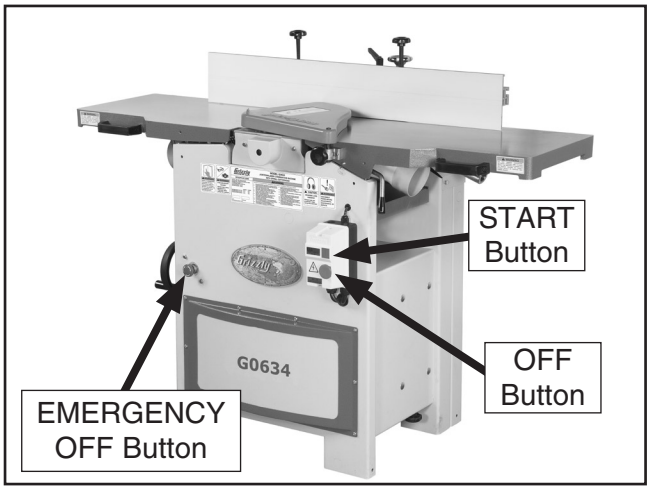


Figure 18. START/STOP button locations.

Table Movement: Loosen the cap screws on the infeed handgrip and outfeed table adjustment knob before moving the infeed and outfeed tables (**Figure 19**). Use an adjustable wrench to turn the outfeed adjustment knob.

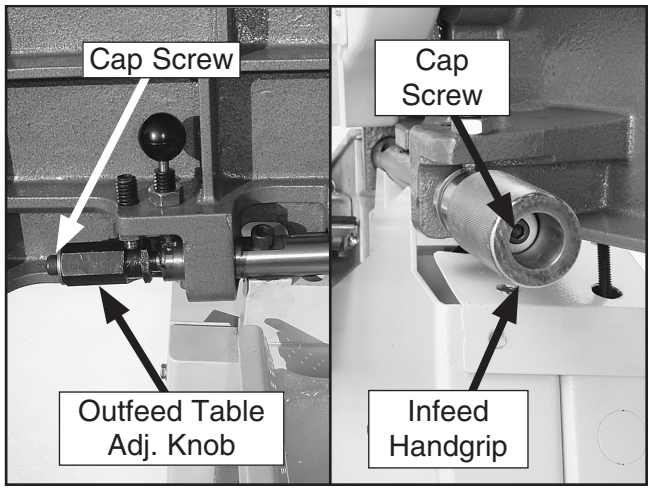


Figure 19. Table control locations.

Fence Movement: The fence lock keeps the fence in position (**Figure 20**). To move the fence, loosen the lock and turn the fence adjustment knob to move it as needed.

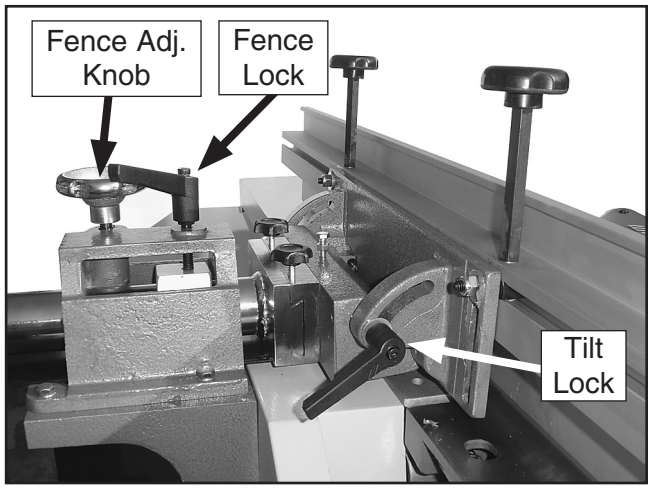


Figure 20. Fence lock location.

Fence Tilting: The tilt lock (**Figure 20**) secures the fence at any position in the available range. Fence stops set the fence at 90° or 45° outward. The tilt lock must be tightened before cutting. See **Page 47** for more detail on adjusting the fence stops.

To move the fence to 45° outward, loosen the tilt lock and fence height knobs, move the fence flush against the table (see **Figure 21**), and tighten the height knobs and tilt lock. Verify the angle with a 45° square. To return the fence to the 90° position, loosen the tilt lock and height knobs, raise the fence to 90°, and tighten the height knobs and tilt lock. Check the fence angle with a 90° square, and make sure the fence and table are flush.

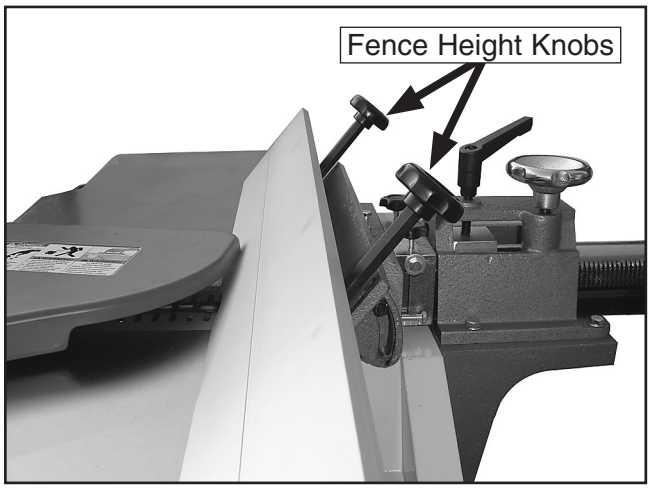


Figure 21. Fence flush with table at 45°.

Basic Planer Controls

This section covers the basic controls used during routine planer operations.

See **Page 22** for a description of START/STOP/ EMERGENCY OFF buttons.

Table Height Handwheel: To move the planer table, rotate the table height handwheel (**Figure 22**).

Table Lock Lever: Turn the lever clockwise to prevent the table moving during planer operations; loosen to move the table handwheel.

Table Height Scale: Read depth-of-cut from the inch/millimeter scale.

Change Lever: When the lever is in the "up" position this converts the machine to planer operations.

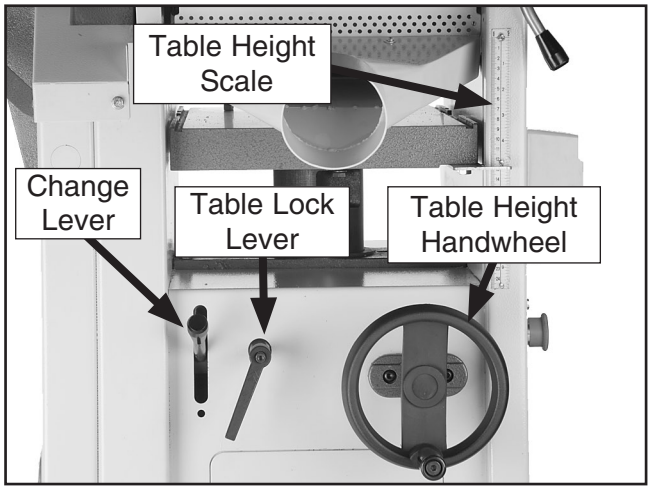


Figure 22. Planer table control locations.

Jointer-Planer Conversion

The Model G0633/G0634 is ready for jointer operations after it is setup. To use the machine as a planer, you must perform a conversion.

To set up the machine for planer operations:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the cutterhead guard.

3. Loosen the quick release knobs (**Figure 23**) and slide the fence off the machine.

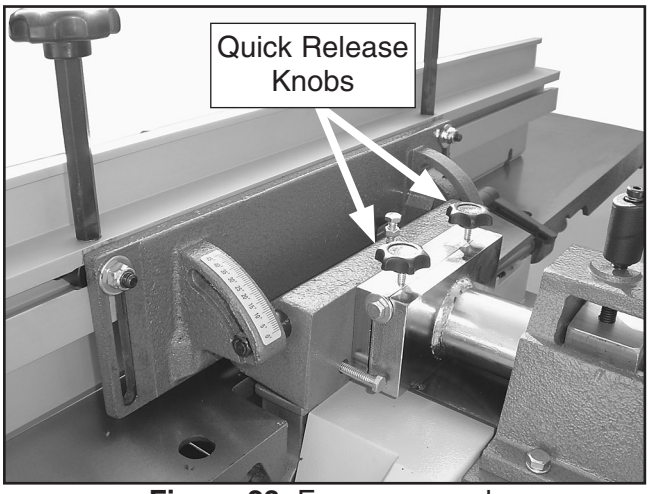


Figure 23. Fence removal.

4. Remove the dust hose from the jointer dust port.

5. Turn the table lock lever (**Figure 24**) clockwise, pull it out, and turn the table up. The table will lock into place when raised to its highest position as shown in **Figure 25**.

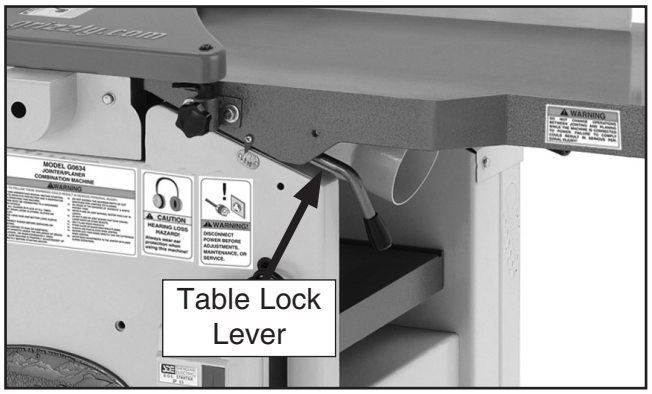


Figure 24. Infeed table lock lever.

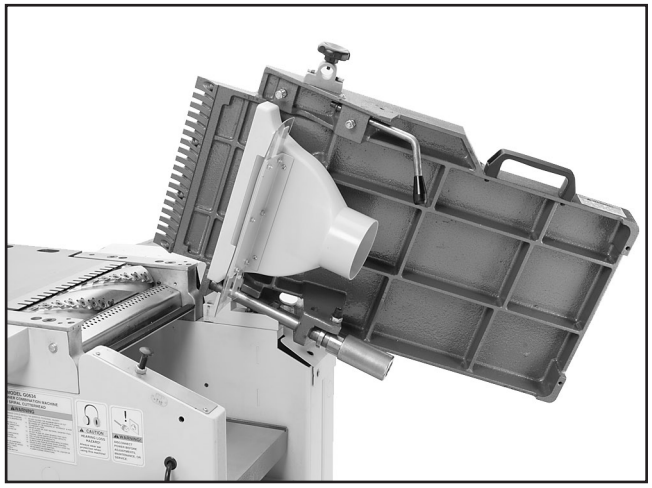


Figure 25. Infeed table in "up" position.

6. Raise the outfeed table in the same manner as you did with the infeed table.

7. Swing the planer dust port clockwise over the cutterhead as shown in **Figure 26**.

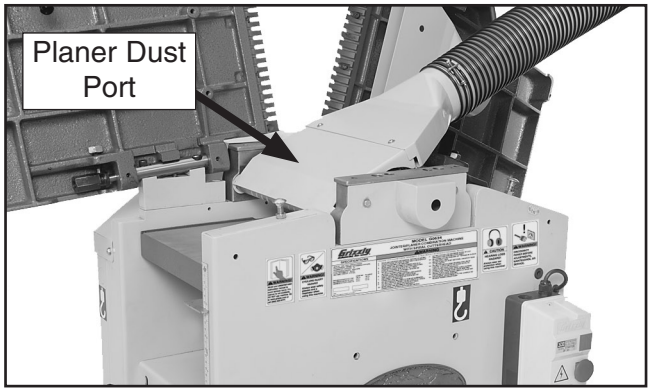


Figure 26. Planer dust port setup.

8. Connect the dust hose to the planer dust port.

9. Flip the change lever (**Figure 22**) up.

To change the machine for jointer operations:

1. Lower the planer table to below the 4" mark on the table height scale.

2. Reverse **Steps 2-9** in the previous subsection. Pull up on the table lock knobs to lower the table. Make sure you lower the planer dust port to the "down" position (as shown in **Figure 27**).

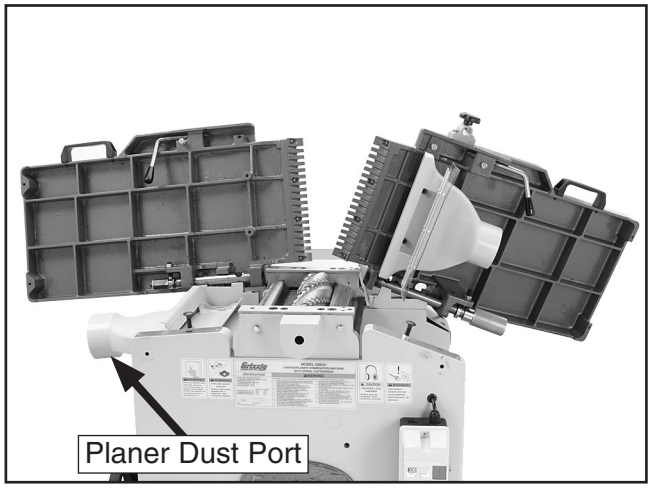


Figure 27. Planer dust port in "down" position.

⚠CAUTION

Serious personal injury could occur if you place your fingers between the tables and base or between pivot points. Your hands could be pinched or crushed!

Stock Inspection and Requirements

Here are some rules to follow when choosing, jointing, and planing stock on a jointer or thickness planer:

- **DO NOT joint or surface plane stock that contains knots.** Injury to the operator or damage to the workpiece can occur if the knots become dislodged during the cutting operation.

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

- **Jointing and surface planing with the grain produces a better finish and is safer for the operator.** Cutting with the grain is described as feeding the stock so the grain points down and toward you on the jointer (**Figure 28**) or away from you on the planer (**Figure 29**), as viewed from the edge.

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

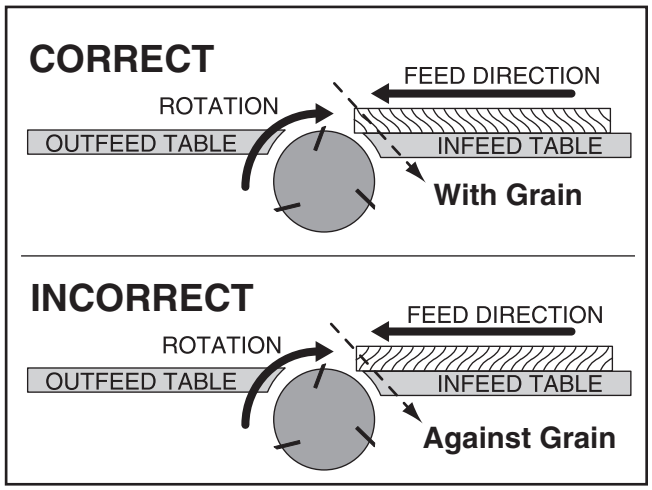


Figure 28. Correct and incorrect grain alignment to cutterhead (jointer).

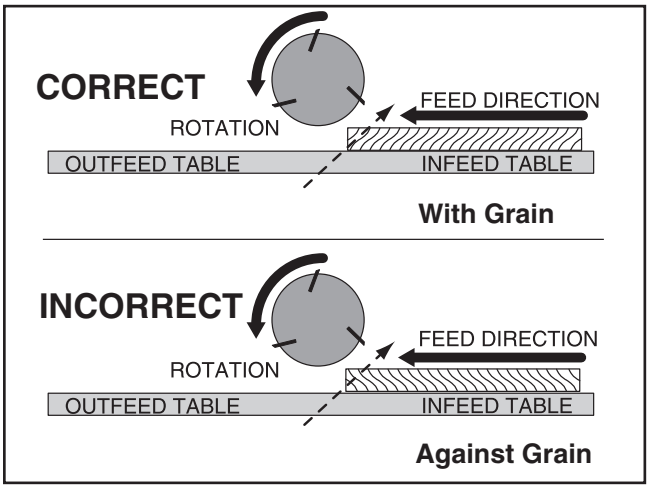


Figure 29. Correct and incorrect grain alignment to cutterhead (planer).

- **Remove foreign objects from the stock.** Make sure that any stock you process with the jointer/planer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects, which if they hit the knives or inserts and are drawn into the dust collector, may cause a fire hazard. The particles may also damage the knives/inserts. Wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.

- **Only process natural wood fiber through your jointer/planer.** Never joint MDF, particle board, plywood, laminates or other synthetically made materials.

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

- **Scrape all glue off of boards before planing.**

- **Keep your work area clear.**

Jointer Specific Rules:

- **Make sure your workpiece exceeds the minimum dimension requirements (Figures 30 & 31) before edge jointing or surface planing, or it may break or kick back during the operation!**

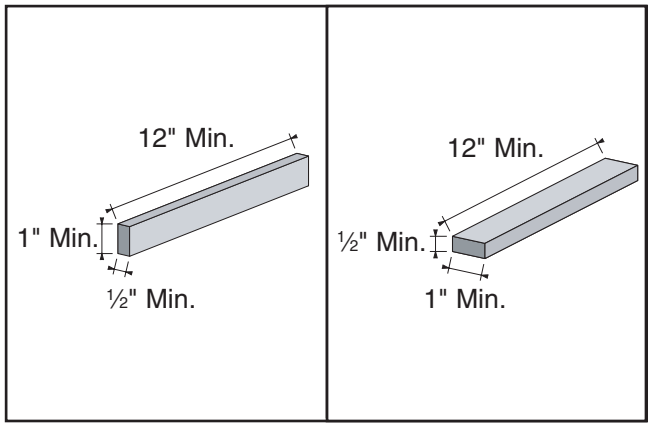


Figure 30. Minimum dimensions for edge jointing and surface planing (jointer).

Thickness Planer Specific Rules:

- Use the full width of the planer. Alternate between the left, the right, and the middle when feeding narrower lumber into the planer. Your knives/inserts will remain sharp much longer.

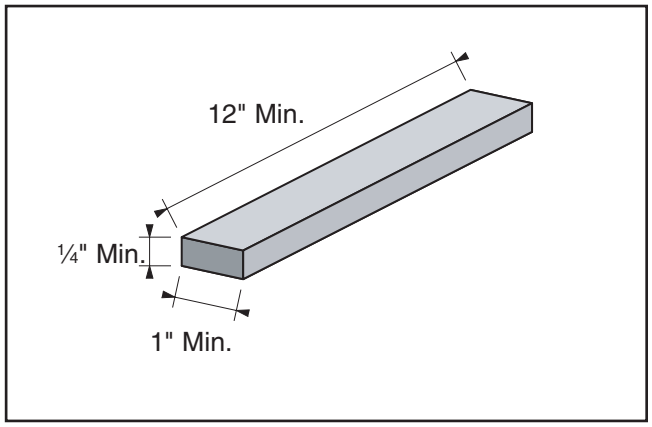
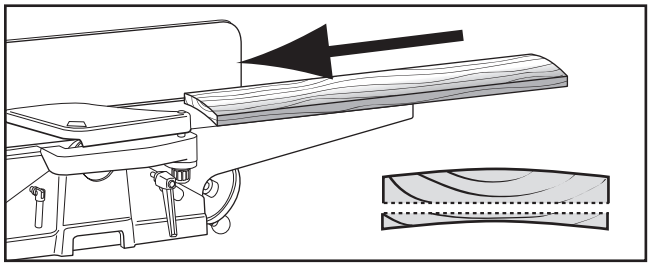


Figure 31. Minimum dimensions for surface planing (thickness planer).

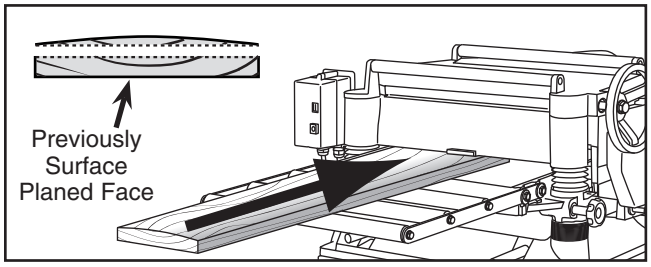
Squaring Stock

Squaring stock involves four steps performed in the order below:

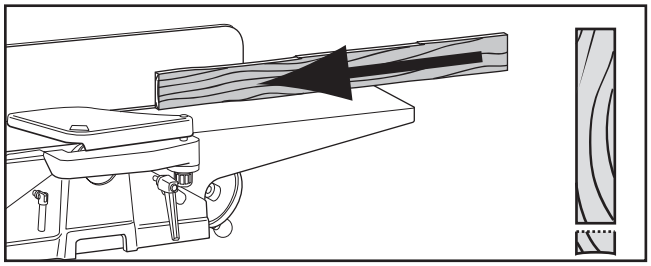
1. **Surface Plane on the Jointer**—The concave face of the workpiece is surface planed flat with a jointer.



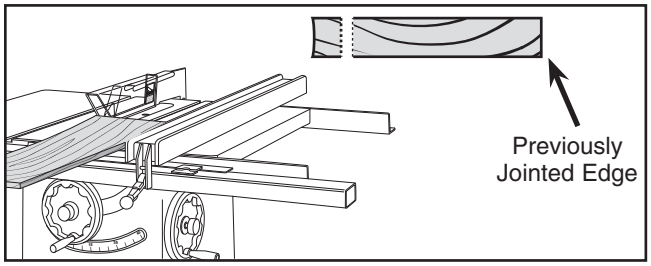
2. **Surface Plane on the Thickness Planer**—The opposite face of the workpiece is surface planed flat with a thickness planer.



3. **Edge Joint on the Jointer**—The concave edge of the workpiece is jointed flat with a jointer.



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



Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see **Figures 32 & 33**) to prepare it for surface planing on the thickness planer.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described. This procedure will better prepare you for the actual operation.

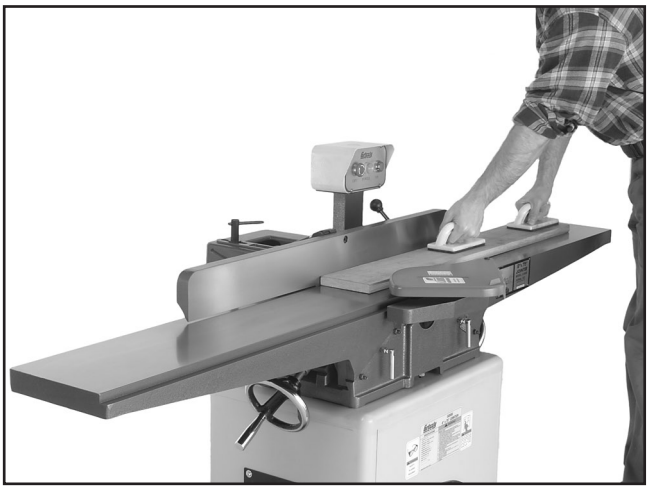


Figure 32. Typical surface planing operation.

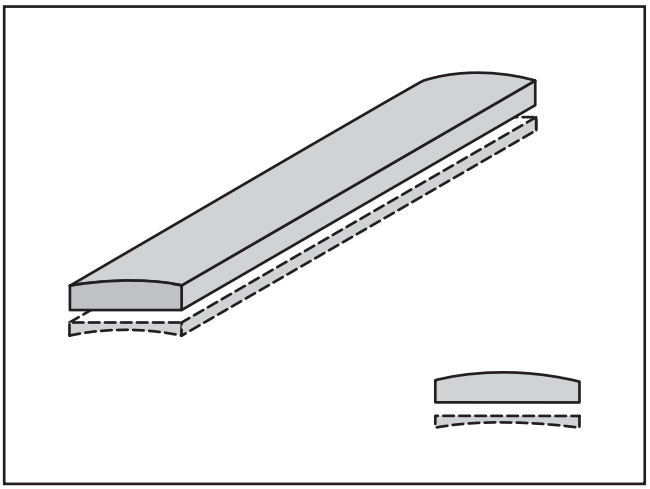


Figure 33. Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 8**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26**.

3. Set the cutting depth for your operation. (We suggest 1/32" for surface planing, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure your fence is set to 90˚.

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

6. Start the jointer.

⚠WARNING

Failure to use push blocks when surface planing may result in cutterhead contact, which will cause serious personal injury. Always use push blocks to protect your hands when surface planing on the jointer.

7. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.

   Note: *If your leading hand (with push block) gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

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

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 34 & 35**) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

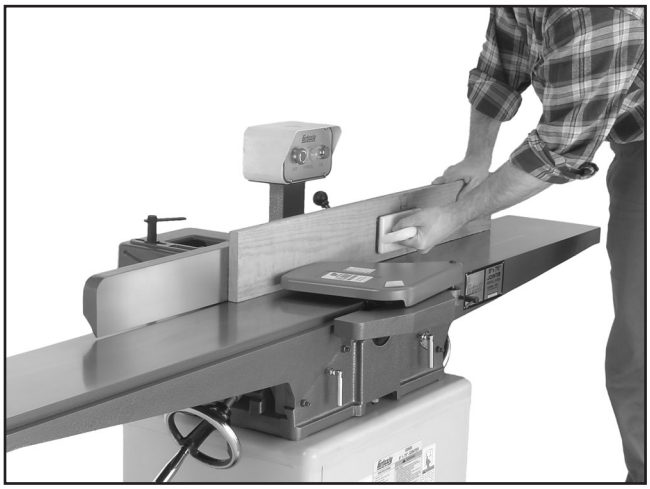


Figure 34. Typical edge jointing operation.

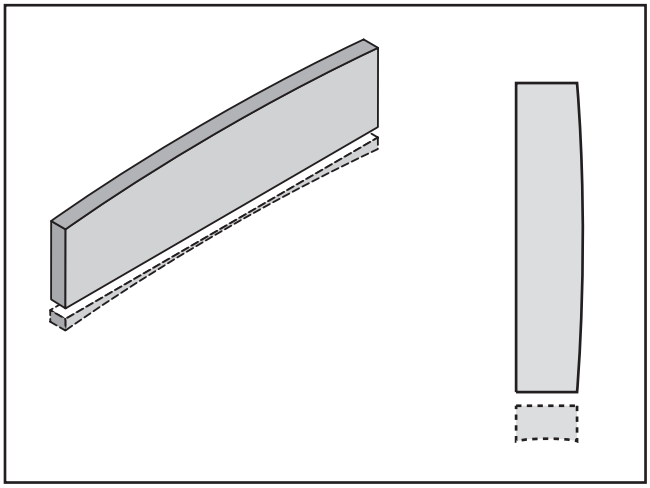


Figure 35. Illustration of edge jointing results.

To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 8**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26**.

3. Set the cutting depth for your operation. (We suggest between 1/16" and 1/8" for edge jointing, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure the fence is set to 90°.

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

6. Start the jointer.

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

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place it on the portion of the workpiece that is over the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

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

Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece (see **Figures 36 & 37**).

The Model G0633/G0634 has preset fence stops at 45˚ outward and 90˚. If your situation requires a different angle, the preset fence stops can be easily adjusted for your needs.

NOTICE

If you are not experienced with a jointer, set the depth of cut to 0", and practice feeding the workpiece across the tables as described below. This procedure will better prepare you for the actual operation.

Figure 36. Typical bevel cutting operation.

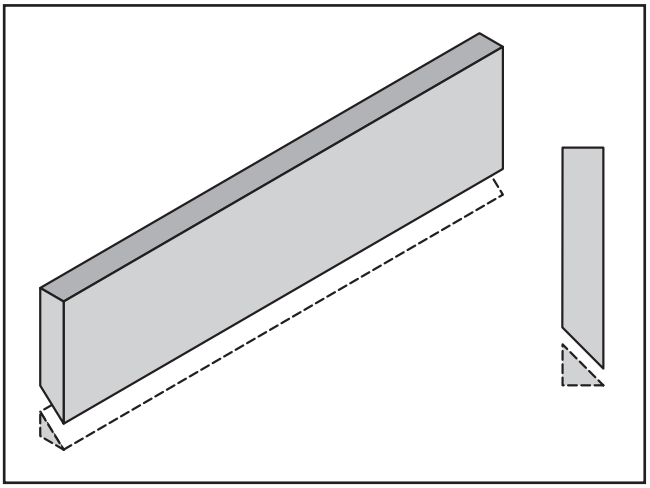


Figure 37. Illustration of bevel cutting results.

To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 8**.

2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 26.**

3. Set the cutting depth for your operation. (We suggest between 1/16" and 1/8" for bevel cutting, using a more shallow depth for hard wood species or for wide stock.)

4. Make sure your fence is set to the angle of your desired cut.

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

6. Start the jointer.

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

   Note: *If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is on the outfeed table. Now, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

8. Repeat **Step 7** until the angled cut is satisfactory to your needs.

Basic Planer Operation

The G0633/G0634 table moves approximately 1/16" with one turn of the handwheel.

The basic steps of operating the planer are as follows:

1. Put on safety glasses.

2. Unless your workpiece is very flat, surface plane the workpiece on the jointer until it is flat—having the face flat will ensure that it sits flat on the planer table during operation.

3. Adjust the table height to slightly lower than your workpiece height to ensure the first cut is as light as possible (approximately 1/32"–1/16") .

4. Start the planer.

5. Place the flat side of the board down on the table (on the left side, facing the front of the machine), and feed the workpiece through the planer—in the opposite direction as when jointing. Make sure not to stand directly in front or behind the workpiece to avoid kickback injury.

—If the cut is too heavy and bogs down the planer, turn the planer ***OFF*** immediately, allow it to come to a complete stop, remove the workpiece, and repeat **Steps 3–5**.

6. Measure your workpiece thickness and adjust the table height as necessary to take a lighter or heavier pass, depending on your needs. For most wood types, 1/16" per pass is a good cutting depth.

Note: *Any time you switch directions with the table height handwheel, there will be a small amount of backlash—so the first crank of the handwheel after switching directions will be slightly less than 1/16". However, as long as you move the handwheel in the same direction during operation, backlash will not be a factor.*

SECTION 5: ACCESSORIES

G1738—Rotacator™ Precision Planer Tool
The Rotacator is a dial indicator on a magnetic base and is designed for quickly and accurately setting the critical tolerances needed when adjusting any planer, so that nasty surprises such as non-parallel and chattered cuts can be eliminated. A great setup tool for other machines! Accurate to 0.001". Indicator rotates 360˚.

Figure 38. Rotacator™ Precision Planer Tool.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 39. Recommended products for protecting unpainted cast iron/steel parts on machinery.

H9816—Power Twist® V-Belt - 3/8" x 60"
Smooth running with less vibration and noise than solid belts. The Power Twist® V-belts can be customized in minutes to any size—just add or remove sections to fit your needs. Requires two Power Twist® V-belts to replace the stock V-belts on your Model G0633/G0634.

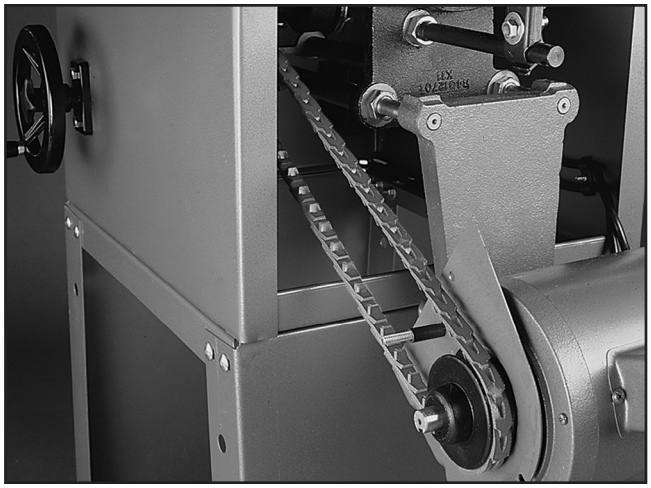


Figure 40. H9816 Power Twist® V-Belt.

G9643—8" Precision Straightedge
G9644—12" Precision Straightedge
H2675—16" Precision Straightedge
Ideal for aligning your outfeed bed to the cutterhead and calibrating your depth scale. These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.

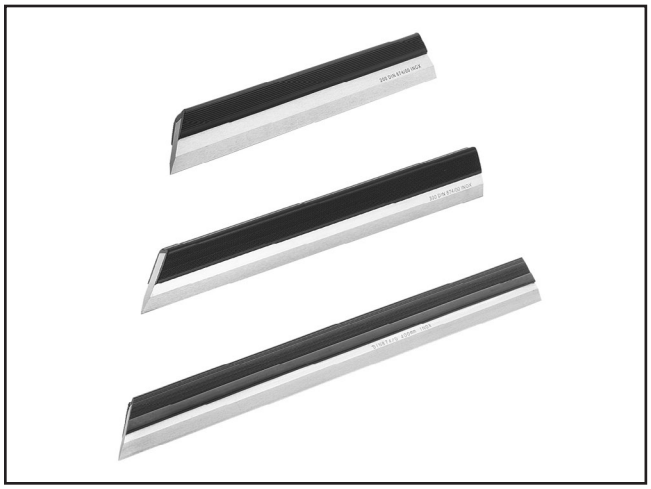


Figure 41. Straightedges.

G7984—Face Shield
H1298—Dust Sealed Safety Glasses
H1300—UV Blocking, Clear Safety Glasses
H2347—Uvex® Spitfire Safety Glasses
H0736—Shop Fox® Safety Glasses
Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

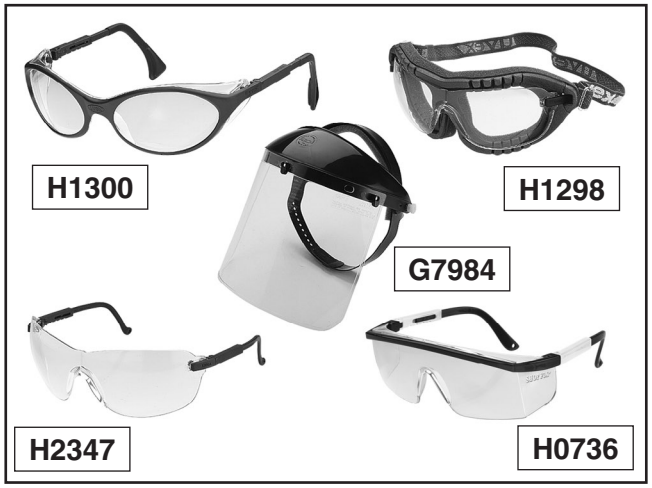


Figure 42. Our most popular safety glasses.

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

Figure 43. Our most popular earmuffs.

H7319—Carbide Inserts (10 Pack)
These indexable carbide inserts can be rotated to provide four factory sharp edges before replacement.

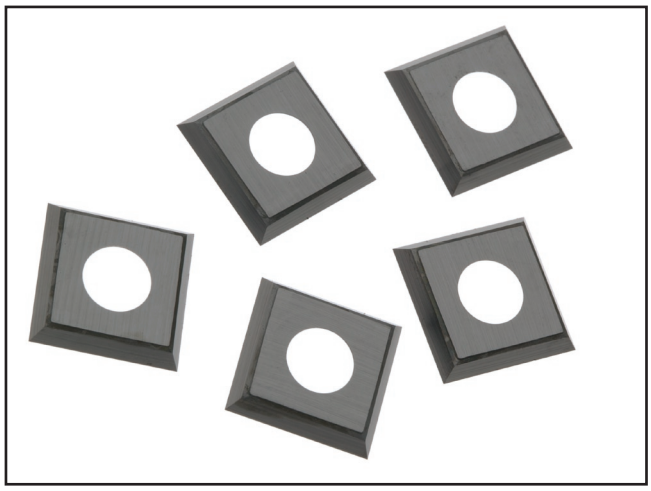


Figure 44. H7319 Carbide Inserts.

H9885—HSS Knives for G0633 (Set of 3)

G9256—6" Dial Caliper
G9257—8" Dial Caliper
G9258—12" Dial Caliper
Essential for planing, jointing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!

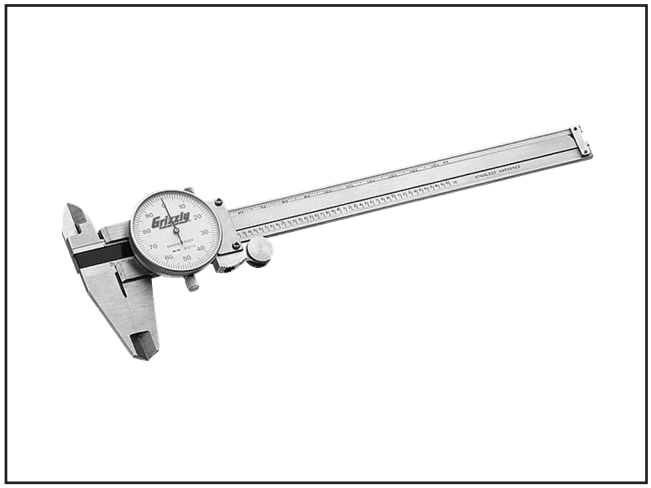
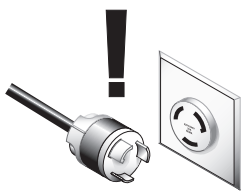


Figure 45. Grizzly® Dial Calipers.

SECTION 6: MAINTENANCE



⚠WARNING

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

Schedule

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

Daily Check:
- Clean unpainted cast iron parts of jointer and planer tables
- Lubricate feed rollers

Weekly Check:
- Clean cutterhead

Monthly Check:
- Inspect V-belt tension, damage, or wear
- Clean/vacuum dust buildup from inside cabinet and off motor
- Lubricate worm gear
- Lubricate roller chains
- Lubricate elevation lead screw
- Lubricate worm shaft

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth—this ensures moisture from wood dust does not remain on bare metal surfaces. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning. We recommend products like SLIPIT®, G96® Gun Treatment, or Boeshield® T-9 (see **Page 32** for more details).

V-Belts

V-belt removal and replacement involves removing the V-belts, rolling them off of the pulleys, replacing them with new belts, then retensioning them.

Always replace V-belts as a set, or belt tension may not be even among the belts and may cause premature belt failure.

Consider replacing stock belts with Power Twist V-belts (see **Page 32**) to reduce vibration and noise, and increase belt lifespan.

To adjust/replace belts the V-belts:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the four hex bolts securing the V-belt cover (see **Figure 46**).

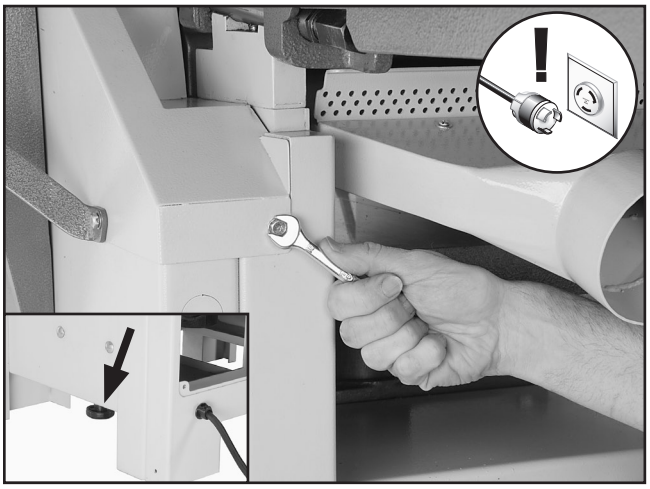


Figure 46. Removing bolts on V-belt cover and belt tension knob (inset).

3. Remove the fence and fence bracket, then remove the motor access cover and belt tension knob (**Figure 46**).

4. Using a 14mm wrench, loosen the four adjustment nuts and raise the motor (see **Figure 47**) to remove V-belt tension. It may help to use a 2x4 to lift the motor.

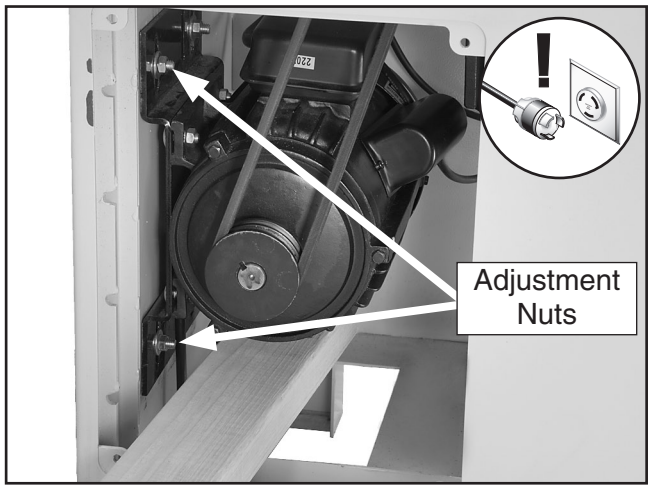


Figure 47. Removing V-belt tension.

5. Remove both the belts and replace them with a new set.

6. Lower the motor and reinstall the belt tension knob.

7. Using the belt tension knob, adjust the V-belt tension so there is approximately ¼"–½" deflection when the V-belts are pushed with moderate pressure as shown in **Figure 48.**

   Note: *After the first 16 hours of belt life, retension the belts, as they will stretch and seat during this time.*

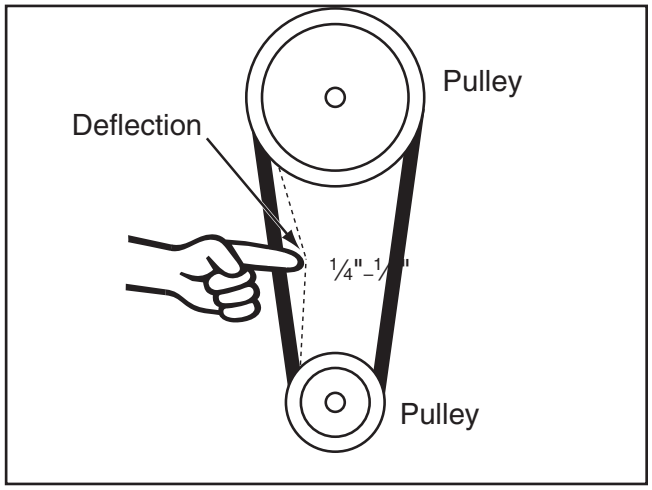


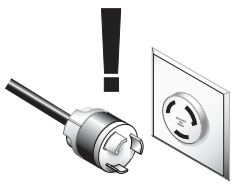
Figure 48. Checking V-belt tension.

8. Replace the motor access cover, fence bracket, and fence.

Lubrication

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

Proper lubrication of other jointer/planer components is essential for long life and trouble-free operation. Below is a list of components that require periodic lubrication. Schedules are based on daily use. Adjust accordingly for your level of use.



⚠WARNING

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

Roller Chains: Inspect monthly and lubricate with multi-purpose grease when needed to avoid rust and binding. See the locations shown in **Figure 49,** and refer to **Parts Breakdown**, Part P0633310 and P0633311 on **Page 60**. Remove the fence assembly and V-belt cover to gain access.

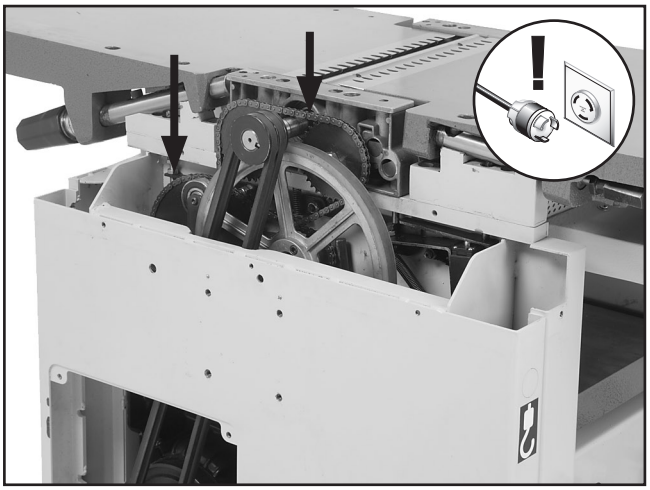


Figure 49. Roller chains.

Lead Screw: The lead screw should be lubricated with multi-purpose grease once a month. See **Figure 50** and **Parts Beakdown**, P0633411, **Page 61** for location. Remove the left side access panel for ingress.

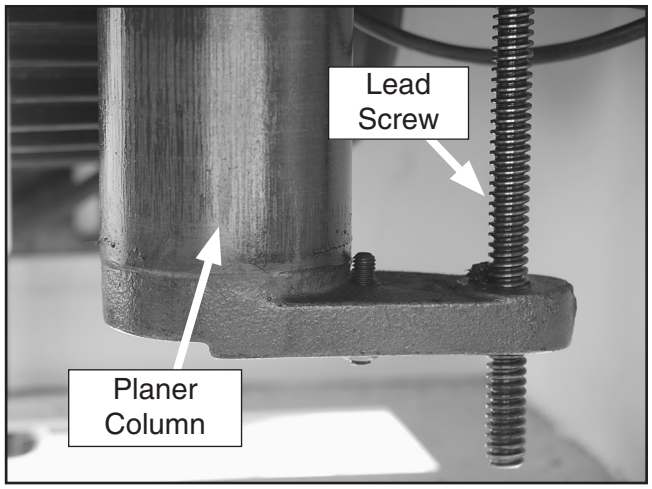


Figure 50. Planer column and lead screw.

Planer Column: Clean with solvent, wipe dry, and relubricate with multi-purpose grease when needed.

Worm Gear: Inspect every six months and lubricate with multi-purpose grease when needed (see **Parts Breakdown**, P0633409). Remove the worm gear box (see P0633407, **Page 61**) to inspect.

Fence: Lubricate with multi-purpose grease when needed in the locations shown in **Figure 51**.

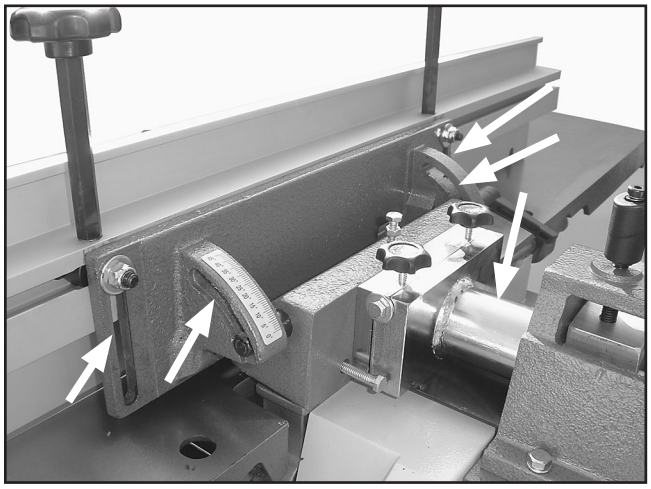


Figure 51. Fence lubrication locations.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting

Motor & Electrical

Symptom	Possible Cause	Possible Solution
Motor will not start or fuses or circuit breakers blow.	1. Emergency off button depressed. 2. Short circuit in line cord or plug. 3. Start capacitor is at fault. 4. Thermal protection circuit breaker amperage is set too low or motor is at fault. 5. Open circuit in motor or loose connections.	1. Rotate clockwise until it pops out/replace. 2. Repair or replace cord or plug for damaged insulation and shorted wires. 3. Replace start capacitor. 4. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting. If switch is maxed out, replace motor. 5. Inspect all lead connections on motor for loose or open connections.
Motor fails to develop full power or motor decreases rapidly with load, overheats, or stalls.	1. Motor run capacitor at fault. 2. Motor overloaded during operation. 3. Air circulation through the motor restricted. 4. Motor overloaded during operation. 5. Thermal protection circuit breaker amperage is set too low or motor is at fault. 6. Short circuit in motor or loose connections. 7. Circuit breaker tripped.	1. Replace run capacitor. 2. Reduce cutting load; take lighter cuts. 3. Clean out motor to provide normal air circulation. 4. Reduce cutting load; take lighter cuts. 5. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting. If switch is maxed out, replace motor. 6. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 7. Install correct circuit breaker; reduce number of machines running on that circuit.
Cutterhead slows or squeals when cutting, especially on start-up.	1. V-belt loose. 2. V-belt worn out.	1. Tighten V-belt (**Page 34**). 2. Replace V-belt (**Page 34**).
Loud repetitious noise coming from machine.	1. Pulley set screws or keys are missing or loose. 2. V-belts are damaged. 3. Motor fan is hitting the cover.	1. Inspect keys and set screws. Replace or tighten if necessary. 2. Replace V-belts (**Page 34**). 3. Adjust fan cover mounting position, tighten fan, or shim fan cover.

Table (Jointer)

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	1. Table gibs are too tight.	1. Adjust table gibs (**Page 49**).
Tables do not lock.	1. Table lock levers too high or too low.	1. Adjust lock nuts and bolts.

Cutting (Jointer and Planer)

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	1. Outfeed table is set too low. 2. Operator pushing down on trailing end of workpiece. 3. Workpiece is not supported as it leaves the planer.	1. Align outfeed table with cutterhead knife at top dead center (**Page 18**). 2. Reduce/eliminate downward pressure on trailing end of workpiece. 3. Support the workpiece as it leaves the outfeed end of the planer.
Workpiece stops/ slows in the middle of the cut.	1. Taking too heavy of a cut. 2. Table not parallel with head casting. 3. Pitch and glue build up on planer components.	1. Take a lighter cut. 2. Adjust the table so it is parallel to the head casting (**Page 50**). 3. Clean the internal cutterhead components with a pitch/resin dissolving solvent.
Chipping (consistent pattern).	1. Knots or conflicting grain direction in wood. 2. Nicked or chipped knife or carbide insert. 3. Taking too deep of a cut.	1. Inspect workpiece for knots and grain direction; only use clean stock. 2. Replace the knife or rotate/replace affected insert (**Page 43** or **45**). 3. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)
Fuzzy grain.	1. Wood may have high moisture content or surface wetness. 2. Dull knives or inserts.	1. Check moisture content and allow to dry if moisture is too high. 2. Rotate/replace the knives or inserts (**Page 43** or **45**).
Long lines or ridges that run along the length of the board	1. Nicked or chipped knives or inserts(s).	1. Replace or offset knives or rotate/replace inserts (**Page 43** or **45**).
Uneven knife or insert marks, wavy surface, or chatter marks across the face of the board.	1. Knives not adjusted at even heights in the cutterhead. 2. Carbide inserts not installed evenly. 3. Worn cutterhead bearings.	1. Adjust the knives so they are set up evenly in the cutterhead (**Page 43**). 2. Make sure carbide inserts do not have debris under them; make sure inserts are torqued down evenly. 3. Replace cutterhead bearings.
Glossy surface. (Planer)	1. Knives or carbide inserts are dull. 2. Cutting depth too shallow.	1. Rotate/replace the knives or inserts (**Page 43** or **45**). 2. Increase the depth of cut.
Chip Marks (inconsistent pattern). (Planer)	1. Chips aren't being properly expelled from the cutterhead.	1. Use a dust collection system
Board edge is concave or convex after jointing. (Jointer)	1. Board not held with even pressure on infeed and outfeed table during cut. 2. Board started too uneven. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.	1. Hold board with even pressure as it moves over the cutterhead. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on starting condition of board and depth of cut.

Checking/Adjusting Jointer Table Parallelism

The outfeed table is preset by the factory parallel with the cutterhead. However, it is critical to check this setting. If the tables are not parallel with the cutterhead or each other, then poor cutting results and kickback can occur.

Tools Needed	Qty
Straightedge	1
Adjustable Wrench	1

Checking Outfeed Table Parallelism

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Put on leather gloves, then remove the cutterhead guard and fence.

3. Place the straightedge on the outfeed table so it hangs over the cutterhead in one of the positions shown in **Figure 52**.

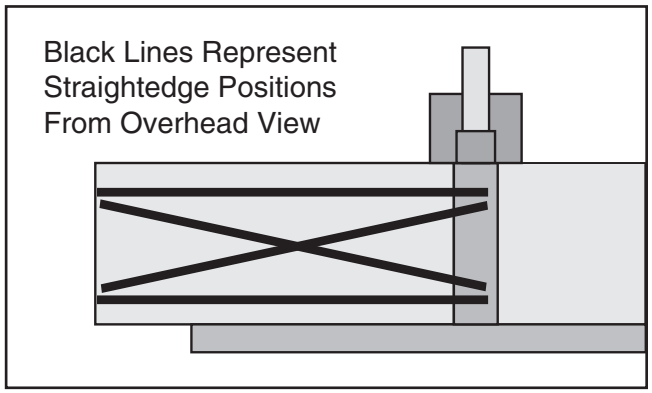


Figure 52. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

4. Try to fit a feeler gauge or combination of feeler gauges 0.062" to 0.069" between the bottom of the ruler and the cutterhead body as shown in **Figure 53**.

   —If the feeler gauge slides with slight resistance between the ruler and cutterhead and no gaps appear, go to **Step 5**.

   —If the feeler gauge(s) do not fit between the ruler and cutterhead, or if there is a gap, adjust the table height until the feeler gauge slides with slight resistance between the ruler and table.

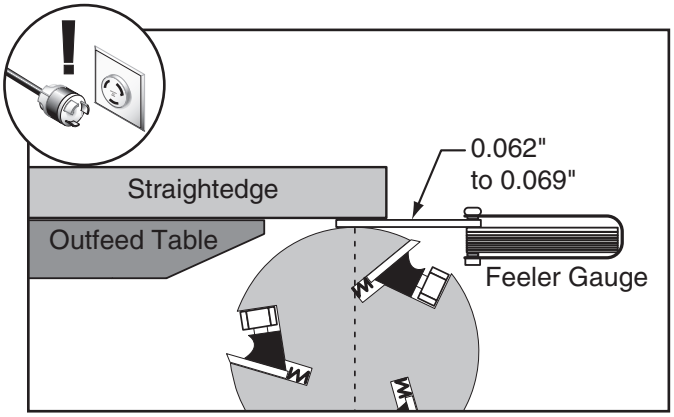


Figure 53. Using feeler gauge to check outfeed table-cutterhead height.

5. Continue placing the straightedge in the remaining positions shown in **Figure 52**. In each position, the feeler gauge measurement should be nearly identical.

   —If the outfeed table height above the cutterhead is equal across the table in each position, then the outfeed table is already parallel with the cutterhead. Go to **Checking Infeed Table Parallelism,** on **Page 40**.

   —If the outfeed table height is not equal across the table in any of the positions, then the outfeed table is not parallel with the cutterhead. Correct the outfeed table parallelism, then correct the infeed table parallelism.

Correcting Outfeed Table to Cutterhead Parallelism

This procedure involves turning the table stop bolts to raise or lower the front of the tables until they are parallel with the cutterhead.

To correct outfeed table parallelism:

1. Loosen the lock nuts on both stop bolts shown in **Figure 54** at the front of the table.

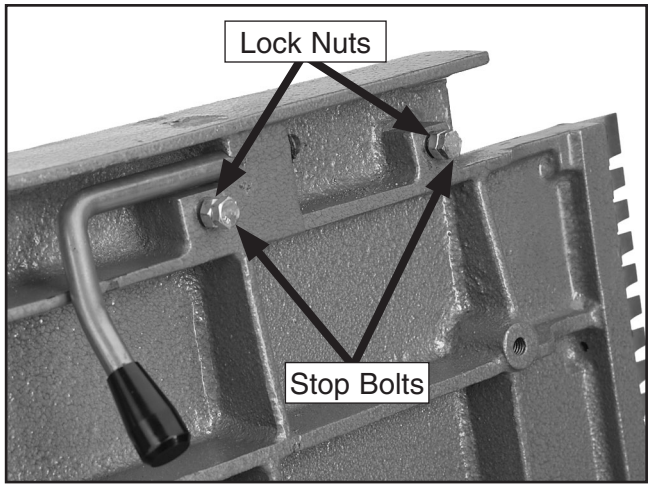


Figure 54. Outfeed table stop bolt and lock nut.

2. Raise the stop bolts just enough so the front edge of the table is higher than the cutterhead, then adjust each stop bolt a sixth of a turn clockwise to gradually lower the table.

3. Check the outfeed table height again (see **Steps 3-5, Page 39**).

4. Continue lowering the bolts and checking until the outfeed table height above the cutterhead is equal across the table.

Checking Infeed Table Parallelism

1. Follow all the steps for checking the outfeed table parallelism to first make sure that the outfeed table is parallel with the cutterhead.

2. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 55**.

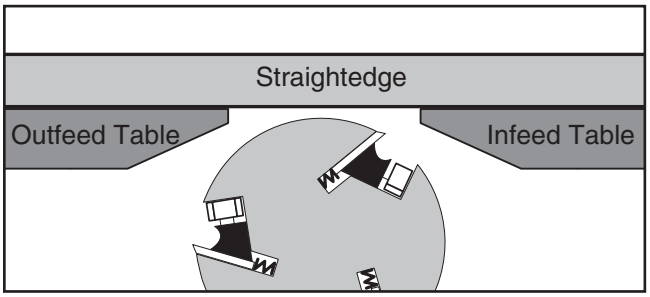


Figure 55. Infeed and outfeed tables set evenly.

—If a knife or insert touches the straightedge, turn the cutterhead so the knives do not interfere.

—If the cutterhead touches the straightedge, raise the outfeed table higher than the cutterhead.

3. Place the straightedge in the positions shown in **Figure 56**. In each position, the straightedge should sit flat against both the outfeed table and the infeed table.

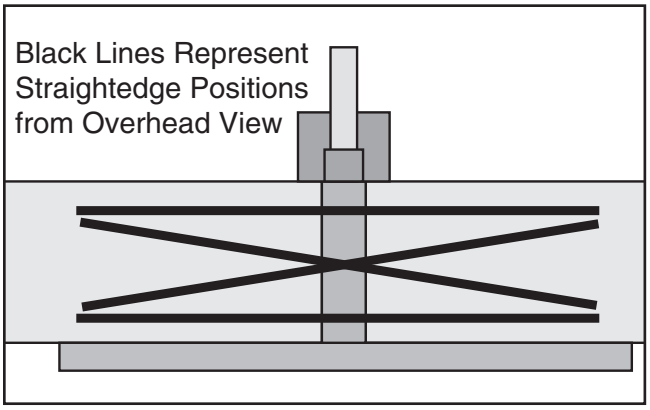


Figure 56. Straightedge positions for checking infeed/outfeed table parallelism.

—If the straightedge sits flat against both the infeed and outfeed table, then the tables are parallel. Set the outfeed table height and replace the cutterhead guard (**Page 18**).

—If the straightedge does not sit flat against both the infeed and outfeed table in any of the positions, then follow the **Adjusting Table Parallelism** instructions.

Adjusting Jointer Table Parallelism

For safe and proper cutting results, the tables must be parallel to 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.

You can adjust stop bolts on the front of the tables and shim under the back of the tables to adjust them parallel to the cutterhead.

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

To adjust the jointer table parallelism:

1. Perform the "Checking/Adjusting Table Parallelism" procedure on **Page 39**, including making any necessary adjustments so the cutterhead and outfeed table are parallel.

2. Place the straightedge halfway across the infeed table and halfway over the outfeed table, and adjust the infeed table even with the outfeed table, as shown in **Figure 55**.

3. Place the straightedge in one of the positions shown in **Figure 56**.

   —If the front of the infeed table is higher or lower than the outfeed table, adjust the infeed table stop bolts (see **Correcting Infeed Table to Cutterhead Parallelism** on **Page 40**).

   —If the rear of the infeed table is higher or lower than the outfeed table, shim the infeed table to adjust it parallel with the outfeed table. Follow **Steps 4-6**.

4. Loosen the cap screws shown in **Figure 57**.

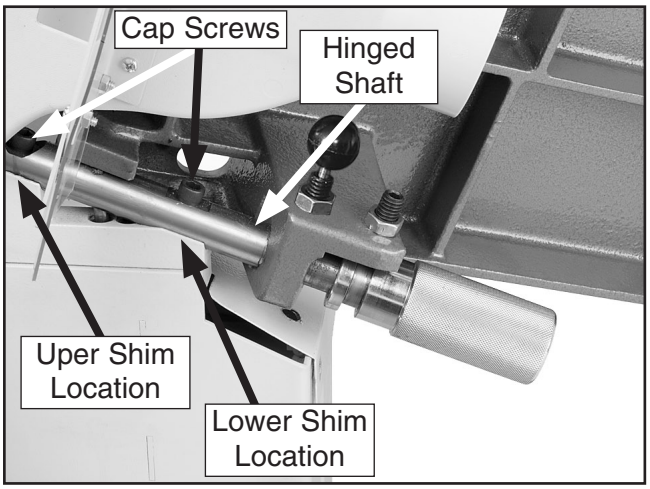


Figure 57. Infeed table hinged shaft. (Jointer table raised for clarity.)

5. While an assistant raises the infeed table, slip shims between the hinged shaft and the jointer base, then retighten the cap screw. Shimming the top position will raise the rear cutterhead side of the table, shimming the lower position will raise the rear infeed side.

6. Repeat **Step 3** with each of the remaining straightedge positions and adjust the table front to back using the shims as many times as necessary until the infeed table is parallel with the outfeed table.

7. Set the knives (refer to **Page 43**).

8. Reinstall the cutterhead guard.

Inspecting Knives (G0633 Only)

Tools Needed: **Qty**
Knife Setting Gauge 1
Straightedge 1

The height of the knives can be inspected with the knife setting jig or with a straightedge.

Inspecting the height of the knives with a straightedge ensures that they are set evenly with the outfeed table at their highest point in the cutterhead rotation.

To inspect the knives with the knife setting gauge:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!
2. Remove the cutterhead guard.
3. Raise both tables out of the way.
4. Place the knife setting gauge on the cutterhead, directly over a knife, as shown in **Figure 58**.

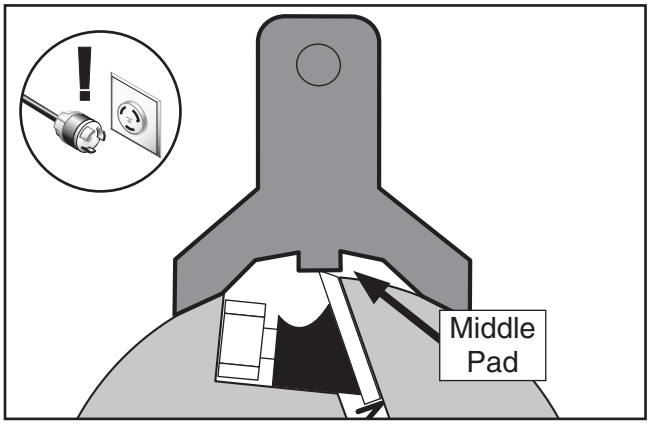


Figure 58. Typical gauge positioned over cutterhead knife.

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

   —If the gauge does not sit firmly on the cutterhead and touch the knife edge as described, then reset that knife. (Repeat this inspection with the other knives before resetting.)
6. Lower the tables back over the cutterhead.
7. REPLACE CUTTERHEAD GUARD!

To inspect the knives with a straightedge:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!
2. Remove the cutterhead guard or block it out of the way.
3. Using a straightedge on the outfeed table, check the height of each knife at the positions shown in **Figure 58**.

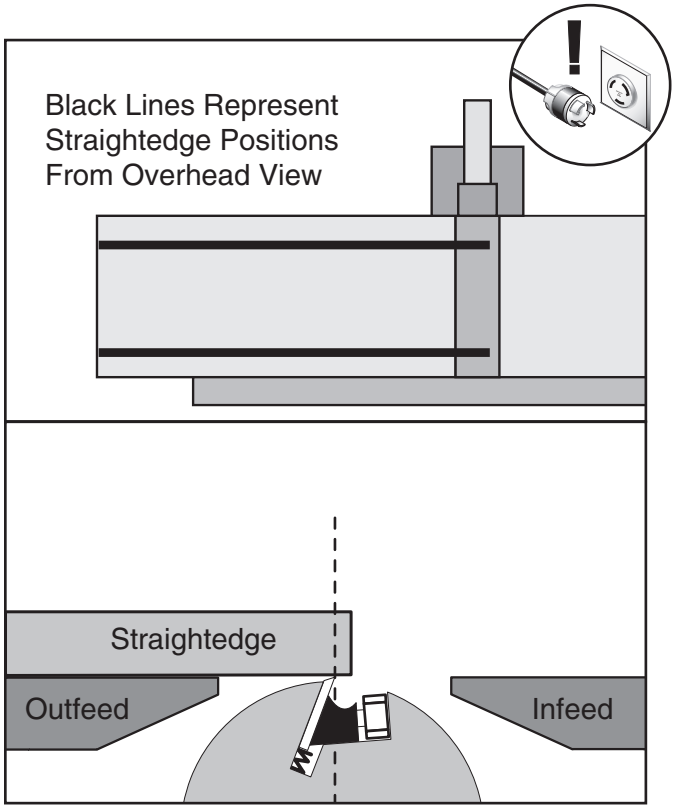


Figure 59. Checking knife height with a straightedge.

—The knives are set correctly when they just touch the bottom of the straightedge in each of the straightedge positions.

—If the knives do not touch the straightedge or they lift it up in any of the positions, then those knives need to be adjusted.

Adjusting/Replacing Knives (G0633)

Tools Needed:	**Qty**
Straightedge	1
Hex Wrench 3mm	1
Wrench 8mm	1

Setting the knives correctly is crucial to the proper operation of the jointer and is very important in keeping the knives sharp. If one knife is higher than the others, it will do the majority of the work, and thus, dull much faster than the others.

There are two options for setting the knives—the straightedge method and the knife setting jig method. Each option has advantages and disadvantages and the correct one for you will become a matter of personal preference. For best results, the tables must be parallel with each other (**Checking/Adjusting Table Parallelism** on **Page 39**) and the outfeed table height must be properly set (**Setting Outfeed Table Height** on **Page 18**).

Straightedge Method: A high quality straightedge is held flat against the outfeed table and the knife heights are set to the bottom of the straightedge, as shown in **Figure 59**. Because the knife projection height from the cutterhead is dependent on the outfeed table height, the outfeed table must be parallel to the cutterhead (**Page 39**) and set as described in **Setting Outfeed Table Height** on **Page 18** for this method to work correctly.

Knife Setting Jig Method: Both tables are flipped up to fit the gauge on the cutterhead, as shown in **Figure 60**, and the knife heights are set to just touch the middle pad of the gauge.

The knife setting gauge makes it easy to ensure that the knives project out of the cutterhead evenly. After using the knife setting gauge to set the knives, you have to re-adjust the outfeed table height to ensure that it is even with the knives at their highest point of rotation.

The included knife gauge is designed to set the knives approximately 0.062" higher than the cutterhead.

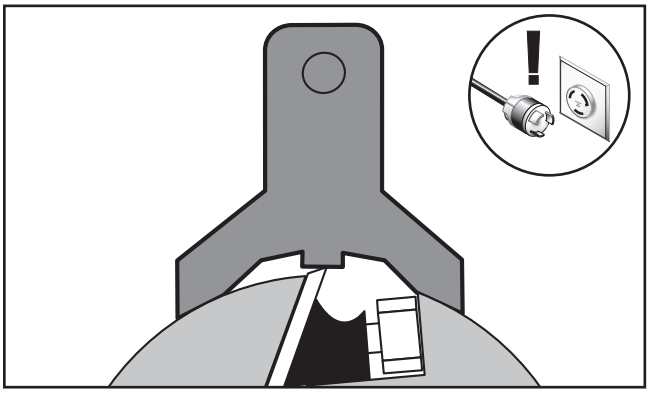


Figure 60. Using knife setting gauge to set knife height.

The Model G0633 comes with both jack screws and springs inside the cutterhead to provide two options for adjusting the knives (see **Figure 61**). **Note:** *Only one of these options is needed to set the knives—see **Step 5** for clarification.*

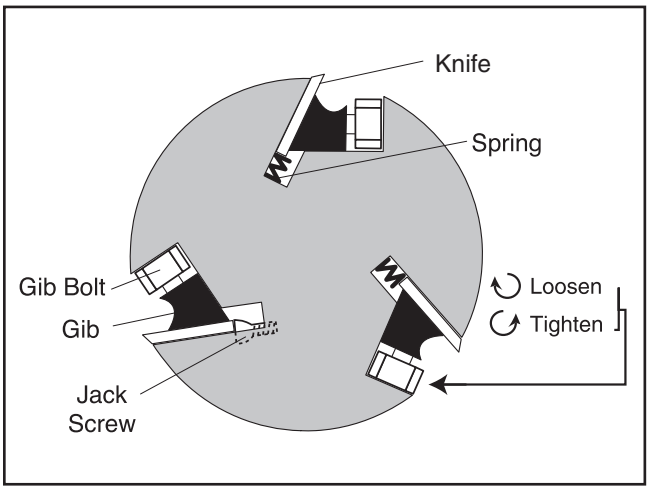


Figure 61. Cutterhead profile diagram.

To adjust/replace the knives:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the cutterhead guard from the table, and flip up the lower the infeed and outfeed tables. This will give you unrestricted access to the cutterhead.

3. Remove the motor access panel to expose the motor pulley.

4. Rotate the motor pulley to give you good access to one of the cutterhead knives.

⚠CAUTION

Knives are sharp! When adjusting knives, wear gloves or cover knives with rags to avoid contact with knives, which could cause serious personal injury.

5. Loosen the cutterhead gib bolts, starting in the middle and alternating back and forth until all of the gib bolts are loose, but not falling out.

   —If this is the first time you are setting the knives, remove the gib and knife from the cutterhead. Decide which adjustment option you are going to use between the jack screws and the springs.

   —If you decide to use the jack screws, remove the springs from the cutterhead (they are located directly below the knives).

   —If you decide to use the springs, just thread the jack screws completely into the cutterhead so they will not get lost. Replace the gib and knife.

6. Remove and clean the gibs and clean inside the cutterhead slot to remove all pitch or sawdust. Coat the knives and gibs with a metal protectant (**Page 32**), then fit the gibs back in the cutterhead with the new knives.

7. Adjusting the knife heights:

   Jack Screws: Using a 3mm hex wrench, find the jack screws through the access holes in the cutterhead (**Figure 62**) and rotate them to raise/lower the knife. When the knife is set correctly, it will barely touch the middle pad of the knife setting gauge. For now, only tighten the gib bolts enough to hold the knife in place. Repeat **Steps 5–7** with the other knives.

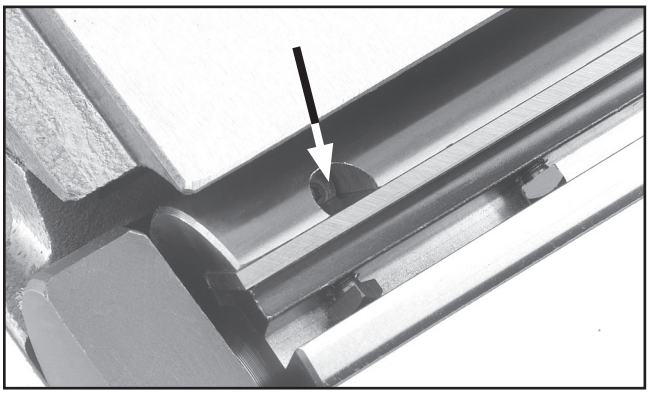


Figure 62. Jack screw access hole.

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

8. Rotate the cutterhead to the first knife you started with. Slightly tighten all the gib bolts by following the tightening sequence show in **Figure 63**. Repeat this step on the rest of the knives, then final tighten each gib bolt.

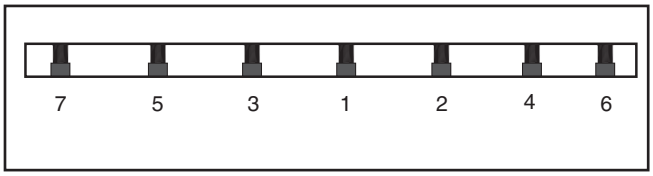


Figure 63. Gib tightening sequence.

9. If you used the knife setting gauge to set the knife heights, use the straightedge to adjust the outfeed table height evenly with the knives at top dead center (the highest point in their rotation). If you used the straightedge to set the knife heights, skip to the next step.

10. Replace the cutterhead guard and the motor access panel.

Replacing Carbide Inserts (G0634)

Tools Needed: **Qty**
T-Handle Wrench w/T-20 Torx Bit..... 1

The cutterhead is equipped with 56 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90˚ to reveal a fresh cutting edge (**Figure 64**).

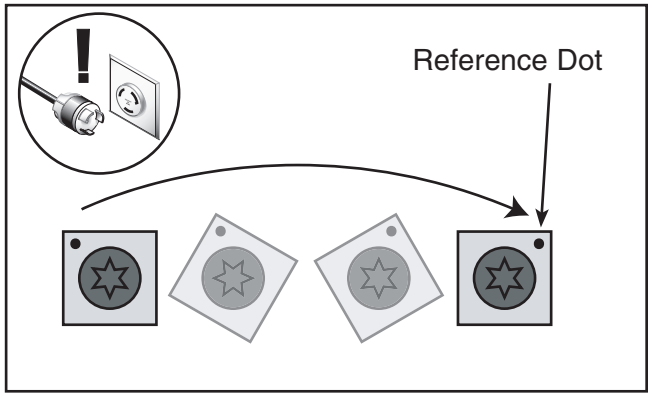


Figure 64. Insert rotating sequence.

In addition, 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. When the reference dot revolves back around to its starting position, the insert should be replaced.

To rotate or change a carbide insert:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove any sawdust from the head of the carbide insert Torx screw.

3. Remove the Torx screw and carbide insert.

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

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

5. Lubricate the Torx screw threads with a light machine oil, wipe the excess oil off the threads, and torque the Torx screw to 48-50 inch/pounds.

   Note: *Excess oil may squeeze between the insert and cutterhead, thereby lifting the insert slightly and affecting workpiece finishes.*

Calibrating Depth Scale

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

Tools Needed	Qty
Straightedge	1
Phillips Screwdriver	1

To calibrate the depth scale:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Set the outfeed table height as described in the **Setting Outfeed Table Height** instructions on **Page 18**.

3. Use the straightedge to help adjust the infeed table exactly even with the outfeed table, as shown in **Figure 65**.

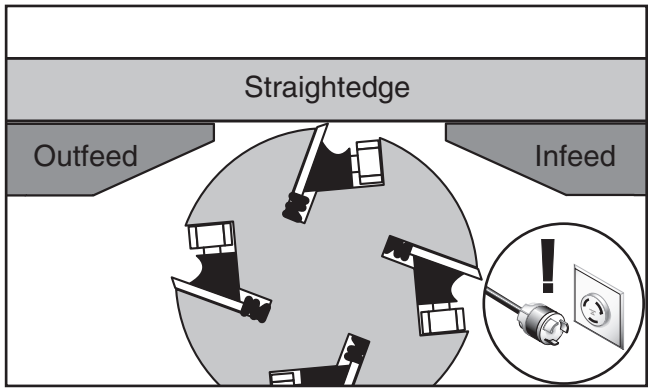


Figure 65. Infeed table even with outfeed table.

4. Using a screwdriver, adjust the scale pointer to zero (**Figure 66**).

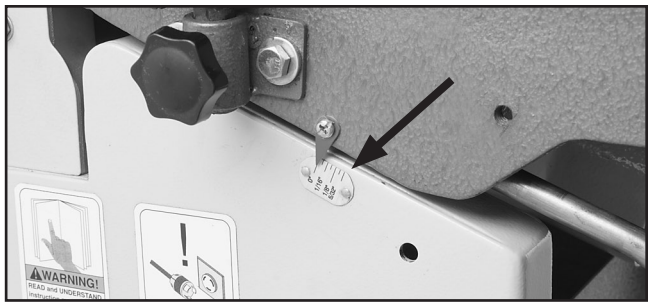


Figure 66. Depth scale adjusted to “0” position.

Pulley Alignment

Tools Needed:	Qty
Straightedge	1
Hex Wrench 3mm	1
C-Clamps	2

Proper pulley alignment (see **Figure 68**) prevents premature belt wear. The pulleys are properly aligned when they are parallel and in the same plane as each other.

To align the pulleys:

1. Remove the fence assembly, fence bracket, and the V-belt cover (**Figure 67**).

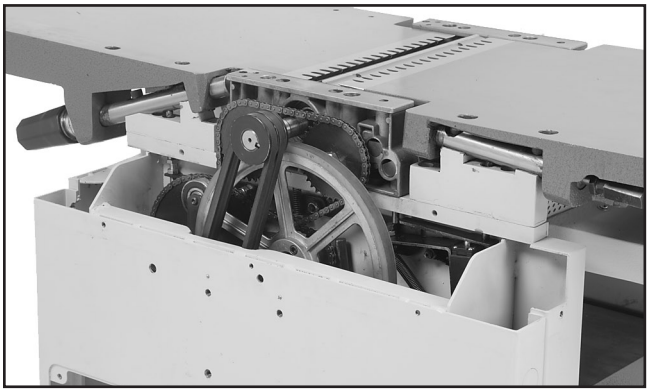


Figure 67. Fence and V-belt cover removed.

2. Place a 2" C-clamp on each pulley so the adjustment shaft faces out, place a straightedge on the clamps, as shown in **Figure 68**, and visually check pulley alignment.

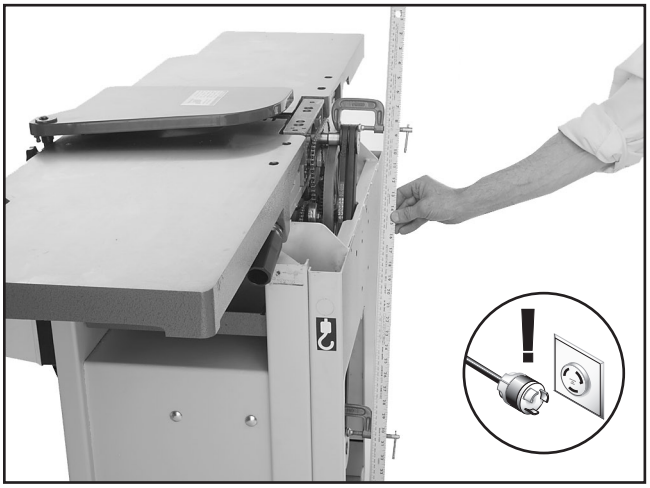


Figure 68. Checking belt alignment.

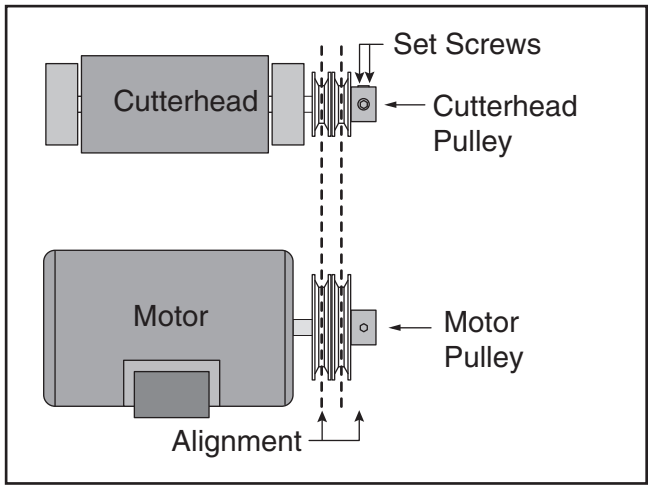


Figure 69. Pulleys properly aligned. V-belts are parallel and coplaner.

— If the pulleys are aligned, then no adjustments are necessary.

— If the pulleys are NOT aligned, perform **Steps 3 & 4**.

3. Remove the V-belts (see **Page 34**), loosen the set screws on the end of the cutterhead pulley, and align the cutterhead pulley with the motor pulley.

4. Tighten the set screws, replace the V-belts, and repeat **Step 2**.

5. Reinstall the V-belt cover, fence bracket and fence assembly.

Setting Fence Stops

The fence stops simplify the task of adjusting the fence to 45˚ and 90˚.

Tools Needed	Qty
45° Square	1
90° Square	1
Sliding Bevel	1
Wrench 10mm	1

To set the 90˚ fence stop:

1. Loosen the lock nut on the 90° fence stop bolt shown in **Figure 70**, and loosen the fence tilt lock.

2. Place a 90° square against the table and fence, and adust the stop bolt, so the fence is set exactly at 90°.

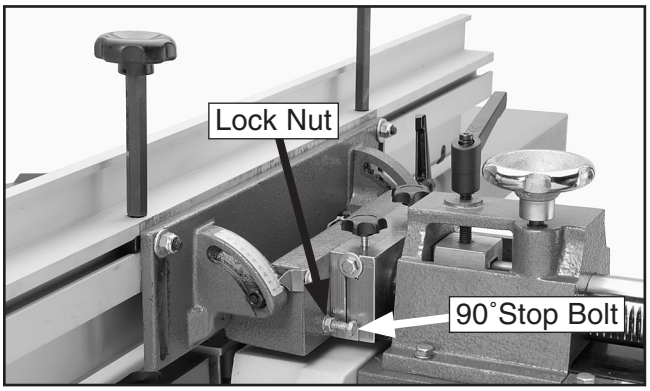


Figure 70. Adjusting fence to 90˚.

3. Tighten the lock nut.

4. Adjust the indicator (if necessary) to 0° to calibrate the fence tilt scale.

To set the 45° fence stop:

1. Loosen the fence tilt lock, and position the fence against the 45° stop bolt.

2. Loosen the lock nut on the 45˚ fence stop bolt (**Figure 71**).

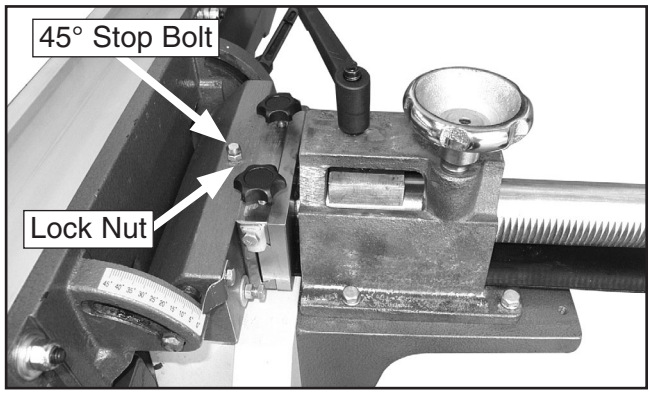


Figure 71. Adjusting fence 45˚ outward.

3. Adjust the 45˚ stop bolt until the fence is exactly 45° outward while resting on the bolt (check the angle with a sliding bevel set to 135° or with a 45° square.

4. Retighten the lock nut loosened in **Step 2**.

Adjusting Table Lock Levers

The table lock levers can be adjusted if they do not lock.

Tools Needed	Qty
Wrench 14 mm	1

To adjust the table lock levers:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Remove the cutterhead guard.

3. Raise the table on the side of the lock lever that does not lock.

4. Loosen the lock nut on the special bolt under the table, as shown in **Figure 72**.

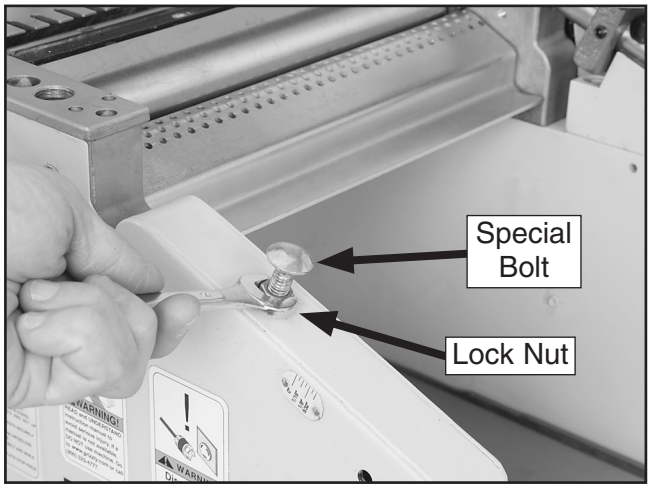


Figure 72. Table lock lever bolt.

5. Adjust the bolt height a few turns, lower the table, and try engaging the lock lever.

6. Repeat **Steps 3-5** until the lever engages, then secure the lock nut.

Adjusting Gibs

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

Tools Needed	Qty
Adjustable Wrench	1
Hex Wrench 8mm	1

To adjust the table gibs:

1. Using an adjustable wrench, loosen the infeed table gib nut under the rear of the table (**Figure 73**).

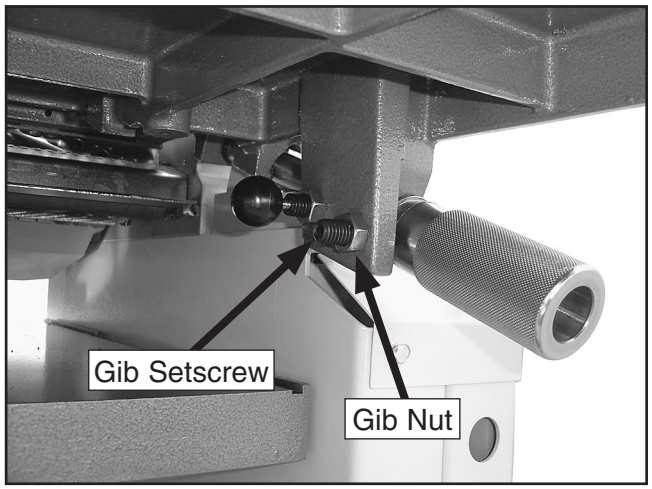


Figure 73. Infeed table gib control.

2. Using an 8mm hex wrench, tighten the gib setscrew a small amount, then check the table by moving it up and down. Adjust the set screw as needed until the friction of the table movement is balanced between minimal play and ease of movement, then secure the lock nut.

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

3. Repeat **Steps 1-2** with the outfeed table gib control (**Figure 74**).

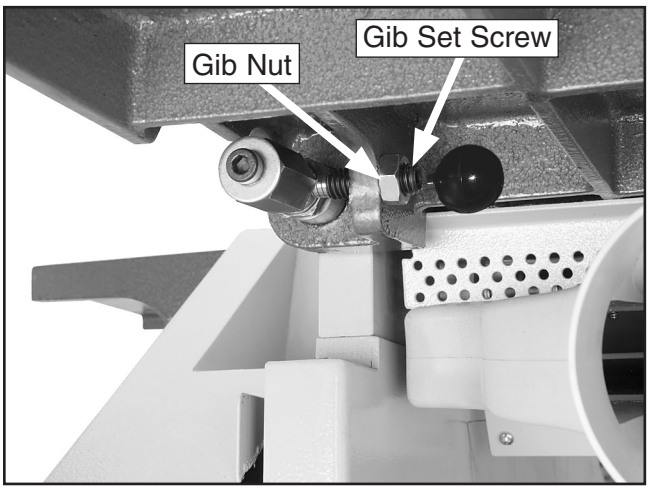


Figure 74. Outfeed table gib control.

4. Set the outfeed table height as described in **Setting Outfeed Table Height** on **Page 18**.

Planer Table Parallelism

Maximum Allowable Tolerances:
Cutterhead/Table Side-to-Side ..... 0.002"
Head Casting/Table Front/Back ..... 0.020"

Tools Needed:	**Qty**
Rotacator	1
Wrench 12mm	1
Hex Wrench 4mm	1
Hex Wrench 8mm	1

Table parallelism is critical to the operation of the planer. As such, it is essential that the planer table is parallel with the cutterhead (within 0.002") from side-to-side, as illustrated in **Figure 75.**

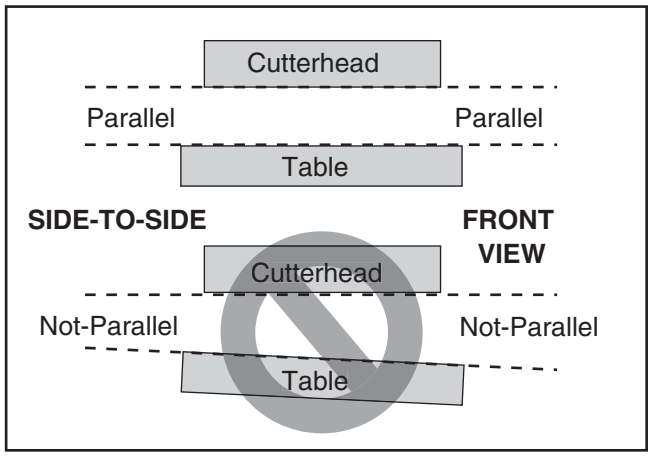


Figure 75. Side-to-side parallelism of table and cutterhead.

How the planer table sits in relation to the head casting from front-to-back is also important (see **Figure 76**). The tolerances on the front-to-back positioning are not as critical as the cutterhead/table side-to-side positioning. Therefore, the maximum allowable tolerance for the front-to-back parallelism is not more than 0.020".

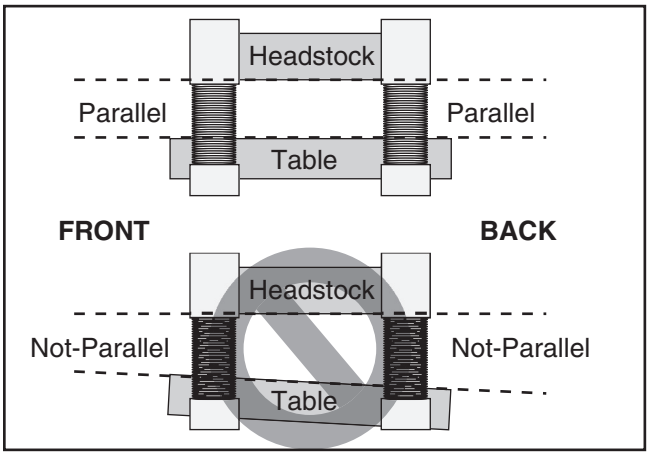


Figure 76. Front-to-back parallelism.

Table Parallelism Inspection

The easiest way to determine if your planer table has a parallelism problem with the headstock is to plane a workpiece and measure the thickness in multiple locations. If the workpiece is tapered from left-to-right or from front-to-back, then parallelism may be a problem.

Use your Rotacator (**Page 32**) to further inspect the table parallelism. If you do not have a Rotacator, a wood block and feeler gauges may be used, but extra care must be taken to ensure accuracy. If the table is not within the maximum allowable tolerances, it must be adjusted.

Table Parallelism Adjustments

The table is adjusted with the set screws on the cylinder liner.

To adjust the table parallelism:

1. DISCONNECT THE JOINTER/PLANER FROM THE POWER SOURCE!

2. Raise the planer table as far as possible.

3. Loosen the four cap screws on the cylinder liner, as shown in **Figure 77**.

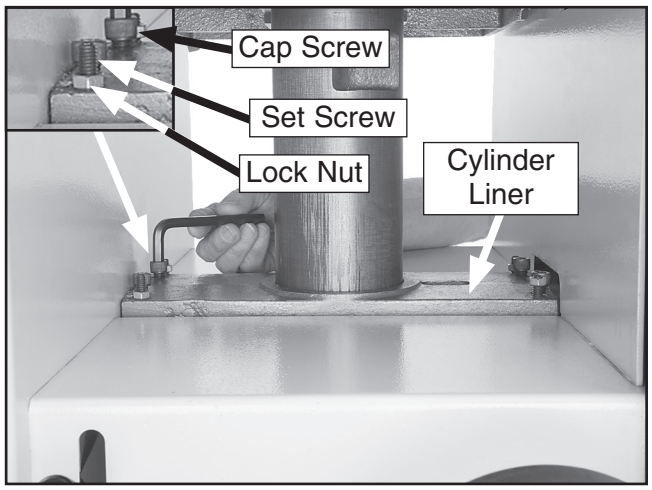


Figure 77. Adjusting table parallelism.

—If the table is not parallel to the cutterhead side-to-side (**Figure 75**), loosen the two lock nuts on the right or left side of the cylinder liner. Adjust the set screws to raise or lower the table so it is parallel to the cutterhead.

—If the table is not parallel to the cutterhead front-to-back (**Figure 76**), loosen the two lock nuts at the front or back of the cylinder liner. Adjust the set screws to raise or lower the front or back of the table so it is parallel to the cutterhead.

4. Tighten the four cap screws on the cylinder liner.

Spring Tension

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

Roller spring tension must be adjusted so that feed roller pressure is uniform. Roller spring tension will vary, depending on the type of wood you plane. This is usually determined from trial-and-error.

Generally speaking, less spring tension is more forgiving on workpieces. Therefore, if you primarily plane milled lumber with relatively consistent surfaces, you can get away with having less spring tension. Likewise, if you primarily plane rough lumber with inconsistent surface heights, more spring tension is a must to keep the workpiece feeding through the planer without stopping.

If workpieces regularly stop feeding during operation, it may be a sign of weak spring tension.

To adjust feed roller spring tension:

1. Locate the four adjustment screws located on the top of the planer, as shown in **Figure 78**.

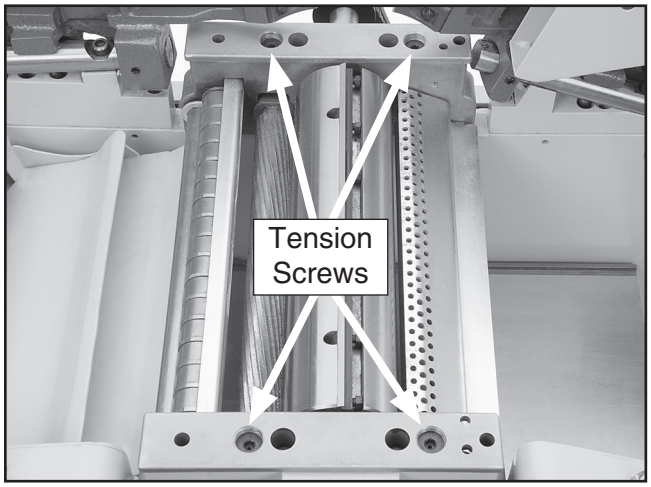


Figure 78. Spring tension screws.

2. Adjust the tension screws counterclockwise so that they are five to seven turns below the top of the head casting.

   —If the workpiece slips when you feed it, turn the screws ½ to 1 turn counterclockwise to increase spring tension.

   —If the workpiece is abruptly grabbed when initially fed into the planer, turn the screws ½ to 1 turn clockwise to decrease spring tension.

Anti-Kickback Fingers

The Model G6333/G0634 provides an anti-kickback system as a safety feature. The anti-kickback fingers hang from a rod suspended across the cutterhead casting. The anti-kickback fingers should be inspected regularly.

Check the fingers (**Figure 79**) to ensure that they swing freely and easily. If the fingers do not swing freely and easily, clean them with a wood resin solvent.

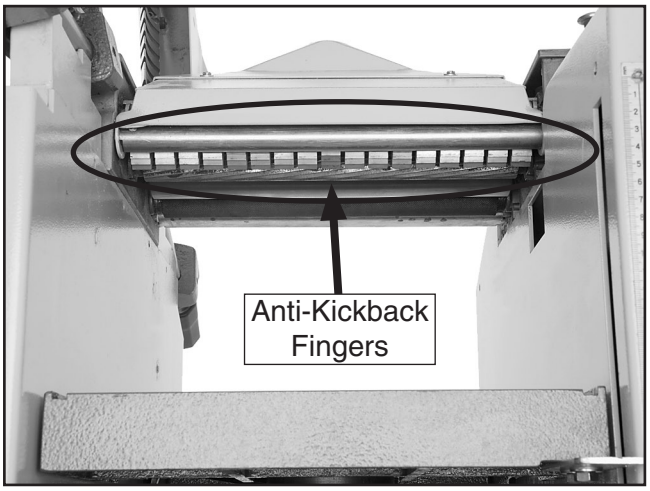


Figure 79. Anti-kickback fingers.

⚠WARNING

Proper operation of the anti-kickback fingers is essential for the safe operation of this machine. Failure to ensure that they are working properly could result in serious operator injury.

Do not apply oil or other lubricants to the anti-kickback fingers. Oil or grease will attract dust, restricting the free movement of the fingers.

Electrical Components

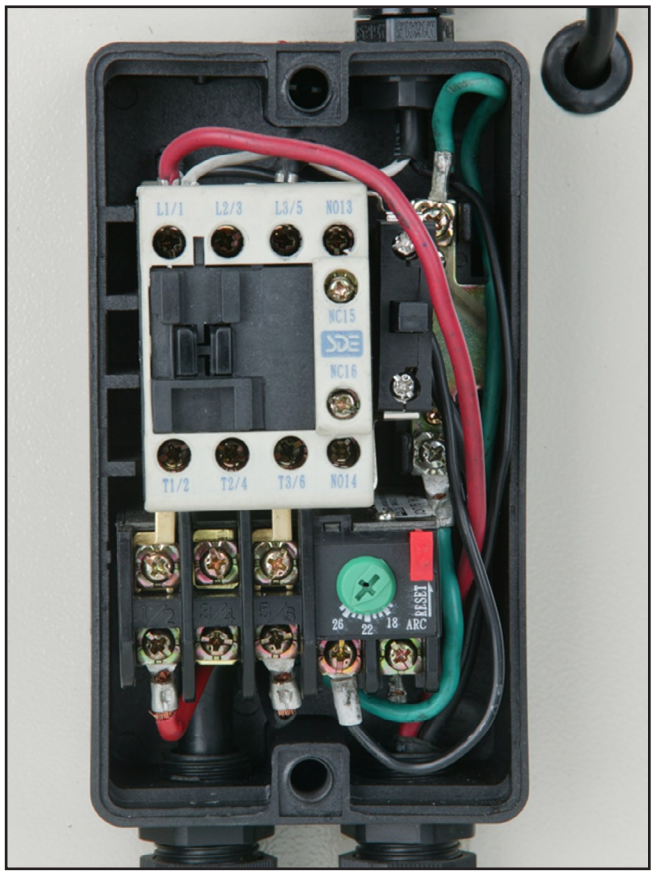


Figure 80. G0633/G0634 magnetic switch.

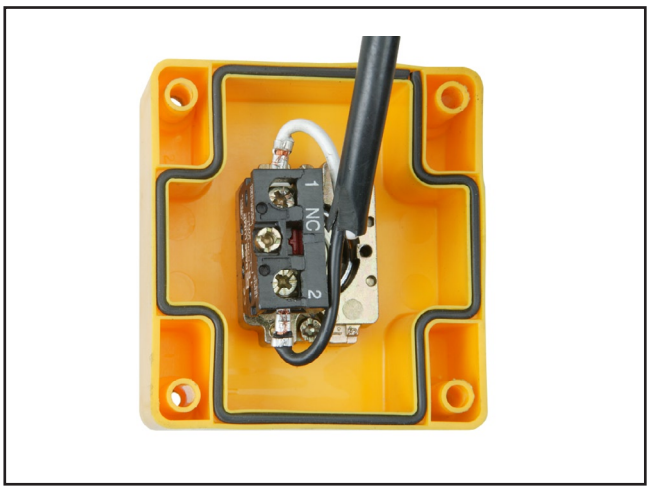


Figure 81. Emergency off switch.

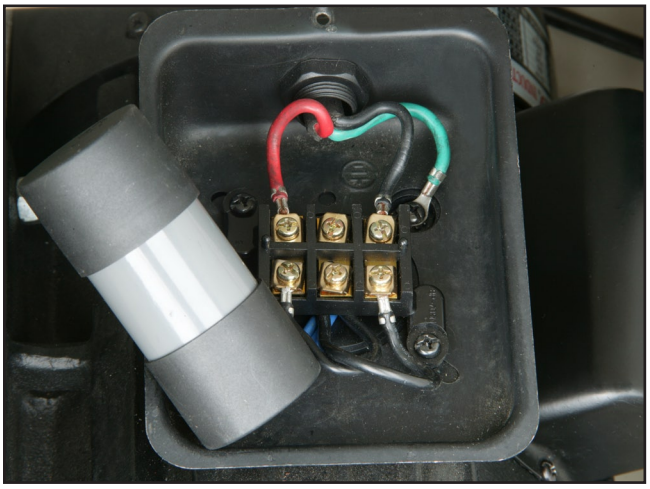


Figure 82. Junction box and start capacitor.

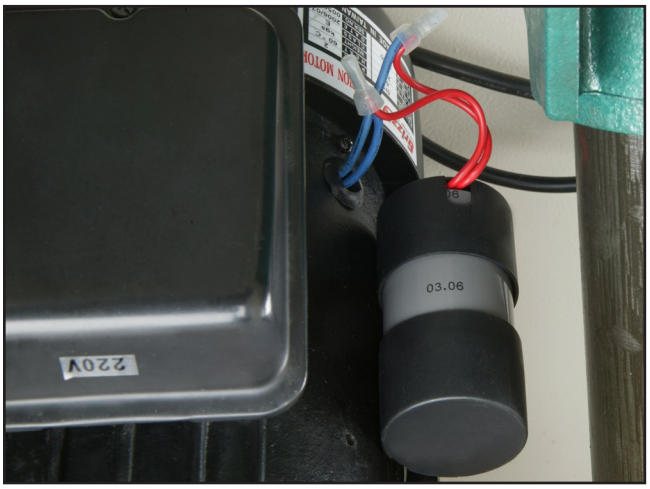


Figure 83. Run capacitor.

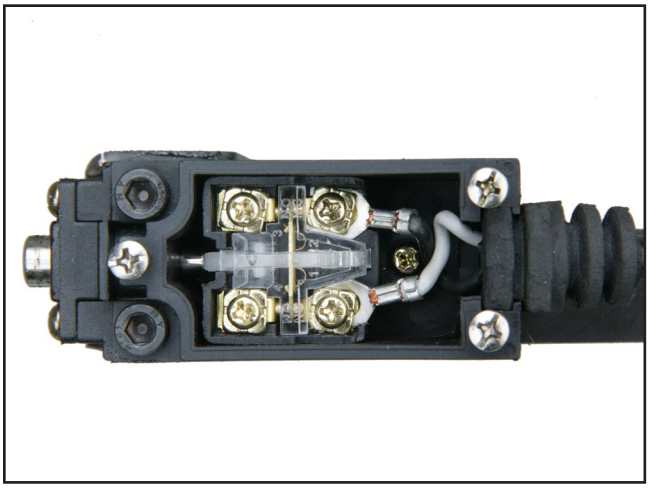


Figure 84. Jointer table limit switch.

Wiring Diagram

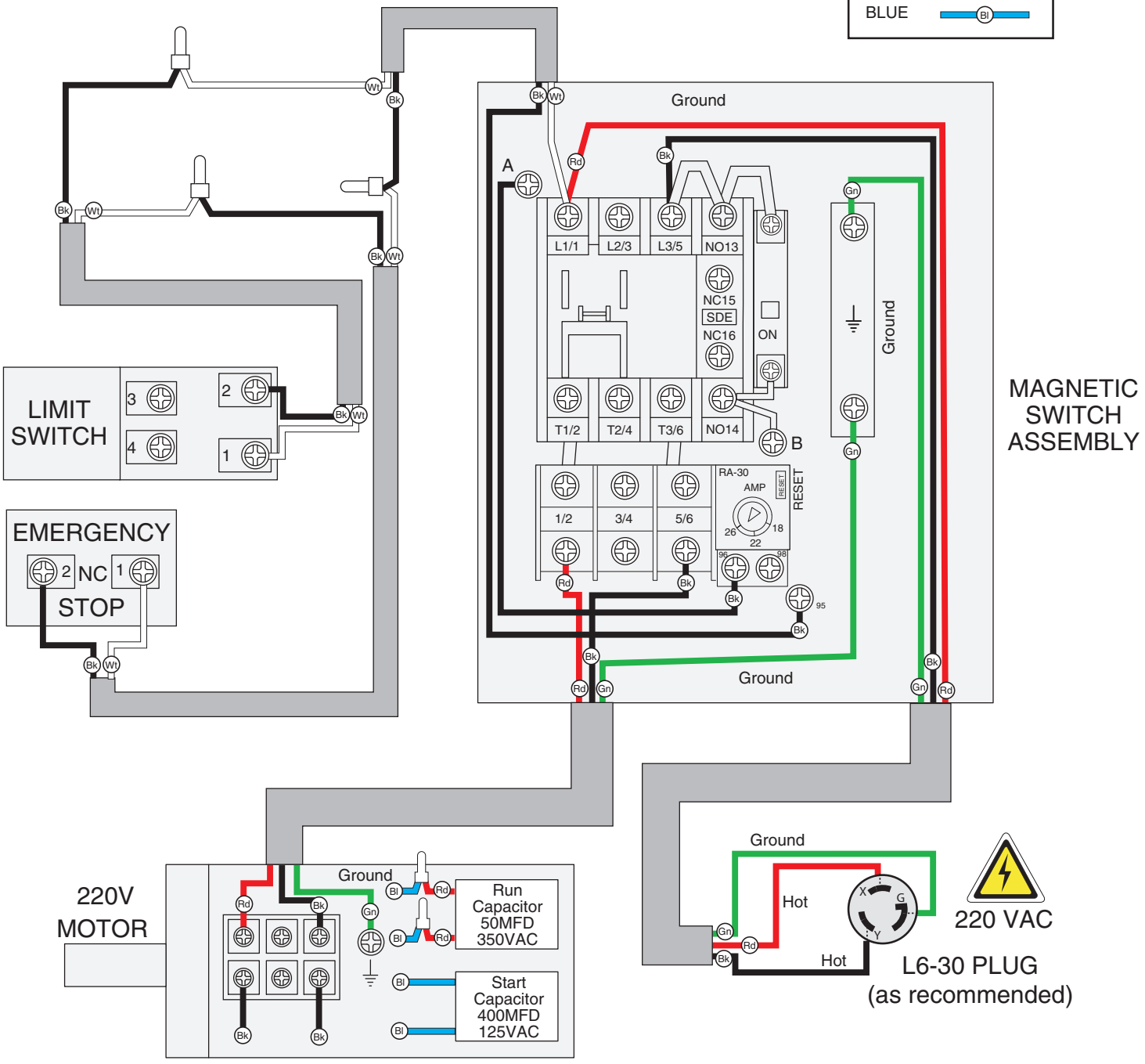
View this page in color at *www.grizzly.com.*

NOTICE

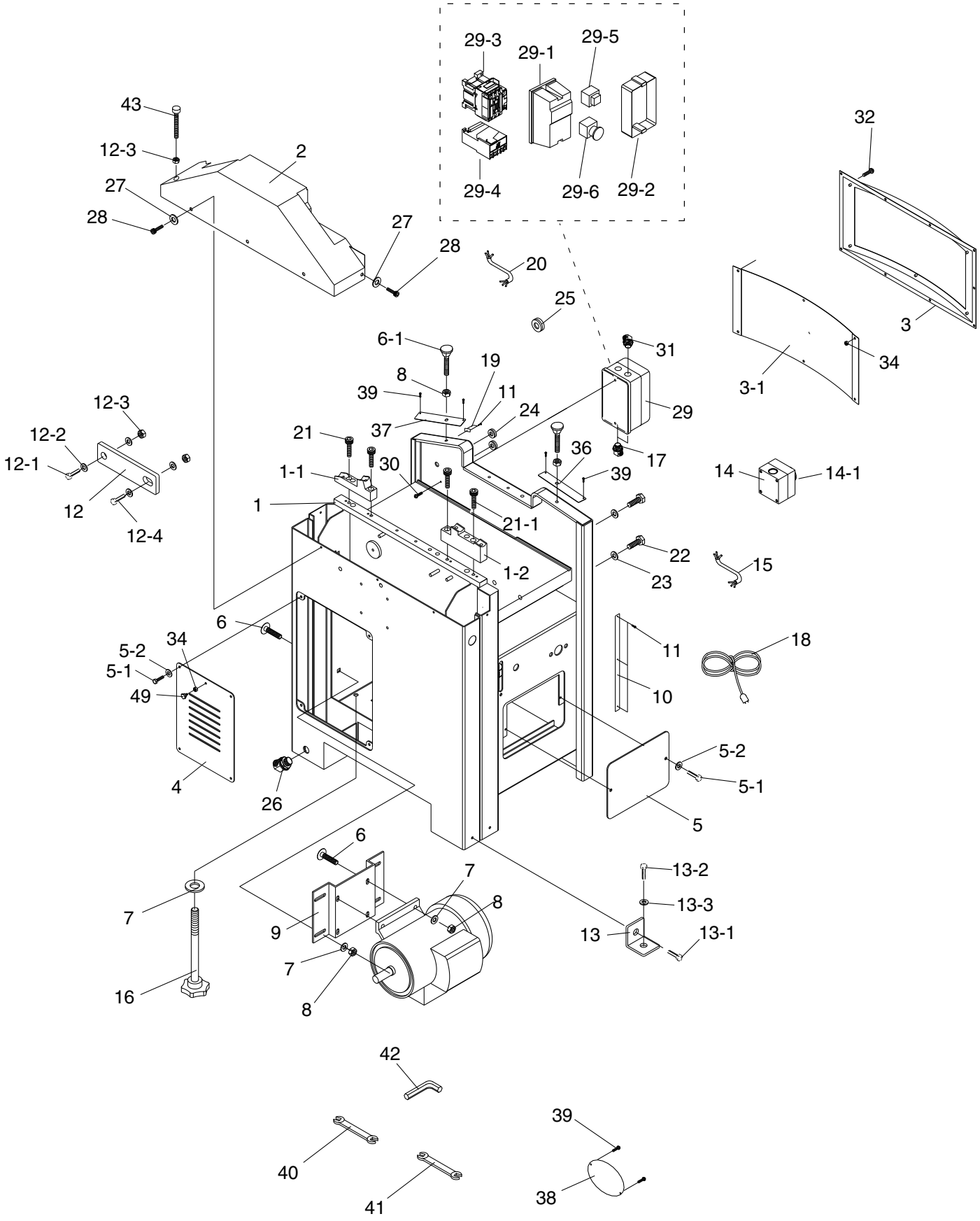
The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

COLOR KEY

BLACK	Bk
WHITE	Wt
GREEN	Gn
RED	Rd
BLUE	Bl



Stand Assembly Parts Breakdown

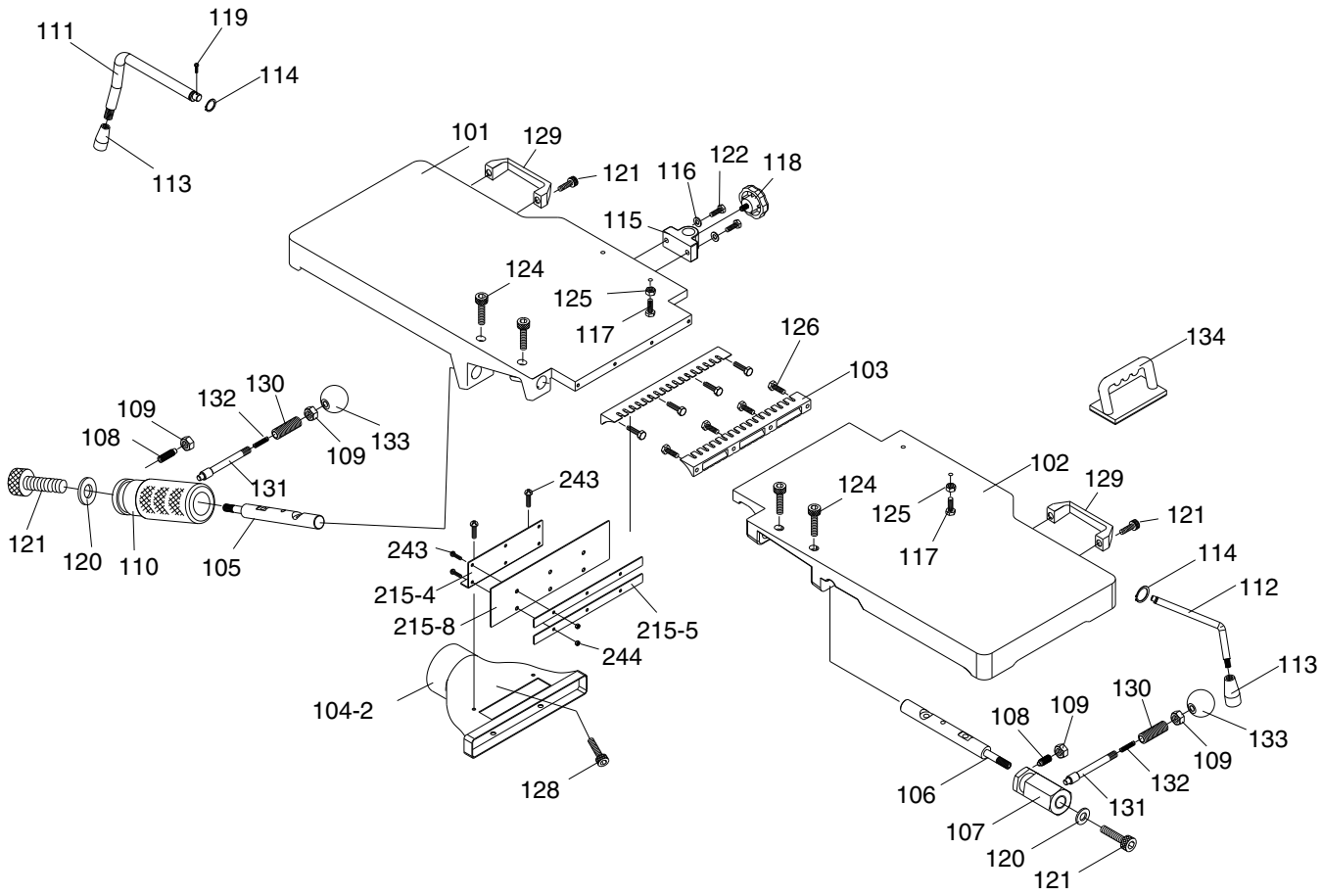


Stand Parts List

REF	PART #	DESCRIPTION
1	P0633001	FRAME
1-1	P0633001-1	HINGE SHAFT BRACKET (RIGHT)
1-2	P0633001-2	HINGE SHAFT BRACKET (LEFT)
2	P0633002	DRIVE SHAFT COVER
3	P0633003	COVER FRAME
3-1	P0633003-1	COVER
4	P0633004	DOOR
5	P0633005	SIDE OPENING COVER
5-1	PB09	HEX BOLT 5/16-18 X 1/2
5-2	PW07	FLAT WASHER 5/16
6	PCB22	CARRIAGE BOLT 3/8-16 X 1
6-1	P0633006-1	SPECIAL SCREW 3/8-16 X 1-1/2
7	PW02	FLAT WASHER 3/8
8	PN08	HEX NUT 3/8-16
9	P0633009	MOTOR BRACKET
10	P0633010	PLANER SCALE
11	P0633011	RIVET
12	P0633012	REINFORCEMENT PLATE
12-1	PB32	HEX BOLT 5/16-18 X 5/8
12-2	PW07	FLAT WASHER 5/16
12-3	PN02	HEX NUT 5/16-18
12-4	PB23	HEX BOLT 5/16-18 X 2-1/2
13	P0633013	SQUARE SUPPORT
13-1	PB09	HEX BOLT 5/16-18 X 1/2
13-2	PHTEK35	TAP SCREW 1/4 X 1
13-3	PW06	FLAT WASHER 1/4
14	P0633014	EMERGENCY OFF SWITCH
14-1	P0633014-1	SWITCH KNOB
15	P0633015	EMERGENCY STOP SWITCH CORD
16	P0633016	KNOB BOLT 3/8-16
17	P0633017	STRAIN RELIEF
18	P0633018	POWER CORD

REF	PART #	DESCRIPTION
19	P0633019	DEPTH SCALE
20	P0633020	LIMIT SWITCH CORD
21	PSB14	CAP SCREW 3/8-16 X 1
21-1	PSB26	CAP SCREW 3/8-16 X 1-1/2
22	PB02	HEX BOLT 1/4-20 X 5/8
23	PW06	FLAT WASHER 1/4
24	P0633024	GROMMET
25	P0633025	GROMMET
26	P0633026	STRAIN RELIEF
27	PW06	FLAT WASHER 1/4
28	PB51	HEX BOLT 1/4-20 X 3/8
29	P0633029	MAGNETI C SWITCH ASSEMBLY
29-1	P0633029-1	MAG SWITCH FRONT COVER
29-2	P0633029-2	MAG SWITCH BACK COVER
29-3	P0633029-3	CONTACTOR
29-4	P0633029-4	THERMAL RELAY
29-5	P0633029-5	ON BUTTON
29-6	P0633029-6	OFF BUTTON
30	PS22	PHLP HD SCR 10-24 X 5/8
31	P0633031	STRAIN RELIEF
32	PS103	PHLP HD SCR 1/4-20 X 5/16
34	PN05	HEX NUT 1/4-20
36	P0633036	PROTECTION PLATE (LEFT)
37	P0633037	PROTECTION PLATE (RIGHT)
38	G8588	GRIZZLY NAMEPLATE-SMALL
39	PHTEK24	TAP SCREW #5 X 3/8
40	PWR1214	WRENCH 12 X14
41	PWR810	WRENCH 8 X 10
42	PAW03M	HEX WRENCH 3MM
43	P0633043	SPECIAL SCREW 5/16-18 X 1-1/2
49	P0633049	KNOB 1/4-20 X 1/2

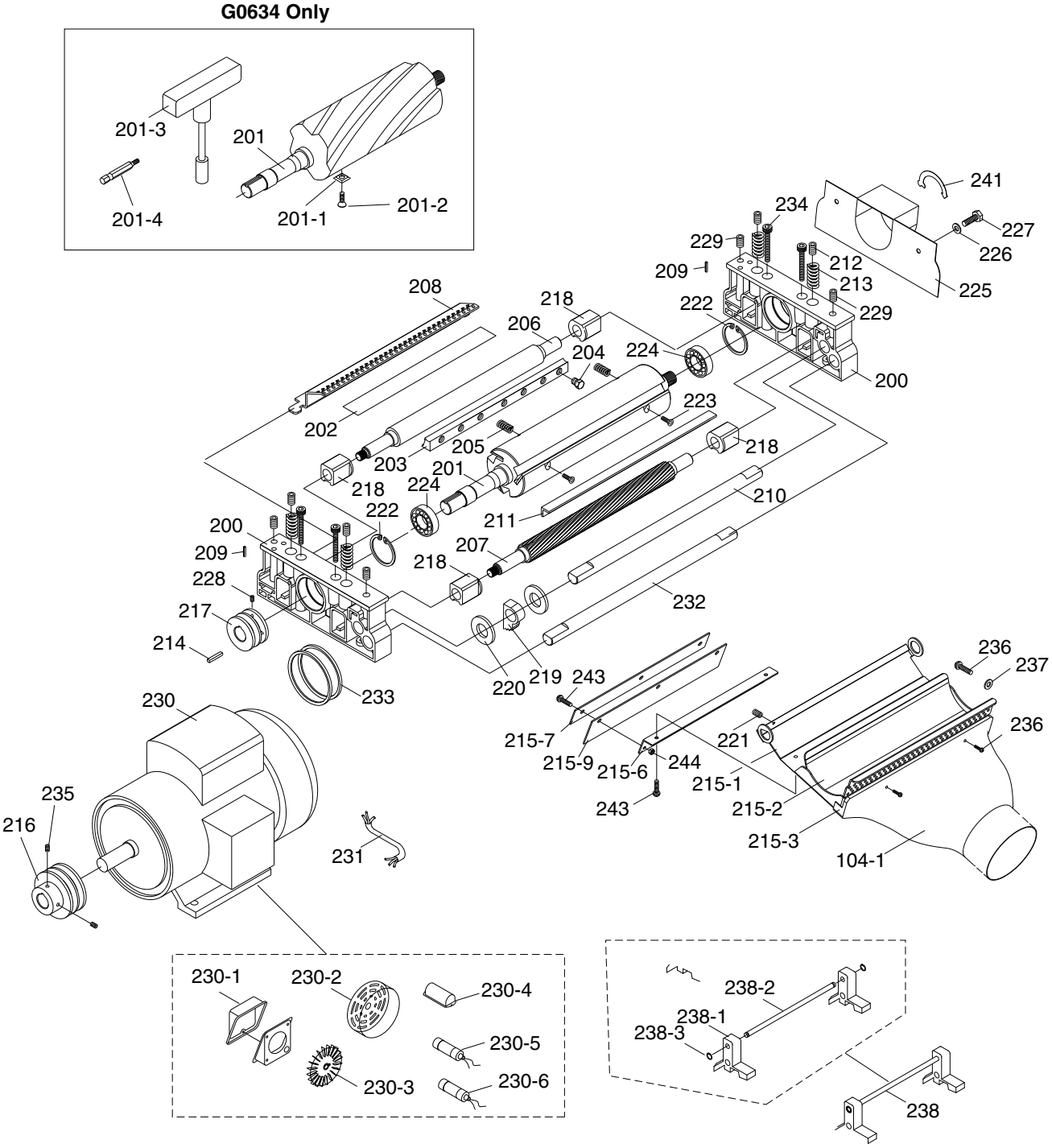
Table Assembly Parts Breakdown & List



REF	PART #	DESCRIPTION
101	P0633101	INFEED TABLE
102	P0633102	OUTFEED TABLE
103	P0633103	TABLE LIP
104-1	P0633104-1	JOINTER DUST PORT
105	P0633105	HINGE SHAFT A
106	P0633106	HINGE SHAFT B
107	P0633107	OUTFEED TABLE ADJ. KNOB
108	P0633108	GUIDE SCREW
109	PN01	HEX NUT 1/2-20
110	P0633110	INFEED HANDGRIP
111	P0633111	INFEED LOCK LEVER
112	P0633112	OUTFEED LOCK LEVER
113	P0633113	PLASTIC KNOB
114	PR03M	EXT RETAINING RING 12MM
115	P0633115	CUTTERHEAD GUARD BRACKET
116	PW06	FLAT WASHER 1/4
117	PB07	HEX BOLT 5/16-18 X 3/4

REF	PART #	DESCRIPTION
118	P0633118	KNOB SCREW 1/4-20 X 1
119	PS18	PHLP HD SCR 10-24 X 1/4
120	PW07	FLAT WASHER 5/16
121	PSB07	CAP SCREW 5/16-18 X 3/4
122	PB31	HEX BOLT 1/4-20 X 1
124	PSB19	CAP SCREW 3/8-16 X 1-1/4
125	PN02	HEX NUT 5/16-18
126	PSB04	CAP SCREW 1/4-20 X 1/2
127	P0633127	PLASTIC PLUG
128	PSB45	CAP SCREW 5/16-18 X 3/8
129	P0633129	HANDLE
130	P0633130	SPECIAL SCREW 1/2
131	P0633131	PLUNGER
132	P0633132	COMPRESSION SPRING
133	P0633133	KNOB
134	G2405	PUSH BLOCK-SMALL

Cutterhead & Motor Breakdown

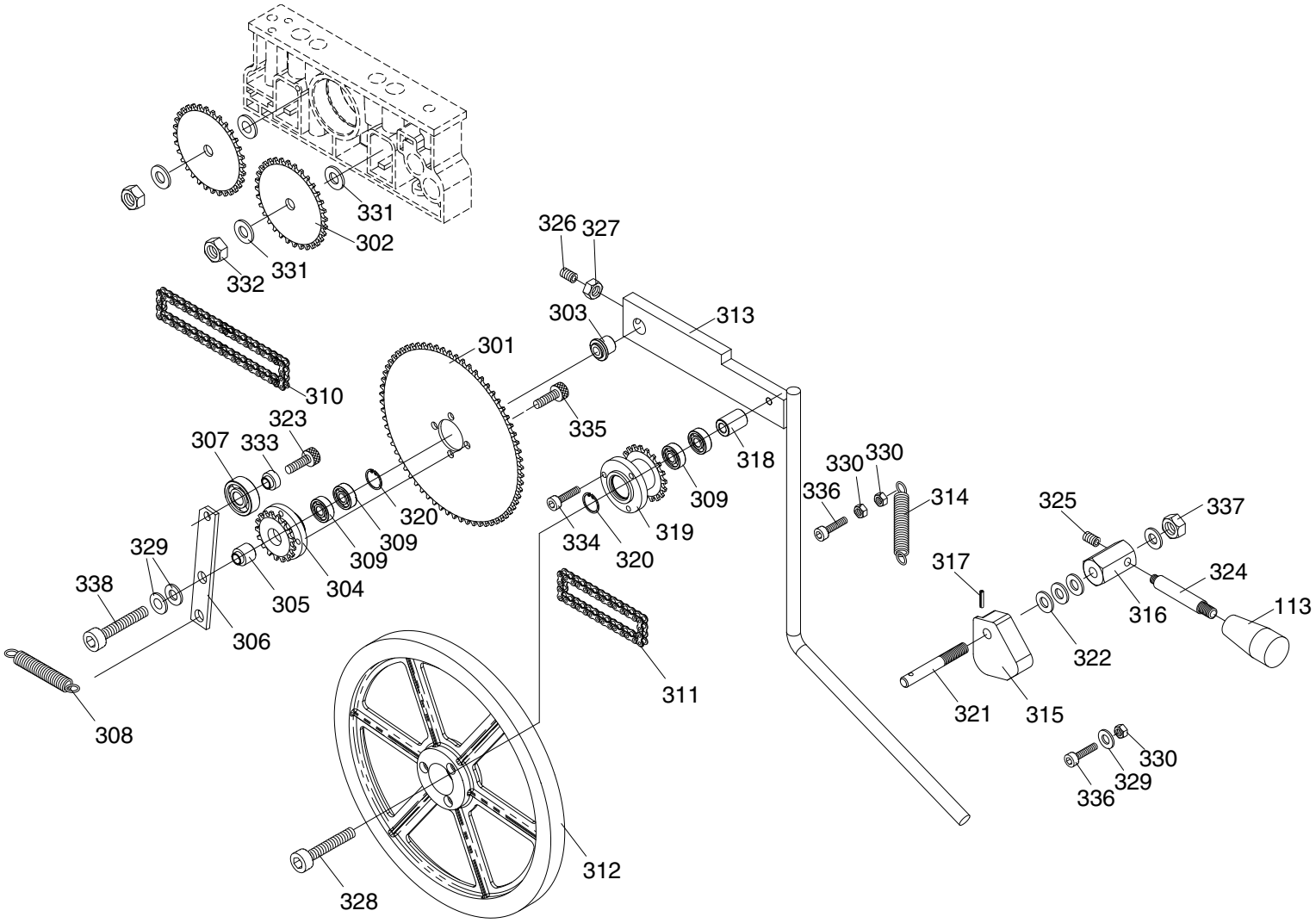


Cutterhead & Motor Parts List

REF	PART #	DESCRIPTION
200	P0633200	CUTTERHEAD BLOCK
201	P0633201	CUTTERHEAD (G0633)
201	P0634201	12" SPIRAL CUTTERHEAD (G0634)
201-1	P0634201-1	INDEXABLE CUTTER (G0634)
201-2	PFH35M	FLAT HD TORX T20 M6-1 X 15 (G0634)
201-3	P0634201-3	TORX T-HANDLE WRENCH 6MM (G0634)
201-4	P0634201-4	TORX BIT T-20 (G0634)
202	P0633202	KNIFE (G0633)
203	P0633203	GIB (G0633)
204	P0633204	GIB BOLT (G0633)
205	P0633205	COMPRESSION SPRING (G0633)
206	P0633206	OUTFEED ROLLER
207	P0633207	INFEED ROLLER
208	P0633208	COVER
209	P0633209	ALIGNMENT PIN
210	P0633210	PIVOT PIN
211	P0633211	SQUARE SUPPORT
212	P0633212	DOWEL
213	P0633213	COMPRESSION SPRING
214	P0633214	CUTTERHEAD PULLEY KEY
215	P0633215	DUST CHUTE
215-4	P0633215-4	L BRACKET
215-5	P0633215-5	PLATE
215-6	P0633215-6	BRACKET
215-7	P0633215-7	PLATE
215-8	P0633215-8	PLATE
215-9	P0633215-9	PLATE
216	P0633216	MOTOR PULLEY
217	P0633217	PULLEY
218	P0633218	SUPPORT
219	P0633219	ANTIKICKBACK FINGER

REF	PART #	DESCRIPTION
220	P0633220	SPACER
221	PSS07	SET SCREW 1/4-20 X 1/2
222	PR26M	INT RETAINING RING 52MM
223	PFH58M	FLAT HD ALLEN SCR M5-.8 X 12 (G0633)
224	P62052RS	BALL BEARING 6205-2RS
225	P0633225	GUARD
226	PW06	FLAT WASHER 1/4
227	PB51	HEX BOLT 1/4-20 X 3/8
228	PSS11	SET SCREW 1/4-20 X 1/4
229	PSS07	SET SCREW 1/4-20 X 1/2
230	P0633230	MOTOR 5HP
230-1	P0633230-1	JUNCTION BOX
230-2	P0633230-2	FAN COVER
230-3	P0633230-3	MOTOR FAN
230-4	P0633230-4	CAPACITOR COVER
230-5	P0633230-5	START CAPACITOR 400MFD 125VAC
230-6	P0633230-6	RUN CAPACITOR 50MFD 350VAC
231	P0633231	MOTOR CORD
232	P0633232	PIVOT PIN
233	PVM52	V-BELT FM-52 3L520
234	PSB55	CAP SCREW 5/16-18 X 3-1/4
235	PSS03	SET SCREW 1/4-20 X 3/8
236	PS06	PHLP HD SCR 10-24 X 3/8
237	PW03	FLAT WASHER #10
238	P0633238	KNIFE SETTING GAUGE
238-1	P0633238-1	KNIFE SETTING GAUGE FEET
238-2	P0633238-2	KNIFE SETTING GAUGE ROD
238-3	PEC10M	E-CLIP 9MM
241	P0633241	CUTTERHEAD ROTATION LABEL
243	PS01	PHLP HD SCR 10-24 X 1/2
244	PN07	HEX NUT 10-24

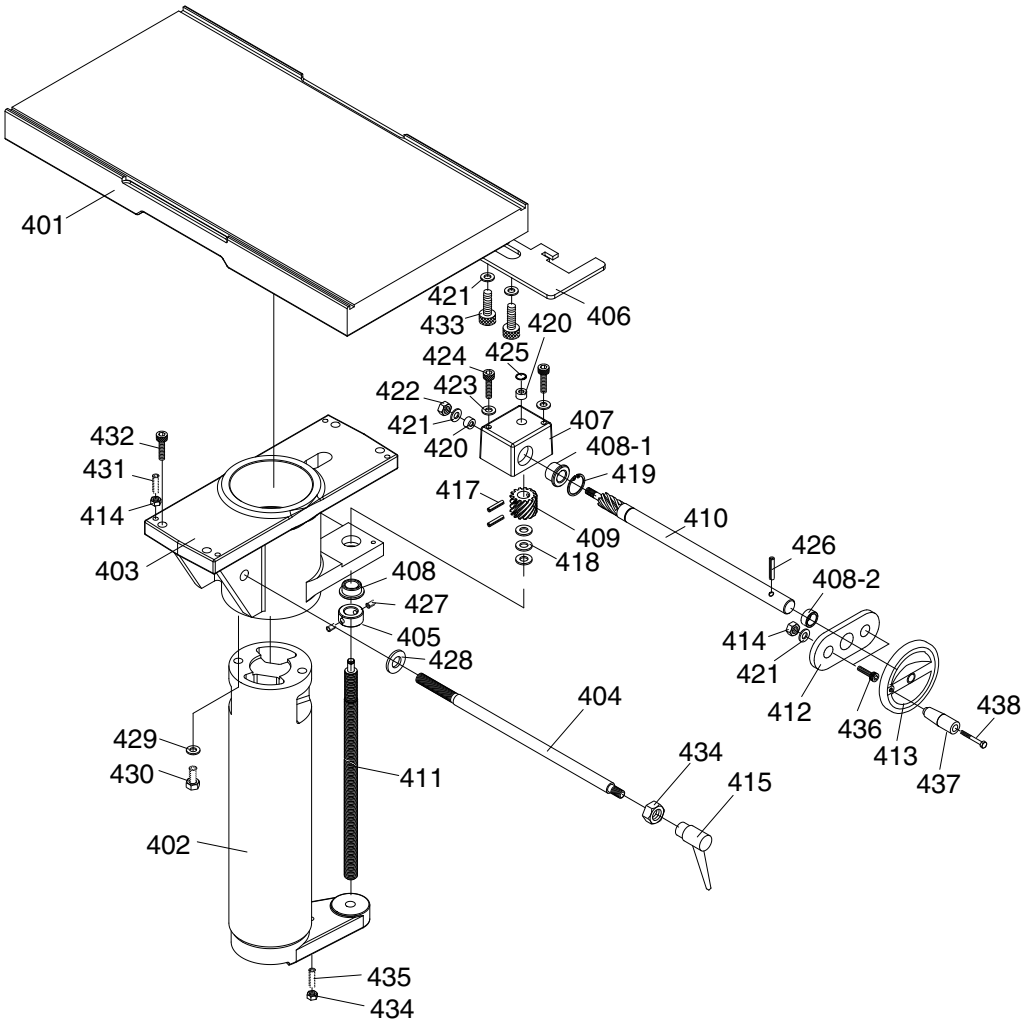
Drive Assembly Breakdown & List



REF	PART #	DESCRIPTION
113	P0633113	PLASTIC KNOB
301	P0633301	SPROCKET 66T
302	P0633302	SPROCKET 34T
303	P0633303	BUSHING
304	P0633304	SPROCKET 18T
305	P0633305	SPACER
306	P0633306	ARM
307	P62042RS	BALL BEARING 6204-2RS
308	P0633308	TENSION SPRING
309	P6082RS	BALL BEARING 608-2RS
310	P0633310	ROLLER CHAIN
311	P0633311	ROLLER CHAIN
312	P0633312	CONTACT WHEEL
313	P0633313	LEVER
314	P0633314	TENSION SPRING
315	P0633315	CAM
316	P0633316	CAM SHAFT
317	P0633317	ROLL PIN
318	P0633318	SPACER
319	P0633319	SPROCKET 19T

REF	PART #	DESCRIPTION
320	PR57M	INT RETAINING RING 22MM
321	P0633321	STUD
322	PW02	FLAT WASHER 3/8
323	PSB100	CAP SCREW 3/8-16 X 1/2
324	P0633324	LEVER
325	PSS02	SET SCREW 5/16-18 X 3/8
326	PSS12	SET SCREW 1/4-20 X 1
327	PN05	HEX NUT 1/4-20
328	PSB70	CAP SCREW 5/16-18 X 2
329	P0633329	FLAT WASHER 5/16
330	PN02	HEX NUT 5/16-18
331	PW01	FLAT WASHER 1/2
332	PN01	HEX NUT 1/2-20
333	P0633333	BUSHING
334	PSB05	CAP SCREW 1/4-20 X 3/4
335	PSB17	CAP SCREW 1/4-20 X 3/8
336	PSB07	CAP SCREW 5/16-18 X 3/4
337	PLN01	LOCK NUT 3/8-16
338	PSB12	CAP SCREW 5/16-18 X 2-1/2

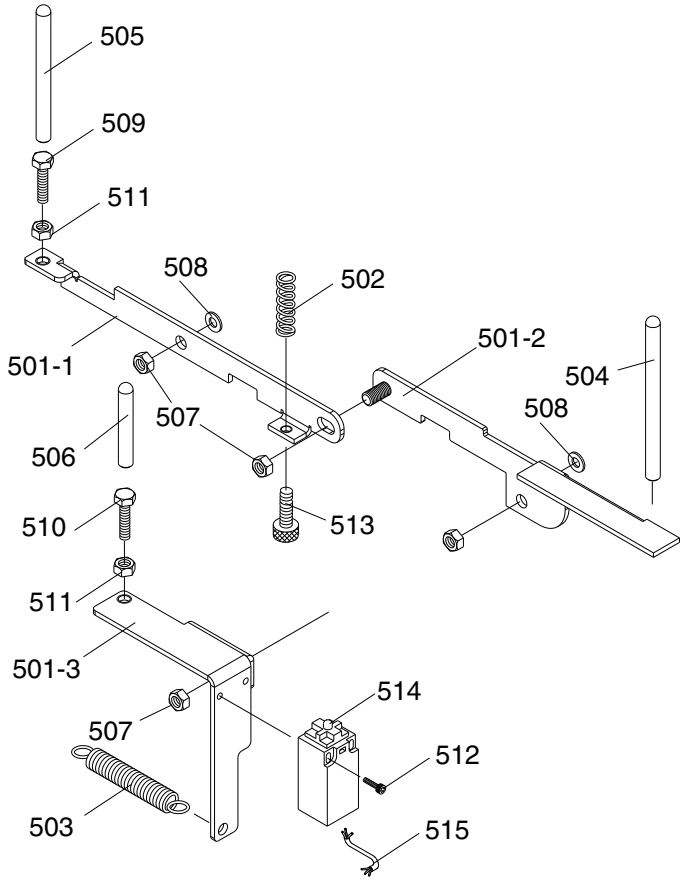
Planer Table Breakdown & List



REF	PART #	DESCRIPTION
401	P0633401	PLANER TABLE
402	P0633402	COLUMN
403	P0633403	CYLINDER LINER
404	P0633404	LOCK SCREW
405	P0633405	COLLAR
406	P0633406	THICKNESS POINTER
407	P0633407	GEAR BOX
408	P0633408	BUSHING
408-1	P0633408-1	SELF-LUBRICATION BUSHING
408-2	P0633408-2	SELF-LUBRICATION BUSHING
409	P0633409	GEAR
410	P0633410	WORM SHAFT
411	P0633411	ELEVATION LEAD SCREW
412	P0633412	SHIELD PLATE
413	P0633413	HANDWHEEL
414	PN02	HEX NUT 5/16-18
415	P0633415	UNIVERSAL LOCK LEVER
417	P0633417	ROLL PIN
418	P0633418	THRUST BEARING NTB1528 +2AS
419	PR79M	INT RETAINING RING 19MM

REF	PART #	DESCRIPTION
420	P0633420	BUSHING
421	PW07	FLAT WASHER 5/16
422	PLN03	LOCK NUT 5/16-18
423	PLW02	LOCK WASHER 1/4
424	PSB56	CAP SCREW 1/4-20 X 2-1/4
425	PR88M	INT RETAINING RING 8MM
426	PRP05M	ROLL PIN 5 X 30
427	PSS05	SET SCREW 5/16-18 X 1/4
428	P0633428	FLAT WASHER
429	PLW04	LOCK WASHER 3/8
430	PB16	HEX BOLT 3/8-16 X 1-1/2
431	PSS01	SET SCREW 5/16-18 X 1
432	PSB19	CAP SCREW 3/8-16 X 1-1/4
433	PB09	HEX BOLT 5/16-18 X 1/2
434	PN08	HEX NUT 3/8-16
435	PSS36	SET SCREW 3/8-16 X 2
436	PS35	PHLP HD SCR 5/16-18 X 3/4
437	P0633437	HANDLE
438	P0633438	SPECIAL SCREW 3/8-16 X 3-3/8

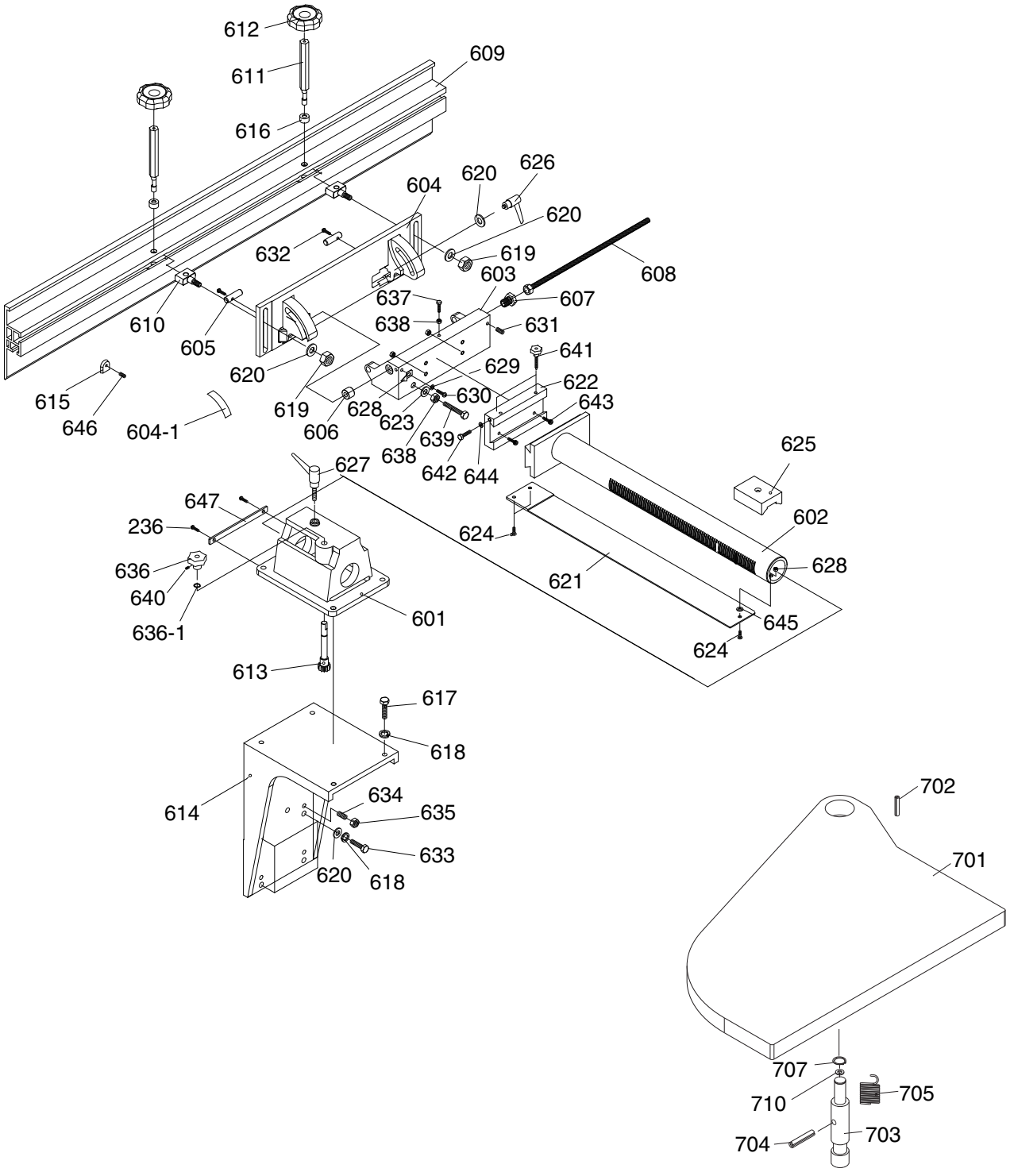
Limit Switch Breakdown & List



REF	PART #	DESCRIPTION
501-1	P0633501-1	SWING LEVER (F)
501-2	P0633501-2	SWING LEVER (M)
501-3	P0633501-3	LIMIT SWITCH BRACKET
502	P0633502	COMPRESSION SPRING
503	P0633503	EXTENSION SPRING
504	P0633504	SWITCH ACTIVATION ROD
505	P0633505	SWITCH ACTIVATION ROD
506	P0633506	SWITCH ACTIVATION ROD
507	PLN03	LOCK NUT 5/16-18

REF	PART #	DESCRIPTION
508	PW07	FLAT WASHER 5/16
509	PB03	HEX BOLT 5/16-18 X 1
510	PB09	HEX BOLT 5/16-18 X 1/2
511	PN02	HEX NUT 5/16-18
512	PSB101	CAP SCREW 10-24 X 1-1/4
513	PSB06	CAP SCREW 1/4-20 X 1
514	P0633514	LIMIT SWITCH
515	P0633515	LIMIT SWITCH CONTROL CORD

Fence/Guard Breakdown & List

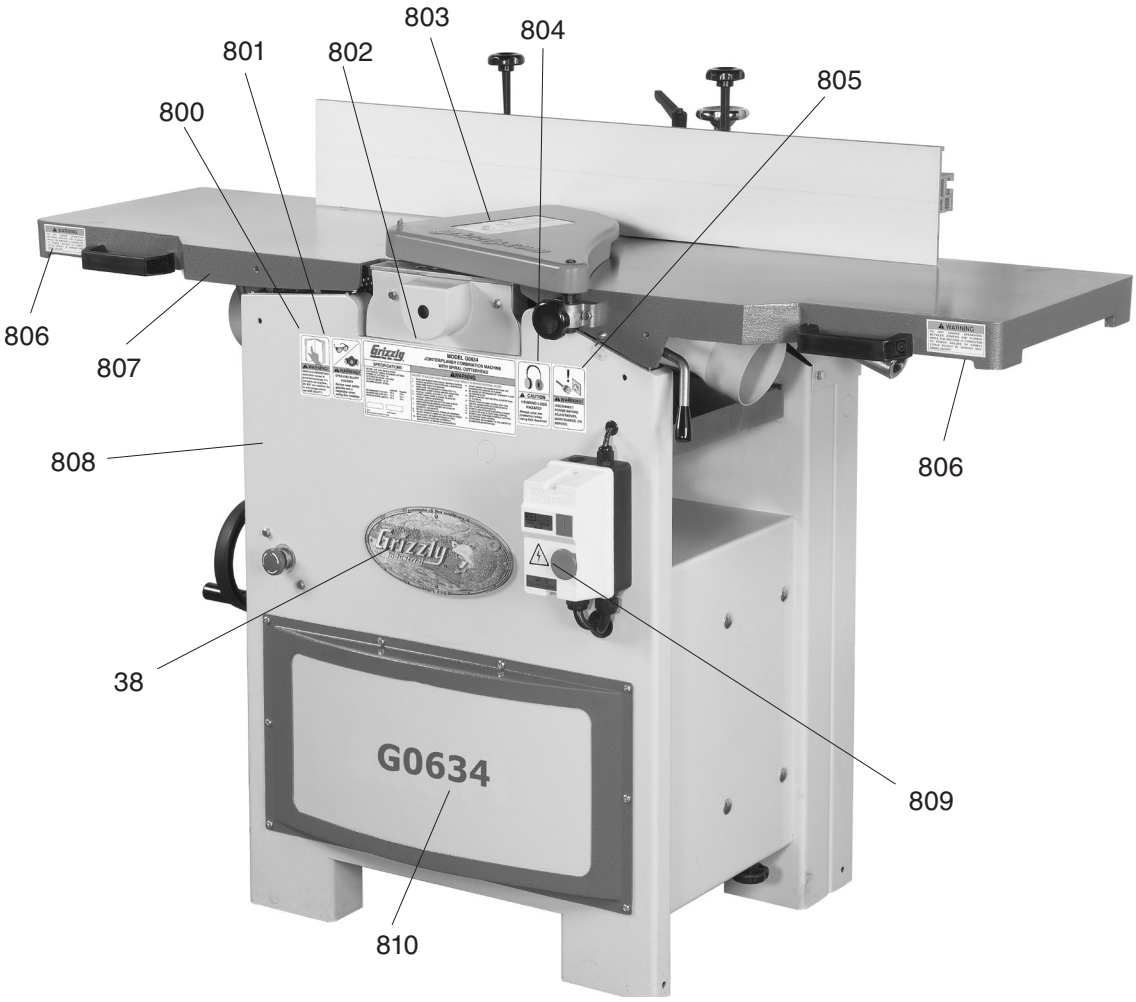


Fence/Guard List

REF	PART #	DESCRIPTION
601	P0633601	FENCE BASE
602	P0633602	ADJUSTMENT TUBE W/RACK
603	P0633603	TRUNNION BRACKET
604	P0633604	TRUNNION
604-1	P0633604-1	FENCE ANGLE SCALE
605	P0633605	PIVOT STUD
606	P0633606	SPACER
607	P0633607	ADJUSTMENT SCREW
608	P0633608	ADJUSTMENT ROD
609	P0633609	FENCE
610	P0633610	SLIDING BOLT
611	P0633611	ECCENTRIC SHAFT
612	PLN01	LOCK KNOB 3/8-16
613	P0633613	PINION SHAFT
614	P0633614	FENCE SUPPORT
615	P0633615	PLASTIC PROTECTION SHOE
616	P0633616	BUSHING
617	PB03	HEX BOLT 5/16-18 X 1
618	PLW01	LOCK WASHER 5/16
619	PLN03	LOCK NUT 5/16-18
620	PW07	FLAT WASHER 5/16
621	P0633621	CUTTER KNIFE GUARD
622	P0633622	DOVETAIL BRACKET FOR QUICK RELEASE
623	PW06	FLAT WASHER 1/4
624	PFH19	FLAT HD SCR 1/4-20 X 3/8
625	P0633625	TUBE LOCKING SHOE
626	P0633626	UNIVERSAL LOCK LEVER
627	P0633627	UNIVERSAL LOCK LEVER

REF	PART #	DESCRIPTION
628	P0633628	POINTER
629	PW06	FLAT WASHER 1/4
630	PS07	PHLP HD SCR 1/4-20 X 3/8
631	PSS03	SET SCREW 1/4-20 X 3/8
632	PS22	PHLP HD SCR 10-24 X 5/8
633	PB12	HEX BOLT 5/16-18 X 1-1/4
634	PSS01	SET SCREW 5/16-18 X 1
635	PN02	HEX NUT 5/16-18
636	P0633636	CONTROL KNOB
636-1	PR01M	EXT RETAINING RING 10MM
637	PB05	HEX BOLT 1/4-20 X 3/4
638	PN05	HEX NUT 1/4-20
639	PB97	HEX BOLT 1/4-20 X 3-1/4
640	PSS11	SET SCREW 1/4-20 X 1/4
641	P0633641	KNOB SCREW 1/4
642	PB19	HEX BOLT 1/4-20 X 1/2
643	PSB06	CAP SCREW 1/4-20 X 1
644	PW06	FLAT WASHER 1/4
645	PW06	FLAT WASHER 1/4
646	PSS29	SET SCREW 10-24 X 1/4
647	P0633647	FENCE BASE PLATE
701	P0633701	CUTTERHEAD GUARD
702	PRP31M	ROLL PIN 6 X 36
703	P0633703	STUD
704	PRP05M	ROLL PIN 5 X 30
705	P0633705	TORSION SPRING
707	PR48M	EXT RETAINING RING 11MM
710	P0633710	LOAD WASHER

Safety Labels and Cosmetic Parts



REF	PART #	DESCRIPTION
38	G8588	GRIZZLY NAMEPLATE-SMALL
800	PLABEL-12	READ MANUAL 2" X 3 5/16"
801	PLABEL-37	RESPIRATOR/GLASSES LABEL
802	P0633802	MACHINE ID LABEL
803	P0633803	CUTTERHEAD GUARD WARNING LABEL
804	PLABEL-15	EAR PROTECTION 2"X3 5/16"H
805	P0633805	DISCONNECT POWER LABEL

REF	PART #	DESCRIPTION
806	P0633806	CHANGING OPERATIONS WARNING LABEL
807	PPAINT-1	GRIZZLY GREEN PAINT
808	PPAINT-11	GREY PUTTY TOUCH UP PAINT
809	PLABEL-14	ELECTRICITY LABEL
810	P0633810	MODEL NUMBER LABEL G0633
810	P0634810	MODEL NUMBER LABEL G0634

⚠WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

WARRANTY AND RETURNS

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

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

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

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

Thank you again for your business and continued support. We hope to serve you again soon.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

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

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

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

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

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE