

Grizzly *Industrial, Inc.*®

MODEL G0490W/G0490XW 8" X 76" JOINTER w/PARALLELOGRAM BEDS OWNER'S MANUAL (For models manufactured since 05/16)



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#BL17848 PRINTED IN CHINA

V2.09.16



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

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

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

Manual Accuracy

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

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

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

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

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure safety glasses and respirator are properly adjusted/setup and	
Specification:		4. Make sure power is connected to grounded circuit before starting.	
Weight:		5. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.	
		6. DO NOT expose to rain or dampness.	
		7. DO NOT modify this machine in any way.	
		8. Make sure power is disconnected.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
		Manufactured for Grizzly in Taiwan	

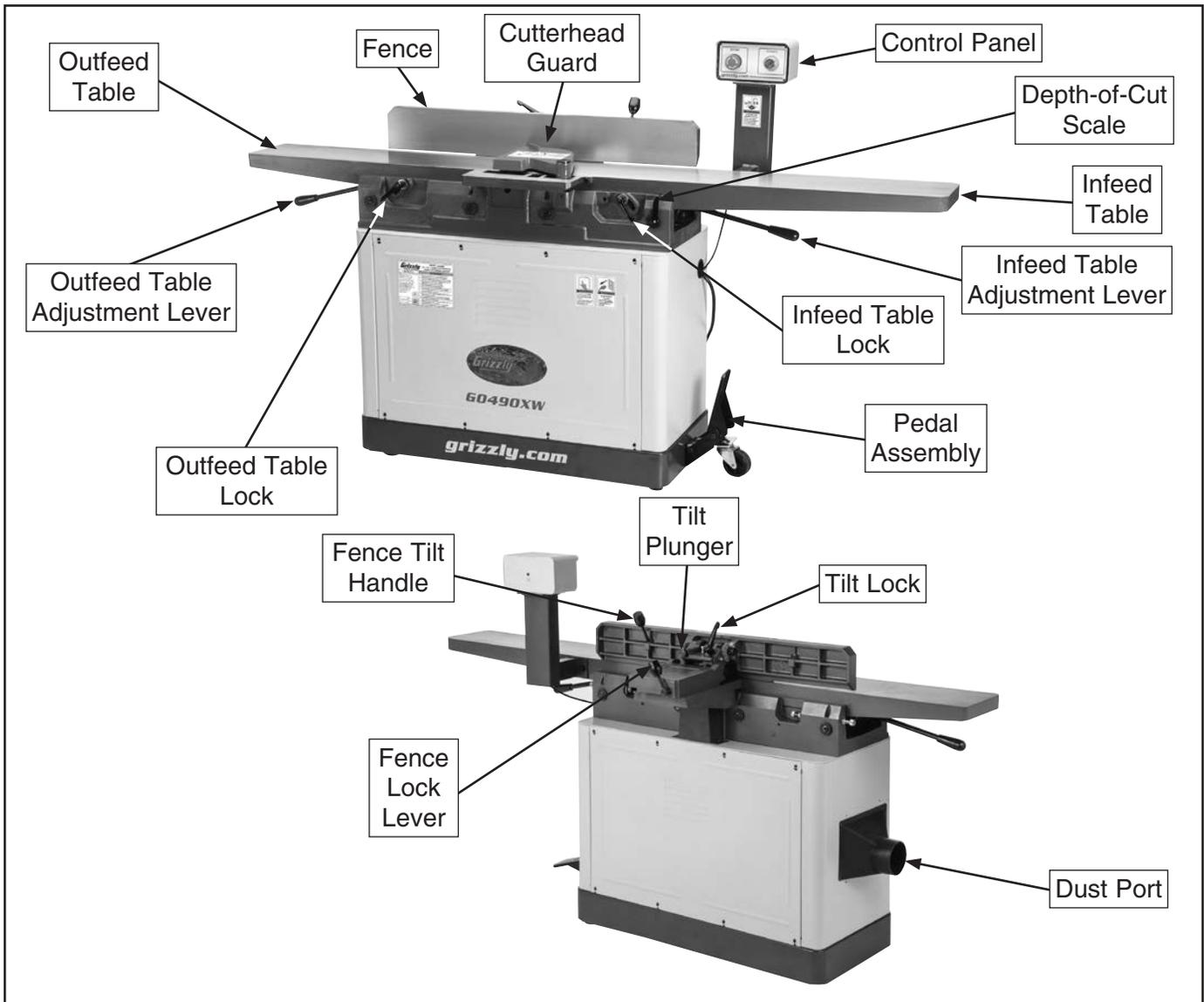
Manufacture Date []

Serial Number []



Identification

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



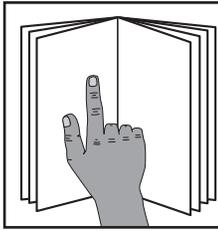
⚠️ WARNING

For Your Own Safety Read Instruction Manual Before Operating Jointer

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



Controls & Components



⚠️ WARNING

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

Refer to **Figures 1–5** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

Control Panel

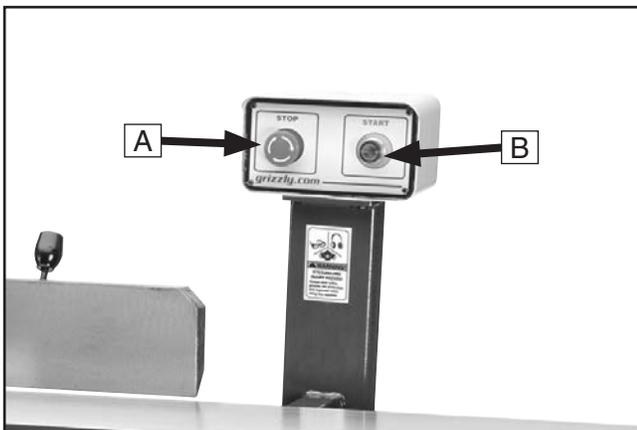


Figure 1. STOP/START button locations.

- A. STOP Button:** Stops motor and cutterhead when pushed. While remaining depressed, prevents motor from being restarted. Reset by twisting clockwise until it pops out. Once reset, motor can be restarted.
- B. START Button:** Starts motor when pressed (only if STOP button has been reset).

Table Controls

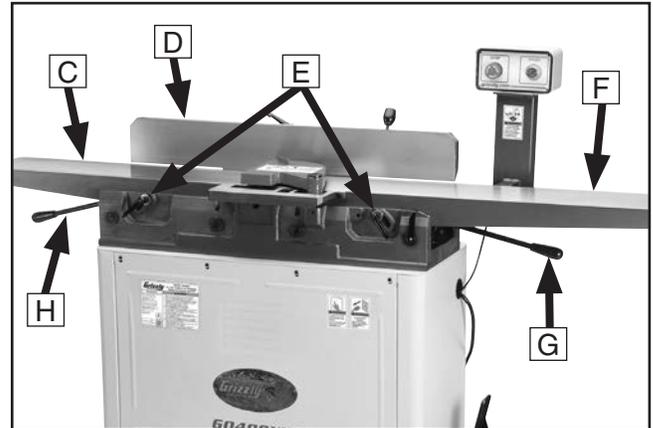


Figure 2. Location of main table controls.

- C. Outfeed Table:** Supports workpiece after it passes over cutterhead. For optimum results, outfeed table must be properly adjusted even with highest point of cutterhead knives/inserts (refer to **Page 46** for more details).
- D. Fence:** Supports workpiece laterally as it moves across cutterhead; determines angle of cut when edge or bevel joining.
- E. Table Locks:** Tighten to secure position of infeed and outfeed tables; loosen to allow vertical table movement with adjustment levers.
- F. Infeed Table:** Supports workpiece before it reaches cutterhead. Position of infeed table relative to cutterhead knives/inserts determines depth of cut.
- G. Infeed Table Adjustment Lever:** Adjusts position of infeed table (when infeed table lock is loosened).
- H. Outfeed Table Adjustment Lever:** Adjusts outfeed table position (when outfeed table lock and positive stop bolts are loosened).



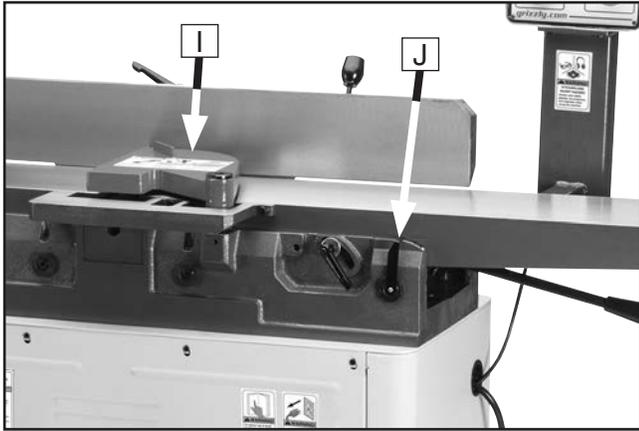


Figure 3. Cutterhead guard and depth-of-cut scale.

- I. Cutterhead Guard:** Covers cutterhead until pushed out of the way by workpiece during operation. When workpiece leaves cutterhead, guard springs back to its starting position.
- J. Depth-of-Cut Scale:** Indicates depth of cut.

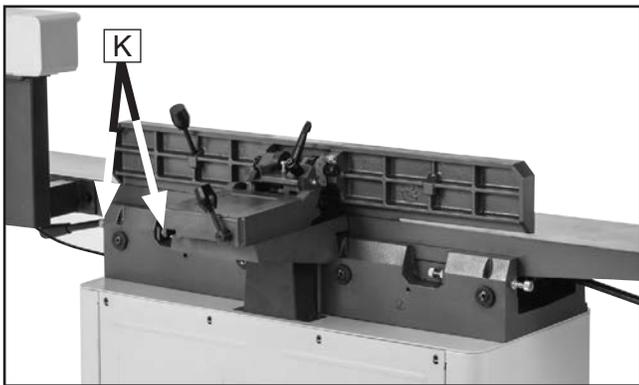


Figure 4. Location of positive stops.

- K. Infeed Positive Stop Bolts:** Control top and bottom range of infeed table movement.
- L. Outfeed Positive Stop Bolts:** Tighten to prevent outfeed table movement; loosen to allow vertical movement of outfeed table.

Fence Controls

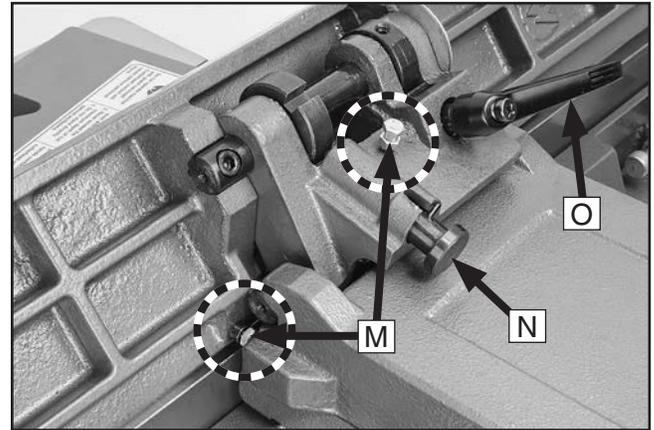


Figure 5. Location of fence controls.

- M. Fence Tilt Stops:** Stop fence at 45° inward and 45° outward (135°).

Note: Even when fence is resting against stops, fence tilt lock must be tightened before starting machine.
- N. Tilt Plunger:** When engaged, sets fence at 90°. When disengaged, allows bevel cuts greater than 90°.
- O. Fence Tilt Lock:** Secures fence at any position in available range.

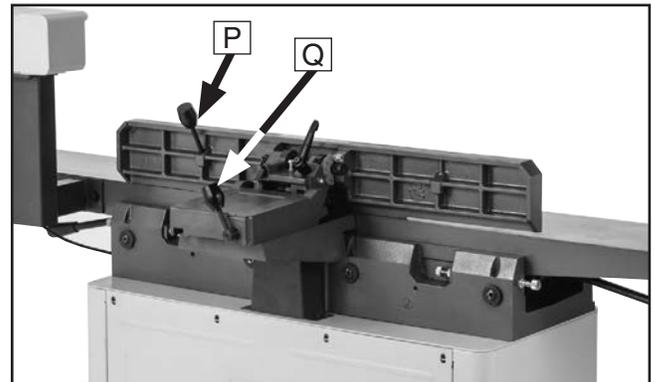


Figure 6. Fence tilt handle and table locks.

- P. Fence Tilt Handle:** Tilts fence throughout its range of motion from 45° inward to 45° outward (135°).
- Q. Fence Lock Lever:** Tightens to secure fence position along width of tables; loosens to allow lateral adjustment.





MACHINE DATA SHEET

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

MODEL G0490W 8" JOINTER WITH PARALLELOGRAM BEDS

Product Dimensions:

Weight..... 482 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 76-1/2 x 26-1/2 x 45-1/2 in.
 Footprint (Length x Width)..... 41 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
 Content..... Machine
 Weight..... 388 lbs.
 Length x Width x Height..... 80 x 26 x 12 in.
 Must Ship Upright..... Yes

Carton #2

Type..... Cardboard Box
 Content..... Stand
 Weight..... 174 lbs.
 Length x Width x Height..... 39 x 19 x 29 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 240V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 12A
 Minimum Circuit Size..... 20A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 12 AWG
 Plug Included..... Yes
 Included Plug Type..... 6-20
 Switch Type..... Magnetic w/Thermal Overload Protection

Motors:

Main

Type..... TEFC Capacitor-Start Induction
 Horsepower..... 3 HP
 Phase..... Single-Phase
 Amps..... 12A
 Speed..... 3450 RPM
 Power Transfer Belt Drive
 Bearings..... Sealed & Permanently Lubricated



Main Specifications:

Main Specifications

Jointer Size.....	8 in.
Bevel Jointing.....	0 – 45 deg. L/R
Maximum Width of Cut.....	8 in.
Maximum Depth of Cut.....	1/8 in.
Minimum Workpiece Length.....	8 in.
Minimum Workpiece Thickness.....	1/2 in.
Maximum Rabbeting Depth.....	1/2 in.
Number of Cuts Per Minute.....	21,400

Fence Information

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

Cutterhead Information

Cutterhead Type.....	4 Knife
Cutterhead Diameter.....	3 in.
Cutterhead Speed.....	5350 RPM

Knife Information

Number of Knives.....	4
Knife Type.....	HSS, Single-Sided
Knife Length.....	8-1/16 in.
Knife Width.....	3/4 in.
Knife Thickness.....	1/8 in.
Knife Adjustment.....	Jack Screws

Table Information

Table Length.....	76-1/2 in.
Table Width.....	8 in.
Table Thickness.....	2-7/8 in.
Floor to Table Height.....	32-1/4 in.
Table Adjustment Type.....	Lever Action
Table Movement Type.....	Parallelogram

Construction

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

Other Information

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

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No





MACHINE DATA SHEET

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

MODEL G0490XW 8" JOINTER WITH SPIRAL CUTTERHEAD

Product Dimensions:

Weight..... 484 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 76-1/2 x 26-1/2 x 45-1/2 in.
 Footprint (Length x Width)..... 41 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
 Content..... Machine
 Weight..... 390 lbs.
 Length x Width x Height..... 80 x 26 x 12 in.
 Must Ship Upright..... Yes

Carton #2

Type..... Cardboard Box
 Content..... Stand
 Weight..... 174 lbs.
 Length x Width x Height..... 39 x 19 x 29 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 240V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 12A
 Minimum Circuit Size..... 20A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 12 AWG
 Plug Included..... Yes
 Included Plug Type..... 6-20
 Switch Type..... Button Controls w/Magnetic Switch Protection

Motors:

Main

Type..... TEFC Capacitor-Start Induction
 Horsepower..... 3 HP
 Phase..... Single-Phase
 Amps..... 12A
 Speed..... 3450 RPM
 Power Transfer..... Belt Drive
 Bearings..... Sealed & Permanently Lubricated



Main Specifications:

Main Specifications

Jointer Size.....	8 in.
Bevel Jointing.....	0 – 45 deg. L/R
Maximum Width of Cut.....	8 in.
Maximum Depth of Cut.....	1/8 in.
Minimum Workpiece Length.....	8 in.
Minimum Workpiece Thickness.....	1/2 in.
Maximum Rabbeting Depth.....	1/2 in.
Number of Cuts Per Minute.....	21,400

Fence Information

Fence Length.....	36-1/8 in.
Fence Width.....	1-1/4 in.
Fence Height.....	5 in.
Fence Stops.....	45, 90, 135 deg.

Cutterhead Information

Cutterhead Type.....	Spiral
Cutterhead Diameter.....	3 in.
Number of Cutter Spirals.....	4
Number of Indexable Cutters.....	40
Cutterhead Speed.....	5350 RPM

Cutter Insert Information

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

Table Information

Table Length.....	76-1/2 in.
Table Width.....	8 in.
Table Thickness.....	2-7/8 in.
Floor to Table Height.....	32-1/4 in.
Table Adjustment Type.....	Lever Action
Table Movement Type.....	Parallelogram

Construction

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

Other Information

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

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No



SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

WARNING

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

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

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

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

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Jointers

WARNING

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

KICKBACK. Occurs when workpiece is ejected from machine at a high rate of speed. To reduce the risk of kickback-related injuries, use quality workpieces, safe feeding techniques, and proper machine setup or maintenance.

GUARD REMOVAL. Operating jointer without guard exposes operator to knives/inserts. Except when rabbeting, never remove guards for regular operations or while connected to power. Turn jointer **OFF** and disconnect power before clearing any shavings or sawdust from around cutterhead. After rabbeting or maintenance is complete, immediately replace all guards and ensure they are properly adjusted before resuming regular operations.

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

OUTFEED TABLE ALIGNMENT. Setting outfeed table too high can cause workpiece to hit table and get stuck, increasing risk of kickback. Setting outfeed table too low may cause workpiece to become tapered from front to back. Always keep outfeed table even with knives/inserts at top dead center (highest point during rotation).

INSPECTING STOCK. Impact injuries or fire may result from using poor workpieces. Thoroughly inspect and prepare workpiece before cutting. Verify workpiece is free of nails, staples, loose knots or other foreign material. Workpieces with minor warping should be surface planed first with cupped side facing infeed table.

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

MAXIMUM CUTTING DEPTH. To reduce risk of kickback, never cut deeper than $\frac{1}{8}$ " per pass.

CUTTING LIMITATIONS. Cutting a workpiece that does not meet the minimum dimension requirements can result in breakup, kickback, or accidental contact with cutterhead during operation. Never perform jointing, planing, or rabbeting cuts on pieces smaller than 8" long, $\frac{3}{4}$ " wide, or $\frac{1}{4}$ " thick.

PUSH BLOCKS. Not using push blocks when surface planing may result in accidental cutterhead contact. Always use push blocks when planing materials less than 3" high or wide. Never pass your hands directly over cutterhead without a push block.

WORKPIECE SUPPORT. Loss of workpiece control while feeding can increase risk of kickback or accidental contact with cutterhead. Support workpiece continuously during operation. Position and guide workpiece with fence. Support long or wide stock with auxiliary stands.

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

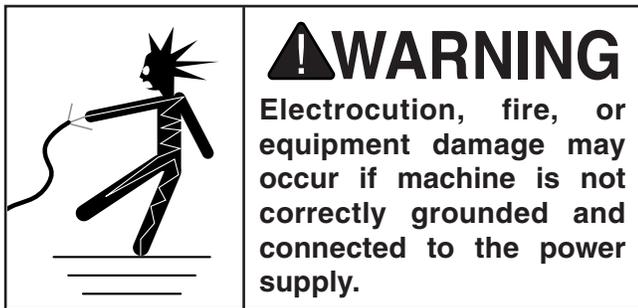
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation. Straight knives should never project more than $\frac{1}{8}$ " (0.125") from cutterhead body.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 240V 12 Amps

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

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

Circuit Information

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

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

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

Circuit Requirements

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps
Plug/Receptacle NEMA 6-20



Grounding Requirements

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

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

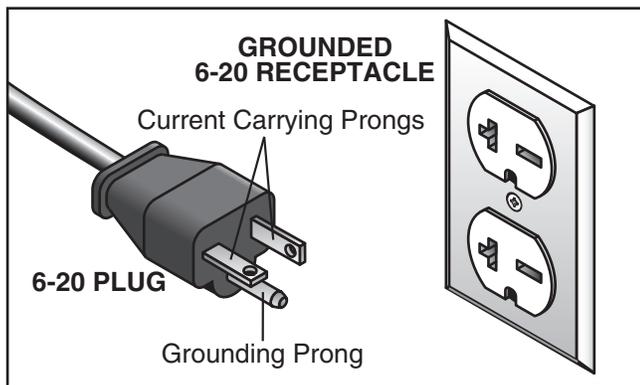
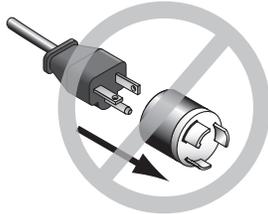


Figure 7. Typical 6-20 plug and receptacle.

CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

WARNING

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

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

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

Extension Cords

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

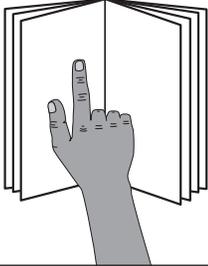
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size 12 AWG
Maximum Length (Shorter is Better).....50 ft.



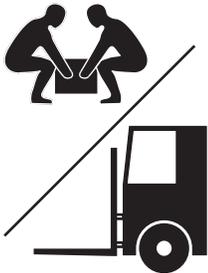
SECTION 3: SETUP



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



!WARNING
 Wear safety glasses during the entire setup process!



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

Needed for Setup

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

- Additional People 1
- Safety Glasses 1 Per Person
- Lifting Equipment (At Least 750 lb. Rating):
 - Forklift or Hoist 1
 - Lifting Straps..... 2
- Wrench or Socket 13mm 1
- Wrench or Socket 10mm 1
- Hex Wrench 6, 8mm 1 Ea.
- Straightedge 4' 1
- Phillips Screwdriver #2 1
- Flat Head Screwdriver #2..... 1
- Dust Collection System 1
- Dust Hose 4" 1
- Hose Clamps 4" 2
- Cleaner/Degreaser (**Page 17**) As Needed
- Disposable Shop Rags..... As Needed

Unpacking

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

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



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



Inventory

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

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

Inventory (Figures 8–10):	Qty
A. Jointer Assembly.....	1
B. Fence and Carriage Assembly.....	1
C. Push Blocks.....	2
D. Service Tools:	
—Open-End Wrench 8/10mm.....	1
—Open-End Wrench 11/13mm.....	1
—Hex Wrenches 3, 4, 5, 6, 8mm.....	1 Ea
E. Fence Tilt Handle.....	1
F. Fence Lock Lever.....	1
G. Cutterhead Guard.....	1
H. Cabinet Stand w/Motor.....	1
I. Control Panel Pedestal Assembly.....	1
J. Dust Port.....	1
K. Belt.....	1
L. Belt Guard.....	1
M. Pedal Assembly.....	1
N. Knife-Setting Jig (G0490W)	
—External Retaining Rings 10mm.....	2
—Knife Jig Feet.....	2
—Knife Jig Rod.....	1
O. Cutterhead Hardware & Tools (G0490XW)	
—Driver Bit Torx T20.....	1
—L-Wrench Torx T20.....	1
—Flat Hd Torx Screws T20 M6-1 x 15 ...	5
—Indexable Inserts 14 x 14 x 2mm.....	5

Hardware Bag (Not Shown):

- Cap Screws M8-1.25 x 50 (Wheel/Stand) .. 3
- Flat Washers 8mm (Wheel/Stand) 6
- Lock Washers 8mm (Wheel/Stand) 3
- Hex Nuts M8-1.25 (Wheel/Stand)..... 3
- Phillips Hd Screws M5-.8 x 10 (Dust Port) . 4
- Flat Washers 5mm (Dust Port)..... 4
- Cap Screws M8-1.25 x 20 (Jointer/Stand).. 8
- Lock Washers 8mm (Jointer/Stand) 8
- Flat Washers 8mm (Jointer/Stand)..... 8
- Flange Bolts M6-1 x 12 (Belt Guard)..... 2

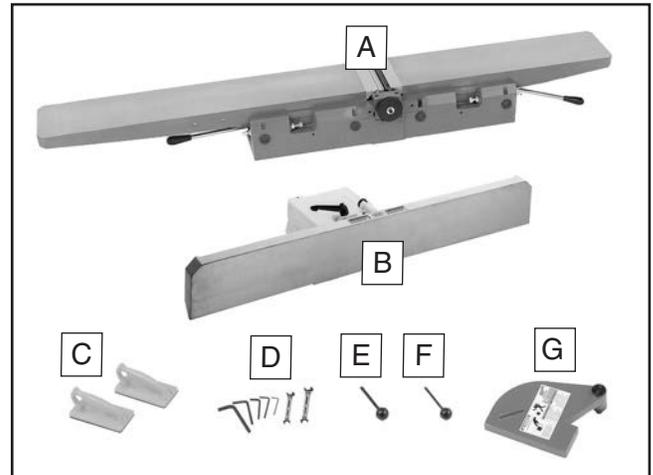


Figure 8. G0490W/G0490XW inventory—box 1.

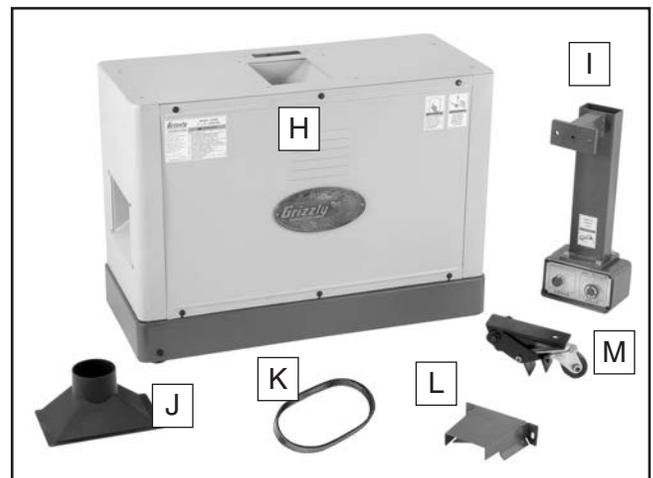


Figure 9. G0490W/G0490XW inventory—box 2.

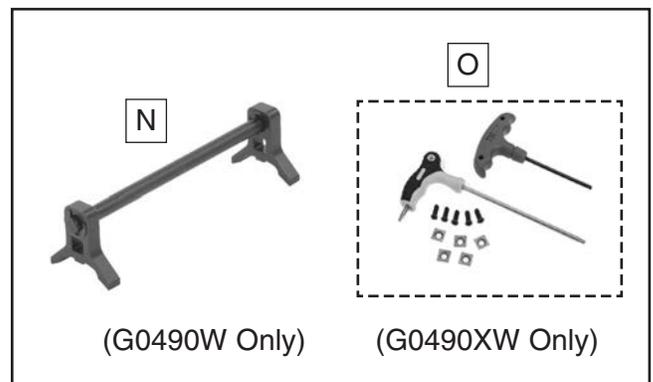


Figure 10. Miscellaneous inventory items.

NOTICE

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



Cleanup

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

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

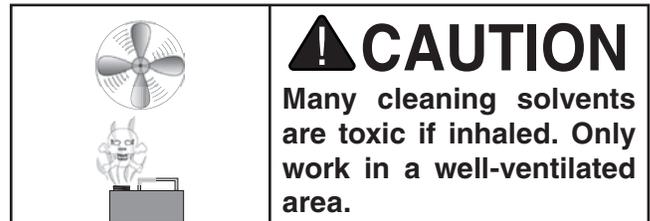
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

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

Basic steps for removing rust preventative:

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



T23692—Orange Power Degreaser

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



Figure 11. T23692 Orange Power Degreaser.



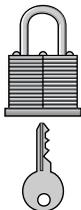
Site Considerations

Weight Load

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

Space Allocation

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

	<p>CAUTION Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
---	---

Physical Environment

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

Electrical Installation

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

Lighting

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

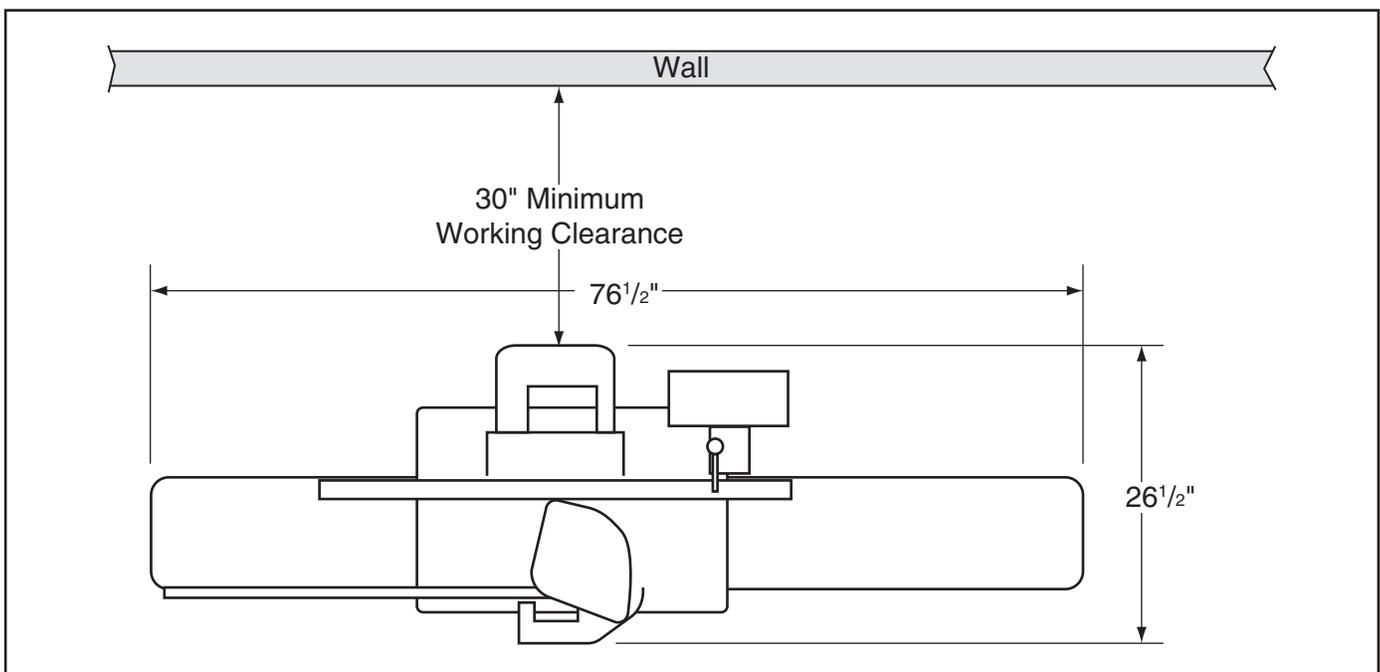


Figure 12. Minimum working clearances.



Assembly

Assembly consists of installing the pedal and jointer assemblies, control panel pedestal, fence, belt, safety guards, and rabbeting table. Complete all steps in the assembly procedure prior to performing the **Test Run** on **Page 24**.

Before beginning, refer to **Needed for Setup** section and gather all applicable items.

To assemble jointer:

1. Attach pedal assembly to right side of stand with (3) M8-1.25 x 50 cap screws, (6) 8mm flat washers, (3) 8mm lock washers, and (3) M8-1.25 hex nuts, as shown in **Figure 13**.



Figure 13. Pedal assembly attached to right side of stand.

2. Feed power cord outside of stand, as shown in **Figure 14**.



Figure 14. Inserting power cord through stand.

3. With help from another person, position stand upright.
4. Attach dust port to stand with (4) M5-.8 x 10 Phillips head screws and (4) 5mm flat washers, as shown in **Figure 15**.

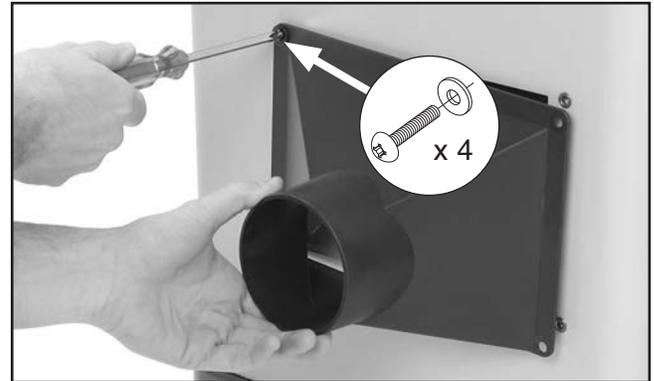


Figure 15. Attaching dust port to stand.

5. From underneath shipping crate, remove two hex nuts and flat washers securing jointer assembly to crate.
6. Wrap lifting straps around infeed and outfeed table, as illustrated in **Figure 16**, then attach ends to forklift forks or hoist.

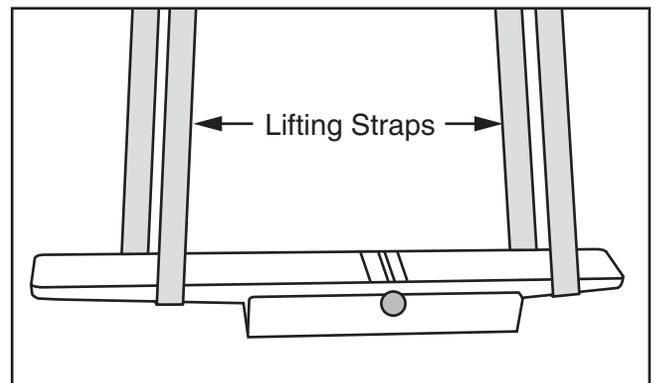


Figure 16. Using lifting straps to lift jointer assembly.

7. With another person to steady the load, carefully lift jointer assembly onto stand and position all four mounting holes into alignment with stand mounting holes.

Note: Make sure cutterhead pulley is facing to rear of stand.



- Attach jointer assembly to stand with (8) M8-1.25 x 20 cap screws, (8) 8mm lock washers, and (8) 8mm flat washers, as shown in **Figure 17**.

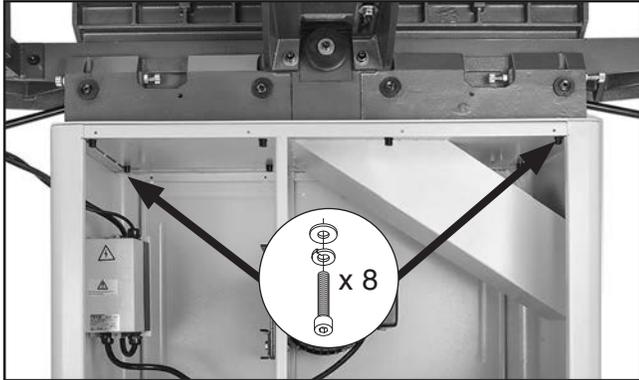


Figure 17. Jointer assembly attached to stand.

- Attach control panel pedestal to back of infeed table with (2) pre-installed M10-1.5 x 20 cap screws and (2) 10mm flat washers (see **Figure 18**).

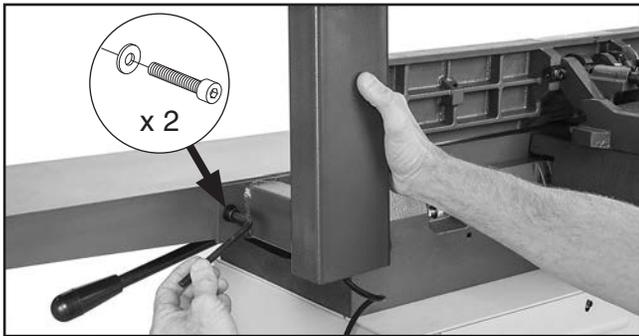


Figure 18. Attaching control panel pedestal to back of infeed table.

- Verify alignment of cutterhead and motor pulleys, as illustrated in **Figure 19**.

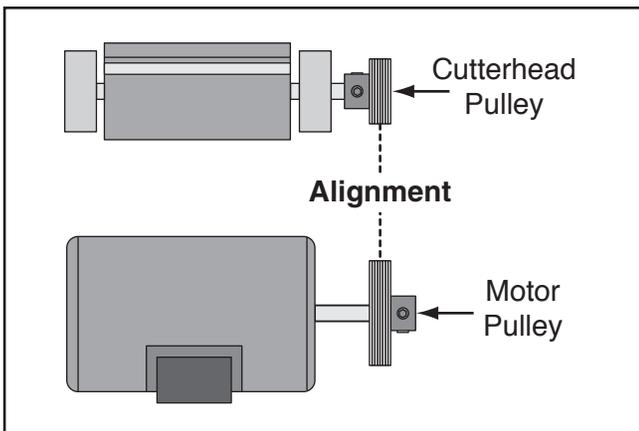


Figure 19. Example of pulleys aligned.

- If pulleys are not aligned, loosen four motor mounting bolts shown in **Figure 20**, shift motor horizontally to align pulleys, then retighten bolts.

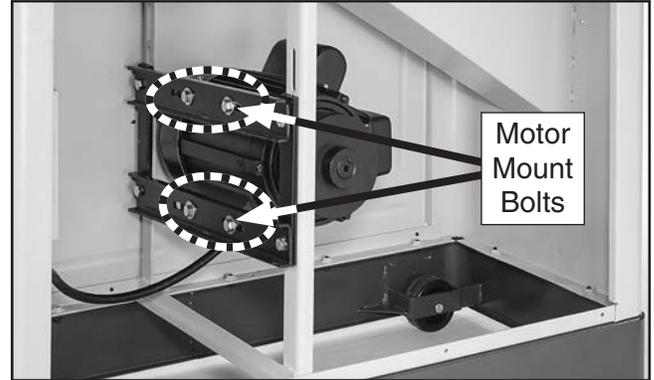


Figure 20. Location of motor mount bolts.

- Use (2) pre-installed M10-1.5 x 30 cap screws, (2) 10mm lock washers, and (2) 10mm flat washers to attach fence carriage base with fence onto rear of jointer assembly, as shown in **Figure 21**, and install fence lock lever.

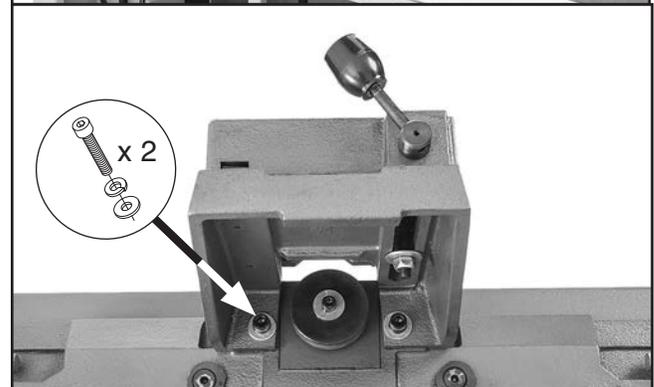
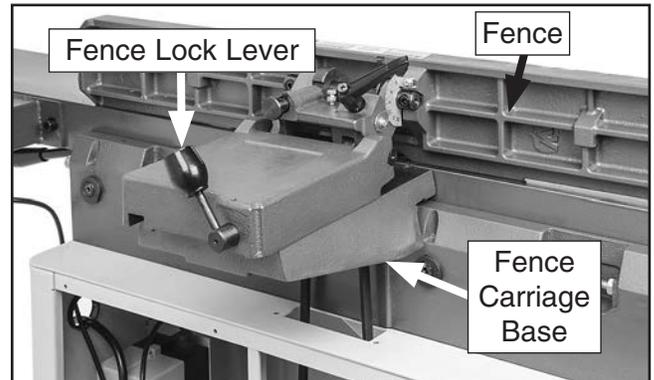


Figure 21. Fence assembly and carriage installed.



12. Loosen fence lock lever and fence tilt lock, make sure fence is at 90° position, then move fence all the way forward to verify it is aligned with *front* edge of tables (see **Figure 22**).

— If fence *is* aligned with front of tables, continue to **Step 14**.

— If fence *is not* aligned with front of tables, continue to **Step 13**.

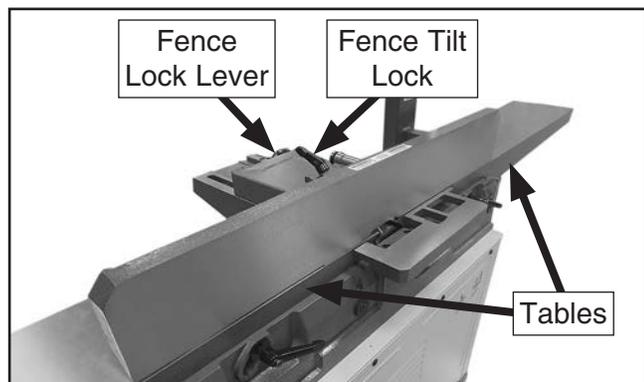


Figure 22. Fence moved to front of tables to check alignment.

13. Loosen (3) M6-1 x 12 cap screws that secure fence key, as shown in **Figures 23–24**, adjust fence side to side until it is aligned with front of tables, then tighten cap screws.

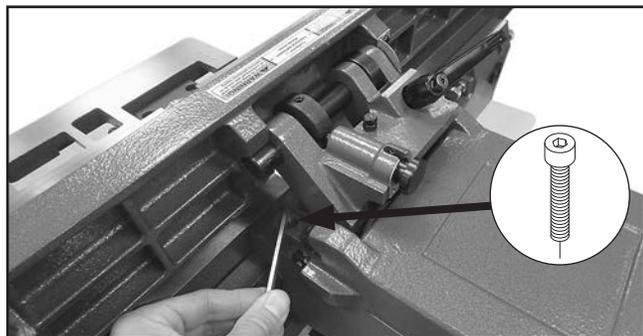


Figure 23. Loosening front cap screw on key.

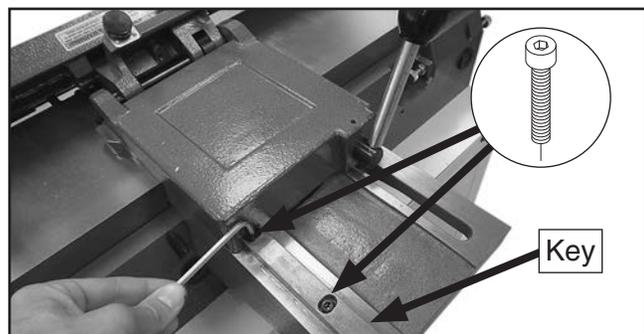


Figure 24. Loosening rear cap screw on key.

14. Install belt on cutterhead and motor pulleys, as shown in **Figure 25**, making sure belt is seated in pulley grooves.

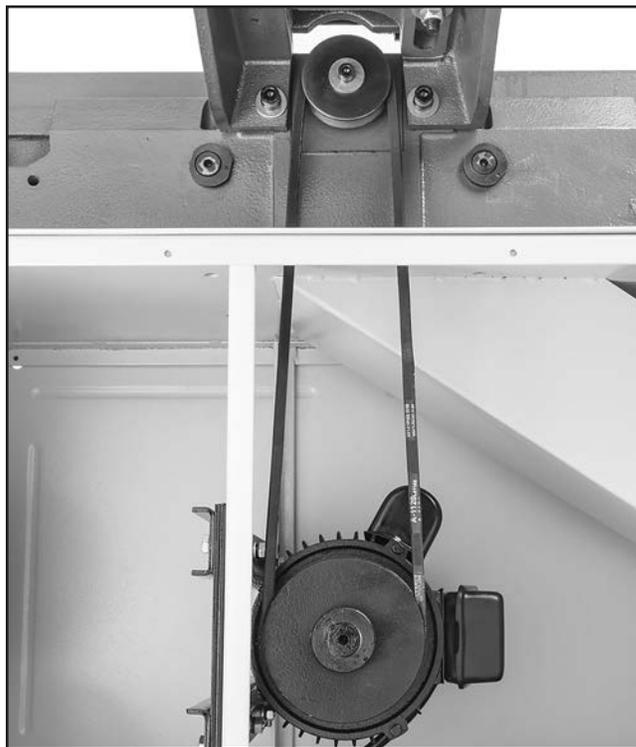


Figure 25. Example of belt installed on cutterhead and motor pulleys.

15. Loosen four bolts/nuts securing motor mount brackets (see **Figure 26**), let motor slide down to tension belt, then retighten bolts/nuts.

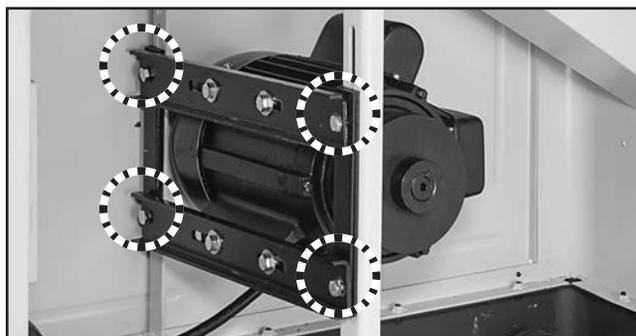


Figure 26. Motor mount bracket bolts.



Note: When properly tensioned, belt has approximately 1/4" deflection when moderate pressure is applied midway between the pulleys, as illustrated in **Figure 27**. If necessary, apply downward pressure on motor before securing motor mount brackets to attain proper belt tension.

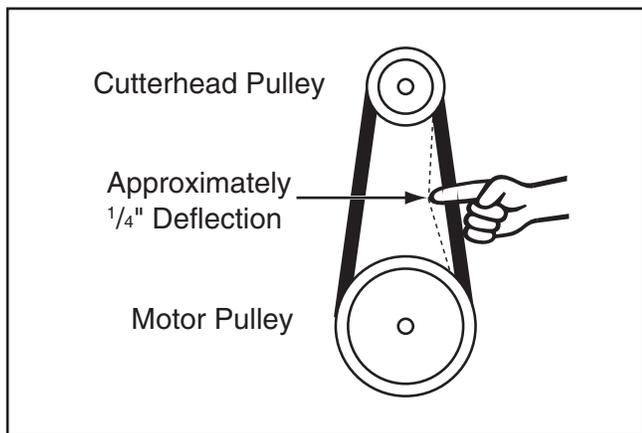


Figure 27. Correct belt deflection when properly tensioned.

16. Install fence tilt handle, as shown in **Figure 28**.

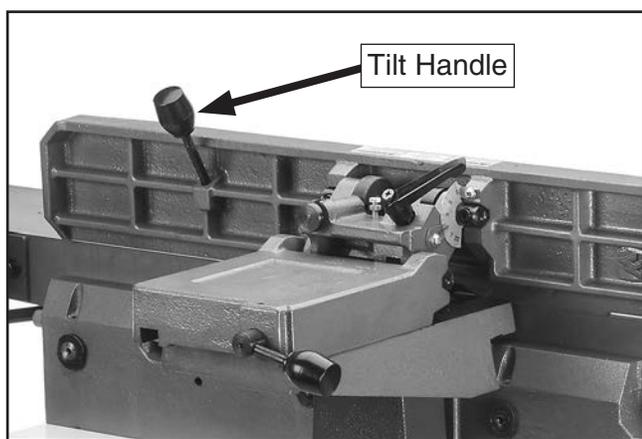


Figure 28. Fence tilt handle installed on rear of fence.

! WARNING

The outfeed table **MUST** be level with cutterhead knives or inserts when they are at top dead center (at their highest point during rotation). Otherwise, the workpiece cannot properly feed past the cutterhead, which may cause a kickback hazard for the operator.

17. Place straightedge on outfeed table so it extends over cutterhead, and use cutterhead pulley to rotate cutterhead until one of the knives or inserts is at top dead center (their highest point during rotation), as illustrated in **Figures 29–30**.

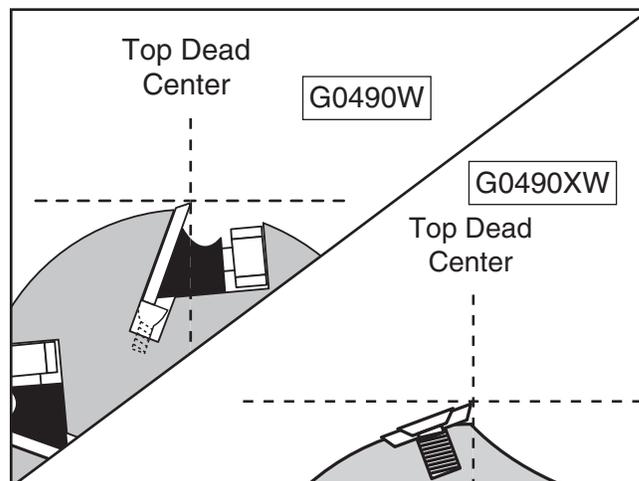


Figure 29. Knife or insert at top dead center.

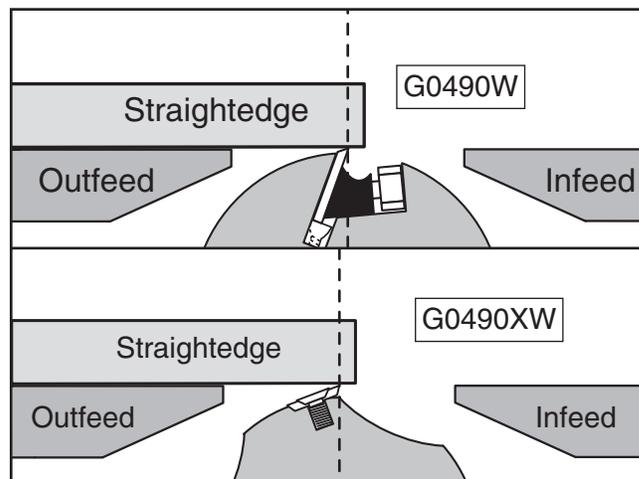


Figure 30. Using straightedge to check outfeed table height.

When outfeed table height is correctly set, knife or insert (at top dead center) will barely touch straightedge, as illustrated in **Figure 30**.

— If knife or insert lifts straightedge off table or is below straightedge, then outfeed table height must be reset (refer to **Setting Outfeed Table Height** on **Page 46** for detailed instructions).



⚠ CAUTION

Belt guard **MUST** be installed before operating jointer or else moving belt will be exposed, creating an entanglement hazard at back of jointer.

18. Install belt guard with (2) M6-1 x 12 flange bolts, as shown in **Figure 31**.

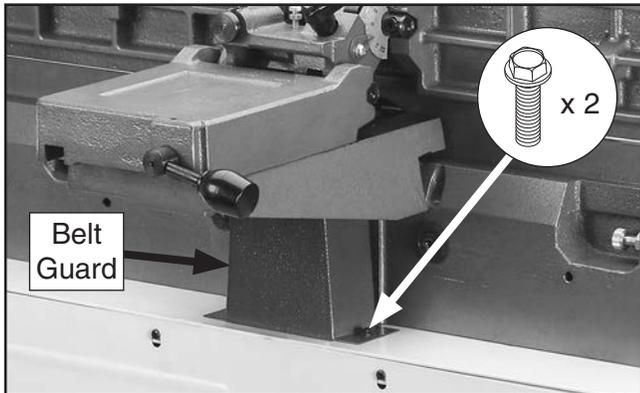


Figure 31. Belt guard installed.

19. Re-install cabinet rear access panel.
20. Move fence all the way back to make room for cutterhead guard.
21. Insert cutterhead guard shaft into jointer, as shown in **Figure 32**, so shaft flat is facing set screw, then tighten pre-installed set screw against shaft. Position the bottom of the guard so it is no more than $\frac{3}{8}$ " above the table, to ensure safety during operations.

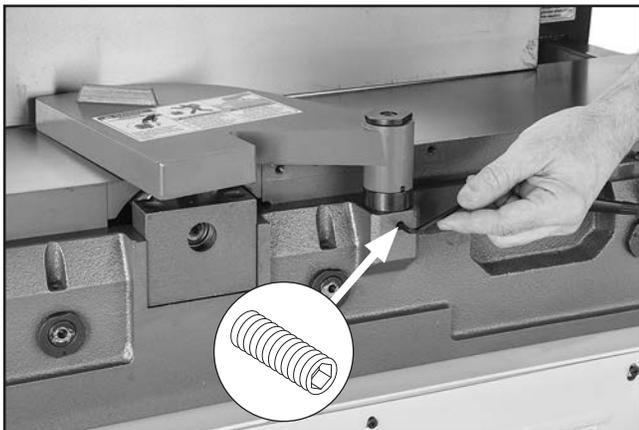


Figure 32. Tightening set screw to secure cutterhead guard.

22. Test operation of guard by pulling it back and letting go. Guard should spring back over cutterhead and stop against the fence.

— If guard drags across table, loosen set screw, raise guard slightly so that it does not drag, then retighten set screw.

— If guard does not spring back over cutterhead, re-install it and make sure flat part of guard shaft faces set screw.

23. Install rabbeting table with (2) pre-installed M8-1.25 x 20 cap screws and (2) 8mm lock washers (see **Figure 21**).

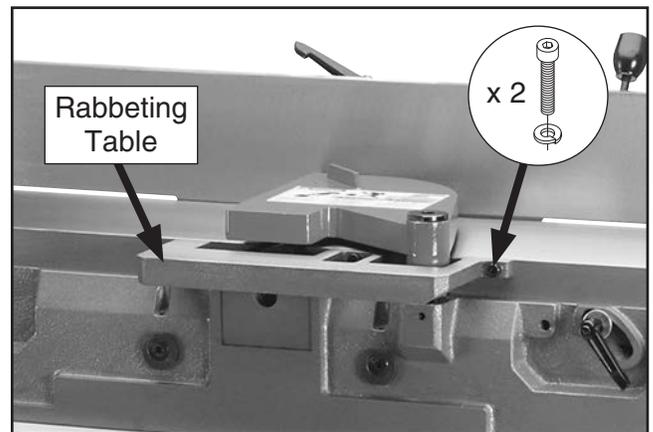


Figure 33. Rabbeting table installed.

24. **Model G0490W Only:** Assemble knife-setting jig, as shown in **Figure 34**.



Figure 34. Knife-setting jig assembled.



Dust Collection

⚠ CAUTION

This machine creates substantial amounts of dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust collection system.

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 dust collection hose:

1. Fit 4" dust hose over dust port, as shown in **Figure 35**, and secure in place with hose clamp.
2. Tug hose to make sure it does not come off. **Note:** A tight fit is necessary for proper performance.



Figure 35. Dust hose attached to dust port.

Test Run

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

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

⚠ WARNING

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

⚠ WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Push STOP button in (see **Figure 36**).
3. Connect machine to power supply.

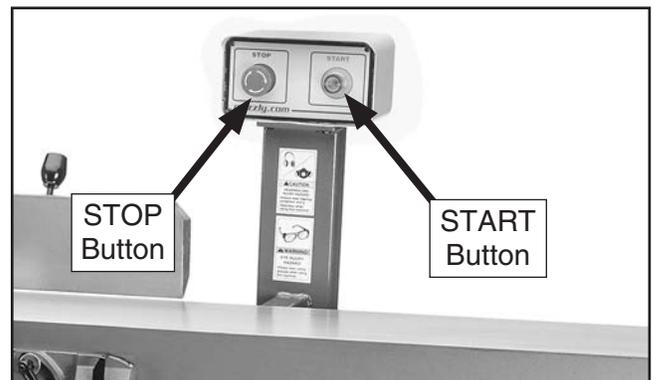


Figure 36. STOP/START button locations.



4. Twist STOP button clockwise until it pops out (see **Figure 37**). This resets switch so machine will start.

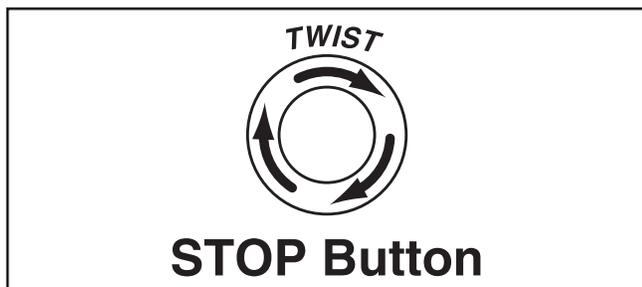


Figure 37. Resetting the switch.

5. Push START button to start machine. A correctly operating machine runs smoothly with little or no vibration or rubbing noises.
6. Press STOP button to turn machine **OFF**.
7. **WITHOUT** resetting STOP button, press START button. Machine should not start.

— If machine *does not* start, the STOP button safety feature is working correctly. Congratulations! The Test Run is complete.

— If machine *does* start (with STOP button pushed in), immediately disconnect power to 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.

Factory adjustments that should be verified:

- Model G0490W Knife Settings (refer to **Page 38**).
- Table Parallelism (refer to **Page 42**).
- Depth Scale Calibration (refer to **Page 47**).
- Fence Stop Accuracy (refer to **Page 48**).

Tighten Belt

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belt will stretch and seat into the pulley grooves. After this time, you must re-tension the belt to avoid slippage and burn out. Refer to **Page 49** when you are ready to perform this important adjustment.

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

A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate a problem with the machine or belt.

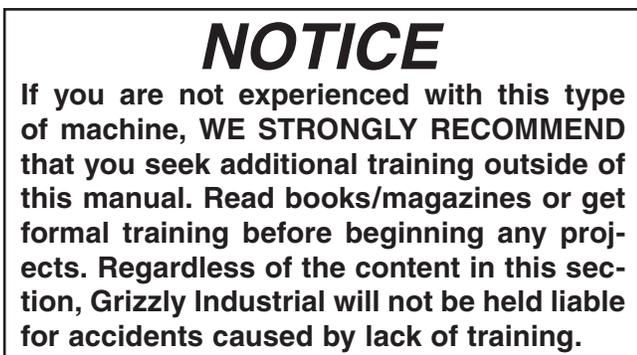
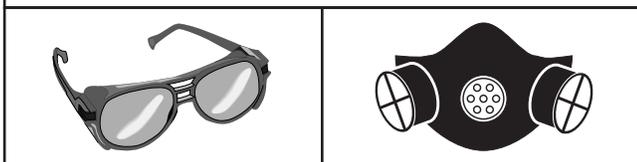


SECTION 4: OPERATIONS

Operation Overview

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

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



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

1. Examines workpiece to verify it is safe and suitable for cutting.
2. Adjusts fence for width of workpiece and locks it in place.
3. Adjusts fence tilt, if necessary.
4. Adjusts infeed table height to set depth of cut per pass.
5. Puts on safety glasses, respirator, and ear protection.
6. Locates push blocks.
7. Starts jointer.
8. Holds workpiece firmly against infeed table and fence, and slides it into cutterhead at a steady and controlled rate until entire length of workpiece has advanced beyond cutterhead to outfeed table.
9. Repeats cutting process until desired results are achieved.
10. Stops jointer.



Stock Inspection & Requirements

Follow these rules when choosing and jointing stock:

- **DO NOT joint or surface plane stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the cutting operation.
- **Jointing and surface planing with the grain is safer for the operator and produces a better finish.** Cutting against the grain increases the likelihood of kickback and workpiece tear-out. DO NOT cut against the grain! Cutting with the grain is feeding the stock across the cutterhead so the grain points down and back, as viewed from the front edge of the stock (see **Figure 38**).

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

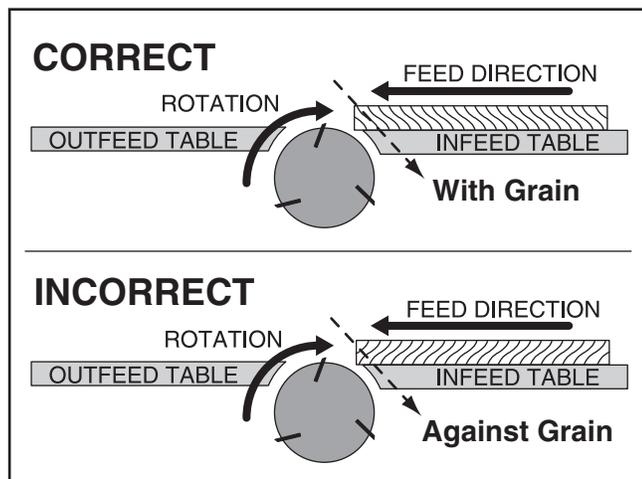


Figure 38. Proper grain alignment with the cutterhead.

- **Only process natural wood fiber through your jointer.** Your jointer is designed to cut only natural wood stock. This machine is NOT designed to cut metal, glass, stone, tile, products with lead-based paint, or products that contain asbestos—cutting these materials with a jointer may lead to injury.

- **Scrape all glue off the workpiece before jointing.** Glue deposits on the workpiece, hard or soft, will gum up the cutterhead and produce poor results.
- **Remove foreign objects from the workpiece.** Make sure that any stock you process with the jointer is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects that could damage the cutterhead. These particles could also cause a spark as they strike the cutterhead and create a fire hazard.

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

- **Make sure all stock is sufficiently dried before jointing.** Wood with a moisture content over 20% will cause unnecessary wear on the cutters and poor cutting results. Excess moisture can also hasten rust and corrosion.
- **Make sure your workpiece exceeds the minimum dimension requirements, as shown in Figure 39, before processing it through the jointer, or the workpiece may break or kickback during the operation.**

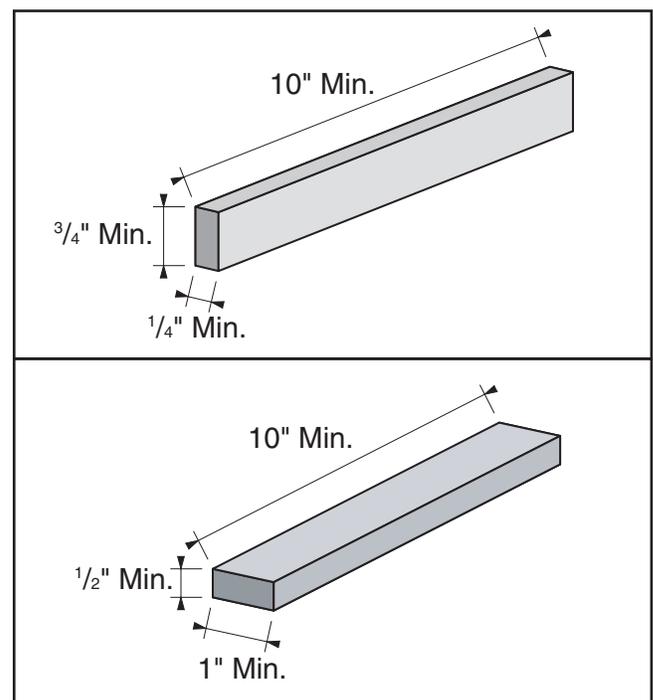


Figure 39. Minimum stock dimensions for jointer.



Squaring Stock

Squaring stock means making it flat and parallel along both length and width, and making the length and width perpendicular to one another.

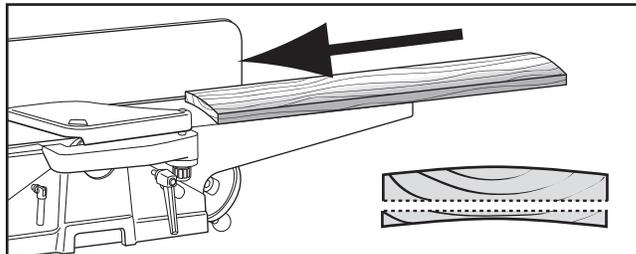
The purpose of squaring stock is to prepare it for accurate cuts and construction later on.

A properly "squared up" workpiece is essential for tasks such as accurate tablesaw cuts, glue-ups/laminations, cutting accurate bevels on a bandsaw, and many other applications where one surface of a workpiece is used to reference another.

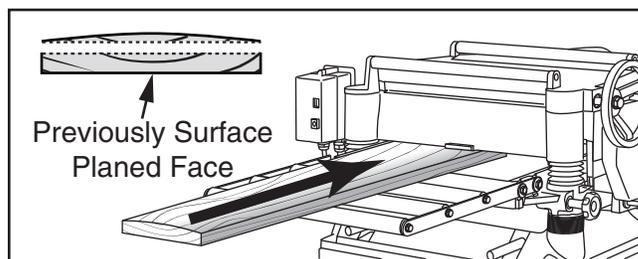
Tools Needed	Qty
Jointer	1
Planer	1
Tablesaw	1

Squaring stock involves four steps performed in the order below:

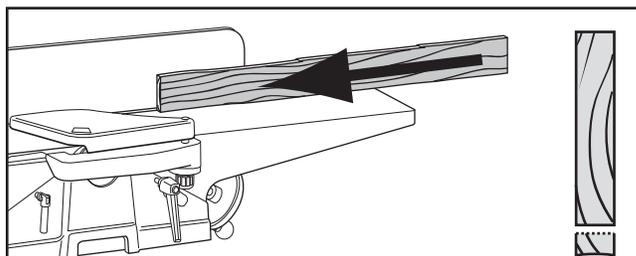
1. Surface Plane on the Jointer—The concave face of the workpiece is surface planed flat with the jointer.



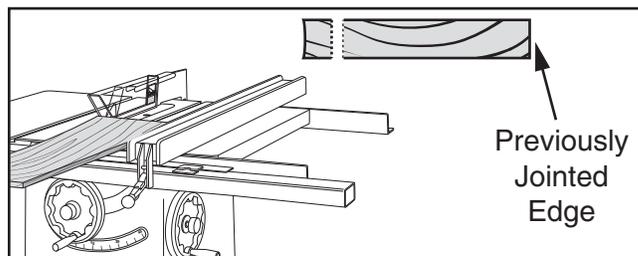
2. Surface Plane on a Thickness Planer—The opposite face of the workpiece is surface planed flat with a thickness planer.



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 (see **Figures 40–41**) on the jointer is to make one flat face on a piece of stock to prepare it for thickness planing on a planer.

NOTICE

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



Figure 40. Example of surface planing operations.

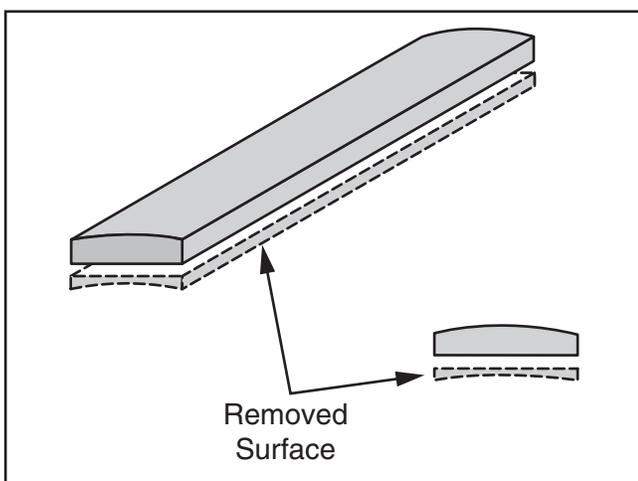


Figure 41. Illustration of surface planing results.

To surface plane on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Set infeed table height to desired cutting depth for each pass.

IMPORTANT: For safety reasons, do not exceed a cutting depth of $\frac{1}{16}$ " per pass when surface planing.

3. Set fence to 90° .
4. Start jointer.
5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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

⚠️ WARNING

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



Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface that is suitable for joinery or finishing, as shown in **Figures 42–43**. It is also a necessary step when squaring rough or warped stock.



Figure 42. Example of edge jointing operation.

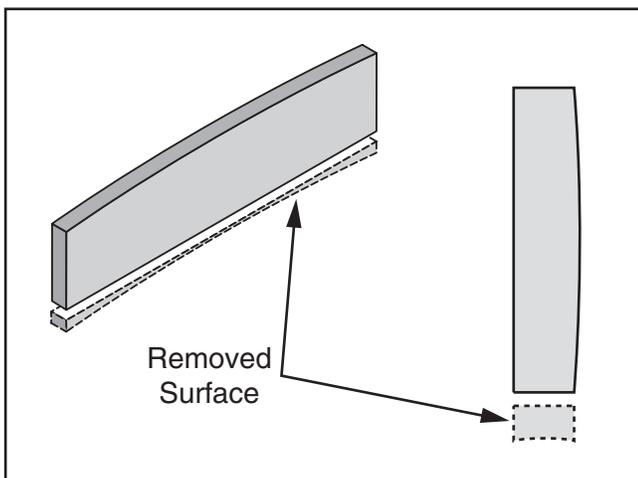


Figure 43. Illustration of edge jointing results.

To edge joint on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Set infeed table height to desired cutting depth for each pass.

IMPORTANT: For safety reasons, cutting depth should never exceed $\frac{1}{8}$ " per pass.

3. Set fence to 90° .
4. Start jointer.
5. Place workpiece firmly against fence and infeed table.

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

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

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

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

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



Bevel Cutting

Bevel cuts (see **Figures 44–45**) can be made by setting the fence at the desired angle and feeding the workpiece firmly along the fence face, with the bottom inside corner firmly against the table. The cutting process typically requires multiple passes or cuts to bevel the entire edge of a workpiece.



Figure 44. Fence setup for a bevel cut of 45°.

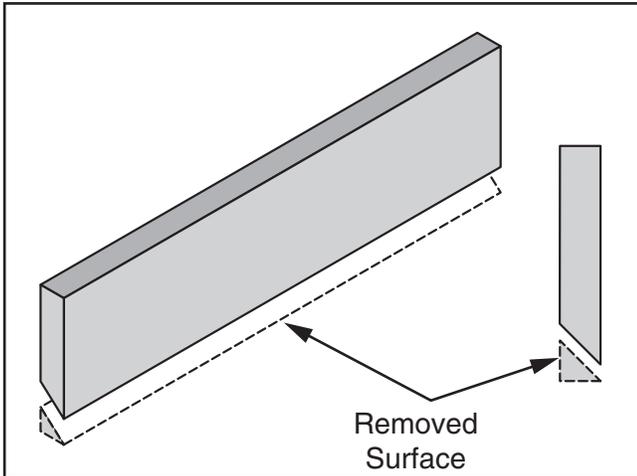


Figure 45. Illustration of bevel cutting results.

To bevel cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Set infeed table height to cutting depth desired for each pass.

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

3. Set fence tilt to desired angle of cut.
4. Place workpiece against fence and infeed table with concave side face down.
5. Start jointer.
6. With a push block in your leading hand, press workpiece against table and fence with firm pressure, and feed workpiece over cutterhead with a push block in your trailing hand.

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

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



Rabbet Cutting

The purpose of rabbet cutting (see **Figures 46–48**) is to remove a section of the workpiece edge, as shown below. When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock.

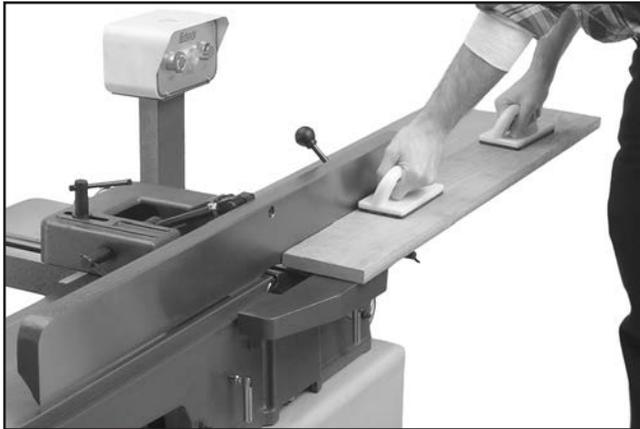


Figure 46. Typical rabbet cutting operation.



Figure 47. Completed rabbet cutting operation.

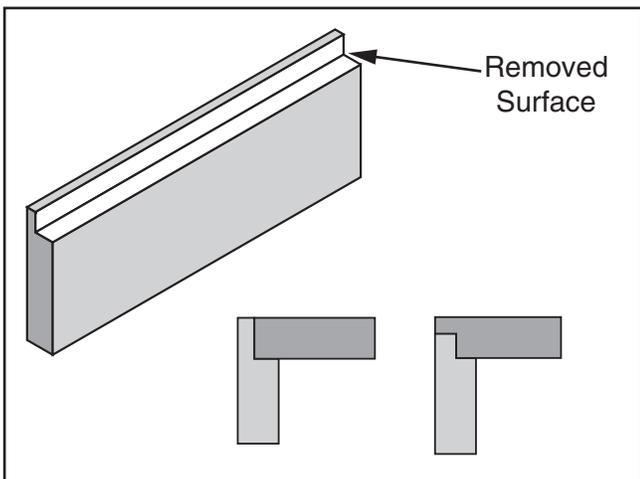


Figure 48. Illustration of rabbet cutting effects and a few sample joints.

To rabbet cut on jointer:

1. Inspect stock to ensure it is safe and suitable for the operation (see **Stock Inspection & Requirements** section).
2. Set infeed table height to desired cutting depth for each pass.

IMPORTANT: For safety reasons, cutting depth should never exceed $\frac{1}{8}$ " per pass.

3. Remove cutterhead guard.
4. Set fence to 90° and near front of jointer, so amount of exposed cutterhead in front of fence matches size of desired rabbet.
5. Start jointer.
6. Place workpiece firmly against fence and infeed table.

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

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

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

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

!WARNING

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



SECTION 5: ACCESSORIES

⚠️ WARNING

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

NOTICE

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

T27445—8¹/₁₆" x 3/4" x 1/8" HSS Jointer Knives, Set of 4 (G0490W)

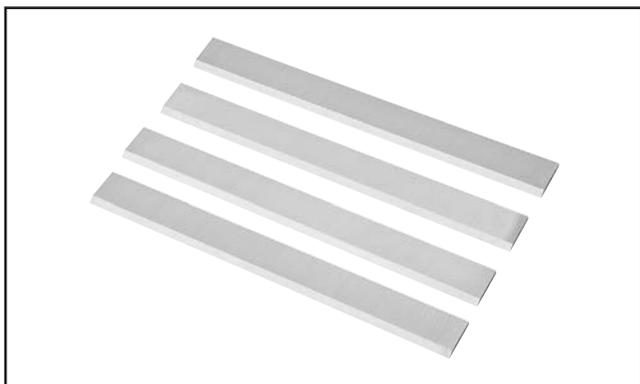


Figure 49. Replacement knives for G0490W.

H7319—Carbide Replacement Inserts (G0490XW)

Solid Carbide Indexable Inserts for G0490XW.
Size: 14 x 14 x 2mm (10 pack).

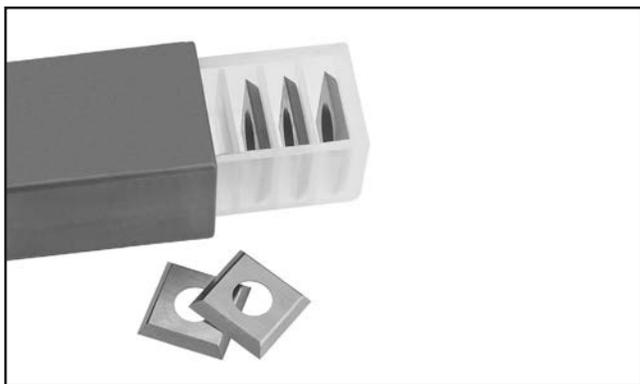


Figure 50. Replacement inserts for G0490XW.

W1211A—Jointer Pal® Magnetic Knife Gauge Polycarbonate Body (For HSS & Cobalt Knives)
W1211A—Jointer Pal® Magnetic Knife Gauge Steel Body (For Carbide Knives)

This patented magnetic knife-setting system lets you set jointer knives in perfect alignment every time! It also allows you to shift nicked knives to get a perfect cut to an accuracy of + or - 0.001".



Figure 51. W1211A Jointer Pal® Knife Gauge.

T27622—8" Byrd® Shelix Cutterhead (G0490W)

Made in the USA by Byrd, this indexable carbide insert cutterhead is the best money can buy! The inserts are not only placed in a spiral pattern, they are also positioned at an angle so the shearing action leaves a glassy smooth cut on the toughest and most figured woods.

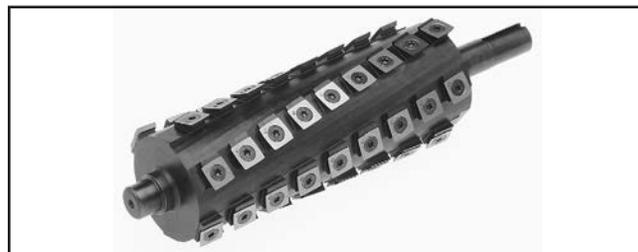
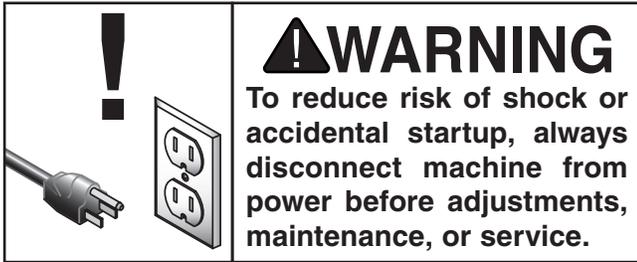


Figure 52. Spiral cutterhead upgrade for G0490W.

order online at www.grizzly.com or call 1-800-523-4777



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

- Vacuum all dust on and around the machine.
- Wipe down the tables and all other unpainted cast iron with a metal protectant.
- Check/repair for worn or damaged wires (**Page 52**).
- Check/replace damaged cutterhead or blades/inserts (**Page 38–41**).
- Check/retighten loose mounting bolts.
- Check/resolve any other unsafe condition.

Monthly

- Belt tension, damage, or wear (**Page 49**).
- Clean/vacuum dust buildup from inside stand and off of motor.

Cleaning & Protecting

Cleaning the Model G0490W/G0490XW 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.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see below for more details).

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 53. Recommended products for protecting unpainted cast iron/steel.



Lubrication

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

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

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

Fence & Carriage

Lube Type.. Model SB1365 or ISO 68 Equivalent
Lube Amount..... As Needed
Lubrication Frequency..... Daily

Place one or two drops of oil on the fence pivot points (see **Figure 55**) as needed. Before lubricating the fence carriage ways, clean them with mineral spirits. Apply a thin coat of oil along the length of the ways (see **Figure 56**). Move the fence back and forth to distribute the oil.

SB1365—South Bend Way Oil-ISO 68

Engineered for the high pressure exerted on horizontal or vertical ways and slides. Protects against rust and corrosion. Ensures stick-free, smooth motion which maximizes finishes and extends the life of your machine. Won't gum up!
12 oz. AMGA#2 (ISO 68 Equivalent)



Figure 54. SB1365 Way Oil.

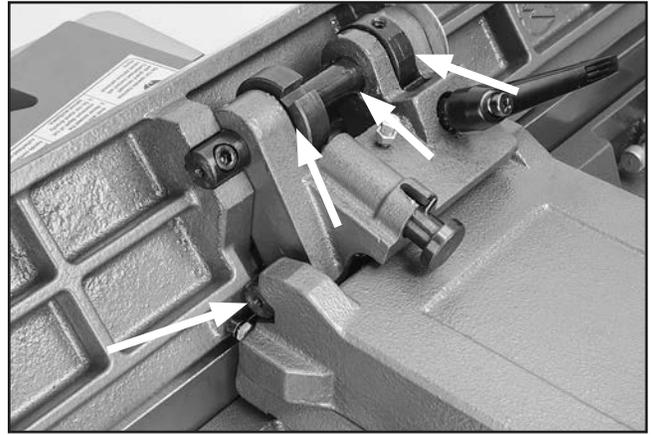


Figure 55. Fence lubrication locations.

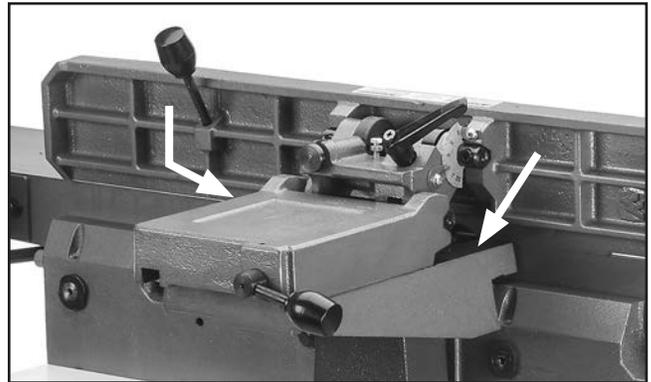


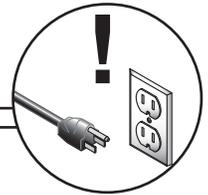
Figure 56. Fence carriage slide lubrication location.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips immediately after startup.	<ol style="list-style-type: none"> 1. STOP button depressed. 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped/fuse blown. 4. Motor wires connected incorrectly. 5. Wiring open/has high resistance. 6. START/STOP switch at fault. 7. Start capacitor at fault. 8. Thermal overload relay has tripped. 9. Contactor not energized/has poor contacts. 10. Centrifugal switch at fault. 11. Motor at fault. 	<ol style="list-style-type: none"> 1. Rotate button head to reset. 2. Ensure correct power supply voltage and circuit size. 3. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 4. Correct motor wiring connections. 5. Check/fix broken, disconnected, or corroded wires. 6. Replace switch. 7. Test/replace. 8. Reset; adjust trip load dial if necessary; replace. 9. Test all legs for power/replace. 10. Adjust/replace centrifugal switch if available. 11. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Workpiece material not suitable. 2. Excessive feed rate. 3. Excessive depth of cut. 4. Dull knives/inserts. 5. Dust collection problem. 6. Belt slipping; oil/grease on belt. 7. Pulley loose or not properly aligned. 8. Motor overheated. 9. Plug/receptacle at fault. 10. Run capacitor at fault. 11. Contactor not energized/has poor contacts. 	<ol style="list-style-type: none"> 1. Ensure workpiece is suitable for jointing (Page 27). 2. Reduce feed rate. 3. Reduce depth of cut. 4. Sharpen/replace knives (Page 38); rotate/replace inserts (Page 41). 5. Clear blockages; move machine closer to dust collector; upgrade dust collector. 6. Tension/replace belt (Page 49); clean belt; ensure pulleys are aligned (Page 50). 7. Re-align pulleys; replace shaft key; tighten pulley set screw. 8. Clean motor, let cool, and reduce workload. 9. Test for good contacts/correct wiring. 10. Test/repair/replace. 11. Test all legs for power/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or other component loose. 2. Belt worn or loose. 3. Motor fan rubbing on fan cover. 4. Pulley loose or not properly aligned. 5. Knives/inserts at fault. 6. Cutterhead bearings at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and retighten with thread locking fluid. 2. Inspect/replace belt (Page 49). 3. Fix/replace fan cover; replace loose/damaged fan. 4. Re-align pulleys; replace shaft key; tighten pulley set screw. 5. Resharpen/replace knives; set knife alignment/height correctly. 6. Replace bearing(s)/realign cutterhead.



Operations

Symptom	Possible Cause	Possible Solution
Tables are hard to adjust.	<ol style="list-style-type: none"> 1. Table lock is engaged/partially engaged. 2. Table stops blocking movement. 	<ol style="list-style-type: none"> 1. Completely loosen table locks (Page 3). 2. Loosen/reset table stop bolts (Pages 46–47).
Excessive snipe (gouge in end of board that is uneven with rest of cut).	<ol style="list-style-type: none"> 1. Outfeed table is set too low, or knives (straight knife cutterheads only) set too high. 2. Operator pushing down on trailing end (infeed side) of workpiece as it leaves cutterhead. 	<ol style="list-style-type: none"> 1. Align outfeed table with cutterhead knives/inserts at top dead center (Page 46). 2. Focus most of the workpiece pressure against outfeed table while cutting.
Workpiece stops in middle of cut.	<ol style="list-style-type: none"> 1. Outfeed table set too high. 	<ol style="list-style-type: none"> 1. Align outfeed table with cutterhead knives/inserts at top dead center (Page 27).
Workpiece chipping, tear-out, indentations, or overall rough cuts.	<ol style="list-style-type: none"> 1. Not feeding workpiece to cut "with" the grain. 2. Dull knives/inserts. 3. Workpiece not suitable for jointing. 4. Nicked or chipped knives or inserts. 5. Feeding workpiece too fast. 6. Excessive depth of cut. 7. Lack of proper dust collection or clogged dust port. 	<ol style="list-style-type: none"> 1. Turn the workpiece 180° before feeding again. 2. Sharpen/replace knives; rotate/replace insert(s) (Pages 38–41). 3. Ensure workpiece is suitable for jointing (Page 27). 4. Replace knives (Page 38); rotate/replace insert(s) (Page 41). 5. Reduce feed rate. 6. Reduce depth of cut. 7. Clear blockages, ensure dust collection is operating efficiently; upgrade dust collector.
Fuzzy grain left in workpiece.	<ol style="list-style-type: none"> 1. Wood has high moisture content. 2. Dull knives/inserts. 	<ol style="list-style-type: none"> 1. Ensure wood moisture content is less than 20%. Allow to dry if necessary. 2. Replace/rotate knives/inserts (Pages 38–41).
Long lines or ridges that run along the length of the board	<ol style="list-style-type: none"> 1. Nicked or chipped knives/inserts. 2. Loose or incorrectly installed insert (s). 3. Dirt or debris under carbide inserts (spiral cutterheads only). 	<ol style="list-style-type: none"> 1. Replace/rotate knives/inserts (Pages 38–41). 2. Remove/replace insert (s) and install properly (Page 41). 3. Remove inserts, properly clean mounting pocket and re-install (Page 41).
Uneven cutter marks, wavy surface, or chatter marks across face of workpiece.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. Knives/inserts not adjusted at even heights in the cutterhead. 3. Dirt or debris under carbide inserts (spiral cutterheads only). 	<ol style="list-style-type: none"> 1. Reduce feed rate. 2. Adjust the knives so they are set up evenly in the cutterhead (Page 38). Remove, clean, and re-install any inserts that are "raised" in the cutterhead (Page 41). 3. Remove inserts, properly clean mounting pocket and re-install (Page 41).
Glossy surface; scorching or burn marks on workpiece.	<ol style="list-style-type: none"> 1. Dull knives/inserts. 2. Feed rate too slow. 	<ol style="list-style-type: none"> 1. Sharpen/replace knives; rotate/replace insert(s) (Pages 38–41). 2. Increase feed rate.
Workpiece is concave or convex along its length after jointing.	<ol style="list-style-type: none"> 1. Workpiece not held with even pressure against outfeed table during cut. 2. Workpiece too uneven at start of operation. 3. Tables are not parallel with cutterhead and each other. 	<ol style="list-style-type: none"> 1. Apply even downward pressure against workpiece throughout entire travel along outfeed side during cut. 2. Take partial cuts to remove extreme high spots before doing a full pass. 3. Check/adjust table parallelism (Page 44).



Inspecting Knives (G0490W)

The height of the knives can be inspected with a straightedge to ensure that they are set even with the outfeed table at their highest point in the cutterhead rotation, or top dead center (TDC).

To inspect the knives:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard or block it open.
3. Using a straightedge on outfeed table, check height of each knife at positions shown in **Figure 57** below.

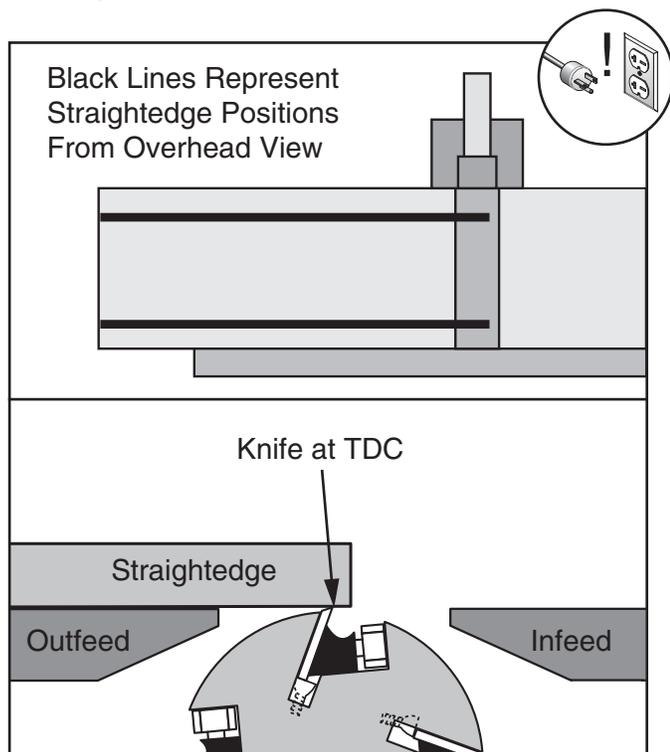


Figure 57. Using a straightedge to inspect knives.

- Knives are set correctly set when they just touch bottom of straightedge at TDC in each of straightedge positions.
- If knives do not touch straightedge or they lift up at any position, then those knives need to be adjusted.

Setting/Replacing Knives (G0490W)

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

There are two options for setting the knives—the straightedge method and the knife-setting jig method. Each option has advantages and disadvantages; the correct one for you will become a matter of personal preference. For best results, the tables must be parallel with each other (refer to **Checking/Adjusting Table Parallelism** on **Page 42**) and the outfeed table height must be properly set (refer to **Setting Outfeed Table Height** on **Page 46**).

Straightedge Method: A high quality straightedge (or Jointer Pal) is held flat against the outfeed table and the knife heights are set to the bottom of the straightedge, as shown in **Figure 57**. Because the knife projection height from the cutterhead is dependent on the outfeed table height, the outfeed table must be set as described in **Setting Outfeed Table Height** on **Page 46** for this method to work correctly.

When using the straightedge method to set the knives, you will not need to move the outfeed table once it is set and you will always be assured that the knives are even with the outfeed table in their highest point of rotation (TDC)—even if the cutterhead is not parallel with the outfeed table.

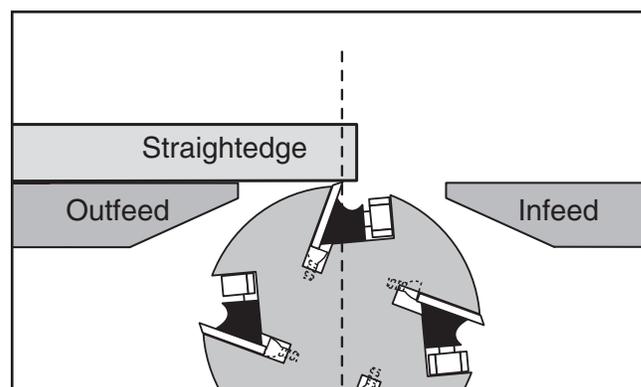


Figure 58. Example of setting knife heights using straightedge method.



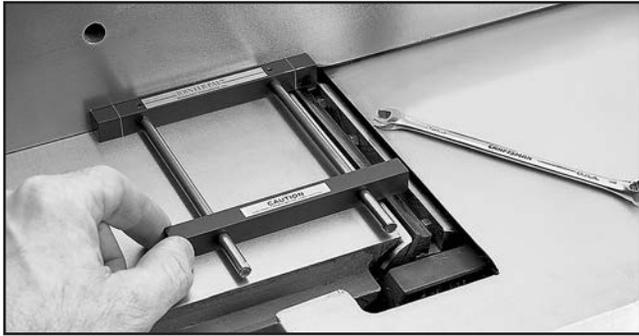


Figure 59. Example of using Jointer Pal®.

Knife-Setting Jig Method: The infeed table is lowered to fit the jig on the cutterhead, as shown in the **Figure** below and the knife heights are set to just touch the middle pad of the jig.

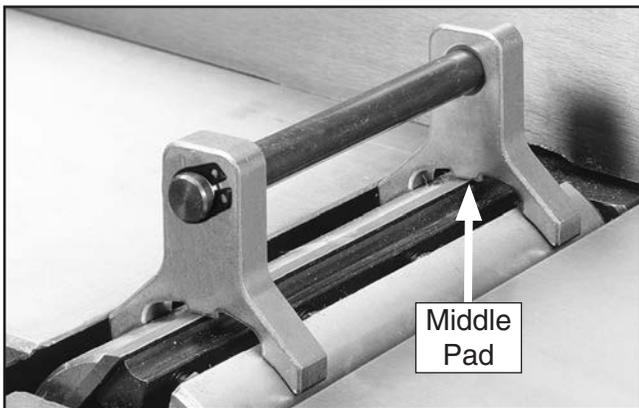


Figure 60. Example of knife-setting jig positioned over cutterhead knife.

The knife-setting jig included with the jointer is designed to set all the knives evenly and at the correct height in the cutterhead.

The cutterhead in this jointer is equipped with jack screws that allow for careful positioning of the knives.

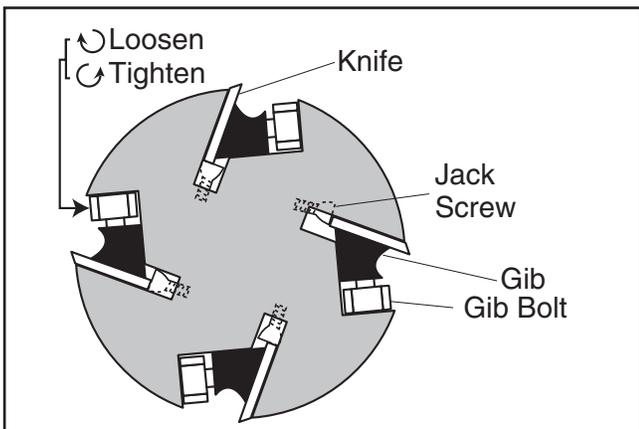


Figure 61. Cutterhead profile diagram.

Tools Needed	Qty
Knife-Setting Jig	1
Hex Wrench 3mm.....	1
Open-End Wrench 10mm.....	1

To inspect positioning of knives in cutterhead:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard or block it open.
3. Lower infeed table to 1/2" scale mark.
4. Place knife jig on cutterhead, directly over a knife.
5. Closely examine how jig touches cutterhead and knife. Knife is set correctly when, on each side of cutterhead, both legs of jig sit firmly on cutterhead body and middle pad of jig just touches top edge of knife.

—If jig does not sit as described, then that knife must be reset. (Repeat this inspection with other knives before resetting.)

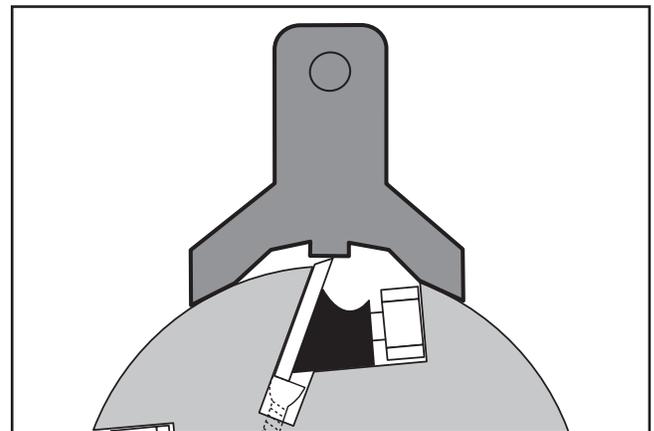


Figure 62. Using knife-setting jig to set knife height.



To set or replace knives:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard from table and lower infeed and outfeed tables as far as they go. This will provide unrestricted access to cutterhead.
3. Remove cabinet rear access panel to expose cutterhead pulley.
4. Rotate cutterhead pulley to provide good access to cutterhead knives, and put on leather gloves.
5. Loosen cutterhead gib bolts, starting in the middle, and alternating back and forth until all gib bolts are loose, but not falling out.

The first time you set or replace a knife, remove gib and knife from cutterhead. Clean gib and clean inside cutterhead slot to remove all pitch or sawdust. Coat knife and gib with a metal protectant.

6. Position knife jig over knife. Loosen gib bolts until knife is completely loose.
7. Access jack screws through holes in cutterhead. Using a hex wrench, rotate jack screws to raise or lower knife. When knife is set correctly, it will barely touch middle pad of knife jig or bottom of straightedge in each of the straightedge positions. Snug gib bolts just tight enough to hold knife in place. Repeat with remaining knives.

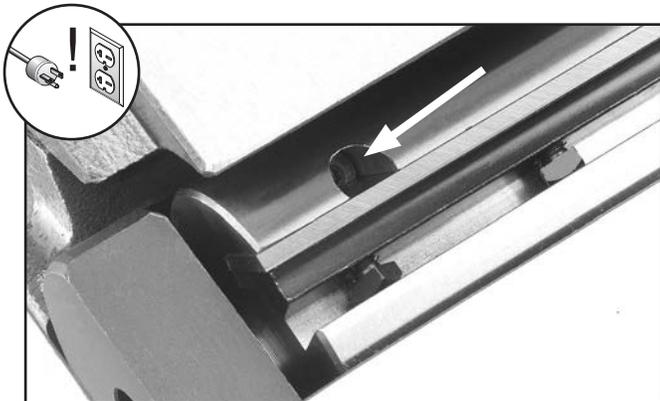


Figure 63. Jack screw access hole.

8. Rotate cutterhead to reveal the first knife you started with. Lightly snug all gib bolts, alternating from one side to the other, and working from the ends to the middle. Repeat with remaining knives.

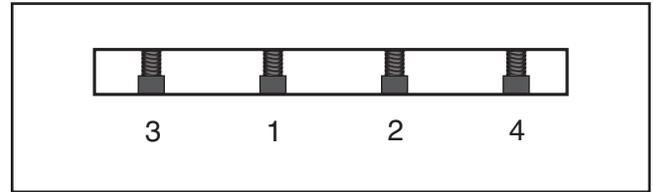


Figure 64. Gib bolt tightening sequence.

9. Tighten each gib bolt in the same alternating manner as you did in the previous step.
10. Make sure outfeed table is set even with the new knives at top dead center.
11. Replace cutterhead guard and cabinet rear access panel.



Rotating/Changing Cutterhead Inserts (G0490XW)

This spiral cutterhead is equipped with 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 as shown below.

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.

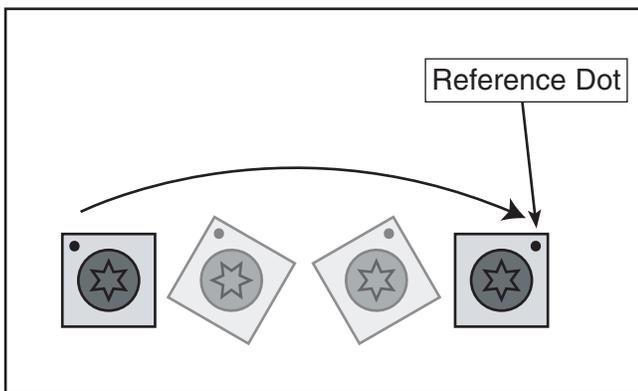


Figure 65. Insert rotating sequence.

Tools Needed	Qty
Phillips Screwdriver #2	1
Torque Wrench	1
T-20 Torx Bit	1
Precision Straightedge	1

To rotate or replace spiral cutterhead insert:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard from table, and lower infeed and outfeed tables as far as they go, to provide access to cutterhead.
3. Remove cabinet rear access panel to expose cutterhead pulley.
4. Rotate cutterhead pulley to provide access to insert(s) to be rotated/replaced.

5. Put on heavy leather gloves to protect fingers and hands.
6. Remove any sawdust or debris from head of insert, Torx screw, and surrounding area (see **Figure**).

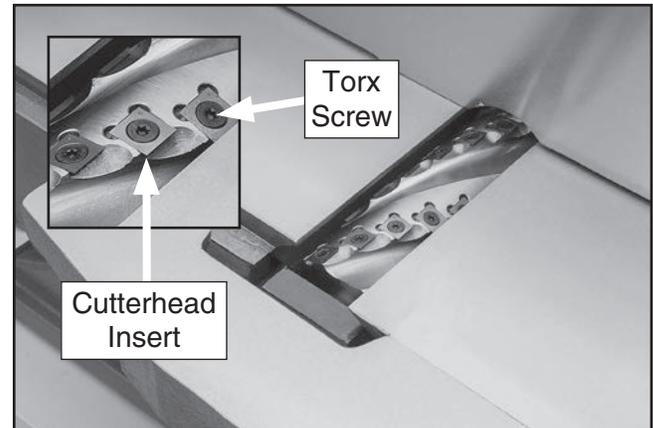


Figure 66. Location of cutterhead inserts and Torx screws.

7. Remove Torx screw and insert, then clean all dust and debris from both parts and pocket they were removed from.

Note: Proper cleaning of insert(s), Torx screw, and cutterhead pocket is critical to achieving a smooth finish. Dirt or dust trapped between insert and cutterhead will raise insert, and make marks on your workpiece when jointing.

Tip: Use low-pressure compressed air or vacuum nozzle to clean cutterhead pocket.

8. Re-install insert so that a fresh cutting edge faces outward, making sure it is properly seated in cutterhead pocket.

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

9. Lubricate Torx screw threads with a small amount of light machine oil, wipe excess off, and torque screw to 48–50 inch/pounds.

Note: If too much oil is applied to the threads, excess will attempt to squeeze out of threaded hole as you install insert and force it to raise slightly, making it out of alignment.



Checking/Adjusting Table Parallelism

If the tables are not parallel with the cutterhead and each other, then poor cutting results and kick-back can occur.

Tools Needed	Qty
Straightedge	1
Open-End Wrench 16mm.....	1
Hex Wrench 3mm.....	1

Checking Outfeed Table

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard, fence, and cabinet rear access panel.
3. Loosen outfeed table lock located at front of machine, and loosen jam nuts and positive stop bolts located at back of machine just behind outfeed table (see **Figure 67**).

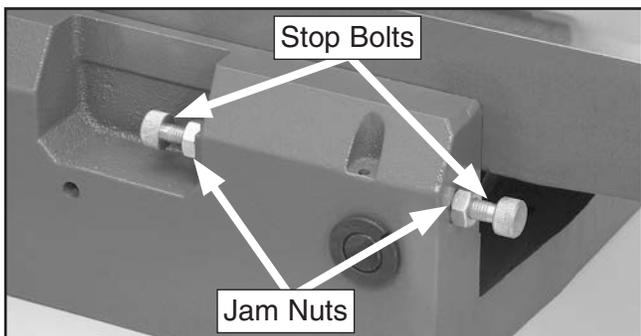


Figure 67. Outfeed table positive stop bolts.

4. Rotate motor pulley so that you can access cutterhead body with straightedge between the knives/inserts, as shown in **Figure 68**.

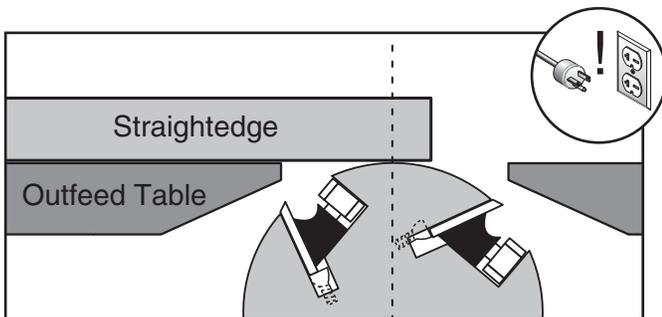


Figure 68. Adjusting outfeed table even with cutterhead body (knife-style cutterhead shown).

5. Place straightedge on outfeed table so it hangs over cutterhead, then lower outfeed table until straightedge just touches cutterhead body.
6. Place straightedge in positions shown in **Figure 69**. In each position, straightedge should touch cutterhead and sit flat on outfeed table.

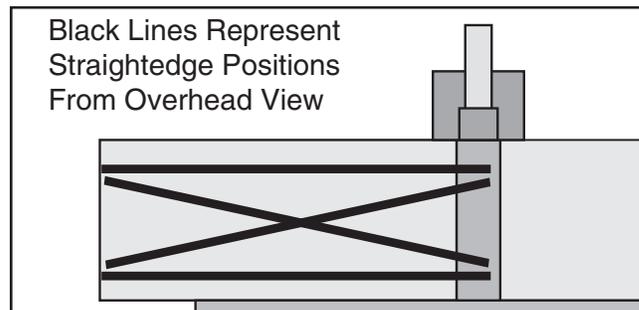


Figure 69. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

- If straightedge touches cutterhead body and sits flat across outfeed table in each position, then outfeed table is already parallel with cutterhead. Follow the **Checking Infeed Table** instructions on **Page 43**.
- If straightedge does not sit flat on outfeed table and touch cutterhead and in any of the positions, then outfeed table is not parallel with cutterhead. Perform **Adjusting Table Parallelism** procedure on **Page 43**, then perform **Checking Infeed Table** instructions on **Page 43**.



Checking Infeed Table

1. Follow all steps for checking outfeed table parallelism to first make sure that outfeed table is parallel with cutterhead.
2. Correctly adjust outfeed table height (refer to **Setting Outfeed Table Height** on **Page 46** for detailed instructions).
3. Rotate cutterhead so knives/inserts will not interfere, then place straightedge on infeed and outfeed tables and adjust infeed table even with outfeed table, as shown in **Figure 70**.

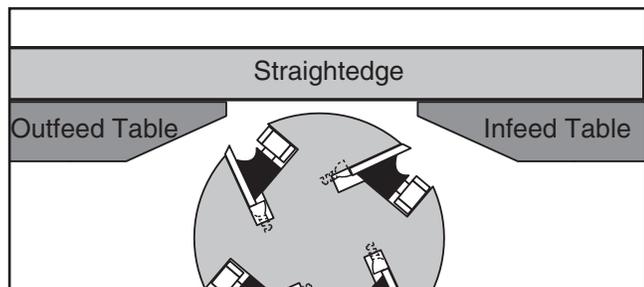


Figure 70. Infeed and outfeed tables set evenly (knife-style cutterhead shown).

4. Place straightedge in the positions shown in **Figure 71**. In each position, straightedge should sit flat against both outfeed table and infeed table.

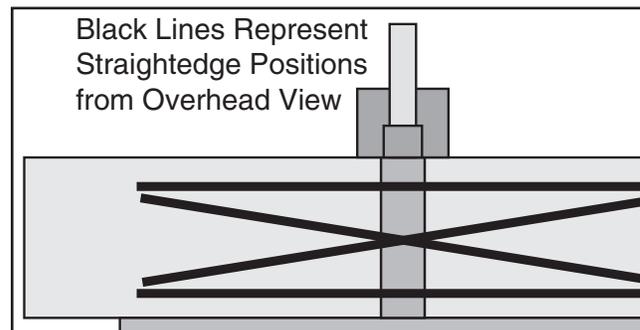


Figure 71. Straightedge positions for checking infeed/outfeed table parallelism.

- If straightedge sits flat against both infeed and outfeed tables in all positions above, then tables are parallel. Replace cutterhead guard, fence, and cabinet rear access panel.
- If straightedge does not sit flat against both infeed and outfeed tables in any of positions, then follow **Adjusting Table Parallelism** instructions on next page.



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.

Each table has four eccentric bushings on the base underneath that allow the table to be adjusted parallel. Each bushing is locked in place by a set screw.

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

When setting the outfeed table, all measurements **MUST** be made from the cutterhead body—not the knives/inserts or the results may be skewed.

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

To adjust table parallelism:

1. Place straightedge on outfeed table so it hangs over cutterhead, and lower outfeed table until straightedge just touches cutterhead *body*, as shown in **Figure 72**.

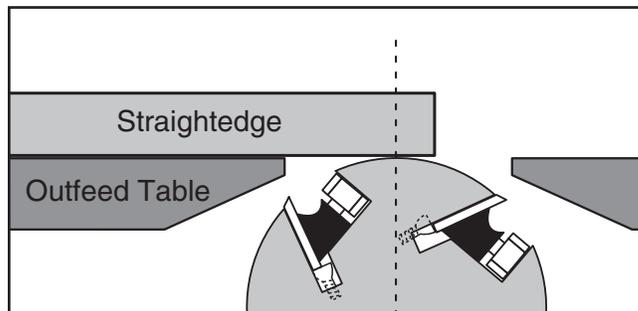


Figure 72. Adjusting outfeed table even with cutterhead body (knife-style cutterhead shown).

2. Remove set screw from each of the four eccentric bushings under outfeed table (see **Figure 73**).

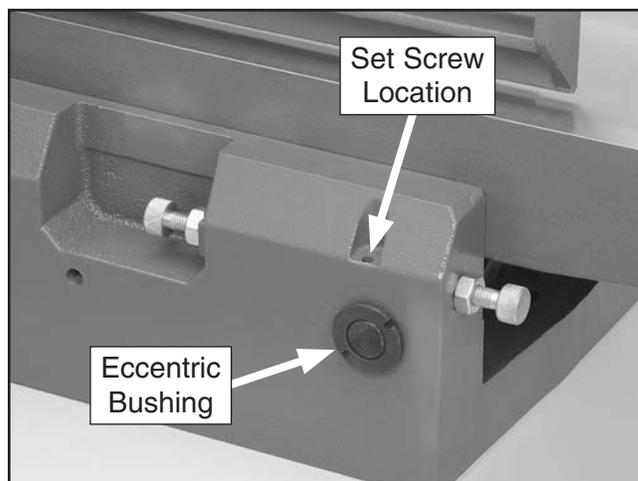


Figure 73. Eccentric bushing and set screw location.



- Place straightedge in one of the positions shown in **Figure 74**, and adjust eccentric bushings so straightedge touches cutterhead body while lying flat across outfeed table (a pin-type spanner wrench or small hammer and punch may be necessary to turn eccentric bushings).

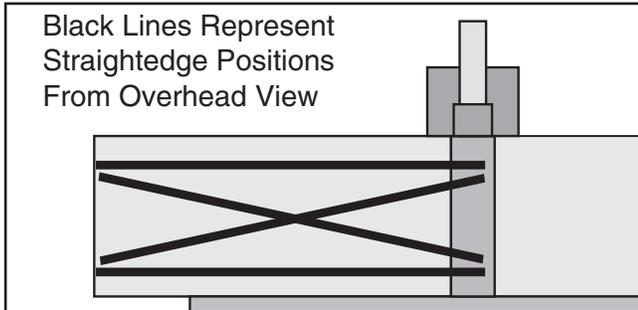


Figure 74. Straightedge positions for verifying if outfeed table is parallel with cutterhead.

- Repeat **Step 3** with each remaining straight-edge position as many times as necessary until outfeed table is parallel with cutterhead.
- Tighten/replace set screws in eccentric bushings on outfeed table.
- Remove set screw from each of the four eccentric bushings under infeed table.
- Place straightedge halfway across infeed and outfeed tables, and adjust infeed table even with outfeed table, as shown in **Figure 75**.

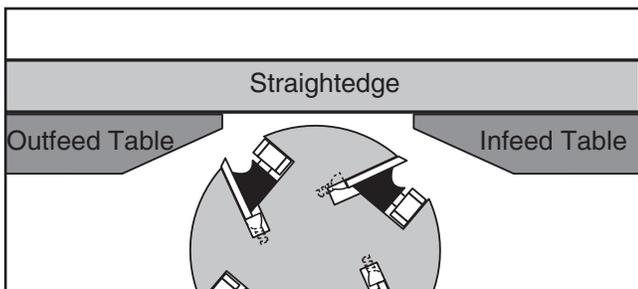


Figure 75. Infeed and outfeed tables set evenly (knife-style cutterhead shown).

- Place straightedge in one of the positions shown in **Figure 76**, and adjust eccentric bushings under infeed table so straightedge lies flat against both tables.

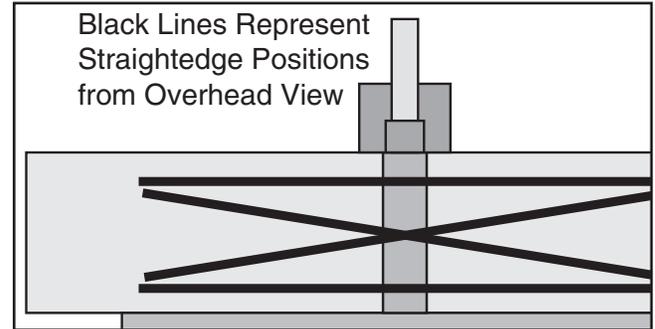


Figure 76. Straightedge positions for checking infeed/outfeed table parallelism.

- Repeat **Step 8** with each remaining straight-edge position as many times as necessary until infeed table is parallel with outfeed table.
- Tighten/replace set screws in eccentric bushings on infeed table.
- Perform **Setting Outfeed Table Height** on next page.



Setting Outfeed Table Height

The outfeed table height must be even with the top of the cutterhead knives. If the outfeed table is set too low, there will be snipe. If the outfeed table is set too high, the workpiece will hit the edge of the outfeed table during operation, increasing the chance of kickback.

Tools Needed	Qty
Straightedge	1
Open-End Wrench 16mm.....	1

To set outfeed table height:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cutterhead guard, fence, and cabinet rear access panel.
3. **Knife-Style Cutterhead Only:** Correctly set knife heights (refer to **Setting/Replacing Knives (G0490W)** on Page 38 for detailed instructions).
4. Loosen outfeed table lock located at front of machine, and loosen jam nuts and positive stop bolts located at back of machine just behind outfeed table (see **Figure 77**).

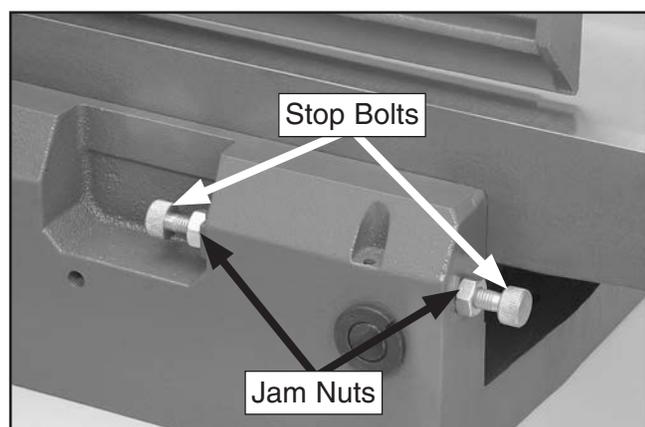


Figure 77. Outfeed table positive stop bolts.

5. Place straightedge on outfeed table so it extends over cutterhead.

6. Use motor pulley to rotate cutterhead until one of the knives or inserts is at top dead center (its highest point during rotation), as illustrated in **Figures 78–79**.

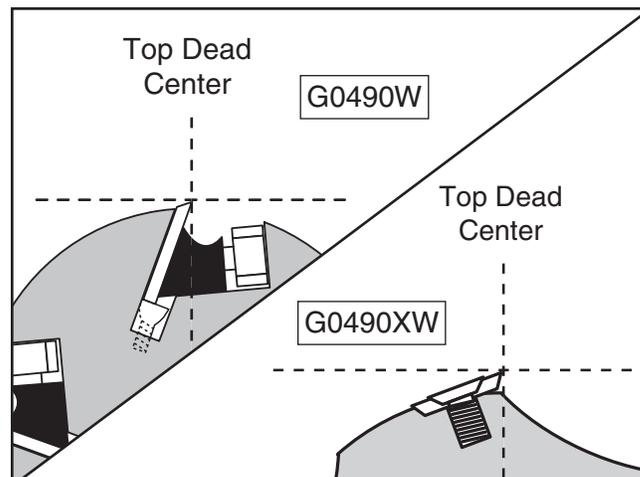


Figure 78. Knife or insert at top dead center.

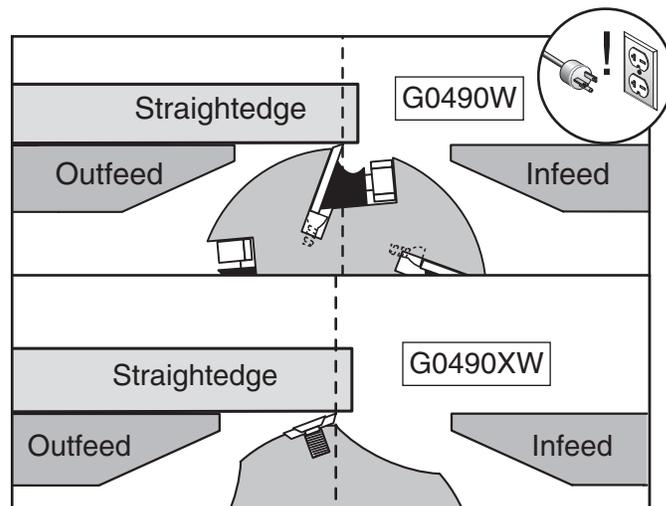


Figure 79. Using straightedge to check outfeed table height.

7. Use outfeed table adjustment lever to set outfeed table so that knife or insert barely touches straightedge, as illustrated in **Figure 79**.
8. Tighten outfeed table lock located at front of machine, and tighten outfeed positive stop bolts and jam nuts located at back of machine (see **Figure 77**) so that outfeed table will not move during operation.
9. Re-install cutterhead guard, fence, and cabinet rear access panel.



Adjusting Infeed Table Stop Bolts

The infeed table on your jointer has positive stop bolts that, when properly set up, allow you to quickly adjust the infeed table to perform heavy or light cuts.

Tools Needed	Qty
Straightedge	1
Open-End Wrench 16mm.....	1

Each positive stop bolt controls top or bottom range of table movement (see **Figure 80**). Jam nuts lock positive stop bolts in position so they will not move during operation.

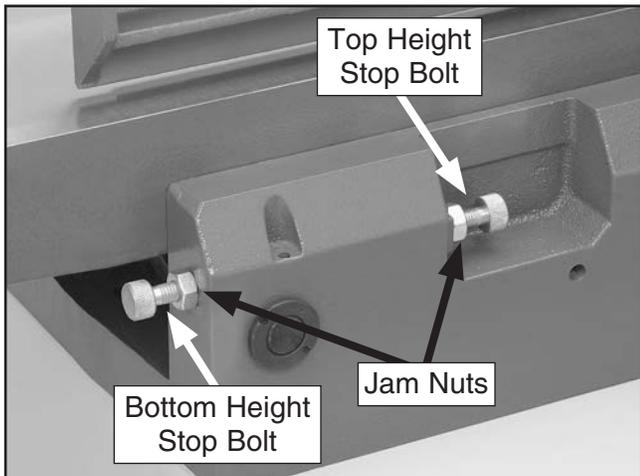


Figure 80. Positive stop bolts for infeed table.

Calibrating Depth-of-Cut Scale

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

Tools Needed	Qty
Straightedge	1
Phillips Screwdriver #2	1

To calibrate depth-of-cut scale:

1. DISCONNECT MACHINE FROM POWER!
2. Set outfeed table height as described in **Setting Outfeed Table Height** on **Page 46**.
3. Place straightedge across infeed and outfeed tables.
4. Adjust infeed table until it is level with outfeed table, as shown in **Figure 81**.

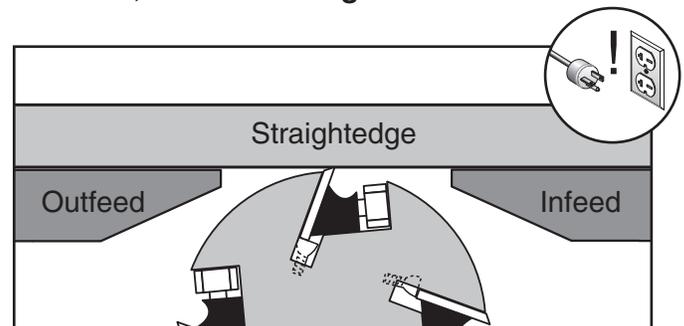


Figure 81. Infeed table even with outfeed table.

5. Using a screwdriver, loosen pivot screw, adjust scale pointer to "0" (see **Figure 82**), then re-tighten pivot screw.

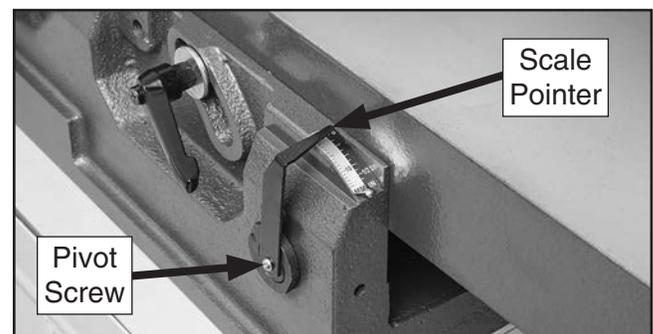


Figure 82. Depth-of-cut scale pointer adjusted to "0".



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 10mm	1
Hex Wrench 5mm.....	1

Setting 45° Inward Fence Stop

1. DISCONNECT MACHINE FROM POWER!
2. Pull out and lock tilt plunger (see **Figure 83**), loosen fence tilt lock and fence lock, then tilt fence approximately 45° inward onto stop cap screw.

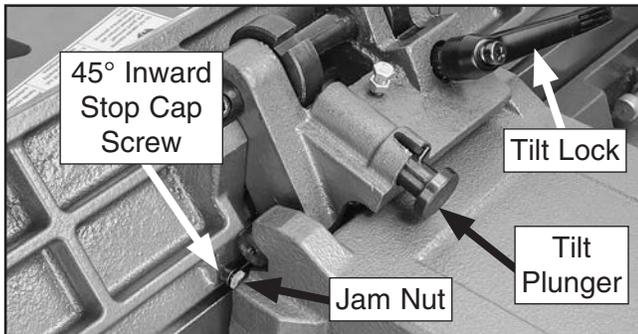


Figure 83. 45° inward positive stop cap screw.

3. Place 45° square against fence and table, (see **Figure 84**).



Figure 84. Fence adjusted to 45° inward.

4. Loosen jam nut shown in **Figure 83**.
5. Adjust stop cap screw until fence is exactly 45° inward while resting on screw (verify angle with a 45° square), retighten jam nut, tilt lock, and fence lock.

Setting 90° Fence Stop

1. DISCONNECT MACHINE FROM POWER!
2. Pull out and lock tilt plunger and loosen fence tilt lock (see **Figure 85**).

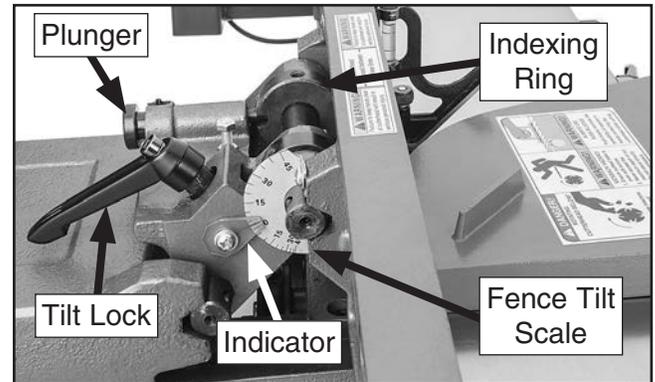


Figure 85. Adjusting fence to 90°.

3. Using a 90° square, adjust fence to 90° position (see **Figure 85**), then unlock plunger. It should insert into indexing ring and lock fence at 90° position.
4. Adjust indicator (if necessary) to 0° to calibrate fence tilt scale.

Setting 45° Outward Fence Stop

1. DISCONNECT MACHINE FROM POWER!
2. Pull out and lock tilt plunger (see **Figure 83**), loosen fence tilt lock and fence lock, then tilt fence against 45° outward stop bolt.
3. Loosen jam nut shown in **Figure 86**.

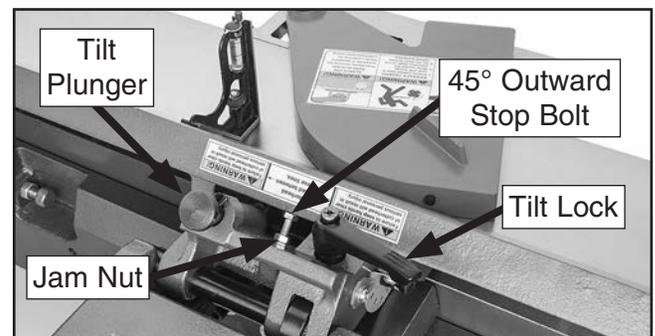


Figure 86. Fence adjusted 45° outward.

4. Adjust 45° outward stop bolt until fence is exactly 45° outward while resting on bolt (check angle with sliding bevel set to 135°), then retighten jam and tilt lock.



Replacing/ Tensioning Belt

To ensure optimum power transmission from the motor to the cutterhead, the belt must be in good condition (free from cracks, fraying and wear) and properly tensioned. After the first 16 hours of belt life, re-tension the belt, as it will stretch and seat during this time.

Tool Needed	Qty
Wrenches or Sockets 13mm	2

Tensioning Belt

1. DISCONNECT MACHINE FROM POWER!
2. Remove cabinet rear access panel.
3. Loosen motor bracket fasteners shown in **Figure 87**.

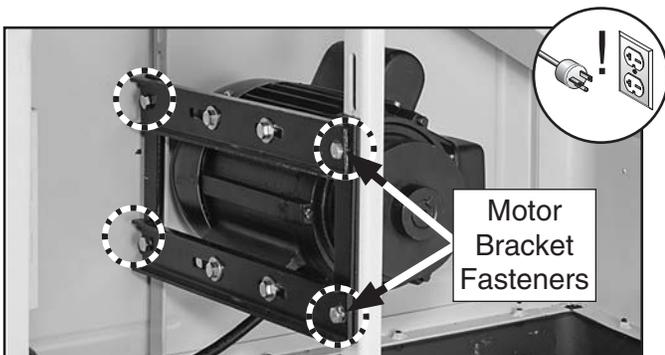


Figure 87. Motor mounting fasteners location.

4. Press down on motor to keep tension on belt.
5. Press belt with moderate pressure in center to check belt tension. Belt is correctly tensioned when there is approximately 1/4" deflection when pushed, as shown in **Figure 88**.

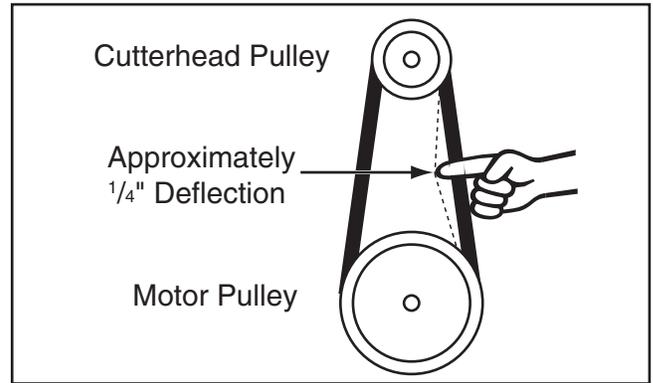


Figure 88. Correct belt deflection when properly tensioned.

— If there is more than 1/4" deflection when you check belt tension, repeat the tensioning procedure until it is correct.

6. Tighten motor bracket fasteners (see **Figure 87**) and replace cabinet rear access panel.

Replacing Belt

1. DISCONNECT MACHINE FROM POWER!
2. Remove cabinet rear access panel.
3. Loosen motor bracket fasteners shown in **Figure 87**.
4. Have another person lift motor as you remove belt and replace it with a new one. It may help to use a 2x4 as a lever to raise motor. Make sure ribs of belt are seated in pulley grooves.
5. Follow **Steps 4–5 in Tensioning Belt** procedure to set correct belt tension.
6. Tighten motor bracket fasteners (see **Figure 87**) and replace cabinet rear access panel.



Aligning Pulleys

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

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

Tool Needed Qty
Wrenches or Sockets 13mm 2

Aligning Pulleys

1. DISCONNECT MACHINE FROM POWER!
2. Remove cabinet rear access panel.
3. Visually check alignment of cutterhead and motor pulleys, as illustrated in **Figure 89**.

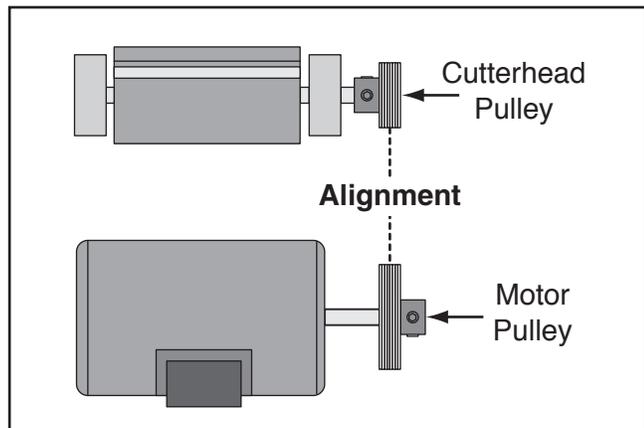


Figure 89. Example of pulleys aligned.

— If they are not aligned, loosen fasteners shown in **Figure 90**, shift motor horizontally to align pulleys, then retighten.

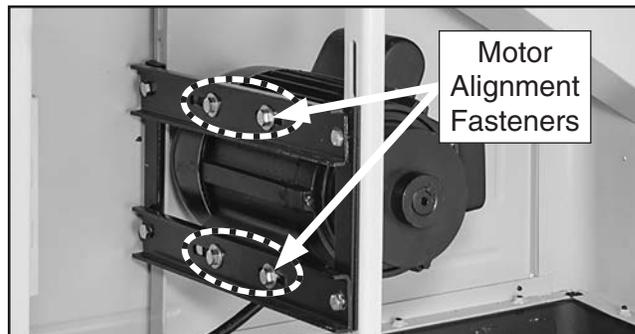


Figure 90. Location of motor alignment fasteners.

4. Replace cabinet rear access panel.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

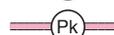
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

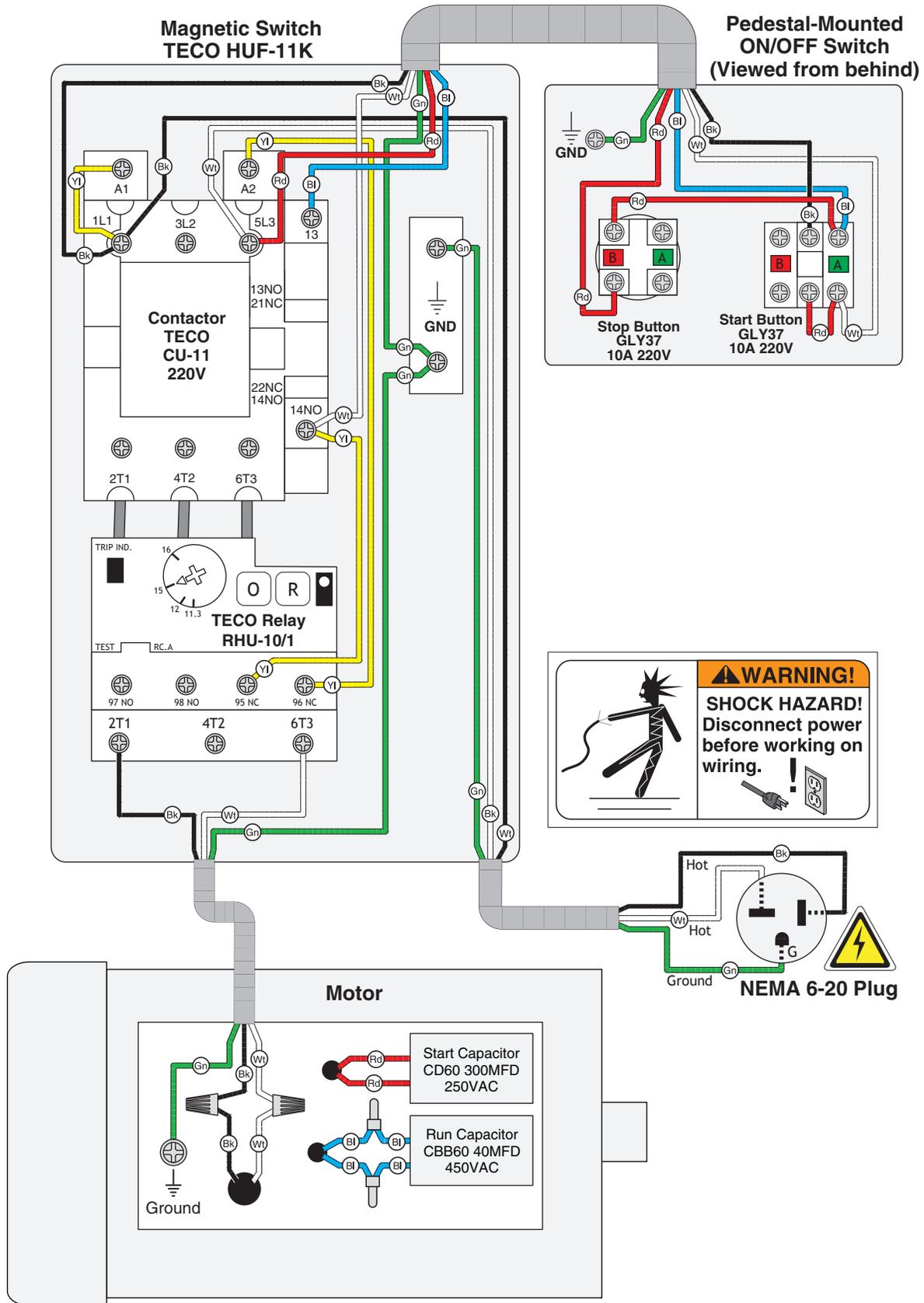
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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

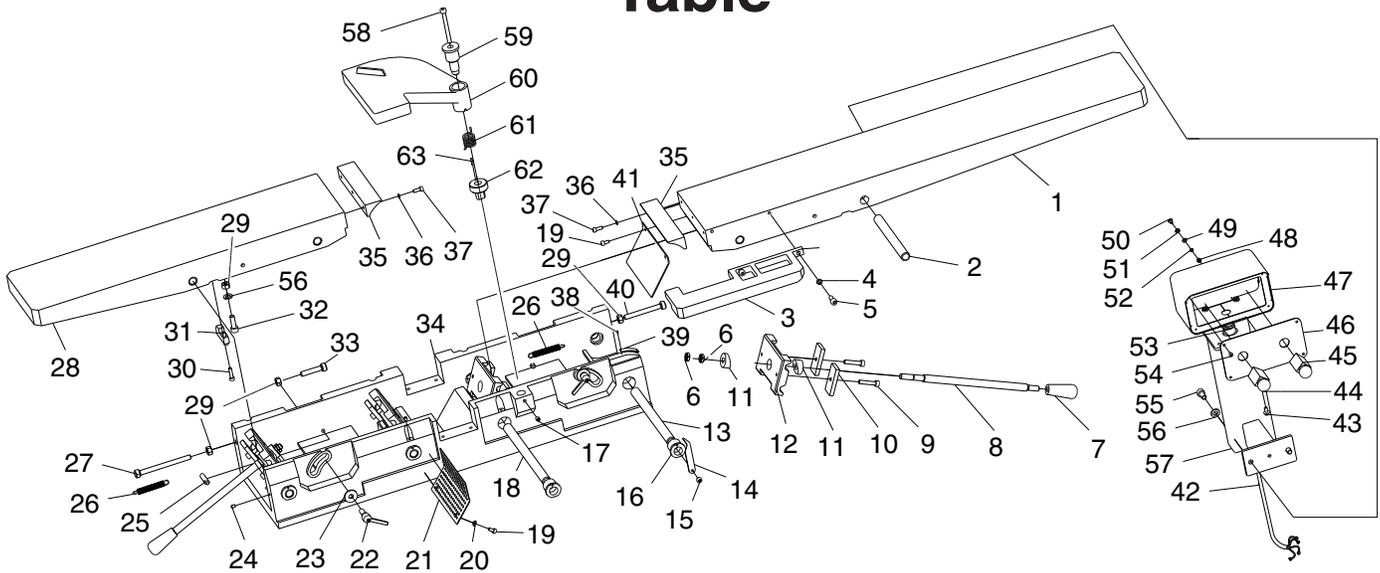


G0490W/G0490XW Wiring



SECTION 9: PARTS

Table

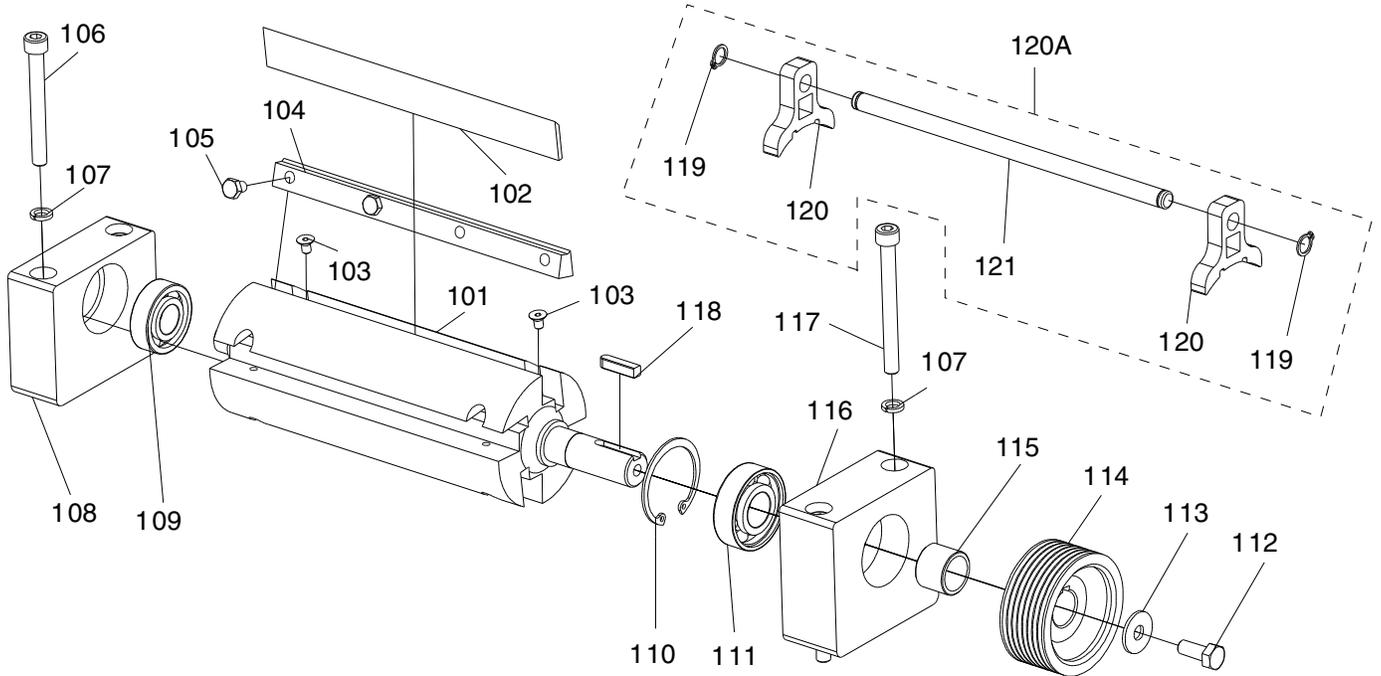


REF	PART #	DESCRIPTION
1	P0490W001	INFEED TABLE
2	P0490W002	TABLE SHAFT 20 X 202MM
3	P0490W003	RABBET TABLE
4	P0490W004	LOCK WASHER 8MM
5	P0490W005	CAP SCREW M8-1.25 X 20
6	P0490W006	HEX NUT M12-1.5 THIN
7	P0490W007	HANDLE M12-1.75, 32 X 80 (PLASTIC)
8	P0490W008	STUD-UDE M12-1.75 X 340, 24, 28
9	P0490W009	CAP SCREW M8-1.25 X 40
10	P0490W010	CLAMP PLATE
11	P0490W011	ADJUSTING BLOCK
12	P0490W012	PIVOT BRACKET
13	P0490W013	BASE SHAFT 20 X 285MM
14	P0490W014	DEPTH-OF-CUT POINTER
15	P0490W015	PHLP HD SCR M4-.7 X 10
16	P0490W016	ECCENTRIC BUSHING
17	P0490W017	SET SCREW M8-1.25 X 10
18	P0490W018	BASE SHAFT 20 X 285MM
19	P0490W019	CAP SCREW M6-1 X 12
20	P0490W020	FLAT WASHER 6MM
21	P0490W021	CHIP BREAKER
22	P0490W022	ADJUSTABLE HANDLE 94L, M10-1.5 x 32
23	P0490W023	FENDER WASHER 10MM
24	P0490W024	SET SCREW M6-1 X 8
25	P0490W025	SLOTTED PIN W/HOLE
26	P0490W026	EXTENSION SPRING
27	P0490W027	ADJUSTING SCREW M10-1.5 X 120
28	P0490W028	OUTFEED TABLE
29	P0490W029	HEX NUT M10-1.5
30	P0490W030	CAP SCREW M6-1 X 25
31	P0490W031	BUMPER
32	P0490W032	CAP SCREW M10-1.5 X 30

REF	PART #	DESCRIPTION
33	P0490W033	ADJUSTING SCREW M10-1.5 X 50
34	P0490W034	TABLE BASE
35	P0490W035	TABLE LIP
36	P0490W036	LOCK WASHER 6MM
37	P0490W037	CAP SCREW M6-1 X 16
38	P0490W038	RIVET 2 X 6MM NAMEPLATE, STEEL
39	P0490W039	DEPTH-OF-CUT SCALE
40	P0490W040	ADJUSTING SCREW M10-1.5 X 90
41	P0490W041	CHIP DEFLECTOR
42	P0490W042	SWITCH CORD 20G 5W 74"
43	P0490W043	FLANGE SCREW M6-1 X 12
44	P0490W044	STOP BUTTON GLY37 22MM
45	P0490W045	START BUTTON GLY37 22MM
46	P0490W046	CONTROL PANEL FACEPLATE
47	P0490W047	CONTROL PANEL BOX
48	P0490W048	HEX NUT M5-.8
49	P0490W049	FLAT WASHER 5MM
50	P0490W050	PHLP HD SCR M5-.8 X 10
51	P0490W051	INT TOOTH WASHER 5MM
52	P0490W052	LOCK WASHER 5MM
53	P0490W053	STRAIN RELIEF M20-1.5 TYPE-3
54	P0490W054	PHLP HD SCR M4-.7 X 8
55	P0490W055	CAP SCREW M10-1.5 X 20
56	P0490W056	FLAT WASHER 10MM
57	P0490W057	CONTROL PANEL PEDESTAL
58	P0490W058	CAP SCREW M8-1.25 X 80
59	P0490W059	GUARD PIVOT SHAFT
60	P0490W060	CUTTERHEAD GUARD
61	P0490W061	TORSION SPRING 2.5 X 26 X 30MM
62	P0490W062	SPRING RETAINER
63	P0490W063	ROLL PIN 3 X 16



Cutterhead (G0490W)

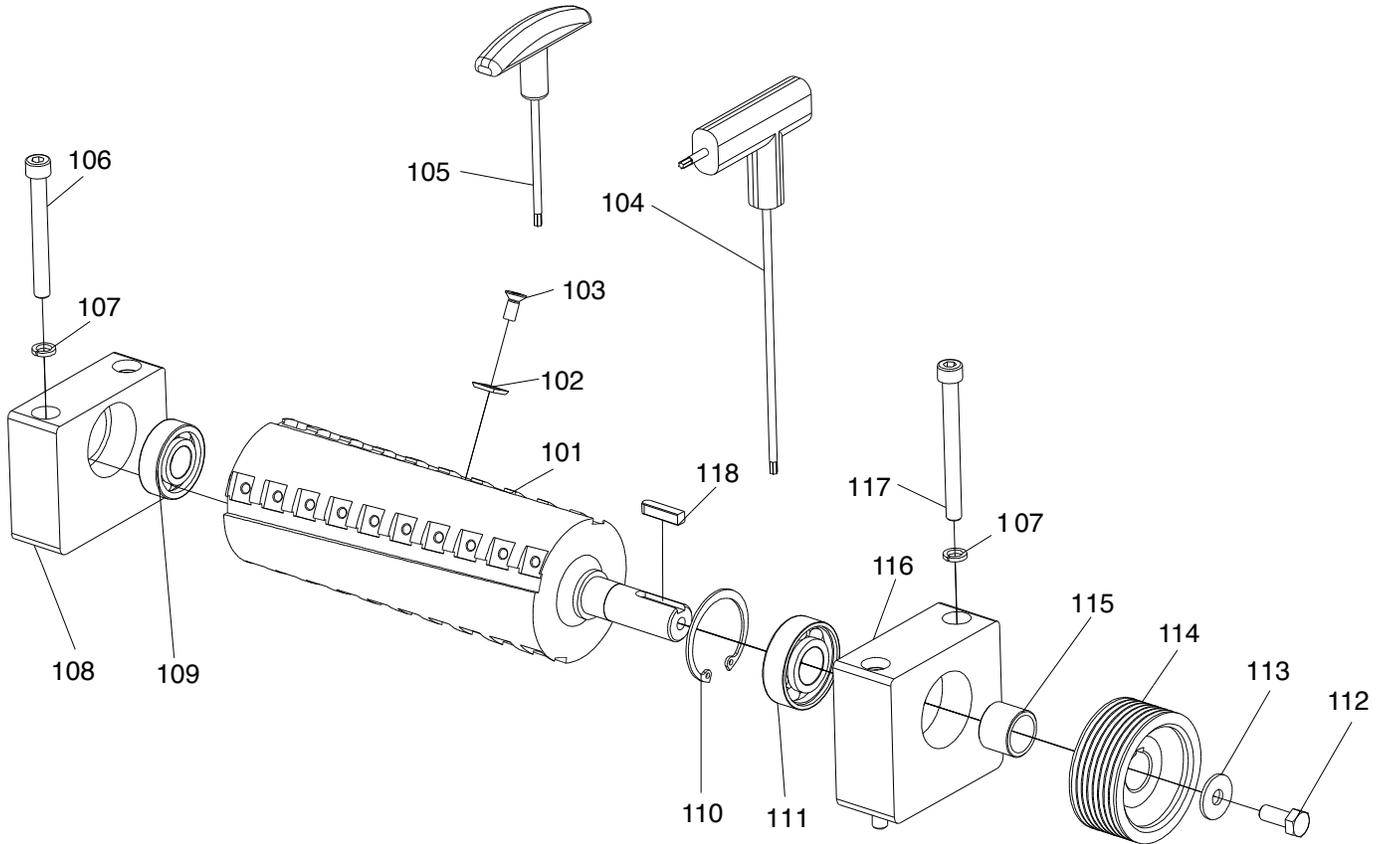


REF	PART #	DESCRIPTION
101	P0490W101	CUTTERHEAD 8" 4-KNIFE
102	P0490W102	JOINTER KNIVES 8-1/16" X 3/4" X 1/8" 4PK
103	P0490W103	FLAT HD CAP SCR M5-.8 X 12
104	P0490W104	GIB
105	P0490W105	GIB BOLT M6-1 X 10
106	P0490W106	CAP SCREW M8-1.25 X 70
107	P0490W107	LOCK WASHER 8MM
108	P0490W108	BEARING BLOCK (L)
109	P0490W109	BALL BEARING 6203-2RS
110	P0490W110	INT RETAINING RING 47MM
111	P0490W111	BALL BEARING 6204-2RS

REF	PART #	DESCRIPTION
112	P0490W112	HEX BOLT M8-1.25 X 20
113	P0490W113	FENDER WASHER 8MM
114	P0490W114	CUTTERHEAD PULLEY
115	P0490W115	BEARING SLEEVE
116	P0490W116	BEARING BLOCK (R)
117	P0490W117	CAP SCREW M8-1.25 X 80
118	P0490W118	KEY 6 X 6 X 25
119	P0490W119	EXT RETAINING RING 10MM
120	P0490W120	KNIFE-SETTING JIG FOOT
120A	P0490W120A	KNIFE-SETTING JIG 8"
121	P0490W121	KNIFE-SETTING JIG SHAFT



Cutterhead (G0490XW)

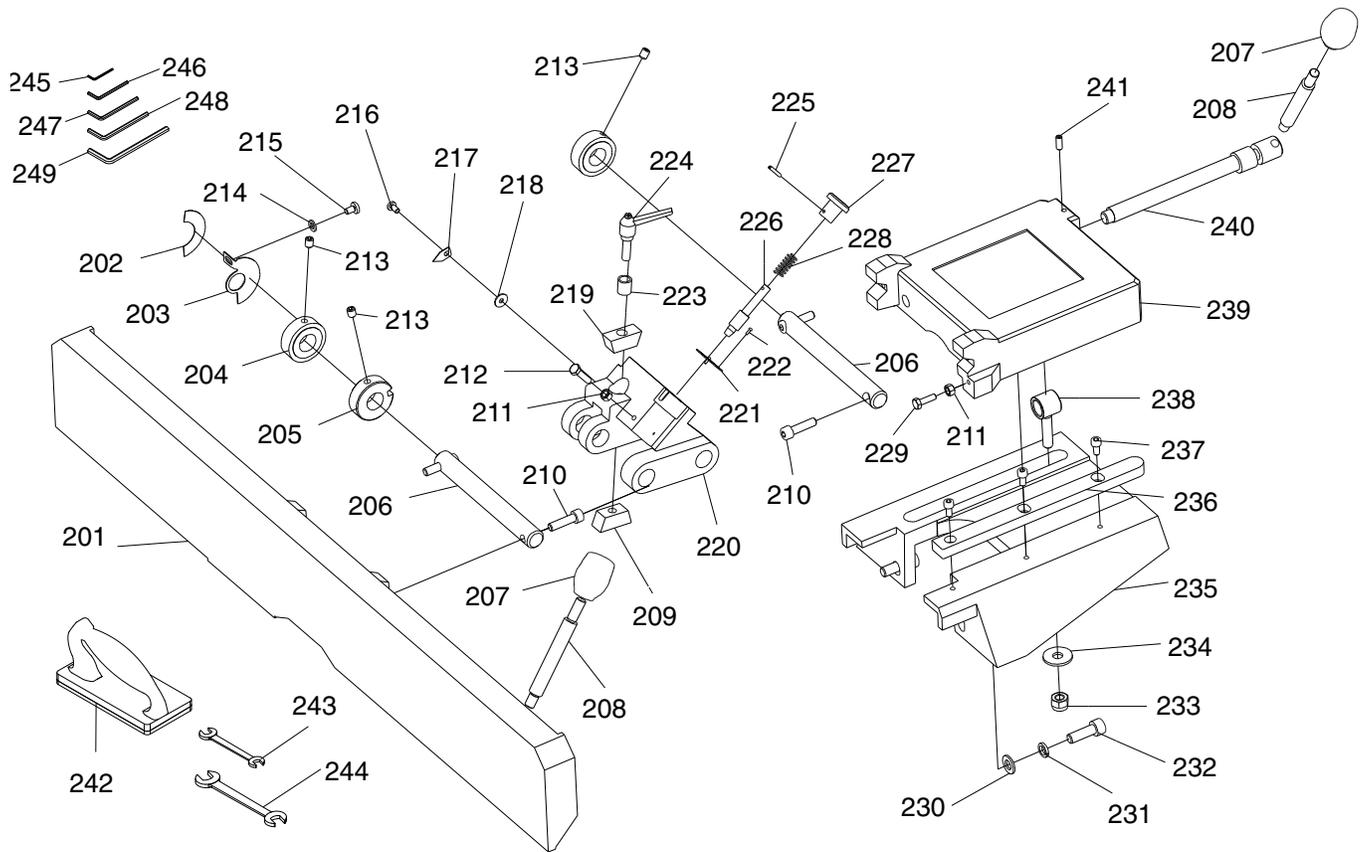


REF	PART #	DESCRIPTION
101	P0490XW101	CUTTERHEAD 8" SPIRAL
102	P0490XW102	CARBIDE INSERTS 14 X 14 X 2 (10-PK)
103	P0490XW103	FLAT HD TORX T20 M6-1 X 15
104	P0490XW104	L-HANDLE TORX DRIVE T-20
105	P0490XW105	T-HANDLE TORX DRIVE T-20
106	P0490XW106	CAP SCREW M8-1.25 X 70
107	P0490XW107	LOCK WASHER 8MM
108	P0490XW108	BEARING BLOCK (L)
109	P0490XW109	BALL BEARING 6203-2RS

REF	PART #	DESCRIPTION
110	P0490XW110	INT RETAINING RING 47MM
111	P0490XW111	BALL BEARING 6204-2RS
112	P0490XW112	HEX BOLT M8-1.25 X 20
113	P0490XW113	FLAT WASHER 8MM
114	P0490XW114	CUTTERHEAD PULLEY
115	P0490XW115	COLLAR
116	P0490XW116	BEARING BLOCK (R)
117	P0490XW117	CAP SCREW M8-1.25 X 80
118	P0490XW118	KEY 6 X 6 X 25



Fence

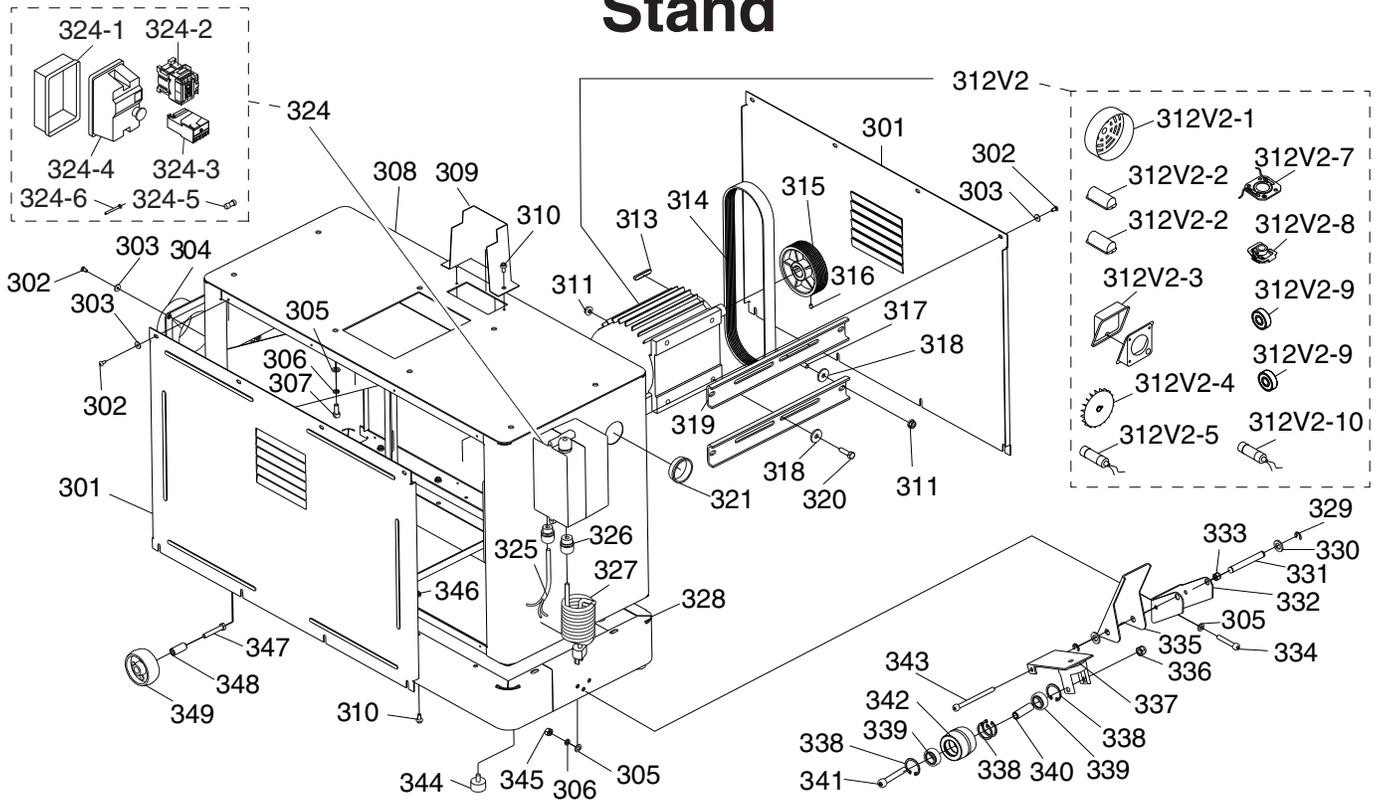


REF	PART #	DESCRIPTION
201	P0490W201	FENCE
202	P0490W202	TILT SCALE
203	P0490W203	TILT SCALE PLATE
204	P0490W204	LOCK COLLAR
205	P0490W205	LOCK COLLAR
206	P0490W206	CONNECTING SHAFT W/2 HOLES
207	P0490W207	KNOB M10-1.5, 35 DIA, 44L (PLASTIC)
208	P0490W208	STUD UDE M10-1.5 X 100, 12, 30
209	P0490W209	THREADED CLAMP M10-1.5
210	P0490W210	CAP SCREW M8-1.25 X 30
211	P0490W211	HEX NUT M6-1
212	P0490W212	HEX BOLT M6-1 X 25
213	P0490W213	SET SCREW M8-1.25 X 10
214	P0490W214	FLAT WASHER 6MM
215	P0490W215	PHLP HD SCR M6-1 X 10
216	P0490W216	PHLP HD SCR M5-.8 X 10
217	P0490W217	TILT POINTER
218	P0490W218	FENDER WASHER 5MM
219	P0490W219	CLAMP
220	P0490W220	FENCE SWIVEL BASE
221	P0490W221	INDEX PIN WASHER
222	P0490W222	RIVET 2 X 6MM NAMEPLATE, STEEL
223	P0490W223	BUSHING 14 X 15
224	P0490W224	ADJUSTABLE HANDLE 94L, M10-1.5 X 50
225	P0490W225	ROLL PIN 3 X 20

REF	PART #	DESCRIPTION
226	P0490W226	INDEX PIN
227	P0490W227	PLUNGER
228	P0490W228	COMPRESSION SPRING 0.7 X 12 X 15
229	P0490W229	HEX BOLT M6-1 X 20
230	P0490W230	FLAT WASHER 10MM
231	P0490W231	LOCK WASHER 10MM
232	P0490W232	CAP SCREW M10-1.5 X 30
233	P0490W233	LOCK NUT M10-1.5
234	P0490W234	FENDER WASHER 10MM
235	P0490W235	CARRIAGE MOUNT
236	P0490W236	FENCE GIB
237	P0490W237	CAP SCREW M6-1 X 12
238	P0490W238	FENCE CARRIAGE CLAMP BOLT
239	P0490W239	FENCE CARRIAGE
240	P0490W240	ECCENTRIC SHAFT
241	P0490W241	SET SCREW M6-1 X 16
242	P0490W242	PUSH BLOCK
243	P0490W243	WRENCH 8 X 10MM OPEN-ENDS
244	P0490W244	WRENCH 11 X 13MM OPEN-ENDS
245	P0490W245	HEX WRENCH 3MM
246	P0490W246	HEX WRENCH 4MM
247	P0490W247	HEX WRENCH 5MM
248	P0490W248	HEX WRENCH 6MM
249	P0490W249	HEX WRENCH 8MM



Stand

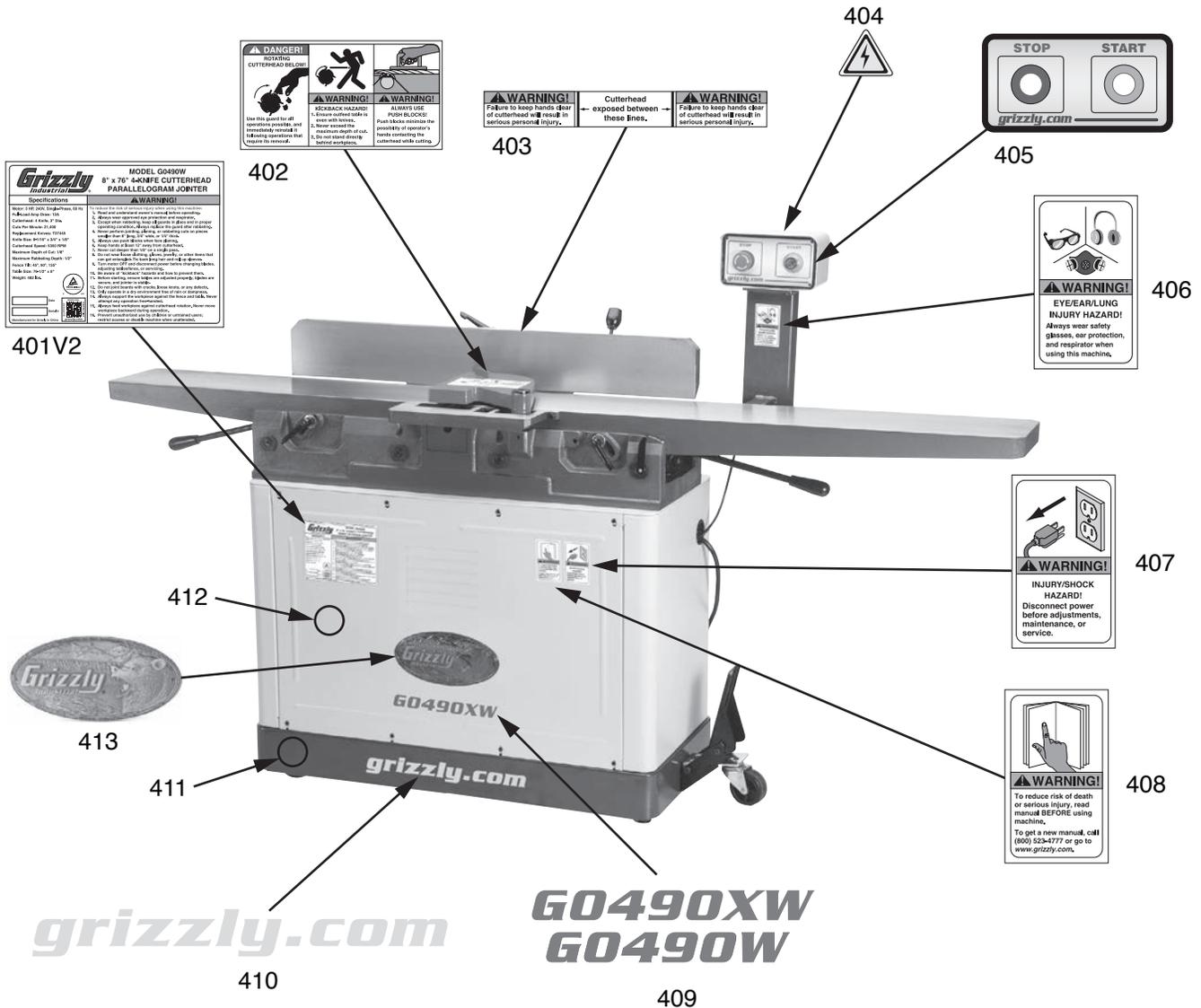


REF	PART #	DESCRIPTION
301	P0490W301	STAND COVER
302	P0490W302	PHLP HD SCR M5-.8 X 10
303	P0490W303	FENDER WASHER 5MM
304	P0490W304	DUST PORT 4"
305	P0490W305	FLAT WASHER 8MM
306	P0490W306	LOCK WASHER 8MM
307	P0490W307	CAP SCREW M8-1.25 X 20
308	P0490W308	STAND
309	P0490W309	BELT GUARD
310	P0490W310	FLANGE BOLT M6-1 X 12
311	P0490W311	FLANGE NUT M8-1.25
312V2	P0490W312V2	MOTOR 3HP 240V 1-PH V2.04.16
312V2-1	P0490W312V2-1	MOTOR FAN COVER
312V2-2	P0490W312V2-2	CAPACITOR COVER
312V2-3	P0490W312V2-3	MOTOR JUNCTION BOX
312V2-4	P0490W312V2-4	MOTOR FAN
312V2-5	P0490W312V2-5	S CAPACITOR 300M 250V 1-7/8 X 3-3/4
312V2-7	P0490W312V2-7	CONTACT PLATE
312V2-8	P0490W312V2-8	CENTRIFUGAL SWITCH
312V2-9	P0490W312V2-9	BALL BEARING 6205ZZ
312V2-10	P0490W312V2-10	R CAPACITOR 40M 450V 1-7/8 X 3-3/4
313	P0490W313	KEY 8 X 7 X 40
314	P0490W314	RIBBED V-BELT 8PK-1180
315	P0490W315	MOTOR PULLEY
316	P0490W316	SET SCREW M6-1 X 8
317	P0490W317	HEX BOLT M8-1.25 X 25
318	P0490W318	FENDER WASHER 8MM
319	P0490W319	MOTOR MOUNT PLATE
320	P0490W320	HEX BOLT M8-1.25 X 30
321	P0490W321	GROMMET 12 X 50MM (PLASTIC)
324	P0490W324	MAG SWITCH TECO HUF-11K

REF	PART #	DESCRIPTION
324-1	P0490W324-1	REAR MAG SWITCH COVER
324-2	P0490W324-2	CONTACTOR TECO CU-11 220V
324-3	P0490W324-3	OL RELAY TECO RHU-10 11.3-16A
324-4	P0490W324-4	FRONT MAG SWITCH COVER
324-5	P0490W324-5	PLASTIC SCREW M12 X 25
324-6	P0490W324-6	PHLP HD SCR M4-.7 X 40
325	P0490W325	MOTOR CORD 12G 3W 37"
326	P0490W326	STRAIN RELIEF M22 TYPE-6 ST
327	P0490W327	POWER CORD 12G 3W 98" 6-20P
328	P0490W328	STAND BASE
329	P0490W329	E-CLIP 9MM
330	P0490W330	FLAT WASHER 12MM
331	P0490W331	PEDAL PIVOT SHAFT 12 X 100MM
332	P0490W332	FOOT PEDAL BRACKET
333	P0490W333	LOCK NUT M8-1.25
334	P0490W334	CAP SCREW M8-1.25 X 50
335	P0490W335	FOOT PEDAL
336	P0490W336	LOCK NUT M10-1.5
337	P0490W337	FOOT PEDAL BASE
338	P0490W338	INT RETAINING RING 35MM
339	P0490W339	BALL BEARING 6202-2RS
340	P0490W340	FOOT PEDAL WHEEL SLEEVE
341	P0490W341	CAP SCREW M10-1.5 X 70
342	P0490W342	FOOT PEDAL WHEEL
343	P0490W343	CAP SCREW M8-1.25 X 100
344	P0490W344	RUBBER FOOT M8-1.25 X 16
345	P0490W345	HEX NUT M8-1.25
346	P0490W346	FLANGE NUT M6-1
347	P0490W347	HEX BOLT M8-1.25 X 50
348	P0490W348	REAR WHEEL SLEEVE
349	P0490W349	REAR WHEEL



Labels & Cosmetics



REF	PART #	DESCRIPTION
401V2	P0490W401V2	MACHINE ID LABEL V2.04.16 (G0490W)
401V2	P0490XW401V2	MACHINE ID LABEL V2.04.16 (G0490XW)
402	P0490W402	CUTTERHEAD WARNING LABEL
403	P0490W403	FENCE WARNING LABEL
404	P0490W404	ELECTRICITY LABEL
405	P0490W405	CONTROL PANEL LABEL
406	P0490W406	EYE/EAR/LUNG WARNING LABEL
407	P0490W407	DISCONNECT POWER LABEL

REF	PART #	DESCRIPTION
408	P0490W408	READ MANUAL LABEL
409	P0490W409	MODEL NUMBER LABEL (G0490W)
409	P0490XW409	MODEL NUMBER LABEL (G0490XW)
410	P0490W410	GRIZZLY.COM LABEL
411	P0490W411	GRIZZLY GREEN TOUCH-UP PAINT
412	P0490W412	GRIZZLY BEIGE TOUCH-UP PAINT
413	P0490W413	GRIZZLY NAMEPLATE

⚠ WARNING

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





WARRANTY CARD

Name _____
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 Phone # _____ Email _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other: _____

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

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

3. What is your annual household income?

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+

4. What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+

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

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------

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

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
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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: _____

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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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