

# *Grizzly* *Industrial, Inc.*®

## MODEL G0495X 8" JOINTER w/DIGITAL READOUT OWNER'S MANUAL



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#BL10436 PRINTED IN CHINA

# **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

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## Foreword

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We are proud to offer the Model G0495X 8" Jointer w/Digital Readout. 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 G0495X 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](http://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

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We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, 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](mailto:techsupport@grizzly.com)

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](mailto:manuals@grizzly.com)

## Functional Overview

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A jointer is mainly used to flatten the face or edge of a workpiece, which is required when properly "squaring up" a workpiece for later construction or joining multiple pieces with glue. A jointer can also cut bevels, rabbets, and other specialized cuts with various jigs or fixtures.

The primary components of the jointer are the infeed table, cutterhead, fence, and outfeed table. A typical cut on a jointer is made by firmly holding a workpiece against the infeed table and fence, then moving the workpiece over the cutterhead while using the fence as a guide. As the workpiece moves over the cutterhead, the inserts make many shallow cuts that "shave" off the workpiece surface. After moving over the cutterhead, the workpiece is supported by the outfeed table, which along with the fence, continue to guide the workpiece across a flat plane until it completely passes the cutterhead. Since only a small amount of the workpiece is removed during a jointer cut, most jointer cuts are repeated many times.

The position of the infeed table relative to the outfeed table controls the cutting depth. If the infeed table is  $\frac{1}{16}$ " lower than the outfeed table, then  $\frac{1}{16}$ " of the workpiece will be removed by the cutterhead as the workpiece passes from the infeed table to the outfeed table.

Since the workpiece is held firmly against the fence as it passes over the cutterhead, the fence controls the angle of the cut. The fence can be moved  $45^\circ$  in either direction and locked in place. The fence also features stops that allow it to be quickly set at  $45^\circ$ ,  $90^\circ$ , and  $135^\circ$ .

The outfeed table must be even with the inserts at their highest point of rotation to keep the freshly cut portion of the workpiece in the same plane as it was cut, which is what yields a flat workpiece.





# MACHINE DATA SHEET

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

## MODEL G0495X 8" X 84" JOINTER WITH EXCLUSIVE DIGITAL HEIGHT READOUT

### Product Dimensions:

Weight..... 596 lbs.  
 Length/Width/Height..... 83 x 24-1/2 x 44 in.  
 Foot Print (Length/Width)..... 45-3/4 x 15 in.

### Shipping Dimensions:

Type..... Wood Crate  
 Content..... Machine  
 Weight..... 750 lbs.  
 Length/Width/Height..... 88-1/2 x 24-1/2 x 50 in.

### Electrical:

Switch..... Magnetic with Thermal Overload Protection  
 Switch Voltage..... 220V  
 Cord Length..... 6 ft.  
 Cord Gauge..... 12 guage  
 Recommended Breaker Size..... 20 amp  
 Plug..... No

### Motors:

#### Main

Type..... tefc Capacitor Start Induction  
 Horsepower..... 3 HP  
 Voltage..... 220V  
 Prewired..... 220V  
 Phase..... Single  
 Amps..... 15A  
 Speed..... 3450 RPM  
 Cycle..... 60 Hz  
 Number Of Speeds..... 1  
 Power Transfer ..... V-Belt Drive  
 Bearings..... Shielded and Permanently Sealed

### Main Specifications:

#### Fence Information

Fence Length..... 38 in.  
 Fence Width..... 1-1/2 in.  
 Fence Height..... 4-3/4 in.  
 Fence Stops..... 45, 90 and 135 deg.

#### Cutting Capacities

Bevel Jointing..... Left & Right 45 deg.  
 Maximum Width of Cut..... 8 in.  
 Maximum Depth of Cut..... 1/8 in.  
 Maximum Rabbeting Depth..... 1/2 in.  
 Number of Cuts Per Minute..... 28000



**Cutterhead Info**

Cutterhead.....	Spiral
Cutterhead Diameter .....	3 1/16"
Number of Cutter Spirals.....	4
Number of Indexable Carbide Cutters.....	36
Cutter Insert Type.....	Indexable
Carbide Insert Dimensions .....	15 x 15 x 2.5mm
Cutterhead Speed .....	7000 RPM

**Table Information**

Total Table Length .....	82 1/2"
Infeed Table Length .....	42 3/8"
Outfeed Table Length.....	39 5/16"
Table Width .....	8 1/8"
Table Thickness .....	3 5/16"
Floor to Table Height.....	31"
Table Adjustment Type .....	Parallelogram
Table Movement Type.....	Handwheel

**Construction**

Base Construction Material .....	Cast Iron
Body Assembly Construction Material .....	Cast Iron
Cabinet Construction Material .....	Steel
Fence Assembly Construction Material.....	Cast Iron
Guard Construction Material .....	Die Cast Metal
Table Construction Material .....	Precision Ground Cast Iron
Parallelogram .....	Yes
Paint .....	Touch-Up and Powder Coated

**Other Information**

Number of Dust Ports.....	1
Dust Port Size .....	4"
Digital Readout Battery, AAA .....	2
Digital Sensor Battery, 1.5V Silver Oxide Type 357/303 .....	1

**Other Specifications:**

Country Of Origin.....	China
Warranty.....	1 Year
Serial Number Location .....	ID Label on Front of Cabinet
Assembly Time .....	45 minutes
Sound Rating .....	85db
ISO Factory.....	ISO 9001

**Features:**

- Digital Readout for Infeed Table Height
- Precision Ground Cast Iron Tables and Fence
- Magnetic Switch with Thermal Overload Protection
- Parallelogram Table Adjustment
- Pedestal Mounted Switch Controls
- Heavy-Duty Center Mounted Fence
- Rack and Pinion Fence Adjustment
- 4" Dust Port



# Identification

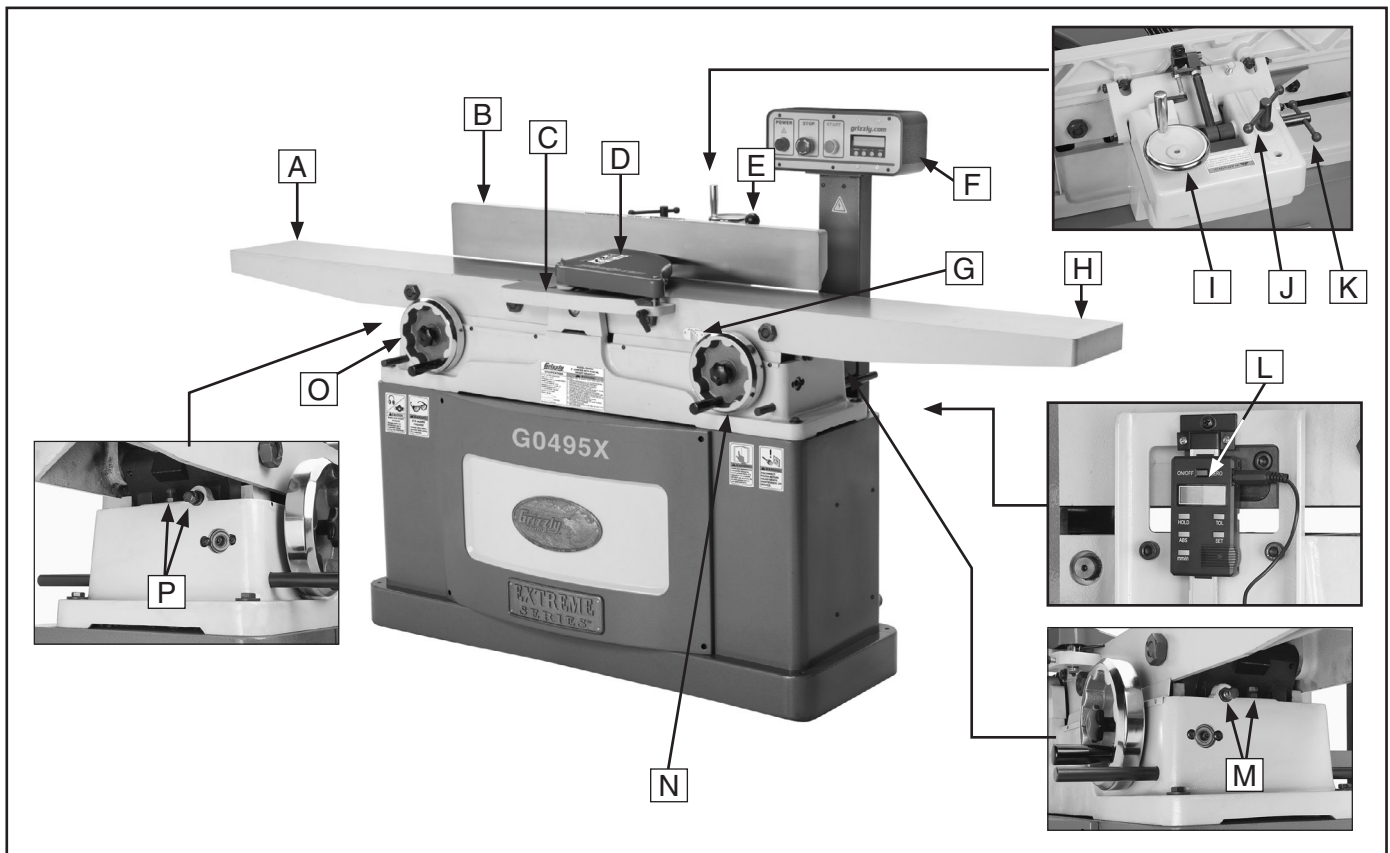


Figure 1. G0495X identification.

- |                                       |                           |
|---------------------------------------|---------------------------|
| A. Outfeed Table                      | I. Fence Adjustment Wheel |
| B. Fence                              | J. Fence Lock             |
| C. Rabbeting Extension                | K. Tilt Lock              |
| D. Cutterhead Guard                   | L. Digital Sensor         |
| E. Fence Tilt Handle                  | M. Infeed Depth Stops     |
| F. Control Panel with Digital Readout | N. Infeed Handwheel       |
| G. Depth Scale                        | O. Outfeed Handwheel      |
| H. Infeed Table                       | P. Outfeed Depth Stops    |

# Control Panel & Digital Sensor Features



Figure 2. Control panel and digital readout features.

- A. POWER Light
- B. STOP Button
- C. START Button
- D. OFF/ON Button
- E. IN/MM Button
- F. M Button
- G. ZERO Button
- H. Digital Display

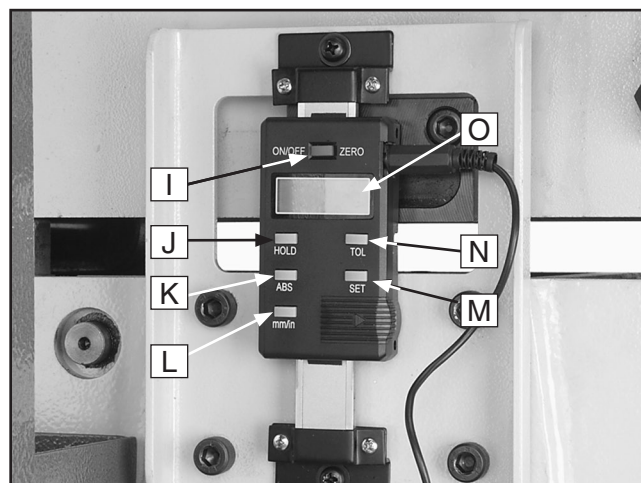


Figure 3. Infeed table digital sensor and controls.

- I. ON/OFF/ZERO Button
- J. HOLD Button
- K. ABS Button
- L. MM/IN Button
- M. SET Button
- N. TOL Button
- O. Digital Readout





# 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.



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



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



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.** Most types of dust (wood, metal, etc.) 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. A kickback may quickly pull your hand into the cutterhead or cause injury from the thrown workpiece. 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 insert at top dead center (TDC) to reduce the risk of kickback and personal injuries.
- 3. PUSH BLOCKS.** In the event of a kickback, a push block typically takes the damage from the cutterhead instead of the operator's hands. Use push blocks whenever possible. 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  $\frac{1}{8}$ ". To minimize kickback, 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, the guard must be installed to reduce the risk of serious injury.
- 9. PROPER CUTTING.** When cutting, always keep the workpiece moving toward the outfeed table until the workpiece has passed completely over the cutterhead. To reduce the risk of kickback, 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.



# SECTION 2: CIRCUIT REQUIREMENTS

## 220V Operation

### **!WARNING**

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



### **!WARNING**

Electrocution or fire could result if machine is not grounded and installed in compliance with electrical codes. Compliance **MUST** be verified by a qualified electrician!

### Full Load Amperage Draw

This machine draws the following amps under maximum load:

Amp Draw..... 15 Amps

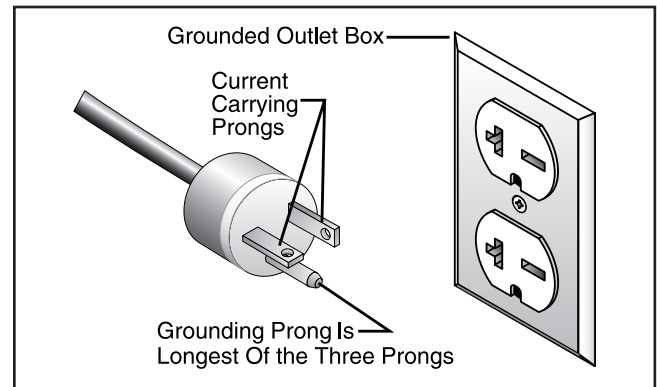
### Power Supply Circuit Requirements

You **MUST** connect your machine to a 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.**

Minimum Circuit Size.....20 Amps

### Power Connection Device

The type of plug required to connect your machine to power depends on the type of service you currently have or plan to install. We recommend using the plug shown in **Figure 4**.



**Figure 4.** NEMA 6-20 plug and receptacle.

### Extension Cords

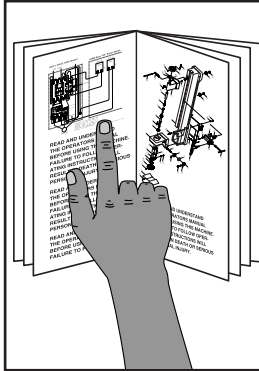
Using extension cords may reduce the life of the motor. Instead, place the machine near a power source. If you must use an extension cord:

- Use at least a 12 gauge cord that does not exceed 50 feet in length!
- The extension cord must also have a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.



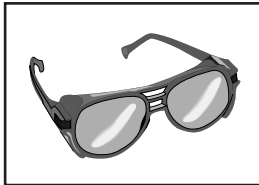
# SECTION 3: SETUP

## Setup Safety



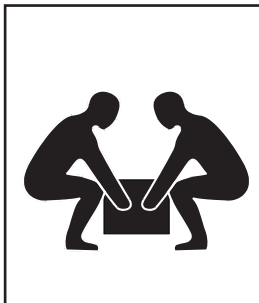
### **!WARNING**

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 setup process!



### **!WARNING**

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

## 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
• Straightedge 4' (or longer).....	1
• Dust Collection System.....	1
• 4" Dust Hose (length as needed).....	1
• 4" Hose Clamp.....	1
• Forklift, Hoist, or Boom Crane.....	1
• Lifting Straps (1000 lb. Capacity Min.).....	2

## Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *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.

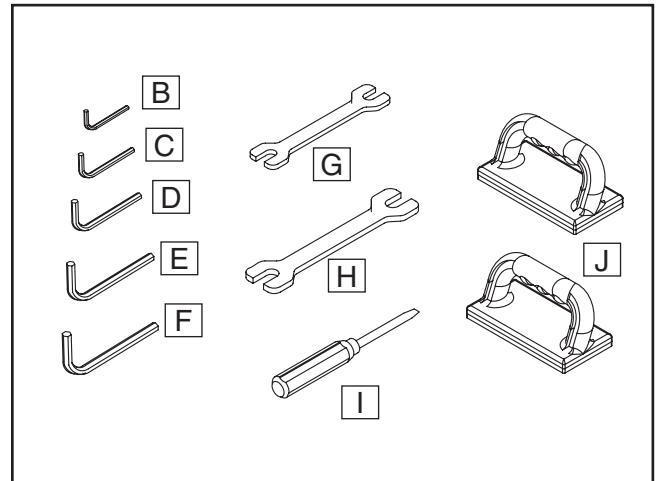


# Inventory

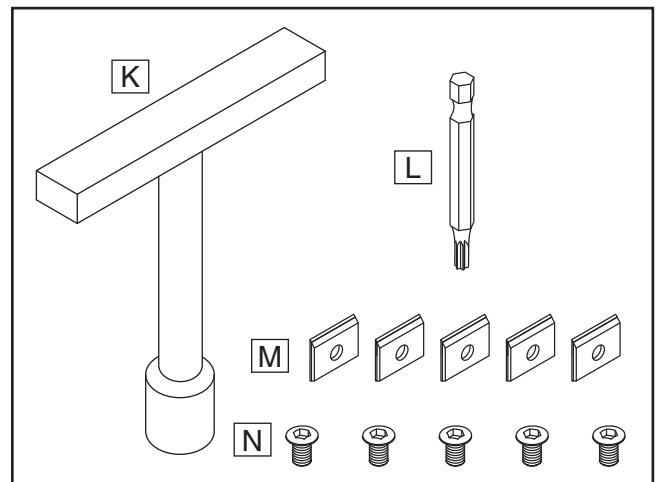
The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

**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.

<b>Box 1: (Figure 5 &amp; 6)</b>	<b>Qty</b>
A. Jointer Assembly (not shown) .....	1
B. Hex Wrench 3mm.....	1
C. Hex Wrench 4mm.....	1
D. Hex Wrench 5mm.....	1
E. Hex Wrench 6mm.....	1
F. Hex Wrench 8mm.....	1
G. Open End Wrench 12/14mm .....	1
H. Open End Wrench 14/17mm .....	1
I. Phillips Head Screwdriver.....	1
J. Push Blocks.....	2
K. T-Handle Driver .....	1
L. Torx Bit T-25 .....	1
M. Inserts 15 x 15 x 2.5.....	5
N. Flat Head Torx Screws #10-32.....	10
O. AAA Batteries (not shown) .....	2




**Figure 5.** Tools inventory.



**Figure 6.** Spiral cutterhead hardware.

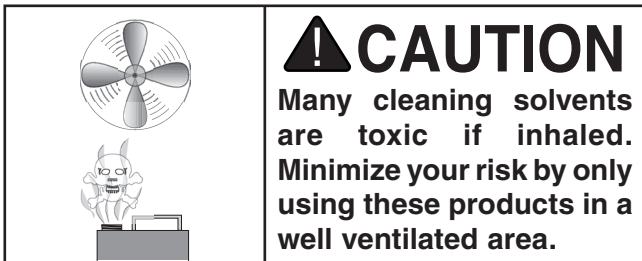
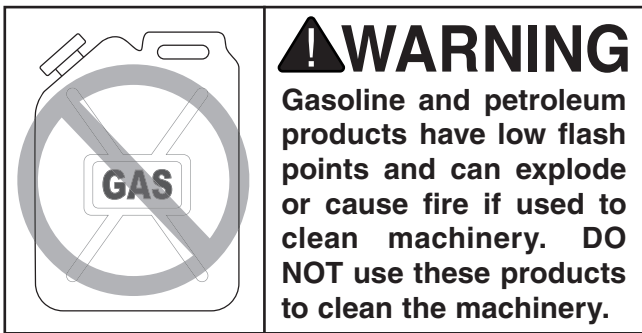
If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

	<p><b>⚠ WARNING</b></p> <p><b>SUFFOCATION HAZARD!</b></p> <p>Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.</p>
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# 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 degreaser shown in **Figure 7**. For thorough cleaning, 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 acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.



## G2544—Solvent Cleaner & Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.



**Figure 7.** Cleaner/degreaser available from Grizzly.

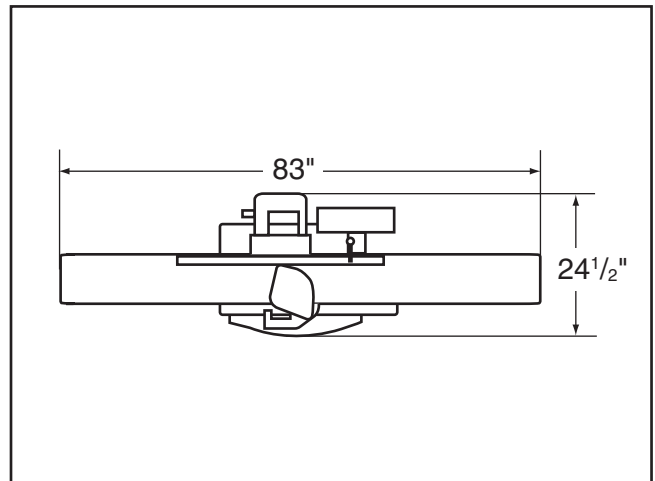
# Site Considerations

## Floor Load

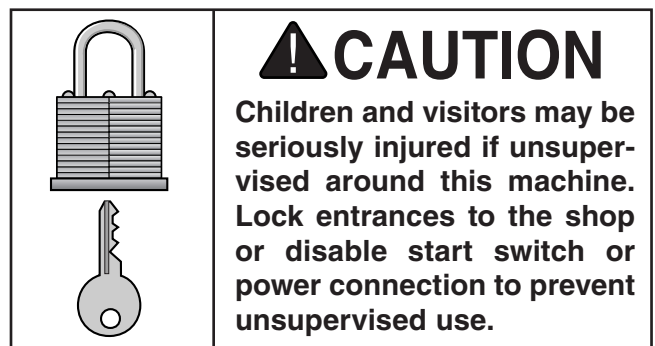
Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

## Placement Location

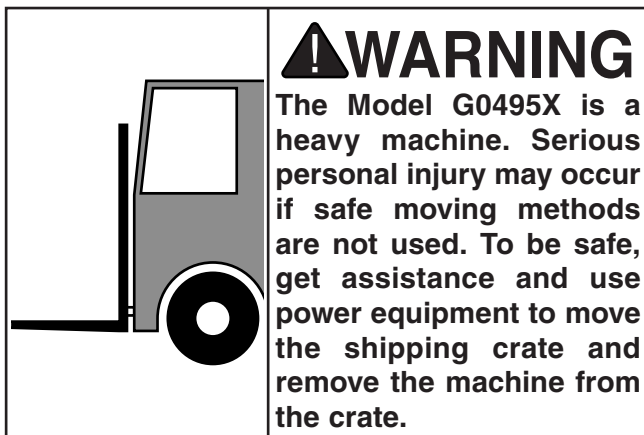
Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 8** for the minimum working clearances.



**Figure 8.** Minimum working clearances.



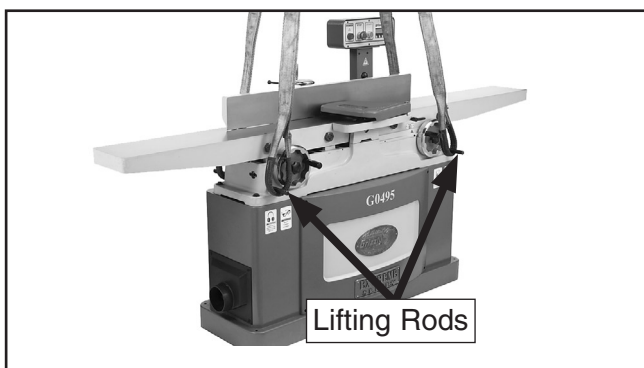
# Moving & Placing Jointer



The Model G0495X requires the use of lifting equipment such as a forklift, engine hoist, or boom crane. DO NOT try to lift the machine by hand.

## To lift the jointer:

1. Unbolt the jointer from the pallet.
2. Wrap lifting straps around the lifting rods, as shown in **Figure 9**.



**Figure 9.** Model G0495X supported evenly by two lifting straps.

3. With lifting straps positioned evenly, lift the jointer off of the pallet and place it in the desired location.

# Mounting to Shop Floor

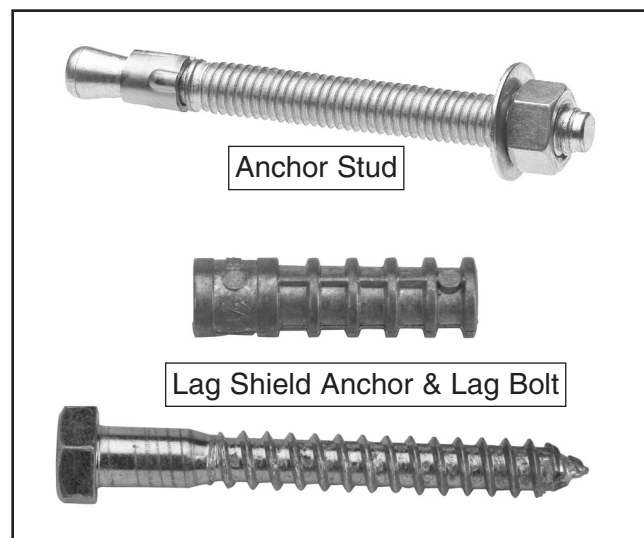
Although not required, we recommend that you mount your new machine to the floor for increased stability and vibration dampening. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. If you bolt your machine to the floor, it is necessary to level your machine with a precision level.

## Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 10**) and anchor studs are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

## NOTICE

**Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.**



**Figure 10.** Typical fasteners for mounting to concrete floors.





# Dust Collection

## ⚠ CAUTION

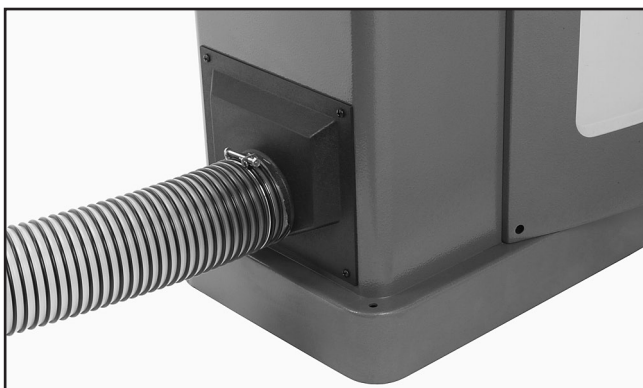
**DO NOT** operate the Model G0495X without an adequate dust collection system. This jointer creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

### Recommended CFM at Dust Port: 400 CFM

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

### To connect the machine to a dust collector:

1. Fit a 4" dust hose that is connected to a dust collector over the dust port, as shown in **Figure 11**, and secure in place with a hose clamp.



**Figure 11.** Dust hose attached to dust port.

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

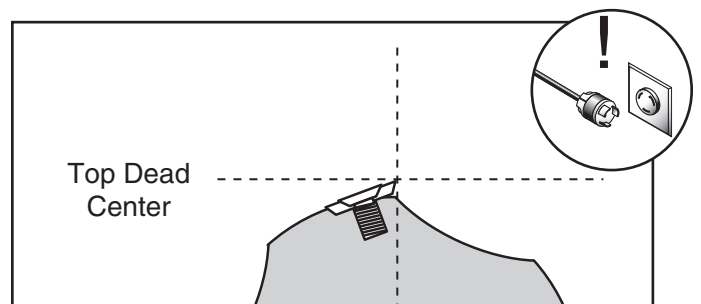
**Note:** A tight fit is necessary for proper performance.

# Setting Outfeed Table Height

The outfeed table height **MUST** be level with the 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.

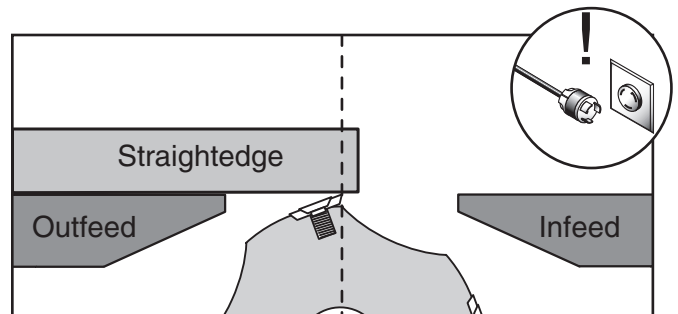
### To set the outfeed table height:

1. DISCONNECT JOINTER FROM POWER!
2. Move the cutterhead guard out of the way or remove it, and remove the V-belt guard.
3. Place a straightedge on the outfeed table so it extends over the cutterhead and rotate the cutterhead pulley until one of the carbide inserts is at top-dead-center (TDC), as shown in **Figure 12**.



**Figure 12.** Cutterhead insert at top-dead-center.

4. When correctly set, the carbide insert will just touch the straightedge when the insert is at its highest point of rotation (**Figure 13**).



**Figure 13.** Using a straightedge to align outfeed table height with insert at TDC.

—If your outfeed table is correctly set, no adjustments are necessary.

—If the insert lifts the straightedge off the table or the table is below the straightedge, loosen the outfeed table lock and outfeed table positive stop bolts and jam nuts (**Figure 1, Page 5**) and adjust the outfeed table height with the handwheel until the straightedge just touches a insert at its highest point of rotation.

**Tip:** Some advanced woodworkers have found that they can virtually eliminate snipe by setting the outfeed table in the following manner: Repeat **Steps 1-4** using a freshly exposed insert. Then lower the outfeed table slightly so the insert lifts the straightedge off the table. Place a ruler next to the straightedge and rotate the cutterhead, watching how far the carbide insert pulls the straightedge. Adjust the outfeed table and recheck until the straightedge only moves  $\frac{5}{32}$ ".

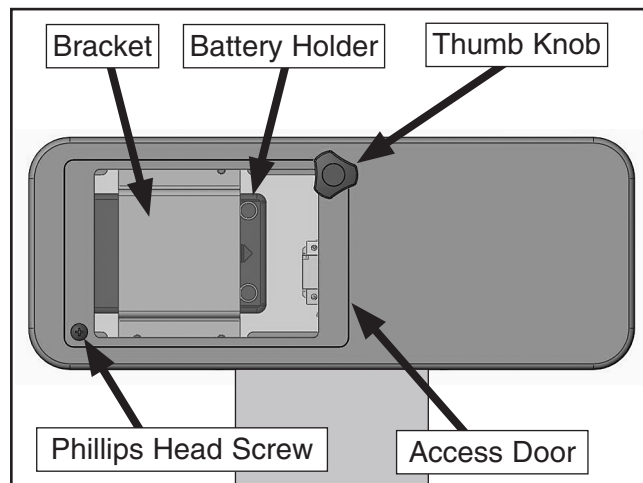
5. Lock the outfeed table, lock the outfeed table positive stop bolts, and reinstall the cutterhead guard (**Page 39**) and V-belt guards.

## Digital Readout Batteries

You must install two AAA batteries into the control panel for the digital readout to function.

**To install the AAA batteries in the control panel:**

1. Unscrew the thumb knob on the rear door on the back of the control panel, loosen the Phillips head screw, then swing the door open.



**Figure 14.** Rear access door on control panel (cutaway view for clarity).

2. Open the battery holder cover, install the included batteries, then close the cover.

**Note:** It may help to loosen the screws on the front of the panel securing the digital readout bracket to open the battery cover.

3. Close the rear access door, tighten the Phillips head screw, then install the thumb knob.

## Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation. The test run consists of verifying the following: 1) The motor powers up and runs correctly and 2) the 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 32**.

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

## **WARNING**

**Before starting the jointer, 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. Connect the machine to the power source. The power light will illuminate.  
  
—If the light does not illuminate, check the power connection.
4. Push the STOP button in, then twist it clockwise so it pops out. When the STOP button pops out, the switch is reset and ready for operation (see **Figure 15**).



**Figure 15.** Resetting the STOP button.

5. Verify that the machine is operating correctly by pushing the START 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.

6. Press the STOP button to stop the machine.
7. WITHOUT resetting the switch, press the START button. The machine should not start.  
  
—If the machine does not start, the STOP button safety feature is working correctly. The test run is complete.  
  
—If the machine does start (with the STOP button pushed in), immediately disconnect power to the machine. The STOP button safety feature is not working correctly. This safety 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, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

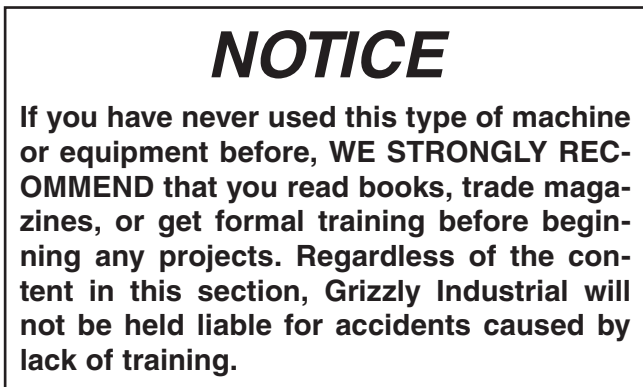
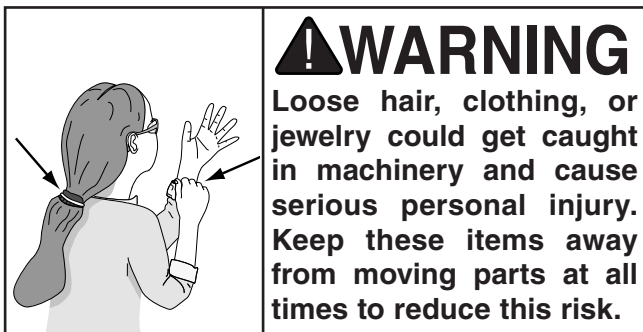
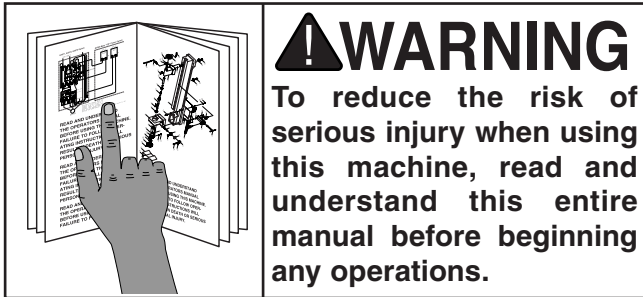
Step-by-step instructions for these adjustments can be found in **SECTION 7: SERVICE**.

### Factory adjustments that should be verified:

1. Table Parallelism (**Page 34**).
2. Infeed Table Calibration (**Page 38**).
3. Digital Sensor and Readout Calibration (**Page 39**).
4. Fence Stop Settings (**Page 40**).
5. Verify V-Belt Tension Adjustment (**Page 42**).

# SECTION 4: OPERATIONS

## Operation Safety



## Basic Joinder Controls

This section covers the basic controls used during routine operations.

**START Button:** Starts motor only if the STOP button is popped out.

**STOP Button:** Disables the START button. Enable the START button by twisting the STOP button until it pops out.

**POWER Light:** Indicates machine is correctly plugged into the power source.

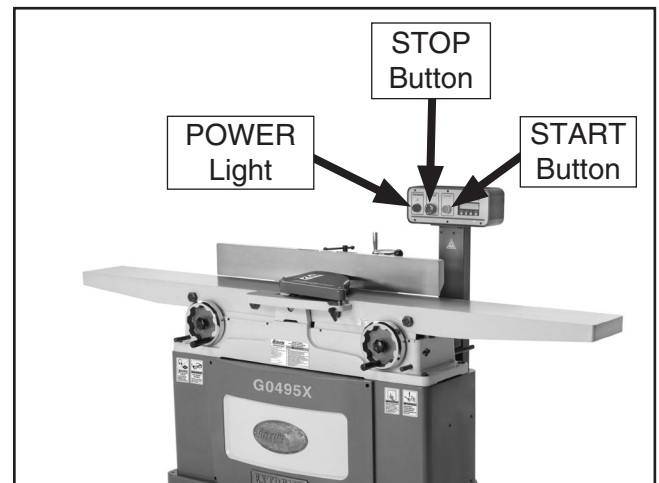
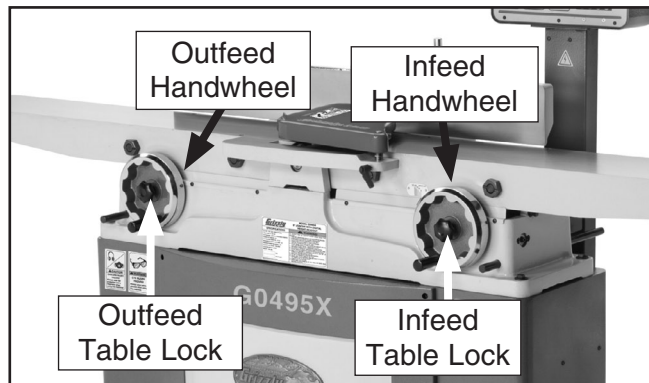


Figure 16. START/STOP button locations.

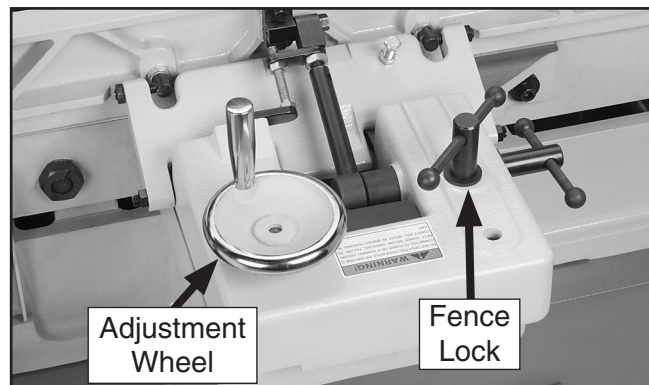


**Table Movement:** To move the infeed or outfeed tables, loosen the table locks (**Figure 17**), move the tables with the infeed or outfeed handwheels (**Figure 16**), then tighten the table locks.



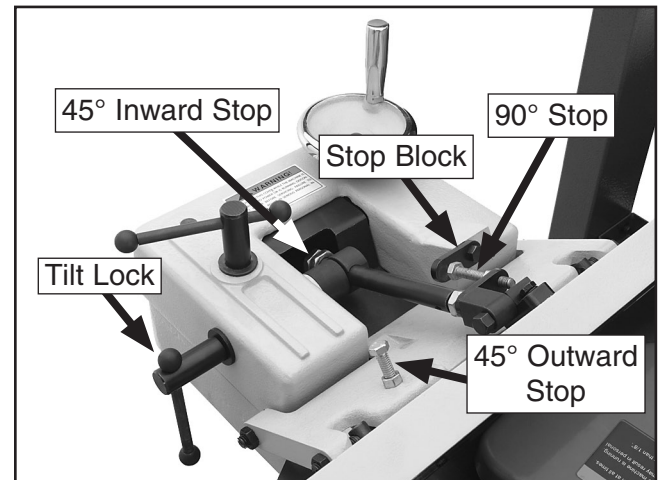
**Figure 17.** Table control locations.

**Fence Movement:** The fence has a lock that keeps it in position (**Figure 18**). To move the fence, loosen the lock and turn the fence adjustment wheel to slide the fence where needed, then retighten the lock.



**Figure 18.** Fence lock location.

**Fence Tilting:** The tilt lock (**Figure 19**) secures the fence at any position in the available range. The stop block locks the fence for 90° cuts. Two positive stops stop the fence at 45° inward and 45° outward for common bevel cuts. Even when the fence is resting against the positive stops, the tilt lock must be tightened before cutting. Also, the stop block must be disengaged for 45° outward bevel cuts.



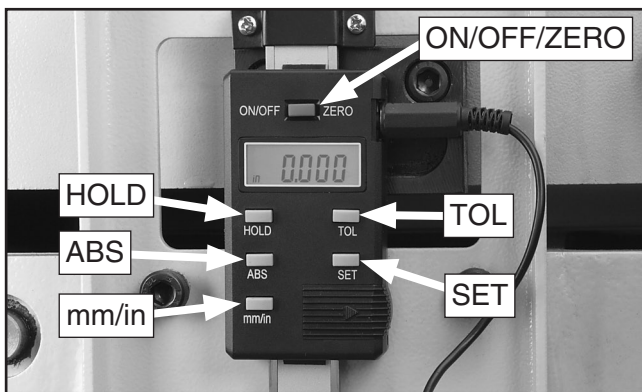
**Figure 19.** Tilt lock and stop block locations.

# Digital Sensor & Readout

The digital readout is used in conjunction with the digital sensor to display the selected cutting depth. Before using the digital sensor and readout, verify calibration on the infeed table (**Page 38**), digital sensor, and digital readout (**Page 39**). Make sure the digital sensor is turned **ON** before using the digital readout, otherwise the readout will not work.

Below is a summary of the features on the rear digital sensor (**Figure 20**) and digital readout on the control panel (**Figure 25, Page 25**).

## Digital Sensor



**Figure 20.** Digital sensor.

**ON/OFF/ZERO:** Turns digital sensor **ON** or **OFF** when pressed for five seconds. Push for two seconds to reset the sensor to 0.000.

**HOLD:** Freezes the digital display at the current value.

**ABS:** Toggles between absolute and incremental values. Absolute mode shows the total depth of cut in relation to an absolute zero point. Incremental mode shows how much the table has moved up or down relative to an arbitrarily chosen zero point. To select incremental mode, press the ABS button, INC is displayed. To return to absolute mode, press the ABS button, INC disappears.

For example, to use ABS and incremental modes:

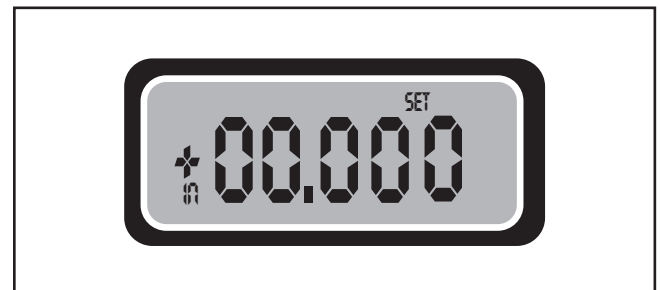
1. Press the ZERO button in ABS mode, then move the infeed table down until the display reads 0.125" (the max cut allowed).
2. Press the ABS button to toggle to INC mode, press the ZERO button to set the arbitrary zero point, then move the infeed table up -0.010".
3. Press the ABS button to toggle back to ABS mode. The screen displays 0.115", the total depth of cut relative to the absolute zero point set in **Step 1**.

**MM/IN:** Toggles between inch and metric display units.

**SET:** Recalls a stored numerical value.

For example, to set the preset to 00.063":

1. Move the infeed table to the desired depth of cut. In ABS mode press ZERO, then press SET. On the screen SET will blink and "+" will appear (**Figure 21**).



**Figure 21.** Initial SET mode screen.

2. While holding SET, move the cursor to the fourth digit, then release the SET button when the desired digit blinks.
3. Press SET six times to increase the value to 6.
4. Hold SET to move the cursor to the fifth digit, release the SET button, then press it three times to change the value to 3, as shown in **Figure 22**.



Figure 22. Set value entered.

5. Hold SET down until "SET" blinks on the display, then press SET again to set the value.

The preset value can be set positive (+) or negative (-). When the "+" flashes, press SET to toggle between "-" and "+".

**TOL:** Use to set the tolerance limits.

In ABS mode, first set the reference dimension, then set the upper and lower tolerance values. While setting the tolerance limits, you will not be able to use the sensor to measure depth of cut.

The upper tolerance limit value must be greater than the lower limit value, otherwise an error code (E-01) will appear. If this happens, press ZERO to return to ABS mode.

**For example, to set the reference dimension at 00.063", upper tolerance at 00.125", and lower tolerance at 00.000":**

1. Follow the instructions for setting the reference dimension to 00.063" on **Page 20**, then enter ABS mode.
2. Press the TOL button. SET flashes and  $\bar{\Delta}$  is displayed, indicating the upper limit mode setting, as shown in **Figure 23**.

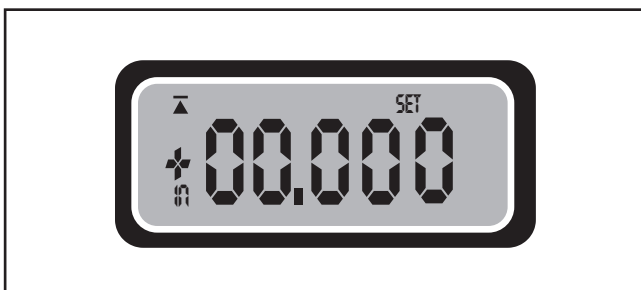


Figure 23. Setting upper limit.

3. Hold the TOL button down and move the cursor right three digits until the digit flashes, then press TOL once to increase the value to 00.100".
4. Hold TOL down to move the cursor right one digit until it flashes, then press TOL twice to change that digit to 2 so the value reads +00.120".
5. Repeat **Step 4** in a similar manner to change the next digit to 5 so the display value is now +00.125".
6. Hold the TOL button down and move the cursor until SET flashes, then press TOL again. SET flashes and  $\nabla$  is displayed, indicating the lower limit mode, as shown in **Figure 24**.

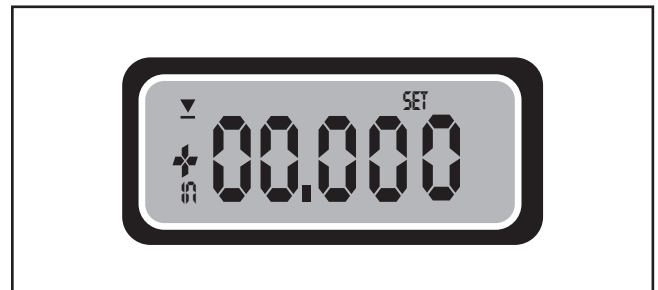


Figure 24. Setting lower limit.

7. To select a lower limit value of +00.000", hold the TOL button down and move the cursor to SET, then press TOL again. The tolerances are set.
8. Raise and lower the infeed table to verify the tolerance settings.
  - If the infeed table is raised or lowered between 00.125" and 00.000", OK displays on the screen.
  - If the infeed table is lowered below 00.125" the  $\bar{\Delta}$  appears.
  - If the infeed table is raised above 00.000" the  $\nabla$  appears with a "-".
9. To change the tolerance limits, repeat **Steps 2-7**.
10. To exit TOL mode, briefly press the TOL button until all TOL mode icons disappear and only the preset value 00.063" appears.

## Digital Readout



Figure 25. Digital readout.

**OFF/ON:** Turns digital display **ON** or **OFF**.

**IN/MM:** Toggles between inch and metric measurements.

**M:** Toggles display between the relative value on the digital readout and the value displayed on the rear sensor.

**ZERO:** Push to reset the display to 0.000.

### To use the digital readout:

1. Make sure the two included AAA batteries are installed in the control panel (refer to **Page 16**, for installation instructions).
2. Turn the digital sensor **ON**, then turn **ON** the digital readout.

**Note:** *If the rear sensor is not turned ON first, the front digital readout will display an error code.*

3. Raise or lower the infeed table to the desired cutting depth. The digital readout displays the table height measured by the rear sensor.
4. Press the ZERO button to reset the digital readout. This new zero point is only shown on the front display.
5. Adjust the table height to the new cutting depth.
6. Press the M button to switch the digital readout back to display the rear digital sensor cutting depth. This will delete the zero point set in **Step 3**.

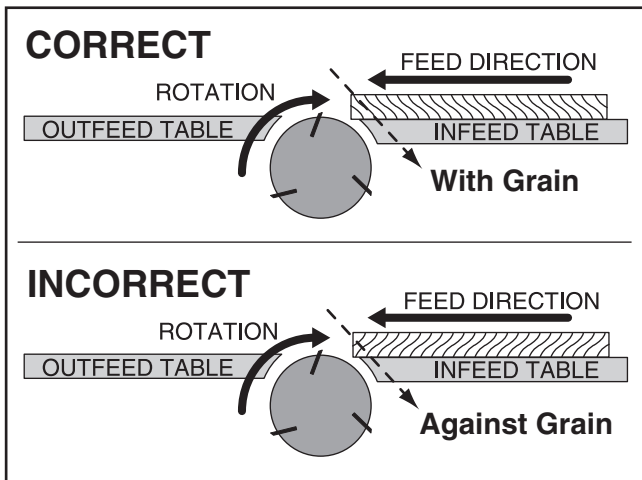


# Stock Inspection & Requirements

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

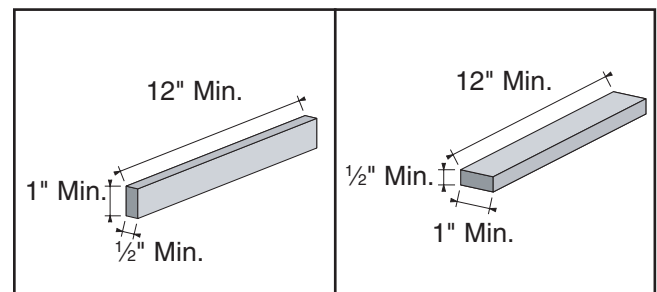
- **DO NOT joint or surface plane stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.
- **DO NOT joint or surface plane against the grain direction.** Cutting against the grain increases the likelihood of stock kickback, as well as tear-out on the workpiece.
- **Jointing and surface planing with the grain produces a better finish and is safer for the operator.** Cutting with the grain is described as feeding the stock on the jointer so the grain points down and toward you as viewed on the edge of the stock (**Figure 26**).

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



**Figure 26.** Correct and incorrect grain alignment with cutterhead.

- **Only process natural wood fiber through your jointer.** Never joint MDF, particle board, plywood, laminates, drywall, metal, stone, tile, glass, plastic or other synthetically made materials.
- **Scrape all glue off of boards before jointing.**
- **Remove foreign objects from the stock.** Make sure that any stock you process with the jointer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects, which if they hit the inserts and are drawn into the dust collector, may cause a fire hazard. The particles may also damage the inserts. Wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.
- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the inserts and poor cutting results. Excess moisture can also hasten rust and corrosion.
- **Make sure your workpiece exceeds the minimum dimension requirements (Figure 27) before edge jointing or surface planing, or it may break or kick back during the operation!**



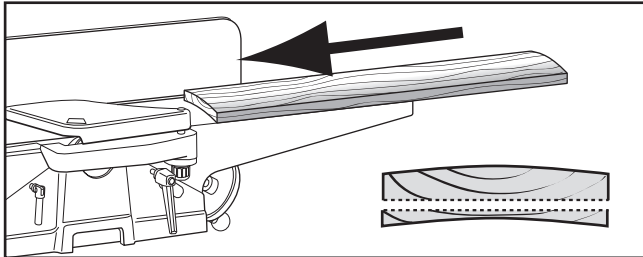
**Figure 27.** Minimum dimensions for edge jointing and surface planing (jointer).



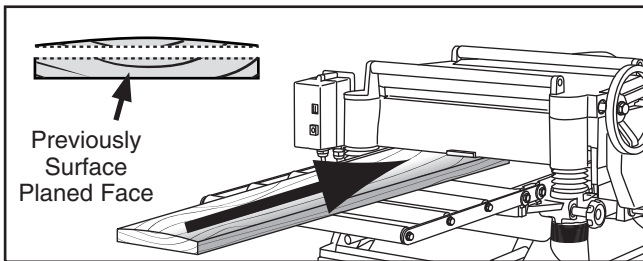
# Squaring Stock

Squaring stock involves four steps performed in the order below:

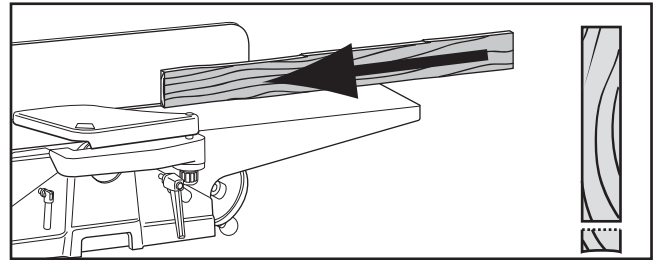
**1. Surface Plane on the Jointer**—The concave face of the workpiece is surface planed flat with the jointer.



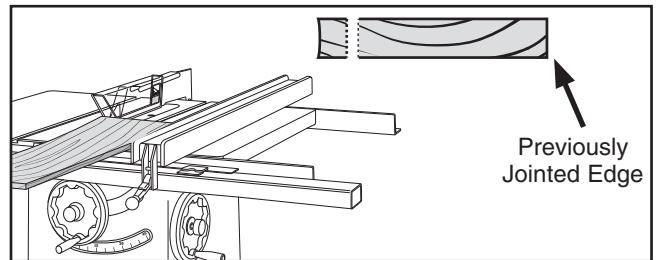
**2. Surface Plane on a Thickness Planer**—The opposite face of the workpiece is surface planed flat with a thickness planer.



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



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



# Surface Planing

The purpose of surface planing on the jointer is to make one flat face on a piece of stock (see **Figures 28 & 29**). This is a necessary step when preparing a workpiece to be run through a planer when squaring 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. This procedure will better prepare you for the actual operation.

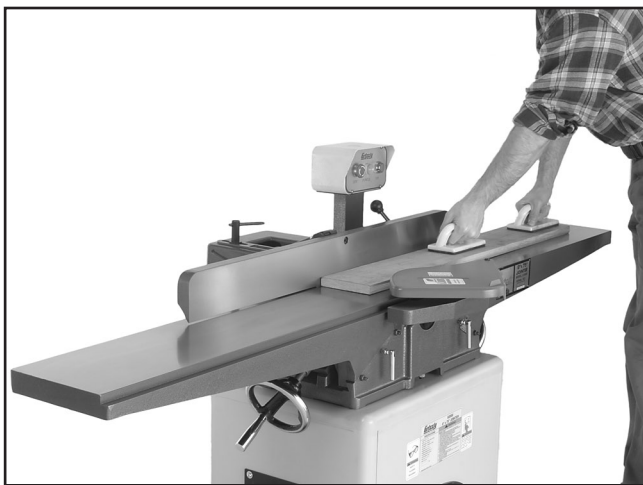


Figure 28. Typical surface planing operation.

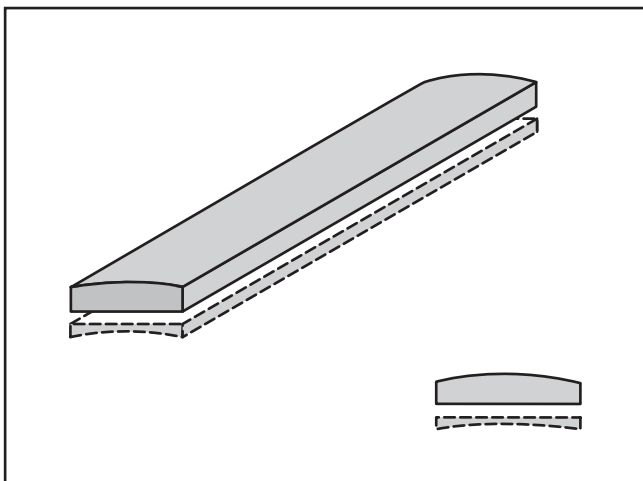


Figure 29. Illustration of surface planing results.

To surface plane on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 23**.
3. Set the cutting depth for your operation. (We suggest  $\frac{1}{32}$ " for surface planing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure your fence is set to  $90^\circ$ .
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

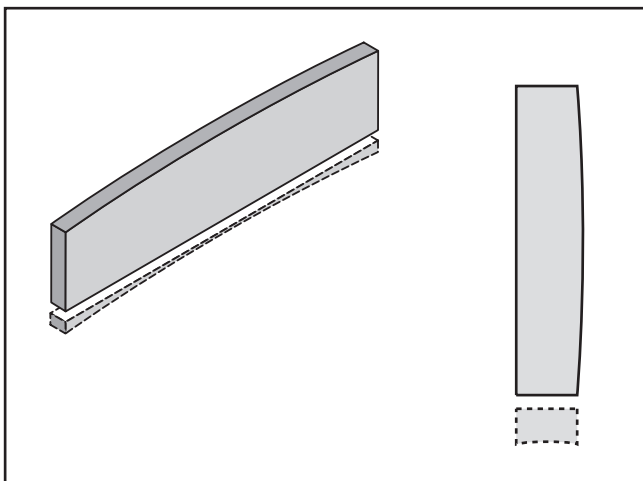
The purpose of edge jointing is to produce a finished, flat-edged surface (see **Figures 30 & 31**) that is suitable for joinery or finishing. It is also a necessary step when squaring rough or warped stock.

## 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 30.** Typical edge jointing operation.



**Figure 31.** Illustration of edge jointing results.

## To edge joint on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 23**.
3. Set the cutting depth for your operation. (We suggest between  $\frac{1}{16}$ " and  $\frac{1}{8}$ " for edge jointing, using a more shallow depth for hard wood species or for wide stock.)
4. Make sure the fence is set to  $90^\circ$ .
5. If your workpiece is cupped (warped), place it so the concave edge 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. 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 32 & 33**).

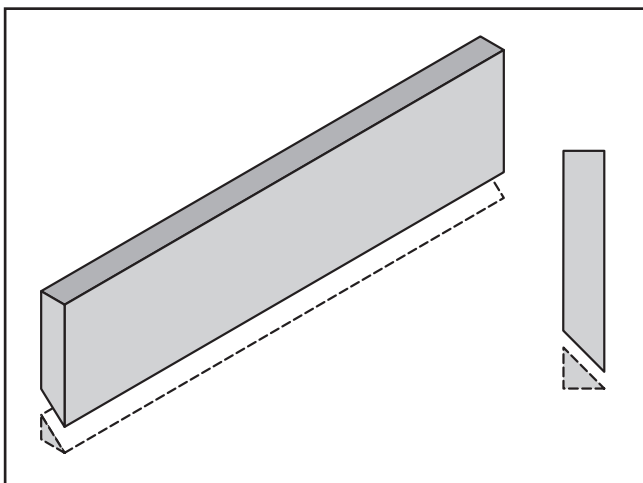
The Model G0495X has preset fence stops at 45° inward, 90°, and 45° outward (135°). If your situation requires a different angle, the fence can be locked anywhere between these angles.

## NOTICE

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



**Figure 32.** Typical bevel cutting operation, fence stop at 45° outward.



**Figure 33.** Illustration of bevel cutting results.

## To bevel cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 23**.
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 edge is face down on the surface of the infeed table.
6. Start the jointer.
7. With a push block in your leading hand (**Figure 32**), 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.

# Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge (see **Figures 34 & 35**). When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

## NOTICE

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

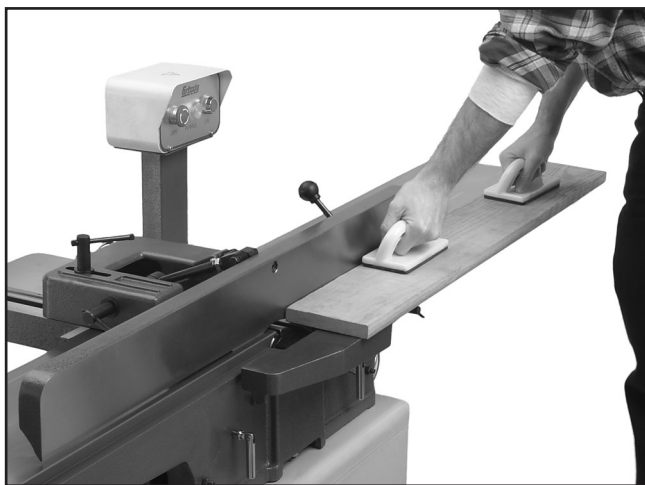


Figure 34. Typical rabbet cutting operation.

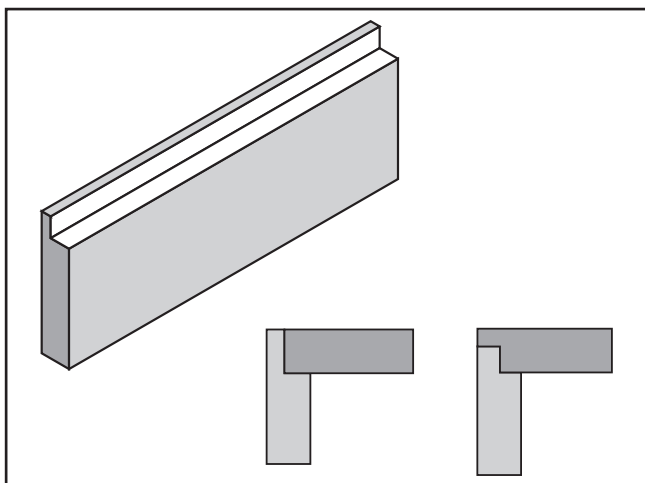


Figure 35. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on the jointer:

1. Read and understand **SECTION 1: SAFETY**, beginning on **Page 7**.
2. Make sure your stock has been inspected for dangerous conditions as described in the **Stock Inspection & Requirements** instructions, beginning on **Page 23**.
3. Set the cutting depth for your operation. (We suggest between  $\frac{1}{16}$ " and  $\frac{1}{8}$ " for rabbet cutting.)
4. Remove the cutterhead guard.
5. Make sure your fence is moved forward, so the amount of infeed/outfeed table exposed is the same as the size of your rabbet. Also, make sure your fence is set to  $90^\circ$ .
6. Start the jointer.
7. With a push block in each hand, press the workpiece against the table and fence with firm pressure, and feed the workpiece over the cutterhead.  
  
*Note: 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 your rabbet is cut to depth.

## ⚠ WARNING

When the cutterhead guard is removed, attempting any other cut besides a rabbet directly exposes the operator to the moving cutterhead. Always replace the cutterhead guard after rabbet cutting!

# SECTION 5: ACCESSORIES

## H9815—Power Twist® V-Belt - 1/2" x 48"

Smooth running with less vibration and noise than solid belts. The Power Twist® V-belt can be customized in minutes to any size—just add or remove sections to fit your needs. Size: 1/2" x 48"; replaces all "A" sized V-belts. Requires two Power Twist® V-belts to replace the stock V-belt on the Model G0495X.

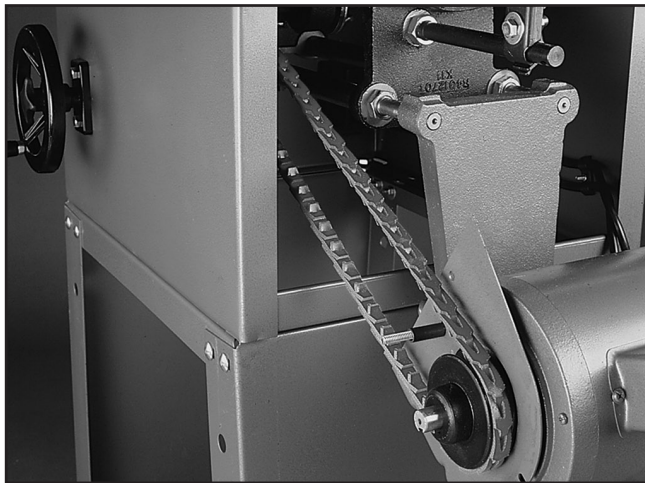


Figure 36. H9815 Power Twist® V-Belt.

## H9893—10 pk. Carbide Inserts 15x15x2.5mm

## 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 37. Recommended products for protecting unpainted cast iron/steel parts on machinery.

## G0495X 8" Jointer w/Digital Readout

## H8029—5 Piece Safety Kit

This kit has four essential jigs. Includes two push blocks, push stick, featherboard and combination saw and router gauge. Featherboard fits 3/8" x 3/4" miter slots. Made of high visibility yellow plastic.



Figure 38. H8029 5 Piece Safety Kit.

## G9643—8" Precision Straightedge

## G9644—12" Precision Straightedge

## H2675—16" Precision Straightedge

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



Figure 39. Straightedges.

Call 1-800-523-4777 To Order

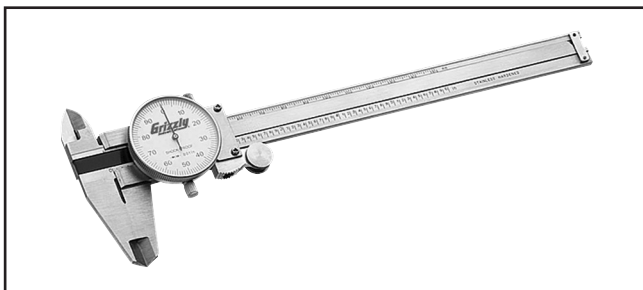
**T20514—Small Half-Mask Respirator**  
**T20515—Medium Half-Mask Respirator**  
**T20516—Large Half-Mask Respirator**  
**T20511—Pre-Filter P100**  
**T20539—Cartridge Filter 2PK P100**  
**T20541—Cartridge Filter 2PK P100 & O Vapor**  
 Wood and other types of dust can cause severe respiratory damage. If you work around dust every day, a half-mask respirator can greatly reduce your risk. Compatible with safety glasses!



**Figure 40.** Half-mask respirator with disposable cartridge filters.

**G9256—6" Dial Caliper**  
**G9257—8" Dial Caliper**  
**G9258—12" Dial Caliper**

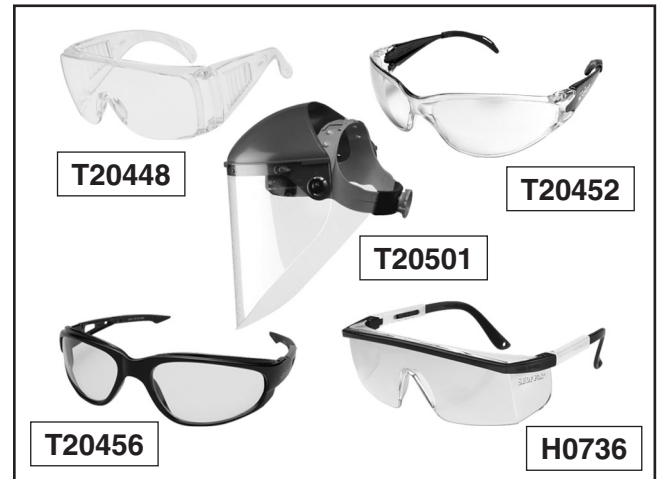
Required for jointing, planing, or sanding to critical tolerances. These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display. An absolute treat for the perfectionist!



**Figure 41.** Grizzly® Dial Calipers.

**T20501—Face Shield, 4" Crown, Clear**  
**T20502—Face Shield, 7" Crown, Clear**  
**T20448—Economy Clear Safety Glasses**  
**T20452—"Kirova" Anti-Reflective Glasses**  
**T20456—"Dakura" Clear Safety Glasses**  
**H0736—Shop Fox® Safety Glasses**

These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!



**Figure 42.** Our most popular eye protection.

**H6175—Power Respirator**  
**H6892—3M Pre-Filter, 10-Pack**  
**H6893—Filter Cartridge, 10-Pack, P100**

Say goodbye to foggy safety glasses and labored breathing, this battery powered respirator supplies a constant breeze of fresh air all day long. Comes with its own plastic case for clean, sealed storage. Finally, a respirator you can look forward to wearing—at an affordable price!



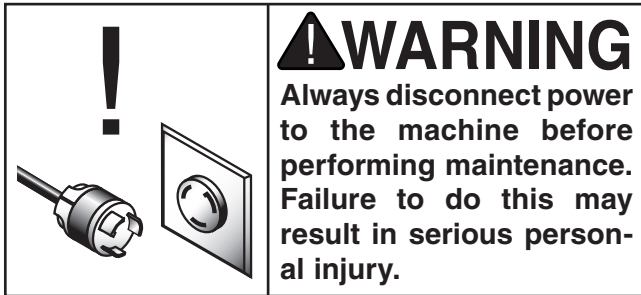
**Figure 43.** H6175 Power Respirator.

**Call 1-800-523-4777 To Order**





# SECTION 6: MAINTENANCE



## Schedule

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

### Daily Check:

- Vacuum all dust on and around the machine.
- Wipe down tables and all other unpainted cast iron with a metal protectant.
- Worn or damaged wires.
- Any other unsafe condition.

### Monthly Check:

- V-belt tension, damage, or wear.
- Clean/vacuum dust build up.
- Replace batteries in control panel and digital sensor as needed.

## Cleaning

Cleaning the Model G0495X is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

## Unpainted Cast Iron

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

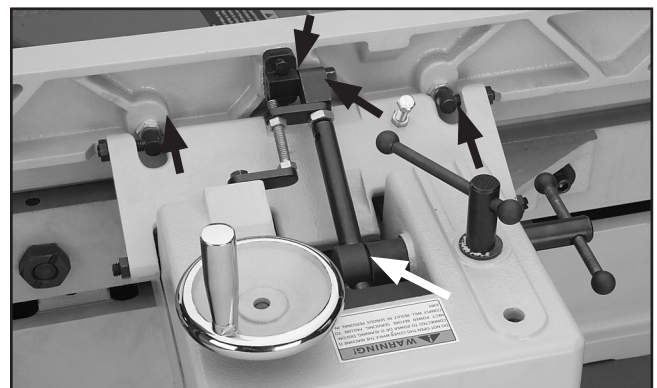
Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 29** for more details).

## Lubrication

Since all bearings on the G0495X are sealed and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.

Below is a list of components that require periodic lubrication. Be careful not to over-lubricate these components. Large amounts of lubricant will attract sawdust, causing the metal components to gum up and bind.

**Fence:** Place one or two drops of light machine oil on the fence pivot points (**Figure 44**) as needed.



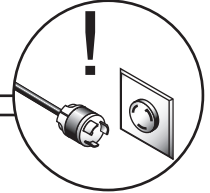
**Figure 44.** Fence lubrication locations.

**Gears:** Use a small brush to apply multi-purpose grease to the worm gear shafts and gears (Parts 96, 82 and 83) indicated on **Page 47**.

# 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
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>Emergency stop push-button is engaged/faulty.</li> <li>Wiring is open/has high resistance.</li> <li>Motor START button or STOP switch is at fault.</li> <li>Fuse has blown.</li> <li>Power supply switched OFF or is at fault.</li> <li>Start capacitor is at fault.</li> <li>Thermal overload relay has tripped.</li> <li>Wall fuse/circuit breaker is blown/tripped.</li> <li>Contactors not getting energized/has burnt contacts.</li> <li>Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Rotate clockwise slightly until it pops out/replace it.</li> <li>Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.</li> <li>Replace faulty START OR STOP switch.</li> <li>Correct short/replace fuse on control panel.</li> <li>Ensure power supply is switched on; ensure power supply has the correct voltage.</li> <li>Test/replace if faulty.</li> <li>Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times. Reduce workload on machine or test and replace motor. If motor is OK, replace relay.</li> <li>Ensure circuit size is suitable for this machine; correct for short. Reset/replace fuse or breaker.</li> <li>Test for power on all legs and contactor operation. Replace unit if faulty.</li> <li>Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>Feed rate/cutting speed too fast for task.</li> <li>Workpiece material is not suitable for this machine.</li> <li>Belt slipping.</li> <li>Motor connection is wired incorrectly.</li> <li>Motor bearings are at fault.</li> <li>Contactors not getting energized or has poor contacts.</li> <li>Motor has overheated.</li> <li>Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Decrease feed rate/cutting speed.</li> <li>Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece.</li> <li>Replace bad belt, align pulleys, and re-tension.</li> <li>Correct motor wiring connections.</li> <li>Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>Test for power on all legs and contactor operation. Replace if faulty.</li> <li>Clean off motor, let cool, and reduce workload.</li> <li>Test/repair/replace.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>Motor or component is loose.</li> <li>Inserts are at fault.</li> <li>V-belt worn or loose.</li> <li>Pulley is loose.</li> <li>Motor mount loose/broken.</li> </ol>	<ol style="list-style-type: none"> <li>Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid.</li> <li>Rotate or replace inserts causing problem.</li> <li>Inspect/replace belt with a new one (refer to <b>Page 42</b>).</li> <li>Realign/replace shaft, pulley, setscrew, and key as required.</li> <li>Tighten/replace.</li> </ol>



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>6. Machine is incorrectly mounted or sits unevenly.</li> <li>7. Motor fan is rubbing on fan cover.</li> <li>8. Motor bearings are at fault.</li> <li>9. Cutterhead bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>6. Tighten/replace anchor studs in floor; relocate/shim machine.</li> <li>7. Replace dented fan cover; replace loose/damaged fan.</li> <li>8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>9. Replace bearing(s)/realign cutterhead.</li> </ol>

## Table

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	<ol style="list-style-type: none"> <li>1. Table lock is engaged or partially engaged.</li> <li>2. Table stops blocking movement.</li> </ol>	<ol style="list-style-type: none"> <li>1. Completely loosen the table lock.</li> <li>2. Loosen/reset table positive stops.</li> </ol>

## Cutting

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge in the end of the board that is uneven with the rest of the cut).	<ol style="list-style-type: none"> <li>1. Outfeed table is set too low.</li> <li>2. Operator pushing down on end of workpiece.</li> </ol>	<ol style="list-style-type: none"> <li>1. Align outfeed table with cutterhead insert at top dead center (<b>Page 15</b>).</li> <li>2. Reduce/eliminate downward pressure on that end of workpiece.</li> </ol>
Workpiece stops in the middle of the cut.	<ol style="list-style-type: none"> <li>1. Outfeed table is set too high.</li> </ol>	<ol style="list-style-type: none"> <li>1. Align outfeed table with cutterhead insert at top dead center (<b>Page 15</b>).</li> </ol>
Chipping.	<ol style="list-style-type: none"> <li>1. Knots or conflicting grain direction in wood.</li> <li>2. Nicked or chipped insert.</li> <li>3. Feeding workpiece too fast.</li> <li>4. Taking too deep of a cut.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect workpiece for knots and grain (<b>Page 23</b>); only use clean stock.</li> <li>2. Rotate insert to expose sharp edge; replace insert (<b>Page 37</b>).</li> <li>3. Slow down the feed rate.</li> <li>4. Take a smaller depth of cut. (Always reduce cutting depth when surface planing or working with hard woods.)</li> </ol>
Fuzzy Grain.	<ol style="list-style-type: none"> <li>1. Wood may have high moisture content or surface wetness.</li> <li>2. Dull inserts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check moisture content and allow to dry if moisture is too high.</li> <li>2. Replace inserts (<b>Page 37</b>).</li> </ol>
Long lines or ridges that run along the length of the board	<ol style="list-style-type: none"> <li>1. Nicked or chipped insert.</li> </ol>	<ol style="list-style-type: none"> <li>1. Rotate insert to expose sharp edge; replace insert (<b>Page 37</b>).</li> </ol>
Uneven insert marks, wavy surface, chatter marks across board face.	<ol style="list-style-type: none"> <li>1. Feeding workpiece too fast.</li> </ol>	<ol style="list-style-type: none"> <li>1. Slow down the feed rate.</li> </ol>
Board edge is concave or convex after jointing.	<ol style="list-style-type: none"> <li>1. Board not held with even pressure on infeed and outfeed table during cut.</li> <li>2. Board started too uneven.</li> <li>3. Board has excessive bow or twist along its length.</li> <li>4. Insufficient number of passes.</li> </ol>	<ol style="list-style-type: none"> <li>1. Hold board with even pressure as it moves over the cutterhead.</li> <li>2. Take partial cuts to remove the extreme high spots before doing a full pass.</li> <li>3. Surface plane one face so there is a good surface to position against the fence.</li> <li>4. It may take 3 to 5 passes to achieve a perfect edge, depending on the starting condition of the board and the depth of cut.</li> </ol>



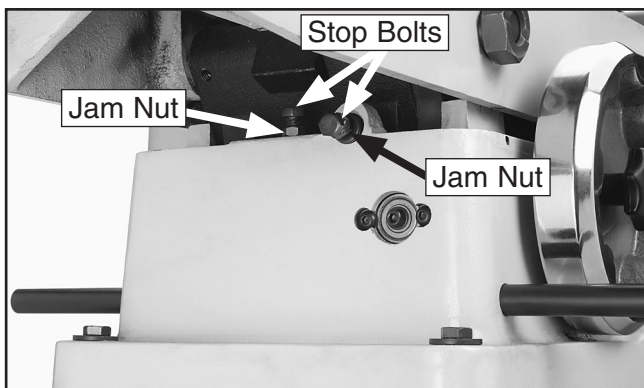
# Checking/Adjusting Table Parallelism

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

Tools Needed	Qty
Straightedge .....	1
Wrench or Socket 12mm .....	1
Wrench or Socket 32mm.....	1
Adjustable Wrench 10" .....	1
Hex Wrench 4mm.....	1
Duct Tape .....	1
Electrical Parts Cleaner.....	1

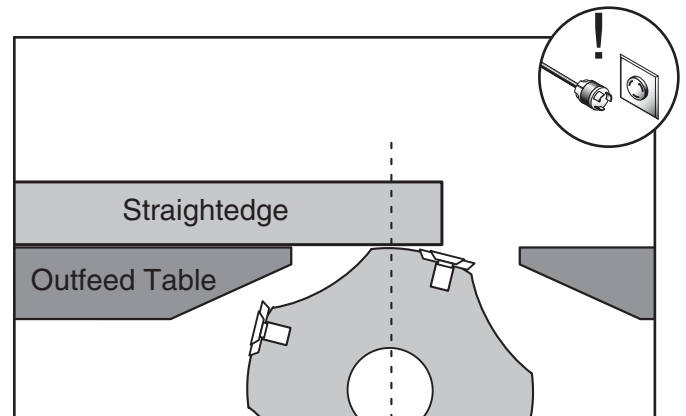
## Checking Outfeed Table

1. DISCONNECT JOINTER FROM POWER!
2. Put on leather gloves.
3. Remove the cutterhead guard and the fence.
4. Loosen the outfeed table lock located at the front of the machine, then loosen the jam nuts and positive stop bolts located under the outfeed table (see **Figure 45**).



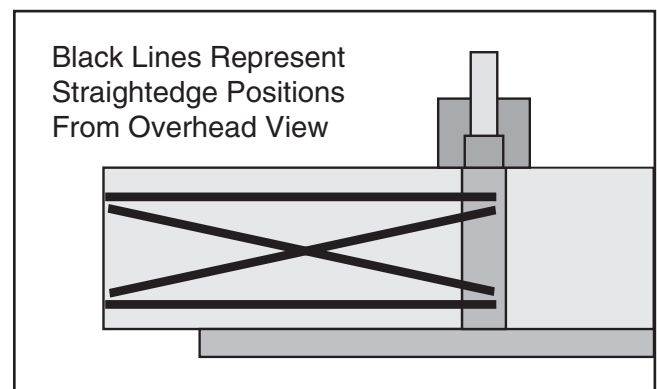
**Figure 45.** Outfeed table positive stop bolts.

5. Place the straightedge on the outfeed table so it hangs over the cutterhead, then lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 46** (rotate the cutterhead if necessary).



**Figure 46.** Adjusting outfeed table even with cutterhead body.

6. Place the straightedge in the positions shown in **Figure 47**. In each position, the straightedge should touch the cutterhead body and sit flat on the outfeed table.



**Figure 47.** Straightedge positions for verifying if outfeed table is parallel with cutterhead.

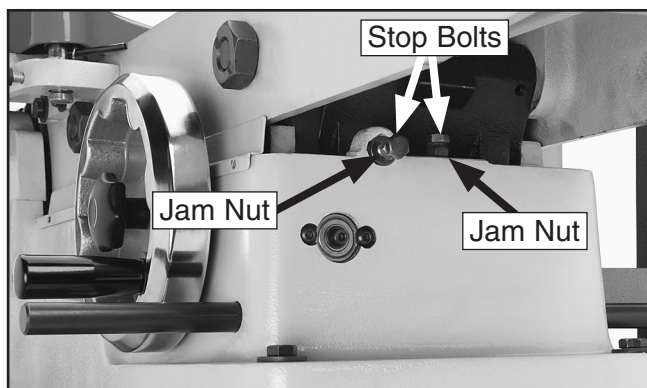
—If the straightedge touches the cutterhead and sits flat across the outfeed table in each position, then the outfeed table is already parallel with the cutterhead. Check the infeed table to make sure that it is parallel with the outfeed table.

—If the straightedge does not touch the cutterhead and sit flat on the outfeed 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.



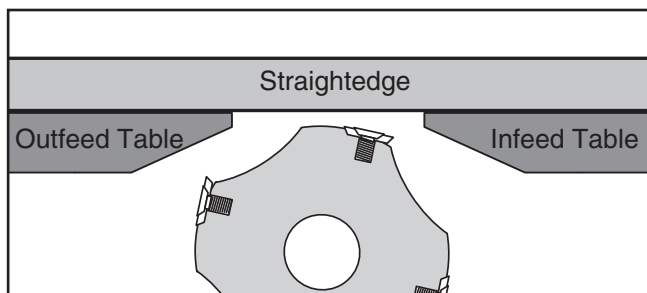
## Checking Infeed Table

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. Raise the outfeed table higher than the cutterhead.
3. Loosen the infeed table jam nuts and positive stop bolts shown in **Figure 48**.



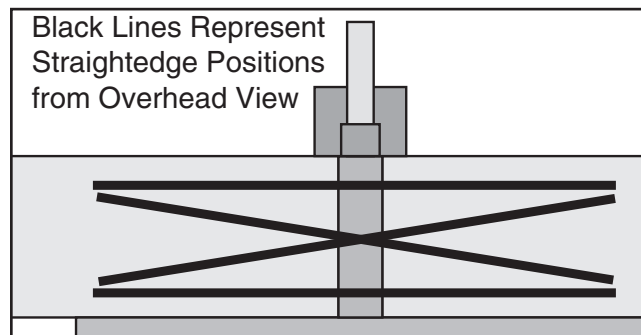
**Figure 48.** Infeed table positive stop bolts.

4. 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 49**.



**Figure 49.** Infeed and outfeed tables set evenly.

5. Place the straightedge in the positions shown in **Figure 50**. In each position, the straightedge should sit flat against both the outfeed table and the infeed table.



**Figure 50.** Straightedge positions for checking infeed/outfeed table parallelism.

—If the straightedge sits flat against both the infeed and outfeed table in each of the positions, then the tables are parallel. Set both table heights (**Pages 15 & 38**) and replace the cutterhead guard.

—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 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.

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

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

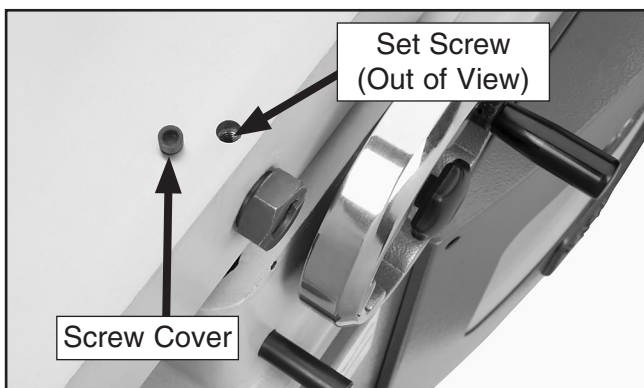
When setting the outfeed table, all measurements must be made from the cutterhead body—not the inserts.

**IMPORTANT:** The steps below are intended to be performed in succession with the steps involved in checking the outfeed table. Do not continue until you have followed those steps.

**To adjust the table parallelism:**

1. Place the straightedge on the outfeed table so it hangs over the cutterhead, then lower the outfeed table until the straightedge just touches the cutterhead body, as shown in **Figure 46** (rotate the cutterhead if necessary).
2. Remove the screw cover (**Figure 51**) covering each set screw on the outfeed table.

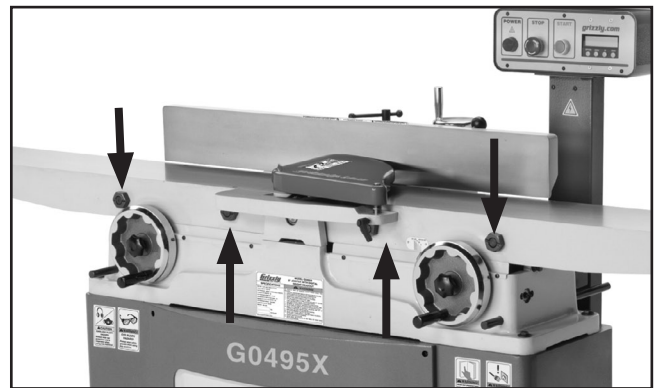
**Note:** It may help to clean the screw covers with electrical parts cleaner. Push duct tape firmly against the cover, then pull straight up.



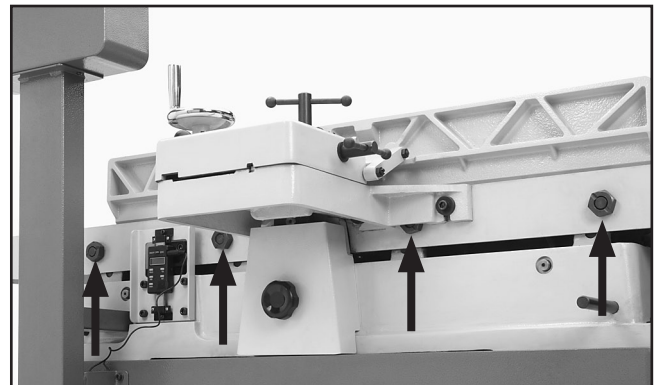
**Figure 51.** Screw cover and set screw location.

3. Loosen each set screw (**Figure 51**) two turns.
4. Place the straightedge in one of the positions shown in **Figure 47**, and adjust the table by turning the eccentric bushings (**Figures 52 & 53**) as needed with an adjustable wrench so that the straightedge touches the cutterhead while lying flat across the outfeed table. Repeat this step with each of the remaining straightedge positions as many times as necessary until the outfeed table is parallel with the cutterhead to within 0.010"-0.012".

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

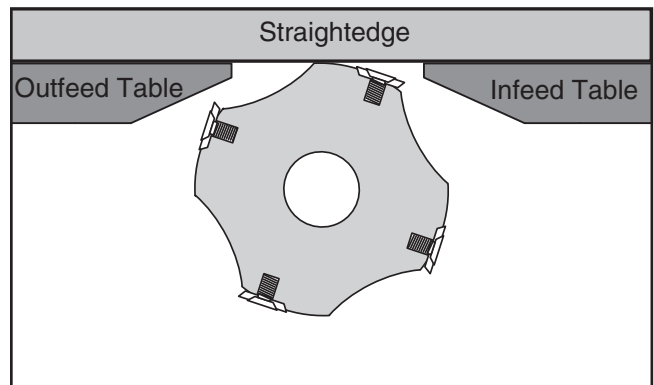


**Figure 52.** Front eccentric bushings.



**Figure 53.** Rear eccentric bushings.

5. Tighten the set screws and replace the screw covers on the outfeed table.
6. Remove each of the four screw covers on the infeed table, and loosen the set screws underneath.
7. Place the straightedge halfway across the infeed table and halfway over the outfeed table, then adjust the infeed table even with the outfeed table, as shown in **Figure 49**.



**Figure 54.** Infeed and outfeed tables adjusted even.

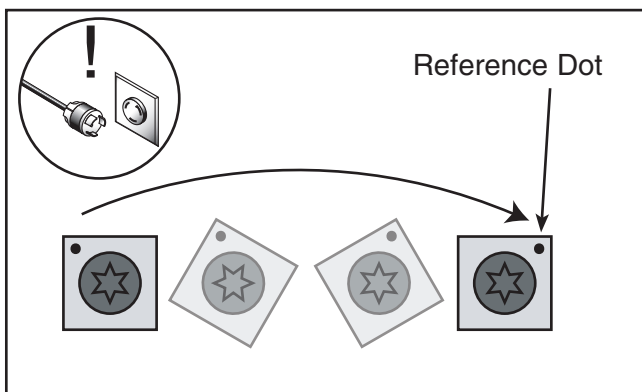


8. Place the straightedge in one of the positions shown in **Figure 50**, and adjust the eccentric bushings under the infeed table so the straightedge lies flat against both tables. Repeat this step with each of the remaining straightedge positions as many times as necessary until the infeed table is parallel with the outfeed table.
9. Tighten the set screws and replace the covers on the infeed table.
10. Set the outfeed table height (refer to **Setting Outfeed Table** on **Page 15**).
11. Reinstall the cutterhead guard and fence.

## Replacing Carbide Inserts

<b>Tools Needed:</b>	<b>Qty</b>
T-Handle Wrench w/T-25 Torx Bit .....	1

The cutterhead is equipped with 36 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 55**).



**Figure 55.** 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 JOINTER FROM POWER!
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.
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:** *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 cut.*

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

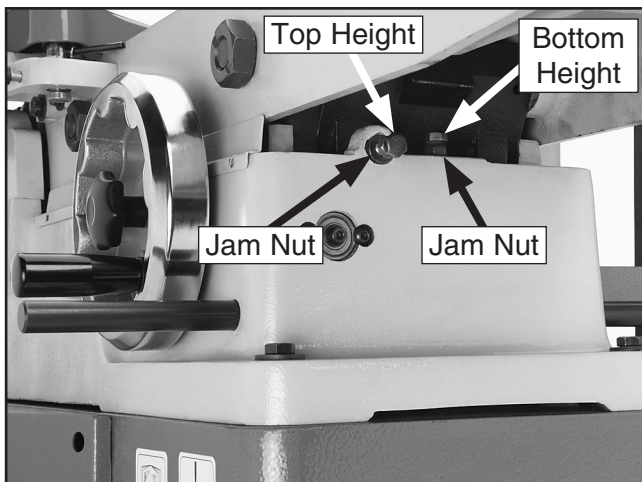


# Setting Infeed Table

The infeed table on the Model G0495X has positive stop bolts that, when properly set up, allow the operator to quickly adjust the infeed table between finish/final cuts and shaping/heavy cuts.

We recommend setting the minimum depth of cut to  $\frac{1}{32}$ " and the maximum depth of cut to  $\frac{1}{8}$ " for most operations. **DO NOT exceed  $\frac{1}{8}$ " cut per pass on this machine or the risk of kickback and serious injury will be greatly increased!**

Each positive stop bolt (**Figure 56**) controls the top or bottom range of the table movement. The jam nuts lock the positive stop bolts in position so they won't move during operation.



**Figure 56.** Infeed table positive stop bolts.

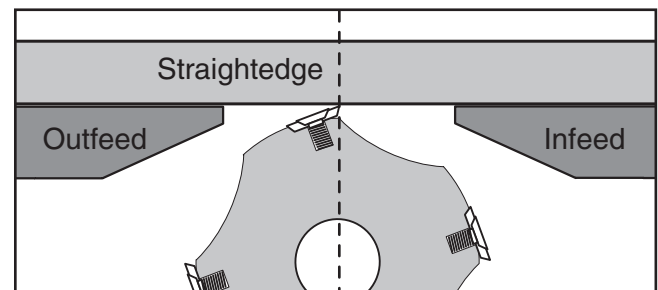
# Calibrating Infeed Table

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

Tools Needed	Qty
Straightedge .....	1
Wrench 12mm .....	1

## To calibrate the depth scale:

1. Set the outfeed table height as described in **Setting Outfeed Table Height** on **Page 15**.
2. Move the cutterhead guard out of the way.
3. Place a straightedge across the infeed and outfeed tables.
4. Adjust the infeed table until it is level with the outfeed table, as illustrated in **Figure 57**.



**Figure 57.** Infeed table adjusted even with outfeed table.

5. Follow instructions on **Page 39** to calibrate the digital sensor and readout so both display 0.000.





# Calibrating Digital Sensor & Readout

The digital readout on the control panel displays the depth of cut using the sensor located on the back of the jointer. The sensor requires a 1.5V type 357/303 silver oxide button cell battery and the display requires two AAA batteries. The 1.5 V battery is preinstalled at the factory but the AAA battery must be installed (refer to **Page 16**, for installation instructions). To conserve the batteries, turn the displays **OFF** when not in use.

## To calibrate the sensor and display:

1. Follow **Steps 1-5** on **Page 38** for calibrating the infeed table.
2. Turn **ON** the rear sensor, then turn **ON** the front digital readout.
3. Press the ZERO buttons on the sensor and front display, as shown in **Figures 58 & 59**.



**Figure 58.** Sensor zero button.



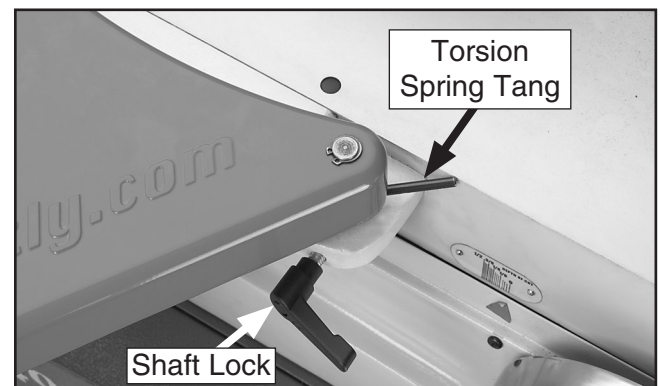
**Figure 59.** Digital readout zero button.

# Cutterhead Guard

The cutterhead guard comes pre-installed for shipping, but it may need to be adjusted if the guard does not quickly snap back against the fence when pulled out and let go.

## To adjust the cutterhead guard:

1. Loosen the shaft lock (**Figure 60**) and remove the cutterhead guard.
2. Wind the tang on the torsion spring clockwise a quarter turn, and slide the guard shaft into the casting so the spring tang points toward the main table but does not overlap it, as shown in **Figure 60**.



**Figure 60.** Guard mounted with spring tang in the correct position for proper return tension.

3. Test the guard by pulling it back and letting go.
  - The guard should quickly snap back over the cutterhead without dragging across the table. If it does, tighten the shaft lock.
  - 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 & 2**, increasing the spring tension as needed.

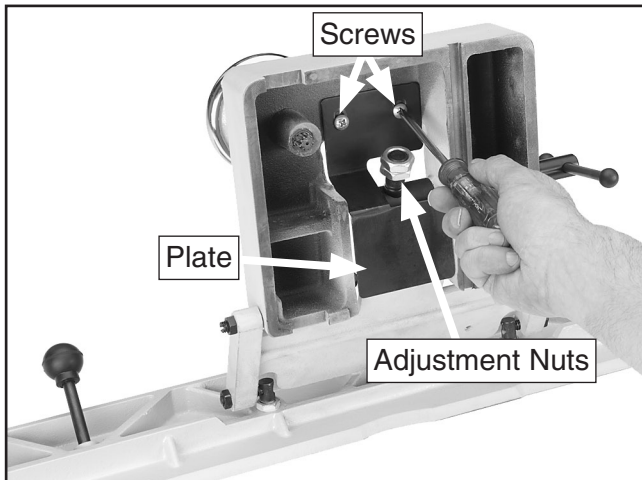
# Setting Fence Stops

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

Tools Needed	Qty
45° Square .....	1
90° Square .....	1
Sliding Bevel.....	1
Wrench 12mm .....	1
Wrench 24mm .....	1
Phillips Screwdriver .....	1

## To set the 45° inward fence stop:

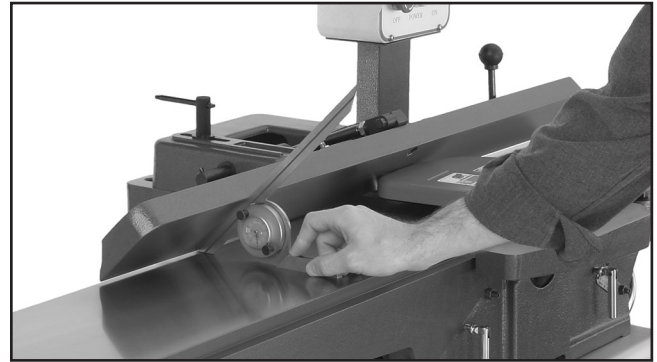
1. Remove the fence assembly from the jointer, remove the Phillips head screws from the plate shown in **Figure 61** under the fence carriage. The plate must be removed to access the adjustment nuts.



**Figure 61.** Removing plate to access inward fence stop.

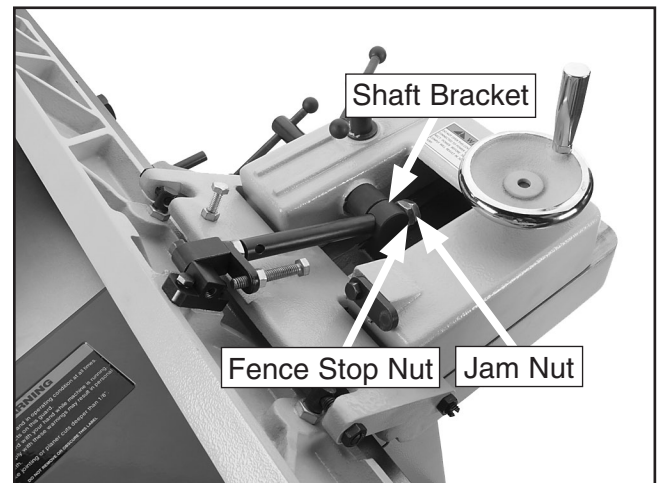
2. Reinstall the fence assembly on the jointer.

3. Using a 45° square, adjust the fence to the 45° inward position, as shown in **Figure 62**.



**Figure 62.** Example of adjusting fence 45° inward.

4. Loosen the jam nut shown in **Figure 63**.

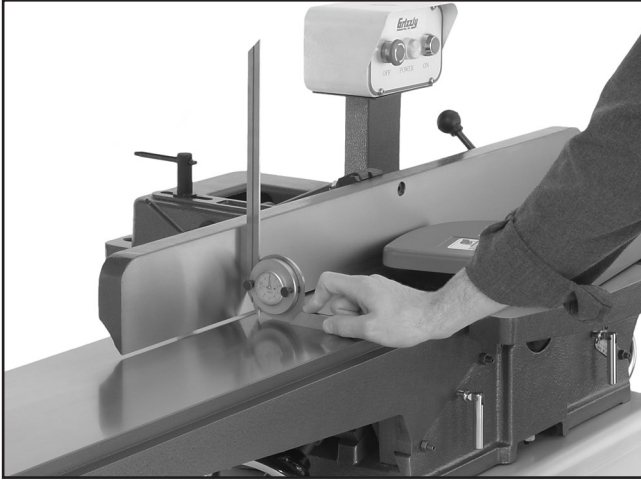


**Figure 63.** 45° inward fence stop jam nut.

5. Adjust the 45° inward fence stop nut until it makes contact with the back of the shaft bracket.
6. Retighten the jam nut loosened in **Step 4**.
7. Remove the fence assembly, reinstall the plate with the screws removed in **Step 1**, then reinstall the fence assembly.

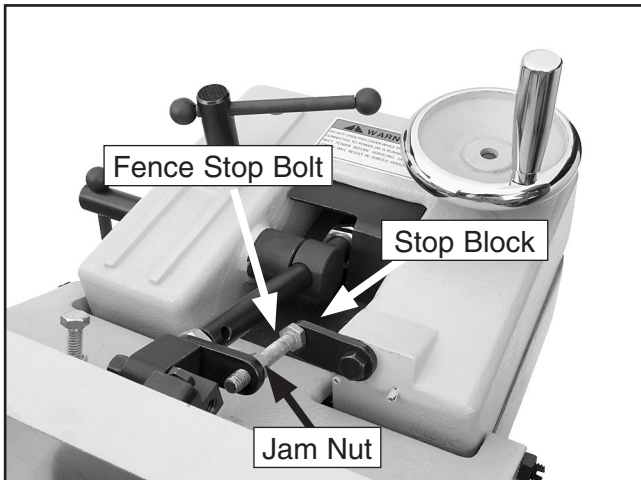
**To set the 90° fence stop:**

1. Using a 90° square, adjust the fence to the 90° position, as shown in **Figure 64**.



**Figure 64.** Adjusting fence to 90°.

2. Flip the 90° stop block into the position shown in **Figure 65**.

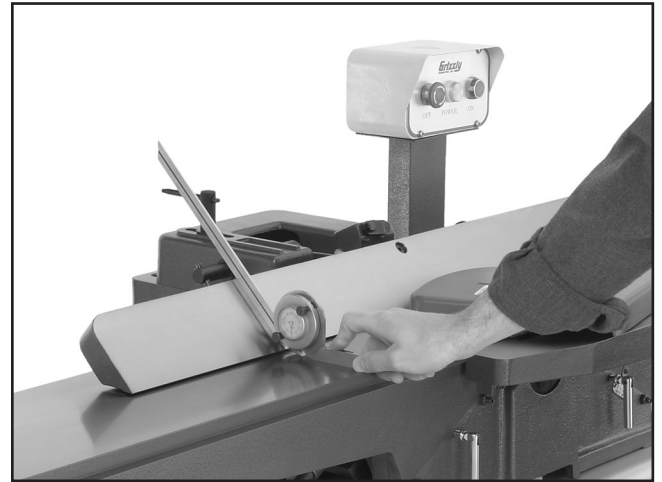


**Figure 65.** 90° stop block engaged.

3. Loosen the jam nut on the 90° fence stop bolt (**Figure 65**).
4. Adjust the 90° fence stop bolt until it makes contact with the 90° stop block.
5. Retighten the jam nut loosened in **Step 3**.

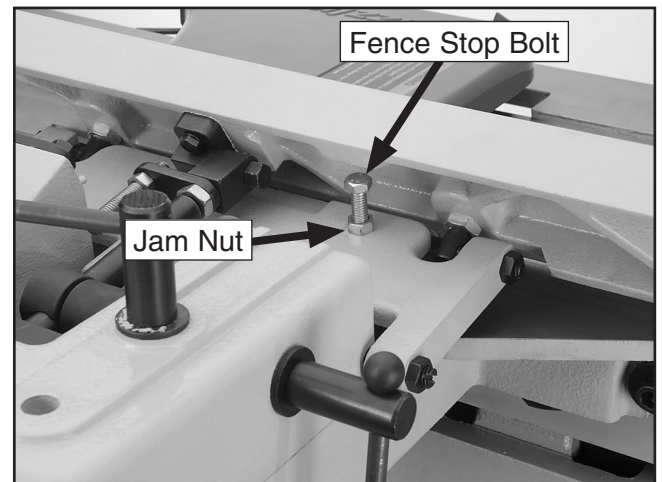
**To set the 45° outward fence stop:**

1. Using a sliding bevel adjusted to 135°, adjust the fence to the 135° (45° outward) position, as shown in **Figure 66**.



**Figure 66.** Adjusting fence 45° outward.

2. Loosen the jam nut on the 45° outward fence stop bolt (**Figure 67**).



**Figure 67.** 45° outward fence stop jam nut.

3. Adjust the 45° outward fence stop bolt until it makes contact with the back of the fence.
4. Retighten the jam nut loosened in **Step 2**.

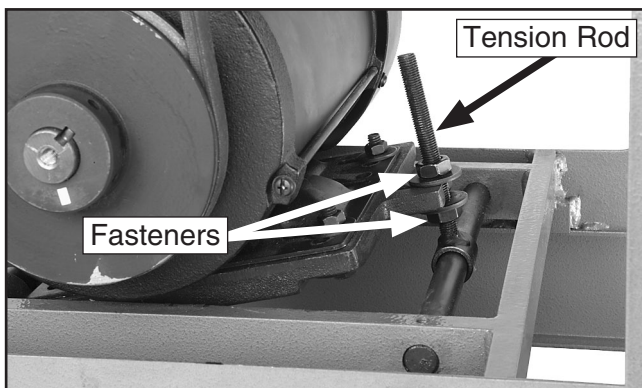
# V-Belt

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

Consider replacing the stock belt with a Power Twist V-belt (see **Page 29, Figure 36**) to reduce vibration and noise, and increase belt lifespan.

## To adjust/replace the V-belt:

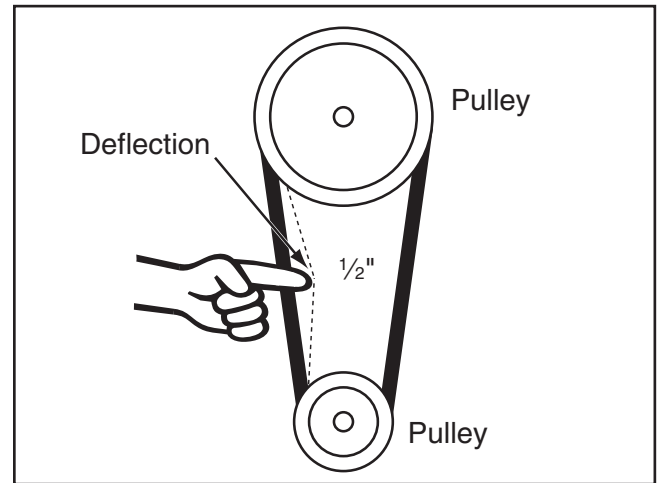
1. DISCONNECT JOINTER FROM POWER!
2. Remove the rear access panel and V-belt guard.
3. Using a 17mm wrench, loosen the fasteners on the tension rod shown in **Figure 68**.



**Figure 68.** Fasteners needed to be loosened for V-belt replacement.

4. Lift the motor up, slide the V-belt off of the motor and cutterhead pulleys, and replace it with a new one.

5. Lower the motor and adjust the V-belt tension with the tension rod fasteners so there is approximately  $\frac{1}{2}$ " deflection when the belt is pushed with moderate pressure, as shown in **Figure 69**.



**Figure 69.** Checking V-belt tension.

6. Replace the rear access panel and the V-belt guard.

# Pulley Alignment

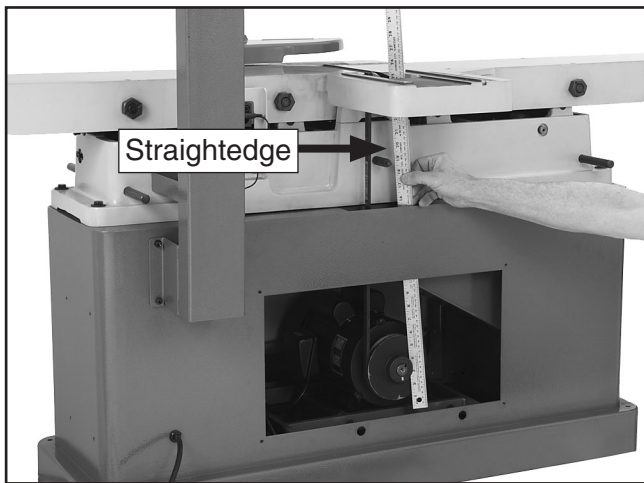
Pulley alignment is another important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplaner) for optimum performance.

Each pulley can be adjusted by loosening the motor mount fasteners, sliding the motor in or out, and retightening the fasteners to lock the motor pulley in place.

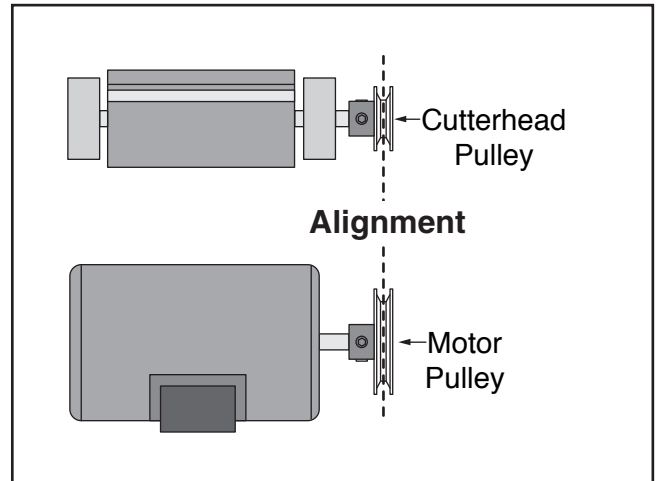
**Tools Needed:** Qty  
Wrench or Socket 17mm ..... 1

## To align the pulleys:

1. DISCONNECT JOINTER FROM POWER!
2. Remove the rear access cover, V-belt guard and the fence assembly.
3. Place a straightedge against both pulleys (**Figure 70**) and check to make sure that they are aligned and that the V-belt is straight up and down (see **Figure 71**).

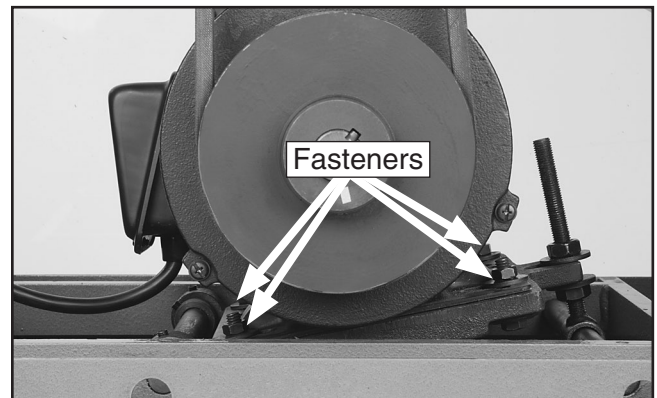


**Figure 70.** Checking belt alignment.



**Figure 71.** Pulleys aligned.

- If the pulleys are aligned, go to **Step 8**.
  - If the pulleys are NOT aligned, perform **Steps 4–8**.
4. Loosen the motor mount fasteners shown in **Figure 72**.



**Figure 72.** Motor mount fasteners.

5. Shift the motor horizontally as needed to align the motor pulley with the cutterhead pulley.
6. Tighten the motor mount fasteners. The V-belt should be parallel and aligned as shown in **Figure 71**.
7. Reinstall the fence assembly, rear access panel, and V-belt guard.



# Electrical Components

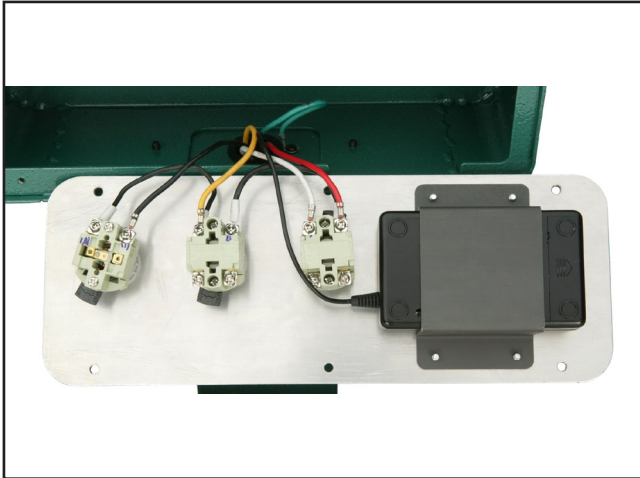


Figure 73. Control panel wiring.



Figure 74. Capacitor wiring.



Figure 75. Magnetic switch wiring.

# Wiring Diagram

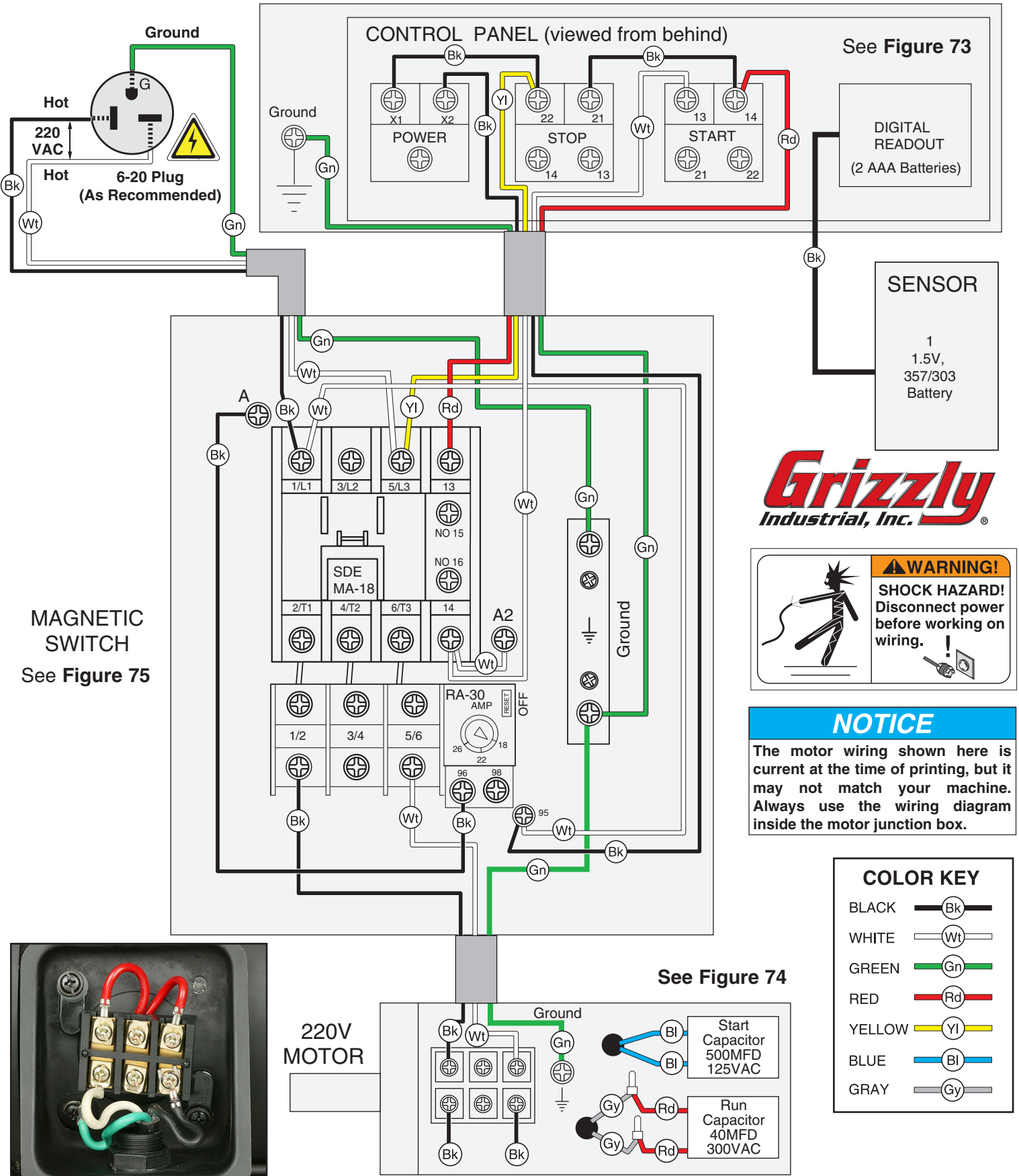
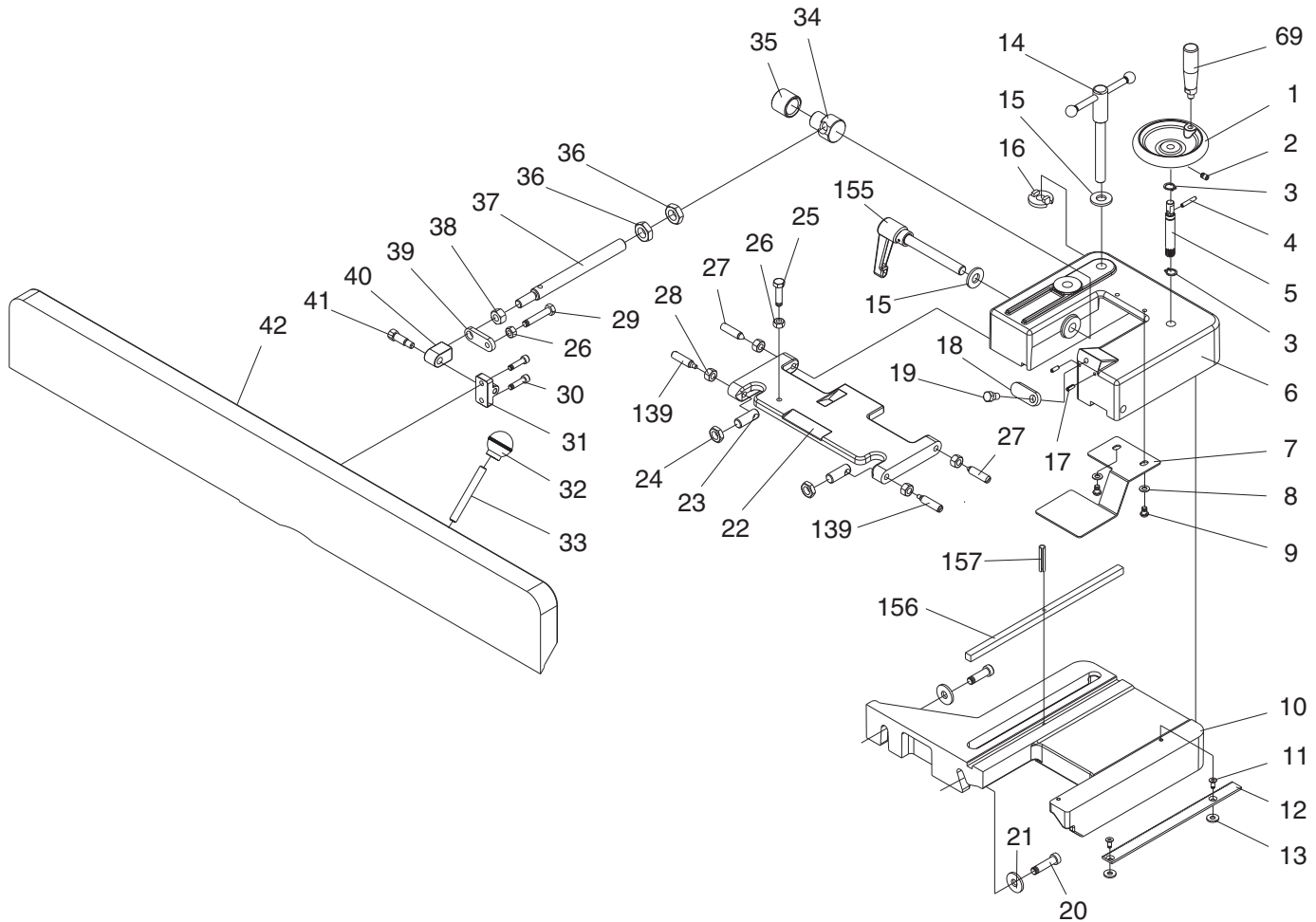


Figure 76. Junction box wiring.

G0495X 8" Jointer w/Digital Readout



# Fence Parts Breakdown & List



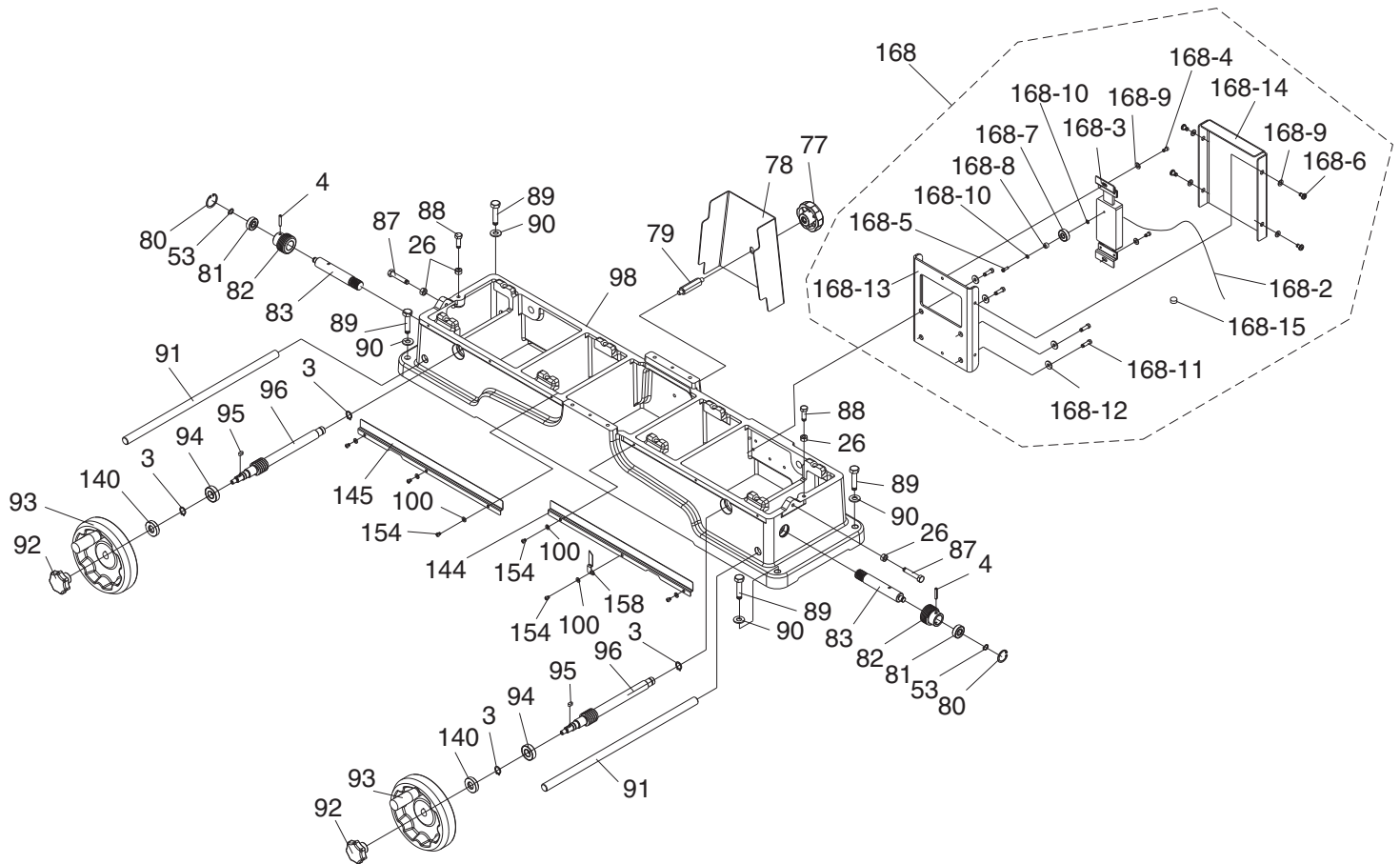
REF	PART #	DESCRIPTION
1	P0495X001	HANDWHEEL
2	PSS03	SET SCREW 1/4-20 X 3/8
3	PR05M	EXT RETAINING RING 15MM
4	PRP56M	ROLL PIN 4 X 25
5	P0495X005	GEAR SHAFT
6	P0495X006	FENCE BRACKET
7	P0495X007	PLATE
8	PW03M	FLAT WASHER 6MM
9	PSB17	CAP SCREW 1/4-20 X 3/8
10	P0495X010	TABLE BRACKET
11	PFH05M	FLAT HD SCR M5-.8 X 12
12	P0495X012	BAR
13	PW03M	FLAT WASHER 6MM
14	P0495X014	LOCKING HANDLE ASSEMBLY
15	P0495X015	SPECIAL WASHER
16	P0495X016	FENCE LOCK NUT
17	PRP18M	ROLL PIN 4 X 12
18	P0495X018	STOP BLOCK
19	P0495X019	SPECIAL BOLT 5/16-18 X 3/8
20	PSB19	CAP SCREW 3/8-16 X 1-1/4
21	PW04M	FLAT WASHER 10MM
22	P0495X022	FENCE HINGE
23	P0495X023	SPECIAL BOLT
24	PN01	HEX NUT 1/2-20

REF	PART #	DESCRIPTION
25	PB12	HEX BOLT 5/16-18 X 1-1/4
26	PN02	HEX NUT 5/16-18
27	P0495X027	SPECIAL BOLT
28	PN08	HEX NUT 3/8-16
29	PB22	HEX BOLT 5/16-18 X 1-3/4
30	PSB06	CAP SCREW 1/4-20 X 1
31	P0495X031	BRACKET
32	P0495X032	HANDLE
33	P0495X033	SHAFT
34	P0495X034	PIVOT NUT
35	P0495X035	COLLAR
36	PN02	HEX NUT 5/16-18
37	P0495X037	ROD
38	PN19	HEX NUT 7/16-14
39	P0495X039	STOP TAB
40	P0495X040	ADAPTER
41	P0495X041	ADAPTER SCREW
42	P0495X042	FENCE
69	P0495X069	FENCE ADJUSTMENT WHEEL HANDLE
139	P0495X139	BOLT
155	P0495X155	TILT LOCK
156	P0495X156	KEY 9.5 x 9.5 x 268
157	PRP19M	ROLL PIN 4 x 14





# Base Parts Breakdown & List

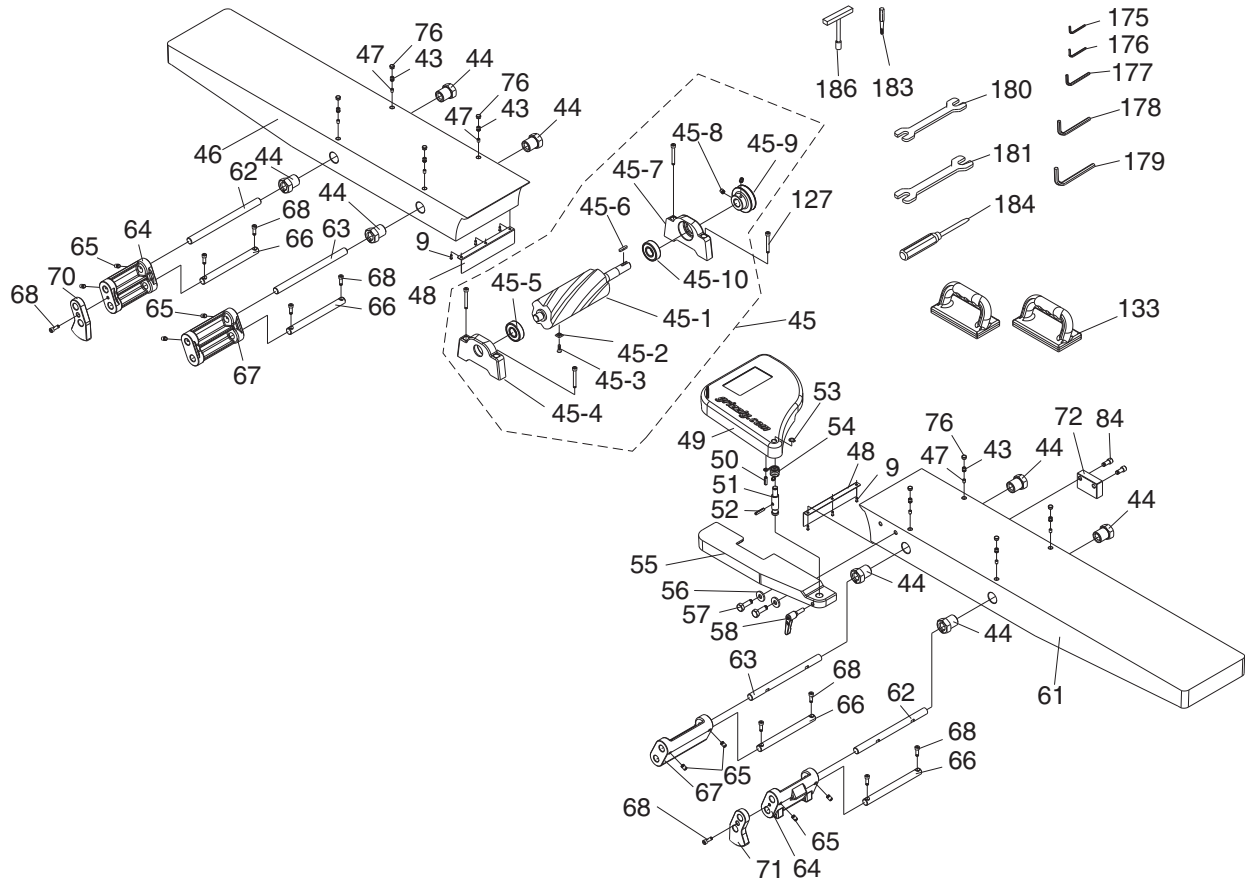


REF	PART #	DESCRIPTION
3	PR05M	EXT RETAINING RING 15MM
4	PRP56M	ROLL PIN 4 X 25
26	PN02	HEX NUT 5/16-18
53	PR16M	EXT RETAINING RING 9MM
77	P0495X077	KNOB
78	P0495X078	GUARD COVER
79	P0495X079	DOUBLE-END STUD
80	PR66M	INT RETAINING RING 25MM
81	P6000	BALL BEARING 6000ZZ
82	P0495X082	PINION GEAR
83	P0495X083	SHAFT
87	PB22	HEX BOLT 5/16-18 X 1-3/4
88	PB03	HEX BOLT 5/16-18 X 1
89	PB58	HEX BOLT 3/8-16 X 2
90	PW04M	FLAT WASHER 10MM
91	P0495X091	LIFTING ROD
92	P0495X092	LOCKING NUT
93	P0495X093	HANDWHEEL ASSEMBLY
94	P6002	BALL BEARING 6002ZZ
95	PK06M	KEY 5 X 5 X 10
96	P0495X096	SPIRAL GEAR SHAFT
98	P0495X098	BASE

REF	PART #	DESCRIPTION
100	PW02M	FLAT WASHER 5MM
140	P0495X140	BUSHING
144	P0495X144	RIGHT DUST PLATE
145	P0495X145	LEFT DUST PLATE
154	PS18	PHLP HD SCR 10-24 X 1/4
158	P0495X158	POINTER
168	P0495X168	SENSOR ASSEMBLY
168-2	P0495X168-2	CORD
168-3	P0495X168-3	DIGITAL SENSOR W/SLIDING SHAFT
168-4	PSB03M	CAP SCREW M5-.8 X 8
168-5	PS50M	PHLP HD SCR M3-.5 X 12
168-6	PS05M	PHLP HD SCR M5-.8 X 8
168-7	P606	BALL BEARING 606
168-8	P0495X168-8	BUSHING
168-9	PW02M	FLAT WASHER 5MM
168-10	PW07M	FLAT WASHER 3MM
168-11	PSB07	CAP SCREW 5/16-18 X 3/4
168-12	PW01M	FLAT WASHER 8MM
168-13	P0495X168-13	PLATE
168-14	P0495X168-14	COVER
168-15	P0495X168-15	BATTERY 1.5V SILVER OXIDE 357/303
185	PSB52M	CAP SCREW M8-1.25 X 10



# Table Parts Breakdown & List

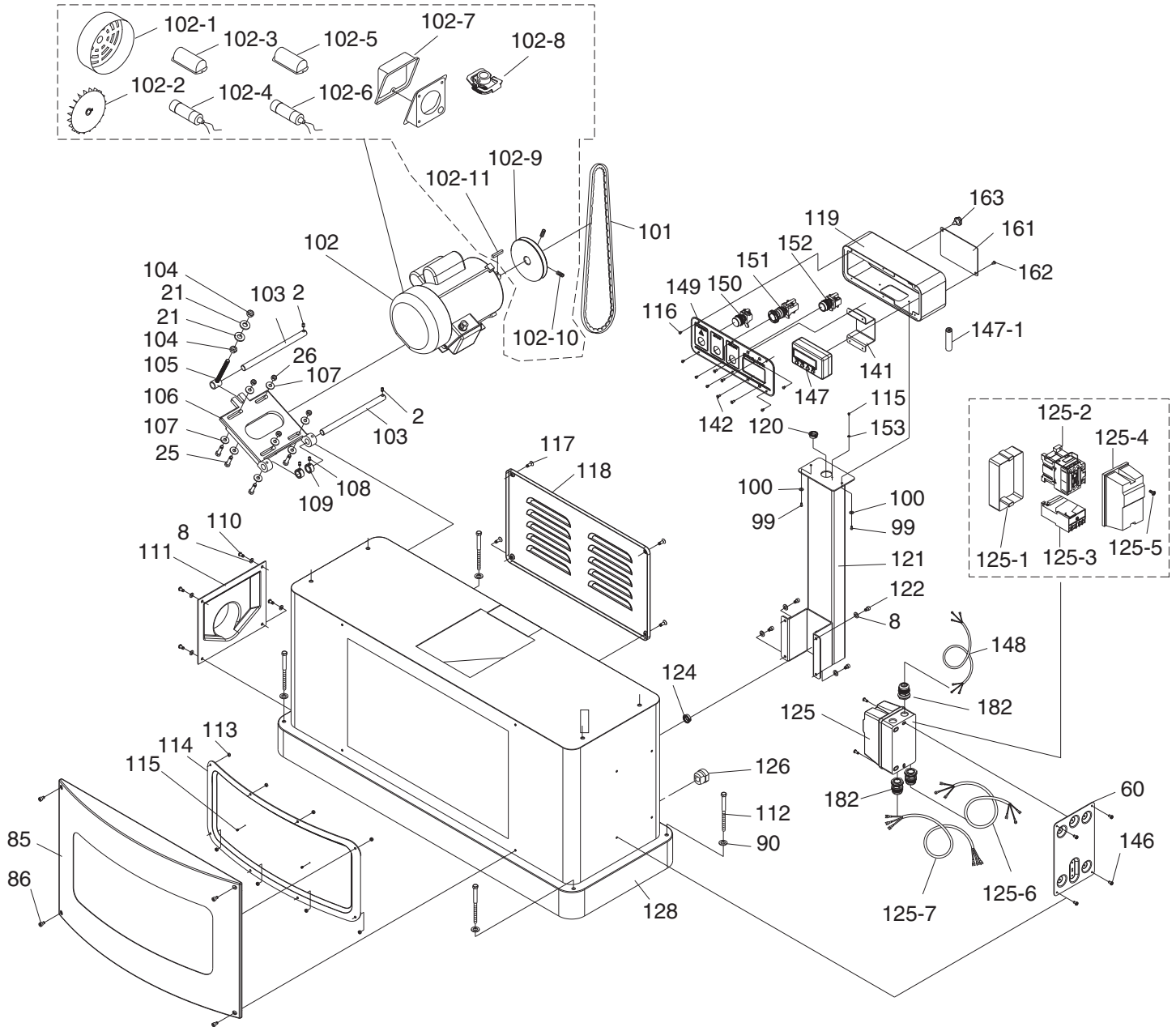


REF	PART #	DESCRIPTION
9	PSB17	CAP SCREW 1/4-20 X 3/8
43	PSS02	SET SCREW 5/16-18 X 3/8
44	P0495X044	ECCENTRIC BUSHING
45	P0495X045	SP CUTTERHEAD ASSEMBLY
45-1	P0495X045-1	SPIRAL CUTTERHEAD
45-10	P6203	BALL BEARING 6203ZZ
45-2	H9893	CARBIDE INSERTS 15 X 15 X 2.5
45-3	P0495X045-3	FLAT HD TORX SCR #10-32 X 1/2
45-4	P0495X045-4	LEFT BEARING SUPPORT BLOCK
45-5	P6203	BALL BEARING 6203ZZ
45-6	PK12M	KEY 5 X 5 X 30
45-7	P0495X045-7	RIGHT BEARING SUPPORT BLOCK
45-8	PSS23M	SET SCREW M4-.7 X 10
45-9	P0495X045-9	CUTTERHEAD PULLEY
46	P0495X046	REAR TABLE
47	P0495X047	BUSHING
48	P0495X048	CHIPBREAKER
49	P0495X049	BLADE GUARD
50	PRP07M	ROLL PIN 6 X 20
51	P0495X051	SHAFT
52	PRP27M	ROLL PIN 5 X 28
53	PR16M	EXT RETAINING RING 9MM
54	P0495X054	TORSION SPRING
55	P0495X055	FENCE LINK
56	PW04M	FLAT WASHER 10MM
57	PB24	HEX BOLT 3/8-16 X 1-1/4

REF	PART #	DESCRIPTION
58	P0495X058	CUTTERHEAD GUARD LOCK HANDLE
61	P0495X061	FRONT TABLE
62	P0495X062	SHAFT
63	P0495X063	SHAFT
64	P0495X064	BRACKET
65	PSS08	SET SCREW 5/16-18 X 1/2
66	P0495X066	ROD SHAFT
67	P0495X067	ROD BRACKET
68	PSB05	CAP SCREW 1/4-20 X 3/4
70	P0495X070	LEFT ELEVATE BRACKET
71	P0495X071	RIGHT ELEVATE BRACKET
72	P0495X072	SENSOR MOUNT BLOCK
76	P0495X076	SCREW COVER
84	PSB07	CAP SCREW 5/16-18 X 3/4
127	PSB25	CAP SCREW 5/16-18 X 1-3/4
133	P0495X133	PUSH BLOCK
175	PAW03M	HEX WRENCH 3MM
176	PAW04M	HEX WRENCH 4MM
177	PAW05M	HEX WRENCH 5MM
178	PAW06M	HEX WRENCH 6MM
179	PAW08M	HEX WRENCH 8MM
180	PWR1214	WRENCH 12 X 14
181	PRR1417	WRENCH 14 X 17
183	P0495X183	TORX BIT T-25
184	P0495X184	PHILLIPS SCREWDRIVER #1
186	P0495X186	T-HANDLE DRIVER



# Stand Parts Breakdown & List



REF	PART #	DESCRIPTION
2	PSS03	SET SCREW 1/4-20 X 3/8
8	PW03M	FLAT WASHER 6MM
21	PW04M	FLAT WASHER 10MM
25	PB12	HEX BOLT 5/16-18 X 1-1/4
26	PN02	HEX NUT 5/16-18
60	P0495X060	SWITCH PLATE
85	P0495X085	CAP
86	PSB04M	CAP SCREW M6-1 X 10
87	PB22	HEX BOLT 5/16-18 X 1-3/4
90	PW04M	FLAT WASHER 10MM
99	PSB03M	CAP SCREW M5-.8 X 8
100	PW02M	FLAT WASHER 5MM
101	PVA52	V-BELT A-52 4L520
102	P0495X102	MOTOR 3HP, 220V, SINGLE-PHASE

REF	PART #	DESCRIPTION
102-1	P0495X102-1	FAN COVER
102-2	P0495X102-2	FAN
102-3	P0495X102-3	S CAPACITOR COVER
102-4	P0495X102-4	S CAP 500M 125V 1-1/2 X 3-1/2
102-5	P0495X102-5	R CAPACITOR COVER
102-6	P0495X102-6	R CAP 40M 300V 1-1/2 X 2-3/8
102-7	P0495X102-7	JUNCTION BOX
102-8	P0495X102-8	CENTRIFUGAL SWITCH
102-9	P0495X102-9	MOTOR PULLEY
102-10	PSS03	SET SCREW 1/4-20 X 3/8
102-11	PK33M	KEY 5 X 5 X 45
103	P0495X103	SHAFT
104	PN02M	HEX NUT M10-1.5
105	P0495X105	ADJUSTING SHAFT

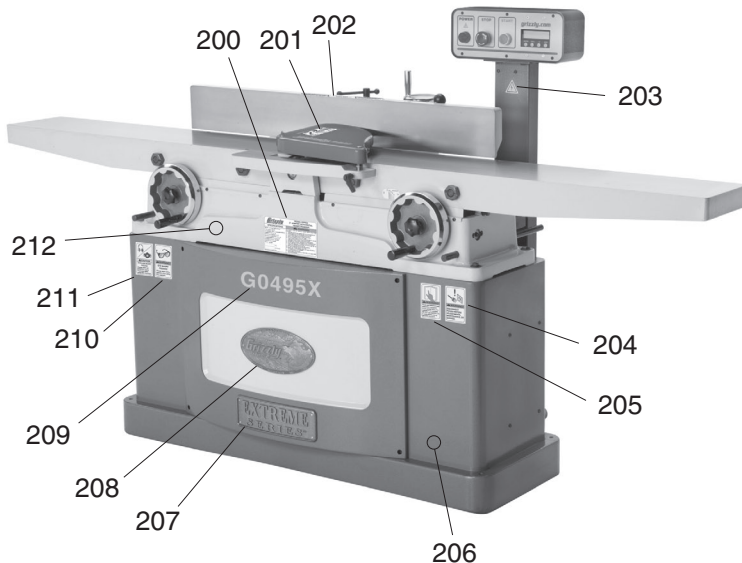


# Stand Parts List

REF	PART #	DESCRIPTION
106	P0495X106	MOTOR PLATE
107	PW01M	FLAT WASHER 8MM
108	PSS03M	SET SCREW M6-1 X 8
109	P0495X109	COLLAR
110	PSB04	PHLP HD SCREW 1/4-20 X 1/2
111	P0495X111	DUST CHUTE
112	PB70	HEX BOLT 3/8-16 X 6
113	PN06M	HEX NUT M5-.8
114	P0495X114	FRONT COVER
115	PS07M	PHLP HD SCR M4-.7 X 8
116	PSBS26M	BUTTON HD CAP SCR M4-.7 X 12
117	PFH05	FLAT HD SCR 1/4-20 X 3/4
118	P0495X118	REAR ACCESS PLATE
119	P0495X119	CONTROL PANEL COVER
120	P0495X120	STRAIN RELIEF NB-2430
121	P0495X121	SWITCH BRACKET ASSEMBLY
122	PSB04	CAP SCREW 1/4-20 X 1/2
124	P0495X124	STRAIN RELIEF NB-1722
125	P0495X125	MAGNETIC SWITCH
125-1	P0495X125-1	MAG SWITCH BACK COVER
125-2	P0495X125-2	CONTACTOR SDE MA-18 220V
125-3	P0495X125-3	OL RELAY SDE RA-30 18-26

REF	PART #	DESCRIPTION
125-4	P0495X125-4	MAG SWITCH FRONT COVER
125-5	P0495X125-5	NYLON SCREW M10-1.5 X 22
125-6	P0495X125-6	POWER CORD 14AWG X 3C
125-7	P0495X125-7	CONTROL PANEL CORD 16AWG X 5C
126	P0495X126	STRAIN RELIEF SB8R-1
128	P0495X128	STAND
141	P0495X141	DIGITAL READOUT BRACKET
142	PFH57M	FLAT HD SCR M3-.5 X 8
146	PS05M	PHLP HD SCR M5-.8 X 8
147	P0495X147	DIGITAL READOUT ASSEMBLY
147-1	P0495X147-1	BATTERY AAA
148	P0495X148	MOTOR CORD 14AWG X 3C
149	P0495X149	SWITCH PLATE
150	P0495X150	LIGHT 250V 1.2W JG18
151	P0495X151	STOP SWITCH
152	P0495X152	START SWITCH
153	PTLW01M	EXT TOOTH WASHER 4MM
161	P0495X161	ACCESS DOOR
162	P0495X162	SPECIAL SCREW
163	P0495X163	KNOB M6-1
182	P0495X182	STRAIN RELIEF

## Label Placement



REF	PART #	DESCRIPTION
200	P0495X200	MACHINE ID LABEL
201	PLABEL-29	CUTTERHEAD GUARD LABEL
202	P0495X202	FENCE/CUTTERHEAD LABEL
203	PLABEL-14	ELECTRICITY LABEL
204	PLABEL-36	DISCONNECT 220V POWER LABEL
205	PLABEL-12A	READ MANUAL-VERTICAL NS 7/05 LABEL
206	PPAINT-1	"GRIZZLY GREEN" TOUCH-UP PAINT
207	P0495X207	EXTREME SERIES PLATE
208	G8588	SMALL GRIZZLY NAMEPLATE
209	P0495X209	MODEL # LABEL
210	PLABEL-11	SAFETY GLASSES 2" X 3-5/16" LABEL
211	P0495X211	EAR PROTECTION/RESPIRATOR LABEL
212	PPAINT-11	"PUTTY" TOUCH-UP PAINT

## **!**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](http://www.grizzly.com) to order new labels.





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<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
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<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

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



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Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

# WARRANTY AND RETURNS

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

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

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

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

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

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

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