

READ THIS FIRST



Model G8621

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

**For Machines Mfd. Since 08/24
and Owner's Manual Revised 10/02**

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

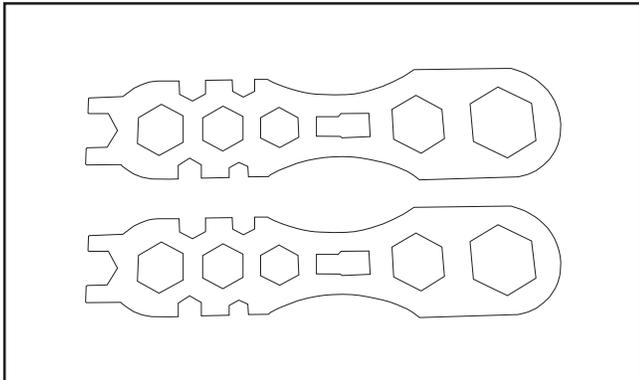
The following change was recently made since the owner's manual was printed:

- Inventory change.

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

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

Revised Inventory



Model G8621 Inventory

Qty

- Multi-Wrenches 10, 12, 13, 14, 19, 21, 23, 26, 30, 38mm 2

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Model G8621

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

For Machines Mfd. Since 03/06
and Owner's Manual Revised 10/02

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

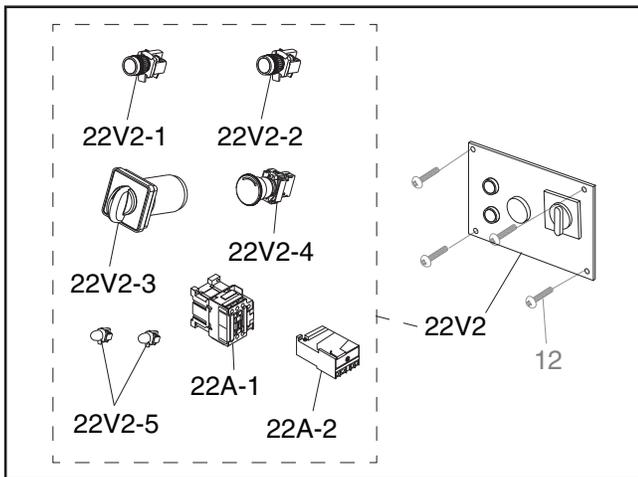
The following change was made since the owner's manual was printed:

- Electrical box assembly changed.

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

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

Revised Parts Breakdown



REF	PART #	DESCRIPTION
22V2	P8621022V2	ELECTRICAL BOX ASSY V2.03.06
22V2-1	P8621022V2-1	RED OFF SWITCH (ROUND)
22V2-2	P8621022V2-2	GREEN ON SWITCH (ROUND)
22V2-3	P8621022V2-3	F/O/R SWITCH KEDU ZH-HC-31-BY
22V2-4	P8621022V2-4	EMERGENCY SAFETY BUTTON
22V2-5	P8621022V2-5	RED AND GREEN 220V LIGHT BULB 2PC
22A-1	P8621022A-1	CONTACTOR
22A-2	P8621022A-2	OVERLOAD RELAY

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SECTION 7: 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 update, 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.

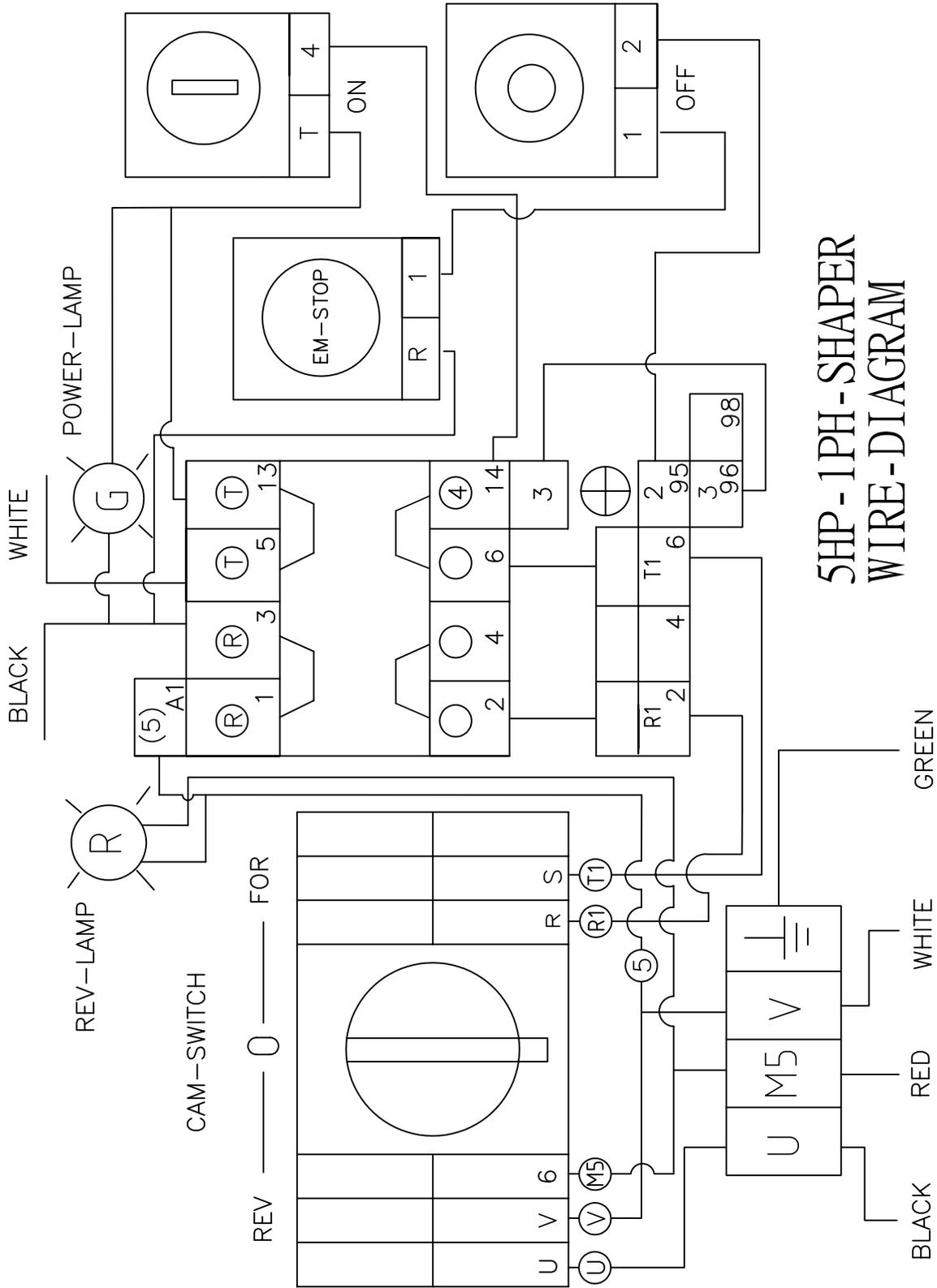
MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

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.



Wiring Diagram



READ THIS FIRST



Model G5912Z/G7214Z/G8621

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

**For Machines Mfd. Since 1/17
and Owner's Manual Printed 2001**

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

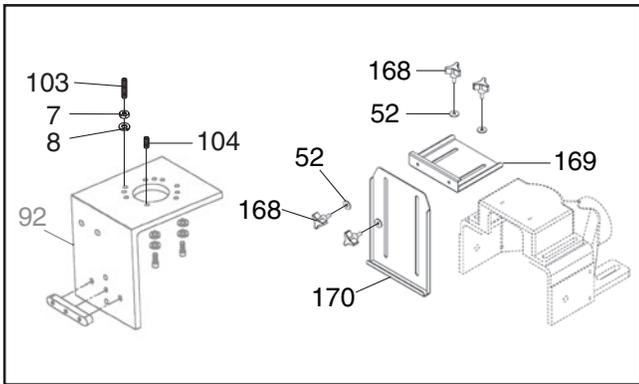
The following changes were recently made to this machine since the owner's manual was printed:

- Added an additional spindle enclosure guard.
- Changed spindle cartridge support fasteners.

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

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

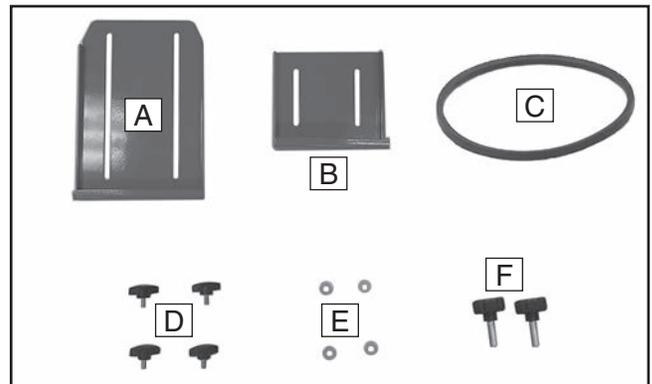
New Parts



REF	PART #	DESCRIPTION
7	P5912Z007	HEX NUT 3/8-16
8	P5912Z008	LOCK WASHER 3/8
52	P5912Z052	FLAT WASHER 1/4
103	P5912Z103	SET SCREW 3/8-16 X 1
104	P5912Z104	SET SCREW 3/8-16 X 1/2
168	P5912Z168	KNOB BOLT 1/4-20 X 1/2
169	P5912Z169	FRONT GUARD EXTENSION PLATE
170	P5912Z170	FRONT SPINDLE ENCLOSURE GUARD

New Inventory

Inventory	Qty
A. Front Spindle Enclosure Guard.....	1
B. Front Guard Extension Plate.....	1
C. V-Belt A28 (G8621).....	1
D. Knob Bolts 1/4"-20 x 1/2".....	4
E. Flat Washers 1/4".....	4
F. Knob Bolts 3/8"-16 x 1" (G5912Z, G7214Z). 2	
F. Knob Bolts 3/8"-16 x 1" (G8621).....	4



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Attaching Spindle Enclosure Guard

Before attaching the spindle enclosure guard, follow instructions in the Owner's Manual for installing the cutter guard and attaching the safety guard (for **G5912Z/G7214Z**, see **Pages 18–19**; for **G8621**, see **Pages 14–15**).

To attach spindle enclosure guard:

1. Attach front guard extension plate to threaded holes on front of safety guard with (2) $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " knob bolts and (2) $\frac{1}{4}$ " flat washers (see **Figure 1**).
2. Attach front spindle enclosure guard to extension plate with (2) $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " knob bolts and (2) $\frac{1}{4}$ " flat washers, (see **Figure 1**).

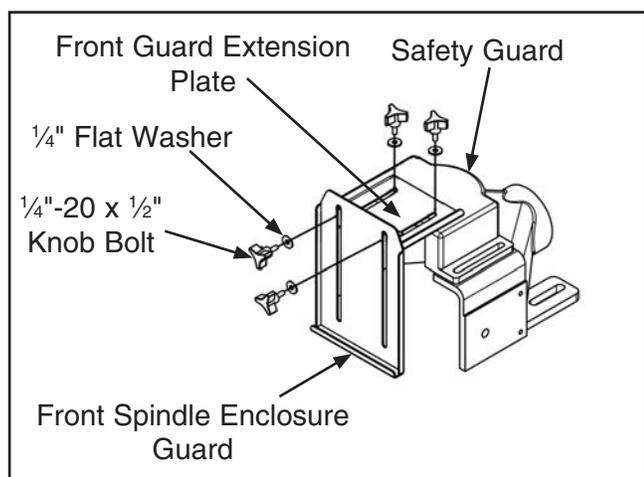
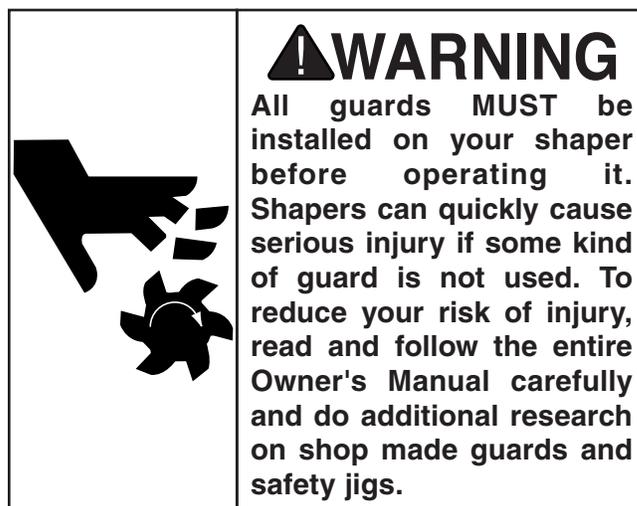


Figure 1. Front guard extension plate and spindle enclosure guard attached to safety guard.

Spindle Enclosure Guard Positioning

The spindle enclosure guard protects the user from exposure to the cutter and chips thrown by it. To minimize the risk of injury, the spindle enclosure guard must be adjusted so it encloses as much of the spindle area as possible, while still allowing the workpiece to pass through the cut. Typically this means the front guard is positioned to just clear the top of the workpiece.

To position the spindle enclosure guard, loosen the top knob bolts and slide the extension plate in or out, then loosen the front knob bolts and raise or lower the spindle enclosure guard as needed. Tighten the knob bolts to secure the setting.



Grizzly
Industrial, Inc.®

**HEAVY-DUTY
SLIDING TABLE SHAPER
MODEL G8621
INSTRUCTION MANUAL**



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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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SECTION 1: SAFETY

WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

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

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

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

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.

 **CAUTION**

NOTICE

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

WARNING

Safety Instructions For Power Tools

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

WARNING

Safety Instructions For Power Tools

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

Minimum Gauge for Extension Cords

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
13. **NEVER OVERREACH.** Keep proper footing and balance at all times.
14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, and the like.
16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.
18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.
20. **NEVER USE UNDER THE INFLUENCE** of alcohol or drugs, or when tired.
21. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

WARNING

Additional Safety Instructions For Shapers

1. **NEVER ALLOW YOUR HANDS** to come within 12 inches of the cutters. Never pass your hands directly over or in front of the cutter.
2. **BLIND CUT WHENEVER POSSIBLE.** This keeps the knives on the underside of the workpiece and provides a distance guard for the operator.
3. **WHEN SHAPING CONTOURED WORK** and using a rub collar, NEVER start out at a corner. See the “Rub Collar” instructions further on in the manual.
4. **WITH THE MACHINE UNPLUGGED,** always rotate the spindle by hand with any new setup to ensure proper cutter clearance before starting the machine.
5. **DO NOT SHAPE STOCK SHORTER** than 12 inches without special fixtures or jigs. Where practical, shape longer stock and cut to size.
6. **NEVER ATTEMPT** to remove too much material in one pass. You are far more likely to enjoy safer and higher quality results if you allow the cutter to remove material in multiple passes.
7. **THE DANGER OF** kickback is increased when the stock has knots, holes, or foreign objects in it. Warped stock should be run through a jointer before attempting to run it through a shaper.
8. **KEEP THE UNUSED PORTION** of the cutter below the table surface.
9. **THE USE OF PUSH STICKS** as safety devices in some applications is smart; in others it can be quite dangerous. If the push stick comes in contact with the cutter on the end grain, it can fly out of your hand like a bullet—potentially causing serious injury. We recommend using some type of fixture, jig, or hold-down device as a safer alternative. Always use the guard as described in the manual.
10. **NEVER FORCE MATERIALS** through the shaper. Let the cutters do the work. Excessive force is likely to result in poor cutting results and will cause dangerous kickback conditions.
11. **ALWAYS** ensure that the cutters, fence, and spindle elevator knob have been tightened properly before beginning any operation.
12. **ALWAYS** feed the work toward the cutters in the direction opposite of the cutter rotation. Also, using and maintaining a sharp cutterhead will greatly reduce the chance of kickback.
13. **NEVER REACH BEHIND CUTTER** to grab the workpiece. Your hand may suddenly be pulled into the cutter in the event of a kickback.
14. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE SHAPER!** Then contact our service department or ask a qualified expert how the operation should be performed.

WARNING

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

CAUTION

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

SECTION 2: CIRCUIT REQUIREMENTS

220V Operation

The Model G8621 Shaper is furnished with a 3450 R.P.M., 5 H.P., Single-Phase 220V motor, push-button ON/OFF magnetic starter switch, forward-reverse switch and a cord set. Under normal use, the motor draws approximately 25 amps @ 220V. We recommend a 30 amp circuit breaker. If frequent circuit failures occur when using the shaper, contact our service department.

The shaper motor must be connected to its own dedicated 30A circuit. The shaper should not share a circuit with any other machine, and the wires in the circuit should be rated for 30A. A standard 2-pole breaker is also necessary for use with the shaper.

We recommend using a NEMA-style L6-30 plug and outlet similar to that in **Figure 1**. You may also “hard-wire” the shaper directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

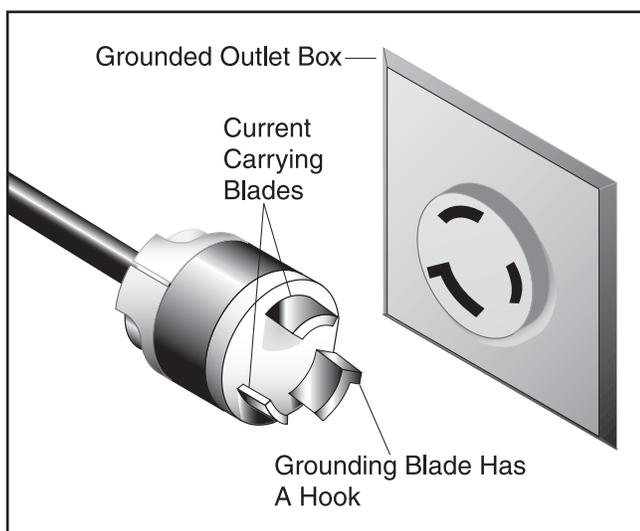


Figure 1. 220V Single-Phase



Grounding

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

Improper connections of the electrical-grounding conductor can result in the risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

	<p>⚠ WARNING</p> <p>This equipment must be grounded. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. Under no circumstances should the grounding pin from any three-pronged plug be removed. Serious injury may occur.</p>
--	--



Extension Cords

We do not recommend the use of extension cords on 220V equipment. Arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords. Should it be necessary to use an extension make sure the cord is rated Hard Service (grade S) or better. Refer to the chart in **Section 1: Safety** to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords when they become worn or damaged.



Wiring

A wiring diagram is provided at the back of this manual should it be necessary to repair or revise the wiring. Always utilize a qualified electrician when doing any electrical work on this equipment.

CAUTION

We have covered some basic electrical requirements for the safe operation of your machine. These requirements are not necessarily comprehensive. You must be sure that your particular electrical configuration complies with local and state codes. Ensure compliance by checking with your local municipality or a licensed electrician.



SECTION 3: GENERAL INFORMATION

Commentary

Grizzly Industrial, Inc. is proud to offer the Model G8621 Shaper. This shaper is part of Grizzly's growing family of fine woodworking and metal-working machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation.

The Model G8621 is intended for heavy-duty professional use. The Model G8621 Shaper features a 5 H.P. single-phase motor, offers 220V operation with magnetic power switching and full reversing capabilities. The Model G8621 also features a precision-ground cast iron table, hold-down springs, three interchangeable spindles and a sliding table. This shaper is capable of operating at four spindle speeds: 3600, 5100, 8000 and 10,000 R.P.M., giving you a versatile shaper with plenty of power.

A number of optional accessories for the Model G8621 are available. Please refer to the current Grizzly catalog for more information.

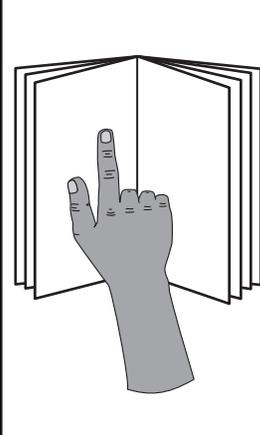
We are also pleased to provide this manual with the Model G8621. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any criticisms that you feel we should address in our next printing, please write to us at the address below:

Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

Most important, we stand behind our machines. We have an excellent service department at your disposal should the need arise. If you have any service questions or parts requests, please call or write to us at the location listed below.

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

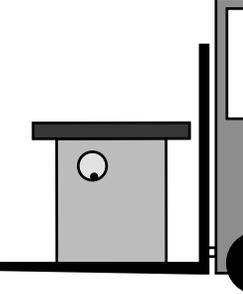
The specifications, drawings, and photographs illustrated in this manual represent the Model G8621 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.

	<p>!WARNING Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.</p>
--	--



Unpacking

The Model G8621 Shaper is shipped from the manufacturer in a carefully packed carton. If you discover the machine is damaged after you've signed for delivery, and the truck and driver are gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for possible inspection by the carrier or its agent. Without the packing materials, filing a freight claim can be difficult. *If you need assistance determining whether you need to file a freight claim, or with the procedure to file one, please contact our Customer Service.*



!WARNING

The G7209/10 is a heavy machine, 770 lbs. shipping weight. **DO NOT over-exert yourself while unpacking or moving your machine – you will need assistance and power equipment. Serious personal injury may occur if safe moving methods are not followed.**



!WARNING

If moving this machine up or down stairs, the machine must be dismantled and moved in smaller pieces. Make sure the stairs are capable of supporting the combined weight of the machine parts and the people moving them.

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or, for the sake of expediency, replacements can be obtained at your local hardware store.

After all the parts have been removed from the carton, you should have:

- Shaper Unit
- Miter Gauge Kit (**Figure 2**)
- Hardware (**Figure 3**)

The Miter Gauge Kit Hardware and Qty:

1.	Miter Gauge	1
2.	Fence	1
3.	Clamping Unit	1
4.	Support Fence	1
5.	Push Shaft	1
6.	Pointer	1
7.	Washer	1
8.	Bolts	2
9.	Threaded Knob	1
10.	Special Nuts	3
11.	Ratchet Handle	1

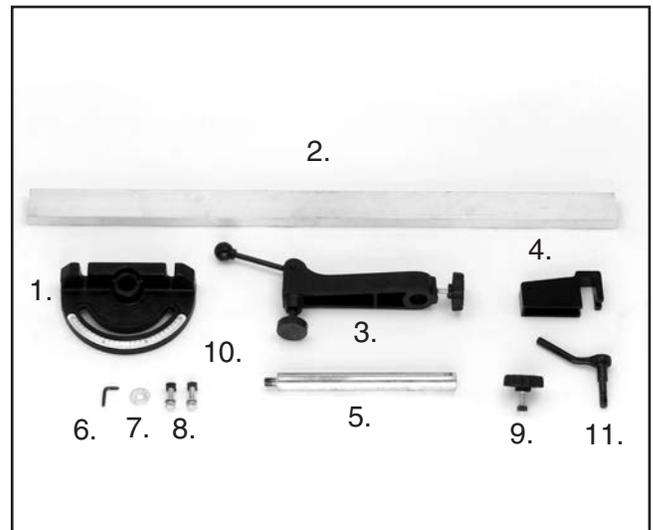


Figure 2. Miter Gauge Kit.

The Model G8621 Hardware and Qty:

3/4" Spindle	1
1" Spindle	1
1 1/4" Spindle	1
3/4" Spindle Nut	2
1" Spindle Nut	2
1 1/4" Spindle Nut	2
Spacer Set	22
Hold Downs	2
Hold Down Bars	2
Hold Down Brackets	2
Fence Pieces	2
Fence Mounts	2
Dust Port	1
Safety Guard	1
Multi Wrench 10, 19, 23, 26, 37mm	1
3mm Allen® Wrench	1
4mm Allen® Wrench	1
1 1/2" Box Wrench	1
1" Box Wrench	1
Stainless Wheel Handles	1
Round Knobs	4
Plastic Adjustment Wheels	2
4 7/8" Threaded Stud Knobs	2
4" Double Threaded-End Bars	2
Draw Bar w/Nut	1
Shaft Guide Bar w/Setscrew	2
Fence-Bracket Ratchet Handles	2
Adjustment Guide Bar	2
5/16" Lock Washers	6
5/16"-18 x 1 5/16" Flat Head Screws	6
5/16" Flat Washers	8
1/2" Flat Washers	4
5/16" Hex Nuts	6



Figure 3. Shaper hardware.

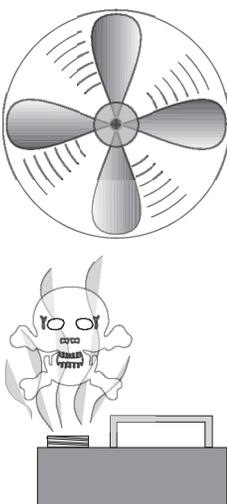


Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the usage instructions on the product you choose to clean.

	<p>! WARNING Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.</p>
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	<p>! WARNING Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.</p>
---	--

	<p>! CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.</p>
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Site Considerations

FLOOR LOAD

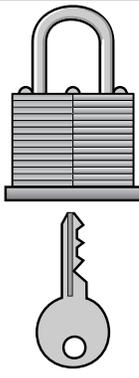
Your Model G8621 Shaper represents a moderately large weight load in a moderate sized footprint. Most commercial shop floors will be adequate for the 770 lb. weight of the Model G8621. Some floors may require additional support. Contact an architect or structural engineer if you have any question about the ability of your floor to handle the weight.

WORKING CLEARANCES

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

LIGHTING AND OUTLETS

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets, or circuits.

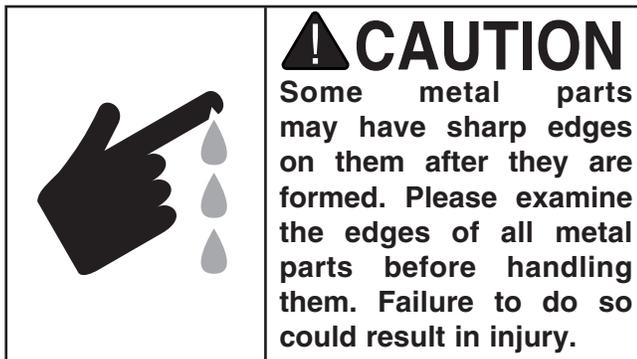
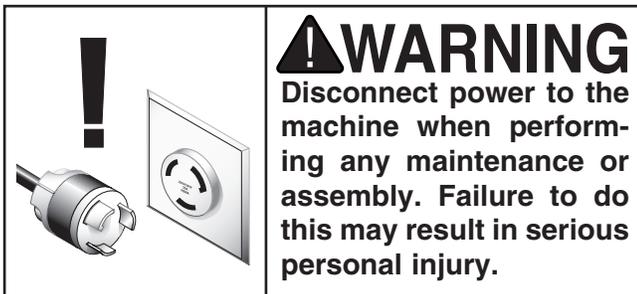
	<p>! CAUTION Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting, or operating equipment.</p>
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SECTION 4: ASSEMBLY

Beginning Assembly

Most of your Model G8621 Shaper has been assembled at the factory, but some parts must be assembled or installed after delivery. We have organized the assembly process into steps. Please follow along in the order presented here.



Handwheel

The handwheel, pre-installed at the factory, is made of cast iron. It is used to raise and lower the spindle to accommodate the height required by your cutter.

Thread the crank handle onto the handwheel.



Figure 4. Handwheel mounted to shaper.



Spindle

The Model G8621 comes with three interchangeable spindles like those in **Figure 5**. The spindles must be inserted correctly and remain stable in order to produce quality work. When installing and changing spindles, make sure the spindle seats snugly and that there is enough drawbar threaded into the bottom of the spindle to safely secure it in place. To install a spindle:

1. You should not have your machine connected to a power source at this time. If you do, **UNPLUG** it before you begin.



Figure 5. Spindles.

2. Thread the drawbar approximately 10-15 turns into the bottom of the spindle. The drawbar has two threaded ends. One of them will remain exposed.
3. Drop the spindle/drawbar into the spindle cartridge at the top of the table. Line up the keyway on the spindle with the locating pin at the top of the spindle cartridge. You will feel the spindle seat itself. See **Figure 6**.

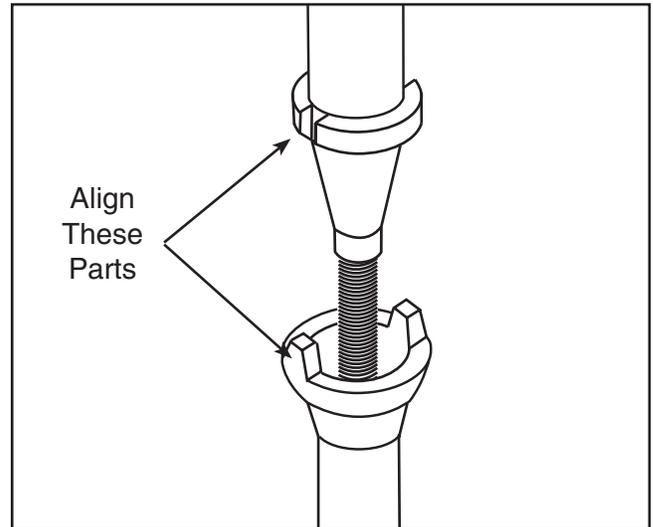


Figure 6. Installing spindle into the cartridge.

4. Thread the drawbar nut, tapered side up, onto the bottom of the drawbar, as illustrated in **Figure 7**.

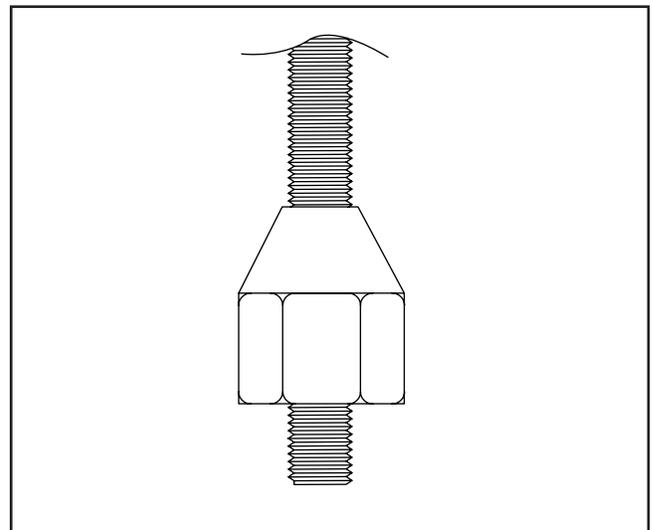


Figure 7. Drawbar nut on spindle.

5. Place the spindle wrench on top of the spindle, so it fits over the head of the spindle. Place a 15mm wrench on the drawbar nut.
6. Hold the spindle in place and tighten the drawbar nut. **DO NOT** use excessive force.



Handles

The guard adjuster is used to secure the guard to the table and to allow the guard to be loosened for adjustment. To assemble the guard adjuster:

1. Install the bar into the shaft guide as shown in **Figure 8**.
2. Line up the groove in the bar with the set-screw.



Figure 8. Slide bar into shaft guide.

3. Tighten the shaft setscrew into the groove to lock the bar in place as shown in **Figure 9**.



Figure 9. Tightening setscrew with hex key.

4. Install the round knobs shown in **Figure 10** onto both ends of the bar.



Figure 10. Thread round knobs onto bar.

The wheel shown in **Figure 11** fits on the adjustment shaft. This locks in place by tightening the setscrew into the groove on the shaft. There is a threaded hole on the wheel that allows for the optional installation of a crank (not included).

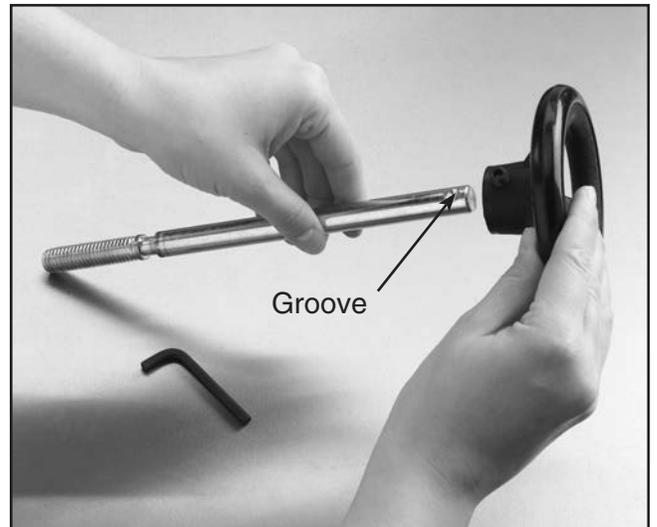


Figure 11. Install wheel onto adjustment guide.



Guard

To mount the cutter guard to the table:

1. Place the guard over the threaded holes on the table.
2. Insert the shaft guide into the guard as shown in **Figure 12**, and thread the shaft guide clockwise to secure the guard to the table.

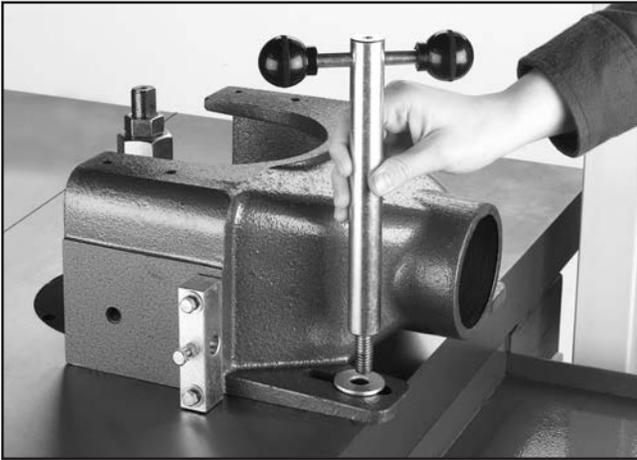


Figure 12. Inserting shaft guide into guard.

Insert the adjustment guide into the screw bracket. Line up the shaft groove shown in **Figure 11** with the center bolt and screw the bolt into the groove as shown in **Figure 13**. Do not completely tighten the bolt. This will allow the shaft to spin without coming out.



Figure 13. Tightening bolt into shaft groove.



Fence Assembly

To mount the fence brackets to the guard body:

1. Insert the adjustment shaft into the fence bracket as shown in **Figure 14**.

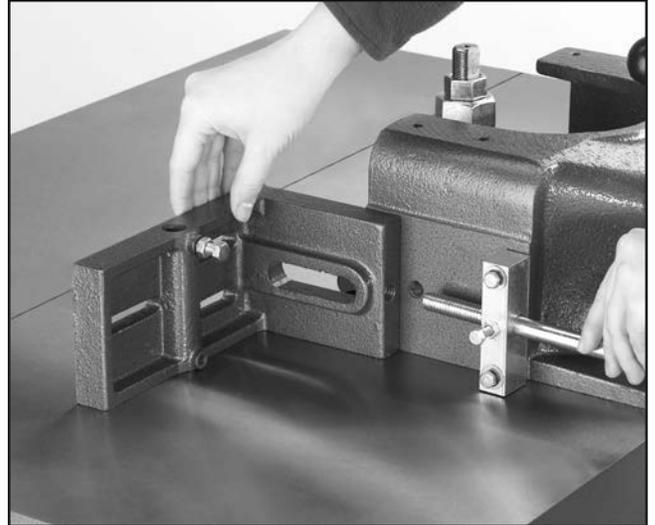


Figure 14. Adjustment guide to fence bracket.

2. Insert the adjustment handle (**Figure 15**) into the fence bracket, and thread it into the guard body.

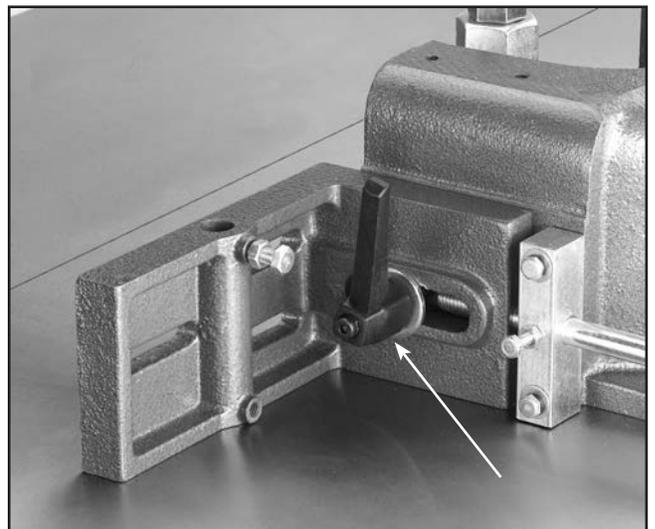


Figure 15. Adjustment handle.

To install the wood facing:

1. Secure the wooden fence pieces (as shown in **Figure 16**) with the $\frac{5}{16}$ "- 18 x 1" Phillips® head screws, washers, and hex nuts provided.
2. If using your own wood faces, make sure the countersunk holes in your fence material are deep enough to keep the entire screw head below the fence surface.

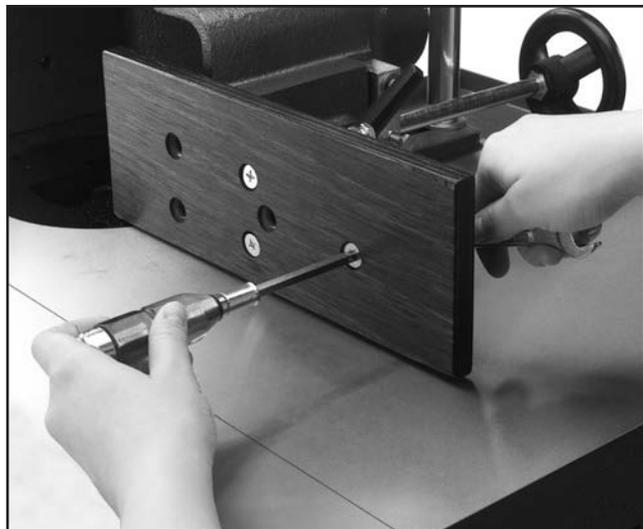


Figure 16. Attach wooden fence assembly.



Guard Cover

To mount the guard cover:

1. Place the guard cover over the threaded holes on top of the guard body as shown in **Figure 17**.
2. Thread the knobs into the guard body and secure the cover.



Figure 17. Guard cover.



Hold-Downs

Hold-downs are used to hold the workpiece flat and snug against table as shown in **Figure 18**. To assemble the hold-downs:

1. Slide a hold-down plate into each of the cast iron hold-down brackets.
2. Insert the bracket pole into the fence bracket and hold-down bracket.
3. Partially screw the handle into the hold-down brackets.
4. Position the hold-downs according to the size of your workpiece.
5. Tighten the handles to secure the hold-downs.

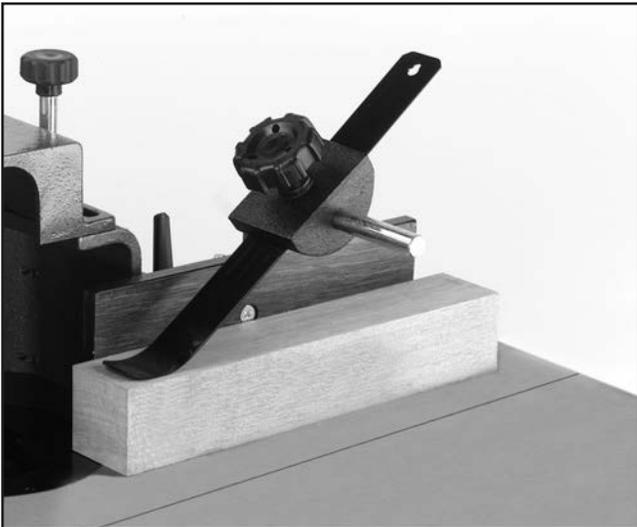


Figure 18. Hold-down on workpiece.



Miter Assembly

The miter gauge for the Model G8621 features a clamp and special fence. The miter gauge assembly can be mounted on either end of the table, depending on the type of desired cut or cutting direction. To mount the miter gauge and its fence:

1. Locate the threaded holes on either side of the table.
2. Install the push shaft as shown in **Figure 19**.



Figure 19. Installing the push shaft.

3. Now, slide the miter gauge down the push shaft as in **Figure 20**.



Figure 20. Installing the miter gauge.

G8621 Heavy-Duty Sliding Table Shaper

4. With the provided washer, thread the ratchet handle through the miter gauge and into the table as shown in **Figure 21**.



Figure 21. Installing the ratchet handle.

5. Insert the the miter gauge pointer shown in **Figure 22**, but do not tighten the nearby set-screw at this time.



Figure 22. Installing the pointer.

6. Place flat washers on the miter fence hex bolts, then start the special nuts onto the ends. Slide the special nuts into the groove of the fence. The end piece for the fence works with the same special nut and hex bolt system. When these have all been installed on the miter fence, it is time to install the fence onto the miter gauge as in **Figure 23**.



Figure 23. Installing the miter fence.

7. Slide the clamping unit onto the push shaft as shown in **Figure 24**.



Figure 24. Installing the clamping unit.



SECTION 5: ADJUSTMENTS



Pulleys & V-Belt

Improper pulley alignment sharply reduces the effectiveness of power transmission and belt life expectancy. To align the pulleys:

1. Remove the motor cover from the back of the shaper cabinet to expose the motor and pulleys.
2. Check the alignment with a straightedge. If the pulleys are in alignment, the straightedge should touch two sides of each pulley evenly as in **Figure 25**.
3. If the pulleys are parallel with each other, but not in-line, the motor needs to be adjusted.

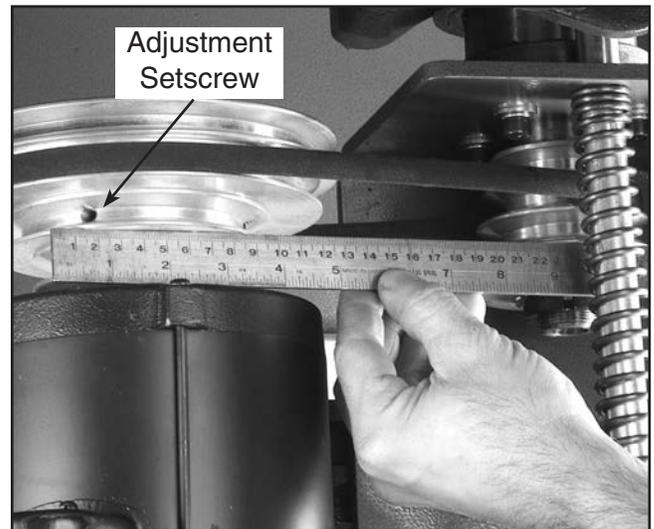


Figure 25. Inspecting pulley alignment.

4. This process is easiest with the help of another person. Loosen the four bolts that attach the motor to the motor base. One person should slide the motor either up or down while the other person measures the alignment of the motor pulley and the spindle pulley with a straightedge.
5. When the motor pulley and the spindle pulley alignment are correct, tighten the motor to the motor base.
6. Inspect your results. If satisfactory, double-check that the mounting bolts are tight.
7. You can also make small adjustments in the motor pulley alignment by raising or lowering it along the motor shaft. To do this, loosen the two setscrews (one is shown in **Figure 25**) which are in the lowest groove of the motor pulley and move the pulley into position. Tighten the setscrews when the alignment is satisfactory.



V-Belt Tension

You should be able to deflect the belt $\frac{1}{4}$ " with moderate finger pressure. This may seem tight compared to most other V-belts, but since the belt is small and runs fast, this amount of tension is necessary. The V-belt will slip if too loose, and will squeal or cause vibration if too tight. Adjust the tension if necessary. To adjust V-belt tension:

1. Make sure the pulleys are properly aligned.
2. Loosen the two motor mount plate bolts and slide the motor left or right to modify the belt tension. Keep the pulleys aligned.
3. Tighten the motor mount plate bolts, test the tension, and check the pulleys.
4. Repeat **steps 2-3** until tension is correct and the pulleys are aligned.



Speed Changes

The Model G8621 Shaper is equipped with a V-belt drive system that controls the speeds. To change spindle speeds:

1. Unplug the machine.
2. Loosen the two motor plate bolts, and slide the motor toward the spindle assembly. **DO NOT** take the bolts out.
3. Select the desired speed. There are four speeds: 3600 R.P.M., 5100 R.P.M., 8000 R.P.M., 10,000 R.P.M. **Figure 26** shows the belt positions for each available speed.

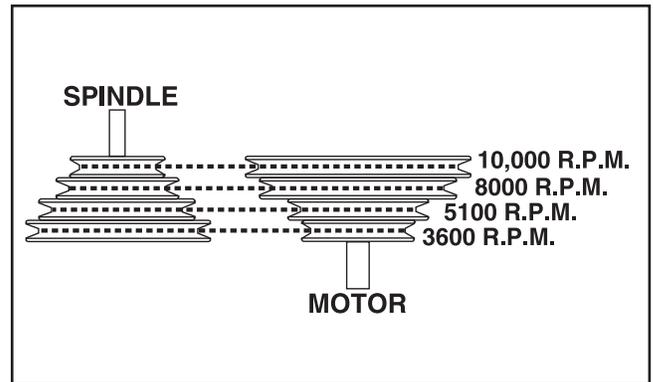


Figure 26. Spindle speed adjustment.

4. Align the belt along the appropriate pulley grooves.
5. Slide the motor back into position and tighten the belt. When the belt is properly tensioned, there should be approximately $\frac{1}{4}$ " of deflection in the center of the belt when you press it with moderate pressure.
6. Tighten all the adjusting bolts.
7. Spin the pulley to ensure proper tracking.



Fence Adjustment

The fence is a two-piece adjusting system. Each fence is independently adjustable to compensate for different cutting thicknesses and special shaping applications. Without any play, one turn of the knob moves the split fence approximately $\frac{5}{64}$ " (.078"). To adjust the fence:

1. Loosen the fence lock handle.
2. Turn the fence adjustment knob until the fence is set to the desired position.
3. Tighten the fence lock handle.

More detailed information concerning fence adjustments is covered in the "Straight Shaping" instructions.



Aligning The Fences

The following procedure ensures that the fence is parallel with itself and square with the table.

1. Check that the bolts through the wood facing are tight on each side and are adequately countersunk.
2. To align the wood facing, adjust one or both fence halves so they are in close alignment. Micro-adjust and check the alignment with a straightedge as shown in **Figure 27**.
3. If the wood fences are not parallel with each other, shim the incorrect side with electrical washers. Normal washers may work, but electrical washers allow for fine adjustments.

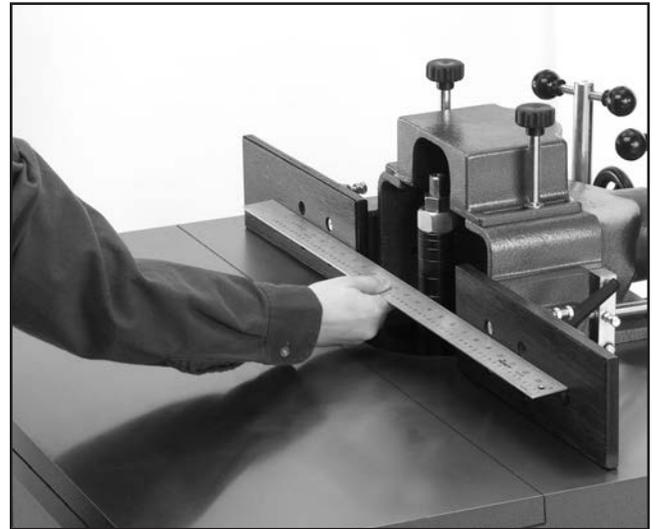


Figure 27. Aligning fences with straightedge.



Table Inserts

The Model G8621 is supplied with two inserts which provide three possible opening diameters in the shaper table surface. Use the smallest opening that a particular cutter will allow. This offers more support for the workpiece and reduces the amount of chips that can fall into the machine. The correct spindle opening also allows any unused portion of the cutter to remain below the table surface—increasing operator protection.

The cast iron table insert must be flush with the top of the table. To adjust the insert:

1. Remove the three Phillips® head screws that hold the cast iron insert in place.
2. By using a straightedge and a screwdriver, turn the barrel screws clockwise or counter-clockwise to level the cast iron insert with the table. **See Figure 28.**



Figure 28. Leveling table insert.

3. Inspect with the straightedge from both side-to-side and front-to-back to ensure the insert is flush with the table. Replace and secure the Phillips® head screws.



Setting Miter Gauge

It is necessary to square the miter gauge each time it is removed from the table. To do this:

1. Ensure that the fence halves are aligned and that the miter assembly is correctly assembled.
2. Place one end of a framing or try square flush with the infeed shaper fence.
3. Rotate the miter gauge so that it lines up flush with the other end of the square.
4. Set the miter gauge pointer to 0° and tighten the setscrew as shown in **Figure 29.**

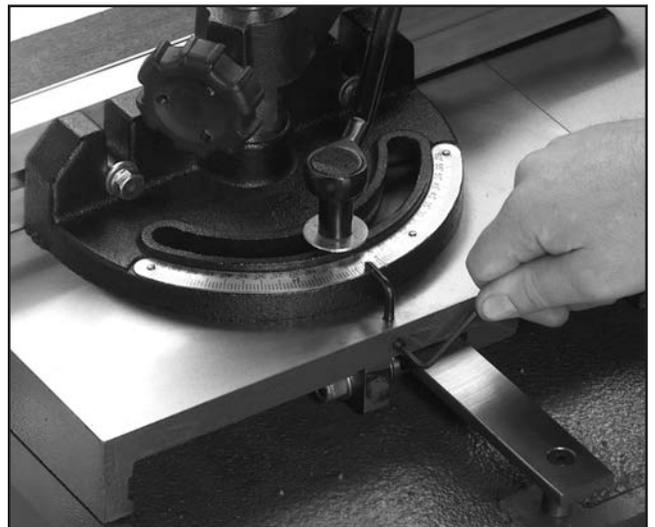


Figure 29. Setting the miter gauge pointer.

5. Keeping the square flush with the infeed fence and the miter fence, clamp it to the table, and slide the table across the shaper. The square should stay flush with both infeed and outfeed fences during this movement. If this is the case, proceed to the next section. If they do not stay flush or are not square to the miter fence, repeat **steps 1-4** until they are true.



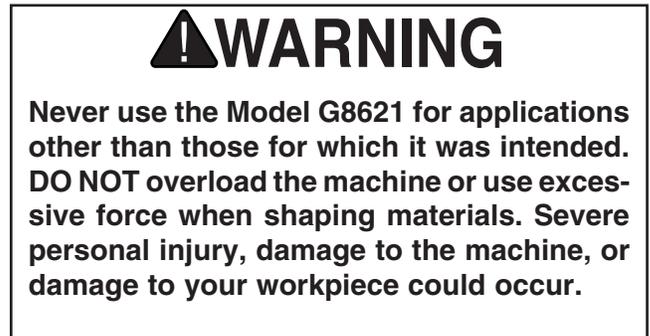
Test Run

Once assembly is complete and adjustments are done to your satisfaction, you are ready to start the machine.

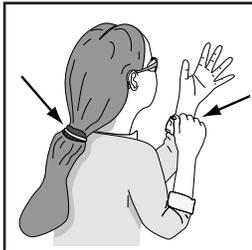
DO NOT have a cutter installed when you test run the shaper. Turn on the power supply at the main panel. Press the *ON* button. Make sure that your finger is poised on the *OFF* button, just in case there is a problem. The shaper should run smoothly with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further.

If the shaper seems to be running correctly, check the directional switch. The spindle should be rotating in a counterclockwise direction when the switch is in the *FWD* position. Run the Model G8621 for a short time to ensure that the moving parts are working properly with no excessive vibration. If any problem develops, correct it before attempting to use the machine.

If you cannot locate the source of unusual noises, immediately contact our service department for help.

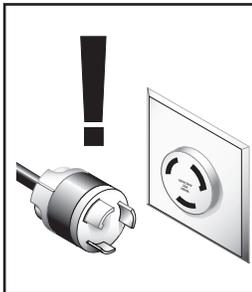


SECTION 6: OPERATIONS



!WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



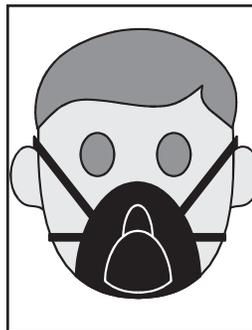
!WARNING

Disconnect power to the machine when performing any adjustments or maintenance. Failure to do this may result in serious personal injury.



!WARNING

Wear safety glasses during all operations on the shaper. Failure to comply may result in serious personal injury.



!CAUTION

Always wear a dust mask when operating the shaper. Using this machine produces sawdust which may cause allergic reactions or respiratory problems.

NOTICE

The following section was designed to give instructions on the basic operations of this shaper. However, it is in no way comprehensive of every shaper application. There are many different jigs that can be built to increase safety, accuracy, and types of cuts. **WE STRONGLY RECOMMEND** that you read books, trade magazines, or get formal training to maximize the potential of your shaper.

Rotation

Your shaper is equipped with a FORWARD/REVERSE switch as shown in **Figure 30**. In many instances, you will need to flip the cutter over and reverse cutter rotation. Whenever possible, mount the cutter so the board is milled on the bottom side. This method does a better job and is safer for the operator.

!CAUTION

Always check the direction of cutter rotation before beginning any shaping operation, and always feed the work against the direction of the cutter rotation.



Figure 30. FORWARD/REVERSE switch.

NOTICE

This machine was designed to be started and stopped with the **ON/OFF** buttons—not the reversing switch.



Cutter Installation

Your shaper operates at speeds of 3600, 5100, 8000 and 10,000 R.P.M. 3½" or larger cutters must be operated at the slowest speed.

Always use the largest spindle size possible, and never use more than one bushing size to gain two spindle sizes. "Stacking" two cutter bushings to decrease the inside diameter of the cutter will cause the cutter to perform incorrectly when placed under a load.

1. Unplug the shaper.
2. Place an appropriate spacer or collar at the base of the spindle for support. Place the cutter on the spindle, making sure the rotation is correct for your application.
3. Use spacers or collars to suit your particular application, then place the spindle washer under the nut. Screw on the nut and lock-nut.
4. Tighten the nuts while holding the spindle stationary. Use a wrench on the notches at the top of the spindle for leverage as shown in **Figure 31**.



Figure 31. Tightening spindle nuts.

! WARNING

Always use a spindle lock nut during operation. If this warning is ignored, the cutter may fly off the spindle during use and cause severe personal injury.



Table Lock

The sliding table works with the clamping miter gauge to allow you to secure your workpiece to the table and make the cut by sliding the table. This feature greatly increases operator safety because it keeps hands away from the cutterhead.

When the sliding operation is not desired, the table lock shown in **Figure 32** will make the table stationary. Simply pull the knurled shaft and twist it so the cross pins slide into the largest slots in the housing. If you want to unlock the table, pull the shaft, twist it, and place the cross pins in the smallest slot.

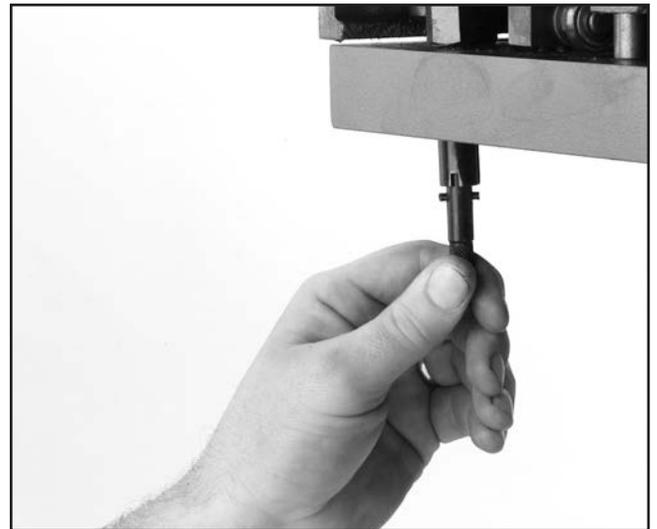


Figure 32. Table lock.

! CAUTION

The sliding table makes it easy to feed the work into the cutter at a faster rate than would normally be used. Always feed the work slow and steady to avoid kickback and to achieve smooth results with your work. Although the miter assembly does aid in safety, common sense should always be used during every shaping operation.

Spindle Height

To adjust the cutter height:

1. Loosen the spindle lock shown in **Figure 33**.
2. Move the spindle up or down with the handwheel until the desired position is obtained.
3. Lock the spindle into position.

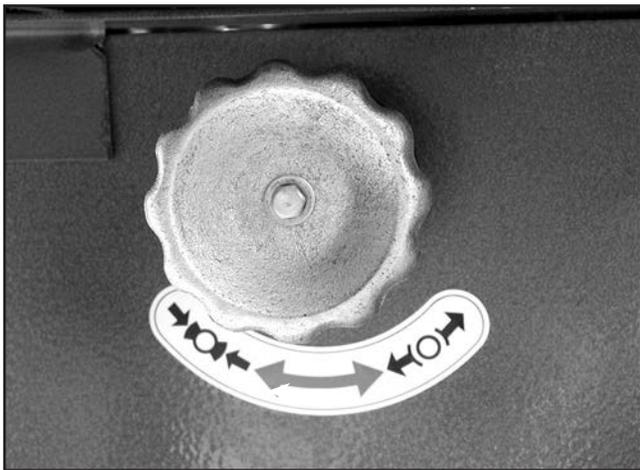


Figure 33. Location of spindle lock.

NOTICE

The lock knob keeps the spindle in a fixed position during shaper operation. Do not over-tighten the lock knob. A snug fit is all that is needed to keep the spindle from moving during shaper operation.

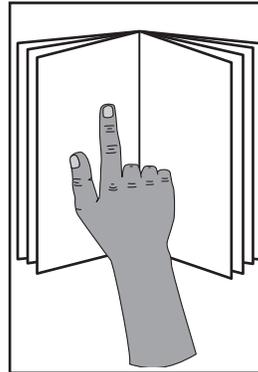


! WARNING

Disconnect power to the machine when performing any adjustments or maintenance. Failure to do this may result in serious personal injury.



Straight Shaping



! WARNING

Read the entire manual before making any cuts with your shaper. Serious personal injury may result if safety or operational information is not understood or followed.

The fence assembly is a two-piece, independently adjustable system. When removing material from the whole face of your workpiece, the outfeed fence can be adjusted to provide support for the workpiece as it passes over the cutter. The outfeed fence can also be set in-line for partial face removal.

If removing material from the whole face, observe the following steps:

1. Loosen the locking handles shown in **Figure 34** that hold the fences in place.

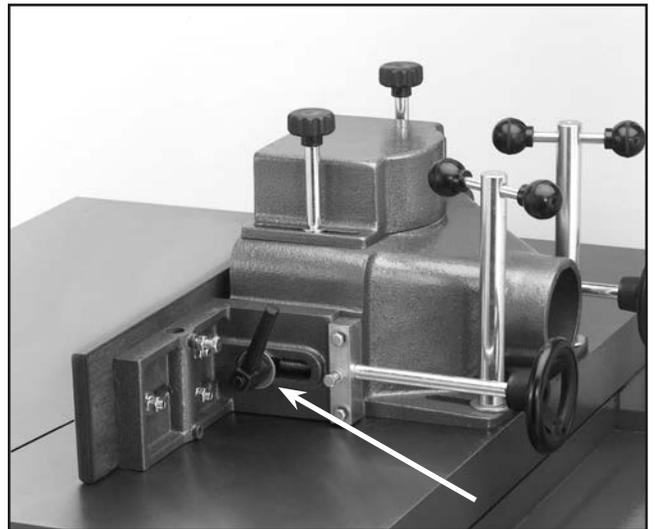


Figure 34. Location of fence locking handles.

2. Adjust the infeed fence by turning the adjustment knobs until the workpiece contacts the cutter in the desired location.
3. Lock the infeed fence in position with the locking handle. Use a test piece to determine the best setting.

- Loosen the mounting screws on the fence faces and set the face ends to barely clear the cutter. This allows the maximum support possible for the workpiece while passing the cutter. Remember to tighten the wood facing before starting the shaper.
- A test sample of the desired cut should be advanced about 8" then stopped.
- Once the shaper is turned off and the cutter has come to a complete stop, adjust the outfeed fence to support the new profiled edge. **See Figure 35.**

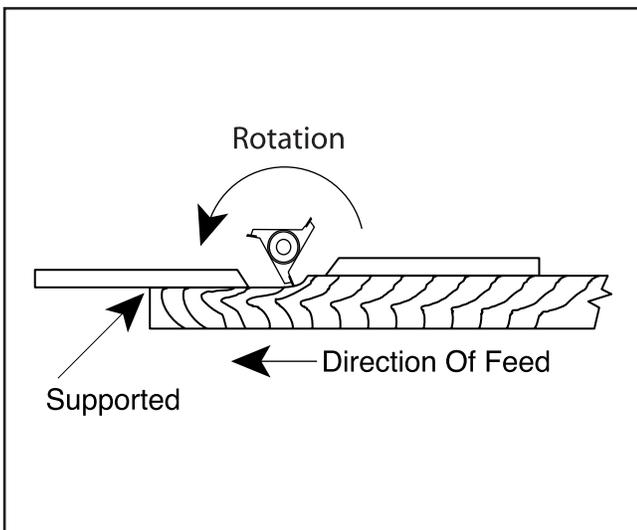


Figure 35. Fence adjusted to support workpiece.

If the face of the workpiece will only be partially removed, observe the following steps:

- Adjust the infeed fence to approximately the desired depth of cut. Lock the infeed fence in place.
- Use a straightedge to adjust the outfeed fence to the same plane as the infeed. Lock the outfeed fence in place.
- Set the right and left wood face ends so they barely clear the cutter. This allows the maximum support possible for the workpiece while passing the cutter. Remember to tighten down the wood facing before starting the shaper.

- Run a test piece through the shaper as shown in **Figure 36.**

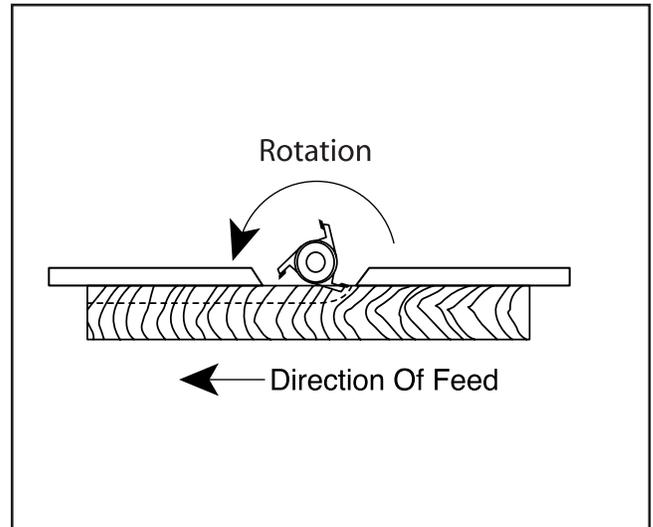


Figure 36. Fence adjustment for blind cuts.

- Always cut the end grain first when putting an edge around the perimeter of your workpiece. **See Figure 37.**

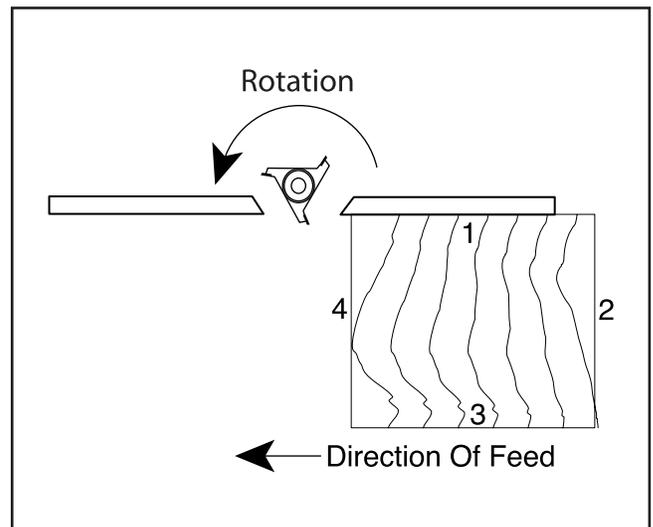


Figure 37. Sequence for multiple cuts.



Rub Collars

Rub collars are used when shaping curved or irregular workpieces, such as arched doors or round table tops. Rub collars also limit the depth of your cut.

There are two types of rub collars—solid and ball-bearing. We recommend against the use of solid rub collars. Grizzly carries an extensive line of ball bearing rub collars designed for use with Grizzly shapers. See the current catalog for listings.

Rub collars may be used in any of the following positions:

1. **Rub collar below the cutter:** When the rub collar is used below the cutter as shown in **Figure 38**, the progress of the cut can be observed. However, any unintentional movement may lift the workpiece into the cutter, damaging your work and creating a dangerous situation that may result in kickback. We do not recommend using the rub collar below the cutter.

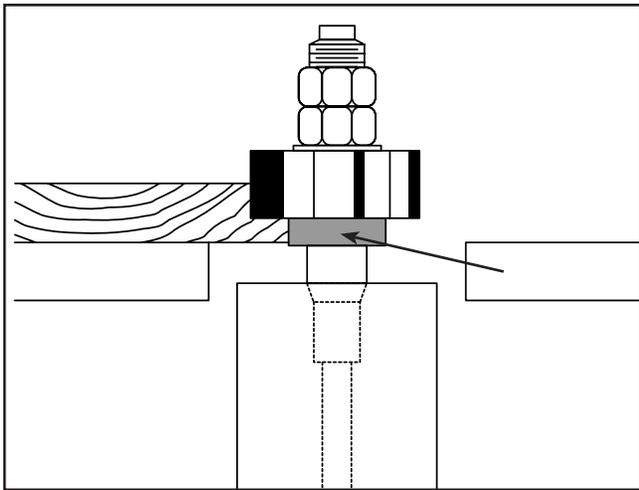


Figure 38. Rub collar installed below cutter.

CAUTION

Whenever the cutterhead is above the workpiece, or you can see it spinning during use, you must take extreme caution to keep your hands away from the cutterhead. Failure to do so may cause serious personal injury.

2. **Above the cutter:** When the rub collar is used above the cutter as seen in **Figure 39**, the cut cannot be seen. This offers some advantage: the stock is not affected by slight variations in thickness and accidental lifting will not damage the workpiece. If lifting occurs, simply correct the mistake by repeating the operation.

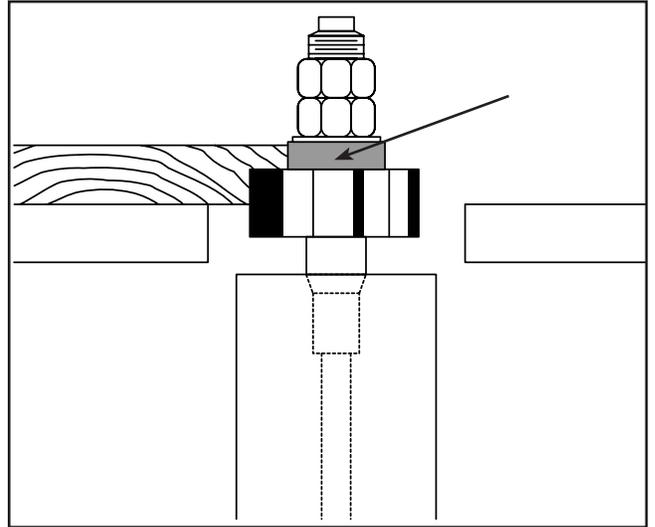


Figure 39. Rub collar installed above cutter.

3. **Between two cutters:** Using a rub collar between two cutters, as in **Figure 40**, has the distinct advantage of performing two cuts at once or eliminating the need to change cutters for two different operations. Notice that part of the edge is left uncut. The uncut portion rides on the rub collar.

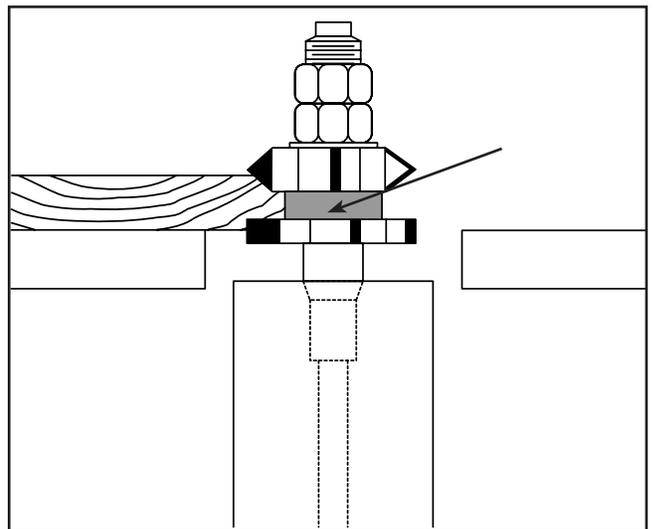


Figure 40. Rub collar between two cutters.



Pattern Work

When using a pattern, the rub collar can be positioned either above, below or between cutters.

The pattern is usually used when the entire edge is to be shaped or when many duplicate pieces are needed. Pattern work is particularly useful when rough cutting irregular or oversize pieces and then shaping the edge in a simple two-step operation. A pattern can be incorporated into a jig by way of adding toggle clamps, hand holds or other safety devices.

You have greater flexibility when choosing the correct diameter rub collar for pattern work than for non-pattern work. If you look at **Figure 41**, you will notice that the position of the pattern determines the depth of cut. In other words, your pattern size is dependent upon the interrelationship of the cutting circle, the desired amount of material removed, and the rub collar size. Changing one or more of these will change the amount of material removed. Planning ahead, you can most effectively decide which rub collars are best suited for your application.

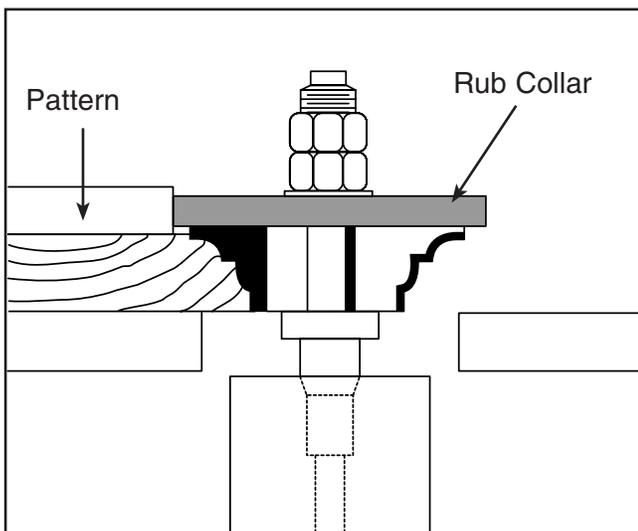


Figure 41. Rub collar determines depth of cut.

When making a pattern jig here are a few things to consider:

1. Build your jig from a material that will smoothly follow the rub collar or fence.

2. Make the jig stable, using proven methods and materials, and fasten the hand holds for operator comfort and safety.
3. Secure your workpiece on the three sides that will not be cut with toggle clamps, or fasten the workpiece to the jig with wood screws.
4. Ensure that clamps and hidden screws do not come into contact with the cutter.
5. Design your jig so that all cutting occurs underneath the workpiece as shown in **Figure 42**. Notice the operator is not exposed to the cutting edge of the cutter!
6. Always consider the cutting circle and rub collar diameter for the correct cutting depth when designing your pattern.
7. Make sure the workpiece rests flat on the table, not on the fixture.

CAUTION

Workpieces must be solid, stable, and secured to the jig; or kickback may occur, causing personal injury.



Figure 42. Pattern jig for making curved pieces.

Irregular or freehand shaping takes a high degree of skill and dexterity. The fence assembly is not used during irregular shaping, so rub collars must be used. Also, unless your jig is designed to touch the rub collar before contacting the blade, a starting fixture must be used to begin your cut.

About starting fixtures:

The purpose of the starting fixture is to support the workpiece during the beginning of the cut. The workpiece is typically placed in the starting position using the starting fixture for support. Then swung into the cutter while holding the workpiece firmly against the starting fixture. After the cut has been started, the work is swung away from the starting fixture and is supported only by the rub collar. **Always feed against the rotation of the cutter and do not start cuts at corners.**

To use your pattern jig:

1. Remove the fence assembly. Choose the appropriate cutter and rub collar for your application and lock them in place. Secure your workpiece to the pattern jig.
2. Check cutter rotation, and adjust the spindle height to align the cutter to your workpiece. Clamp a starting fixture to the table surface, using the location that best supports your work.
3. If everything is correct and the cutter is tight. Turn the shaper on.
4. Place your jig/workpiece against the starting fixture. Using firm pressure, pivot the workpiece into the cutter and make sure the jig is touching the rub collar. Keep your jig in contact with the rub collar and slowly follow the pattern, moving against the cutter rotation.



Freehand Shaping

Freehand methods are one of the most dangerous operations performed on a shaper. Although this machine is capable of performing freehand operations, we do not recommend that you attempt to do so. If you **MUST** perform freehand operations, get formal training and read a book that details freehand operations, their inherent dangers, and ways to avoid those dangers!



Miter Assembly

When the workpiece is clamped to the table using the miter assembly, crosscuts can be made with a much greater degree of safety. The miter gauge can be adjusted to 60° in both directions. **Figure 43** shows the miter gauge set to 0° and **Figure 44** shows it at 45°. To adjust the miter fence:

1. Loosen the miter gauge with the adjustment handle.
2. Assuming that you have performed the steps in the “Setting Miter Gauge” instructions, turn the miter gauge in the desired direction so the pointer indicates the angle, and tighten the miter gauge with the adjustment handle.

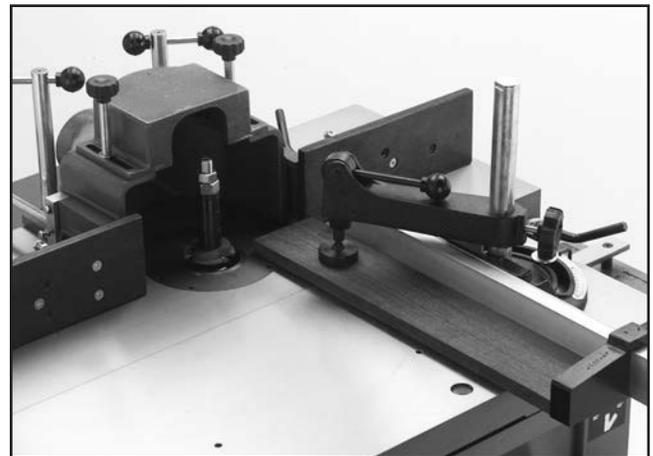


Figure 43. Miter gauge set to 0°
(fences opened for clarity).

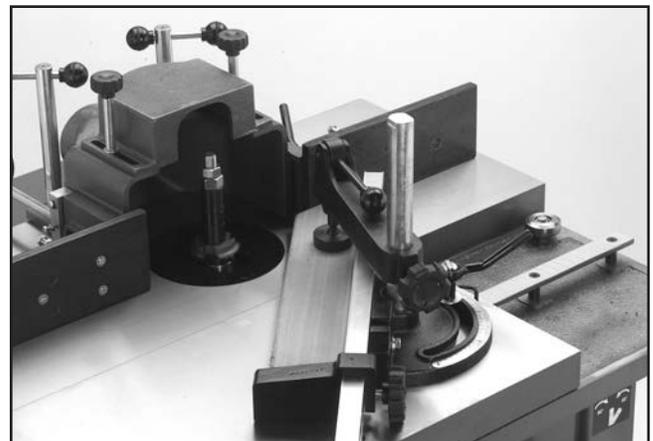


Figure 44. Miter gauge set to 45°
(fences opened for clarity).

Shaper Accessories

The **miter fence** can be adjusted by loosening the two bolts that hold it to the miter gauge and then sliding it in the desired direction.

The **support fence** slides up and down the miter fence and can be locked to hold the back of the workpiece in place.

The **miter clamp** holds the workpiece firm against the table and keeps it in position against all of the associated fences.

To use the miter assembly:

1. Determine the angle of cut and set the miter gauge to that angle, without tightening it yet. (The angle of the miter gauge should be determined by the angle of the workpiece you are about to shape.) Lock the miter gauge in place.
2. Move the infeed and outfeed fences out of the way. Hold the workpiece flush against the miter fence and slide the workpiece and table toward the cutter. Line the workpiece up with the cutter.
3. Slide the support fence to the back of the workpiece and lock in place.
4. Clamp the workpiece to the table with the miter clamp as shown in **Figure 45**.
5. The workpiece is now ready for the cut.



Figure 45. Locking down the miter clamp.

There are many accessories that can be built or purchased to increase the safety of the operator. Many experienced shaper users regularly use proven shop-made fences and safety guards to augment their shaping operations. In addition, many production shops routinely use power feeders with their shapers to streamline their operations.

Here are some basic accessories and their uses:

- **Zero Clearance Fence** — A shop-made fence with an opening only as large as the cutter, so that only the part of the cutter being used is exposed.
- **Box Fence** — A shop-made box that completely surrounds the cutter. A one-piece fence is attached that allows only the thickness of the board to pass underneath, thereby completely shielding the operator from exposure to the spinning cutter. A clear plexiglass window on top of the box allows the operator to view the workpiece during cutting.
- **Power Feeder** — A motorized unit that can be clamped or permanently mounted to the table of a shaper. A power feeder pulls the workpiece through the cut, reducing the risk of operator contact with the spinning cutter and reducing any injuries due to kickback. Because of the steady feed rate, power feeders can also produce cleaner, more consistent cuts. Check the current Grizzly catalog for available power feeders.

Because of the wide range of fences and guards that can be built in the shop, explaining their construction is beyond the scope of this manual. We strongly recommend that you read shaper books, trade magazines, or get formal training to learn more about these.



SECTION 7: MAINTENANCE



General

Regular periodic maintenance on your Model G8621 Shaper ensures its optimum performance. Make a habit of inspecting your shaper each time you use it.

Check for the following conditions and repair or replace when necessary.

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



Table

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



Lubrication

The only parts on this machine that require periodic lubrication are the ways where the cartridge slide rides on the elevation housing and where the worm gear and bushing are located. Use a light grease or anti-seizing compound on the ways and worm gear, and give the shaft mount a shot of light oil.



V-Belt

Avoid getting grease or oil on the V-belt or pulleys. Check the V-belt, as part of a monthly inspection for proper tension and belt condition. Cracking and glazing could result in belt failure. Replace the belt if such conditions appear.



Schedule

Regularly blow out air vents with compressed air and keep the exhaust port clear. Always wear a dust mask during this operation.

For every **1 hour** of use, clean and wipe down with Boeshield™ T-9:

- Table and miter gauge slide
- Fence faces

For every **5 hours** of use, clean and oil:

- Spindle column and cartridge
- Offset adjustment mechanisms on fence
- All worm drive and other gears

Once a year, replace the V-belt.

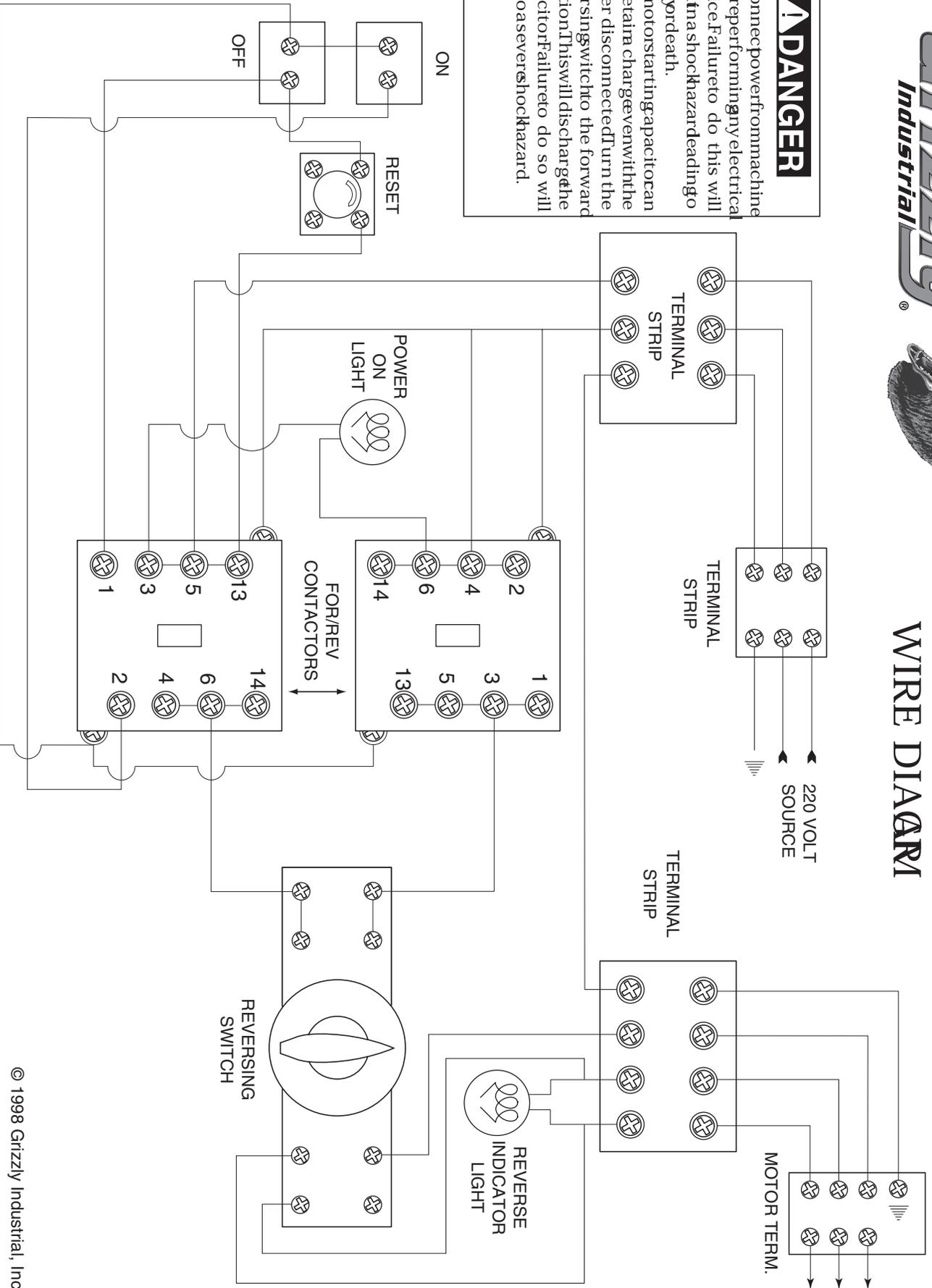




G8621 SHAPER WIRE DIAGRAM

DANGER

Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury or death. The motor starting capacitor can still retain a charge even with the power disconnected. Turn the Reversing switch to the forward position. This will discharge the capacitor. Failure to do so will lead to a severe shock hazard.



G8621 Heavy-Duty Sliding Table Shaper

SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your Model G8621 Shaper.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the **General Information** section. The specifications, drawings, and photographs illustrated in this manual represent the Model G8621 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered as they apply to your specific situation.

WARNING

Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).



G8621 Heavy-Duty Sliding Table Shaper

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

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines and your local library are good places to start.

WARNING

The Model G8621 was specifically designed for wood shaping operations only. **DO NOT MODIFY AND/OR USE THIS MACHINE FOR ANY OTHER PURPOSE.** Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, **DO NOT** use it until all your questions have been answered, or serious personal injury may occur.

WARNING

Like all power tools, there is danger associated with the Model G8621 Shaper. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.





MACHINE DATA SHEET

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

GRIZZLY MODEL G8621 HEAVY-DUTY SLIDING TABLE SHAPER

Design Type Floor Model

Overall Dimensions:

Fixed Table 35½" x 14⁷/₈"
 Sliding Table 35½" x 13¼"
 Height (Includes Fence) 45½"
 Height from Table To Floor 34³/₄"
 Length 34³/₄"
 Width 35½"
 Width w/ table extended 56½"
 Table Fence Length 39½"
 Crate Size 39" L x 31" W x 44" H
 Footprint 25½" x 26³/₄"
 Shipping Weight 720 lbs.

Capacities:

Spindle Sizes ¾", 1", 1¼"
 Spindle Lengths 6" - 7"
 Spindle Capacity Under Nut 4¼", 4⁵/₈", 5¹/₈"
 Spindle Travel 3¼"
 Dust Port 4"
 Table Counter-bore 7" x 5⁵/₈"
 Max. Cutter Diameter 5⁷/₈"
 Spindle Speeds 3600, 5100, 8000, 10000 R.P.M.
 Sliding Table Travel 21⁷/₈"

Construction:

Table Ground Cast Iron
 Fence Assembly Cast Iron / Wood; Independently Micro Adjustable
 Miter Fence Extruded Aluminum
 Body Assembly Cast Iron
 Cabinet Formed Steel

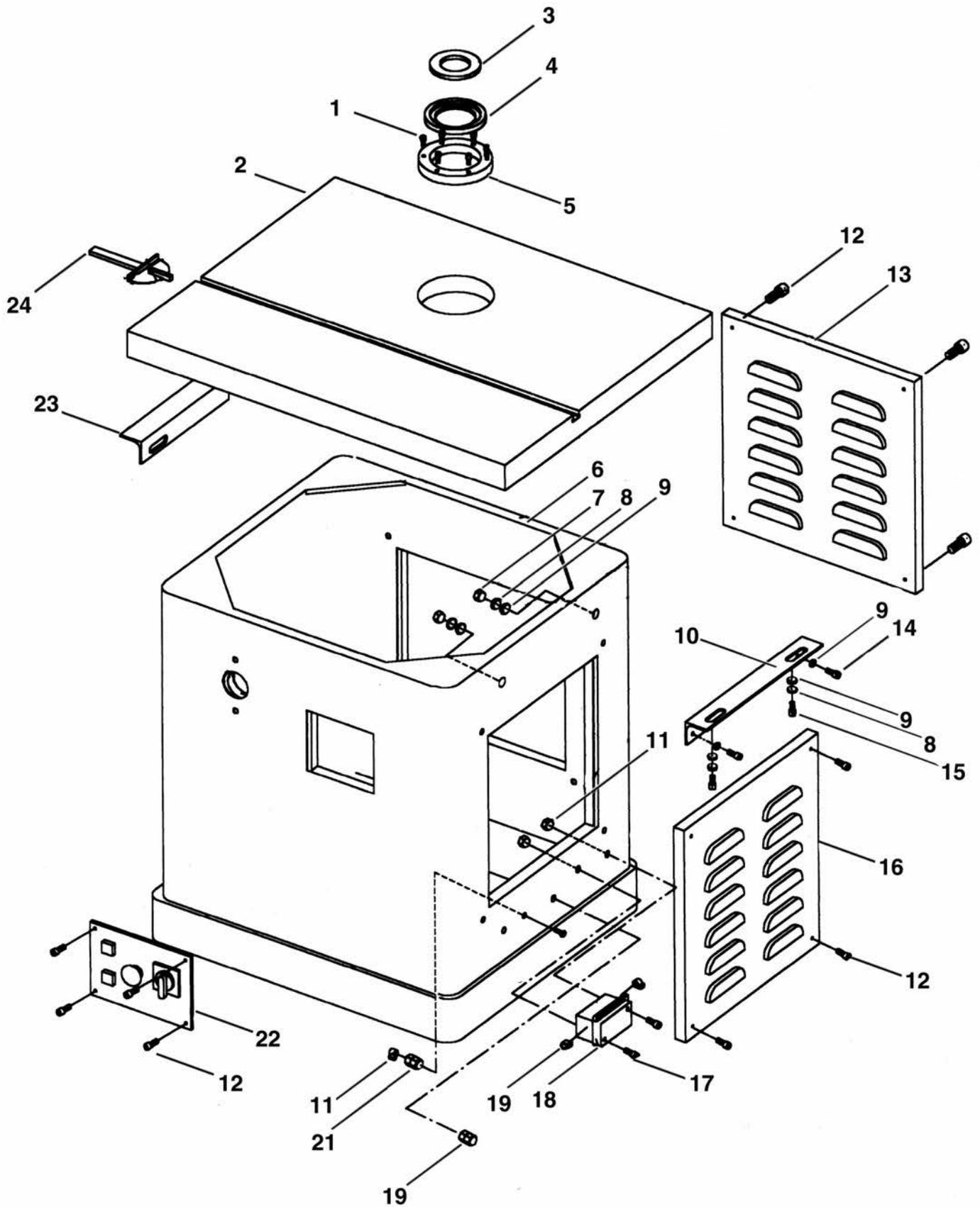
Motor:

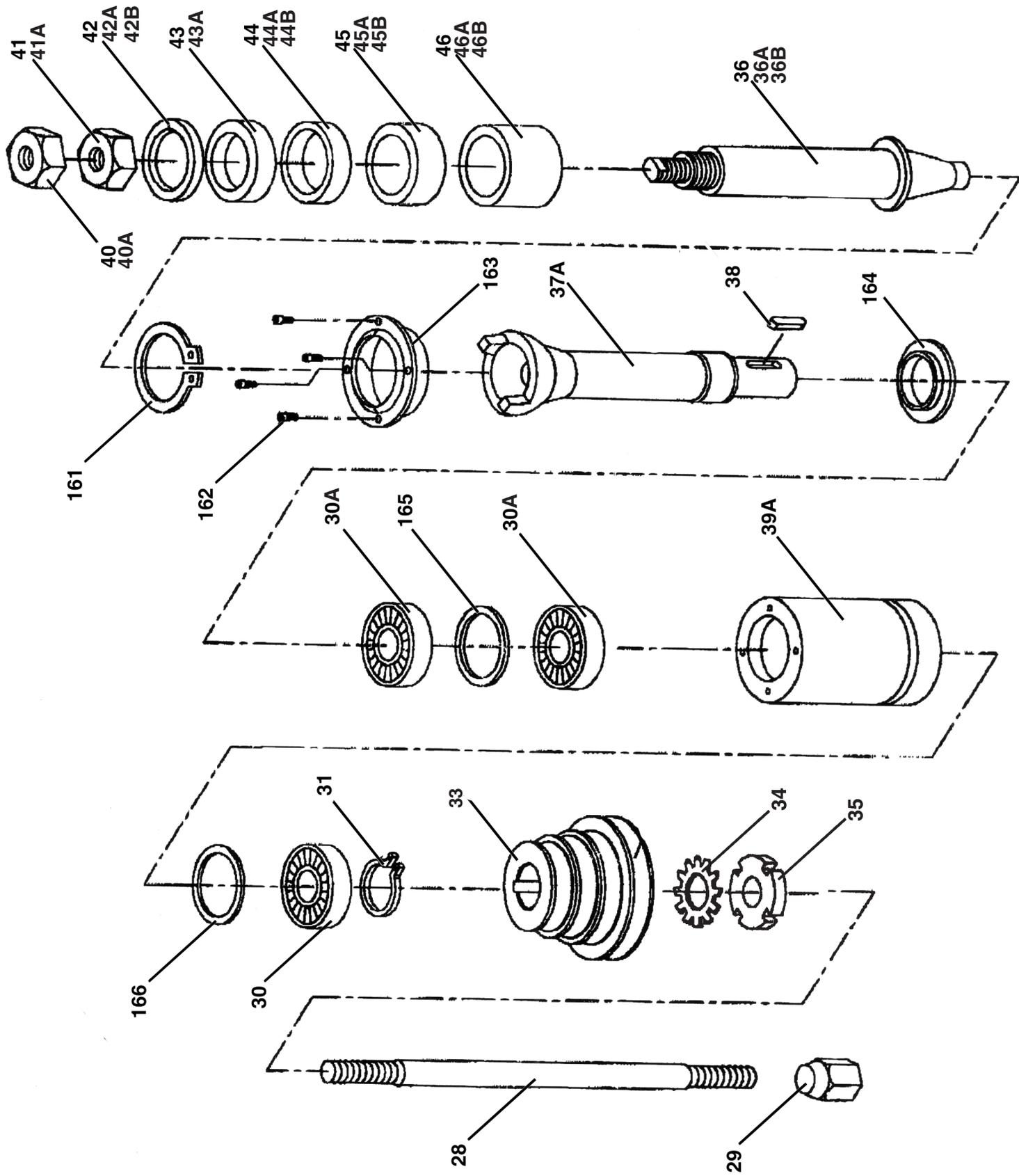
Type TEFC Capacitor-Start Induction
 Horsepower 5 H.P.
 Phase / Voltage Single Phase / 220 V
 Switch Push Button ON/OFF, Emergency Stop; Lever for Forward / Reverse
 Amps 25 A
 Cycle / R.P.M. 60 Hertz / 3450 R.P.M.
 Bearings Shielded & Lubricated Ball Bearings

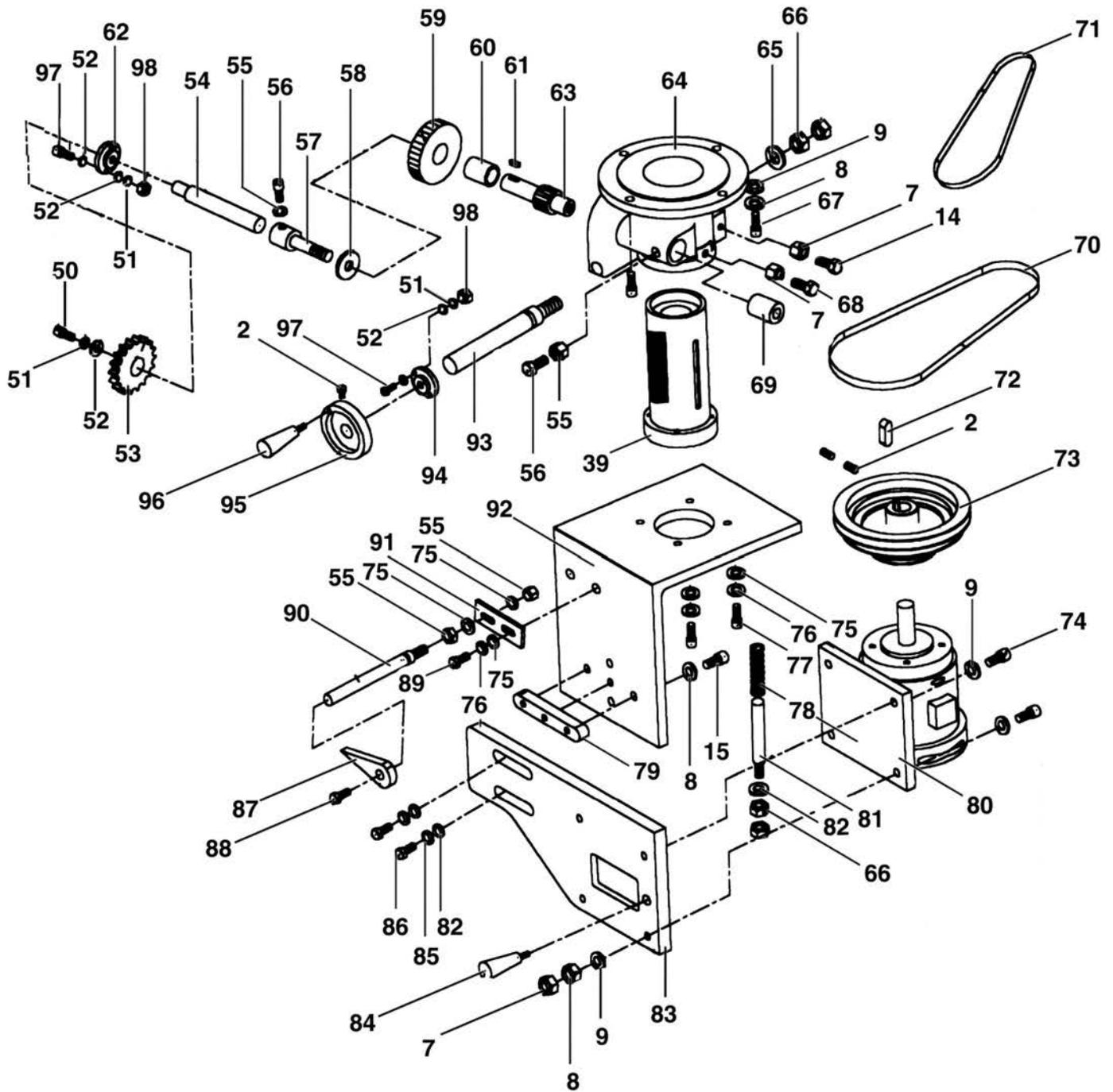
Features:

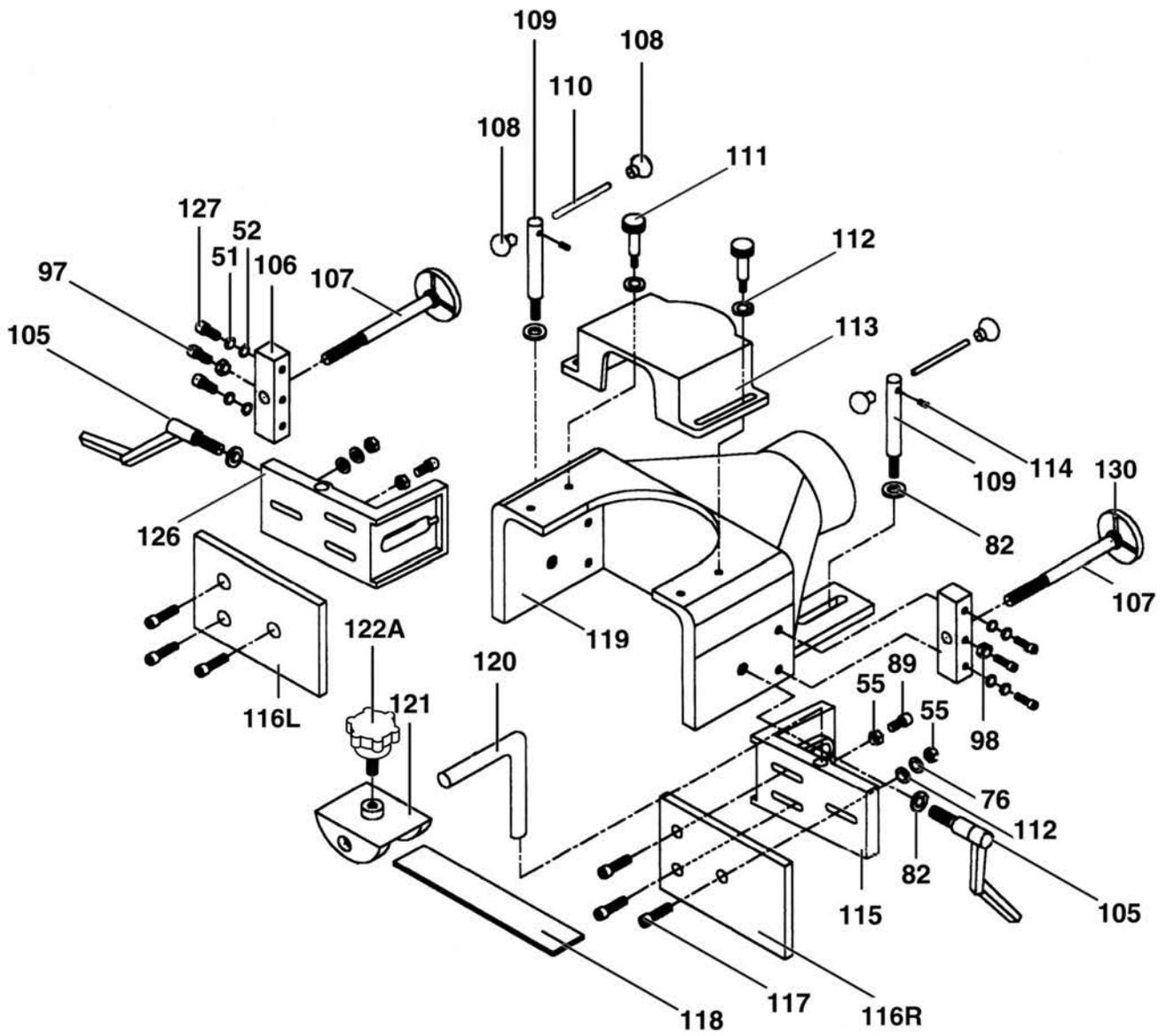
..... Lever Actuated Stock Hold-down
 Miter Angle Adjustable 60° Left to 60° Right
 Miter fence adjustable stop block
 4 Spring Steel Hold-down Assemblies
 Fence adjustments include built-in ratchets and knob-equipped adjusters
 3 Table Inserts
 Spindles include spacers and nuts
 Spindle height scale in inches and mm
 Sliding table rides on eight shielded and lubricated ball bearings

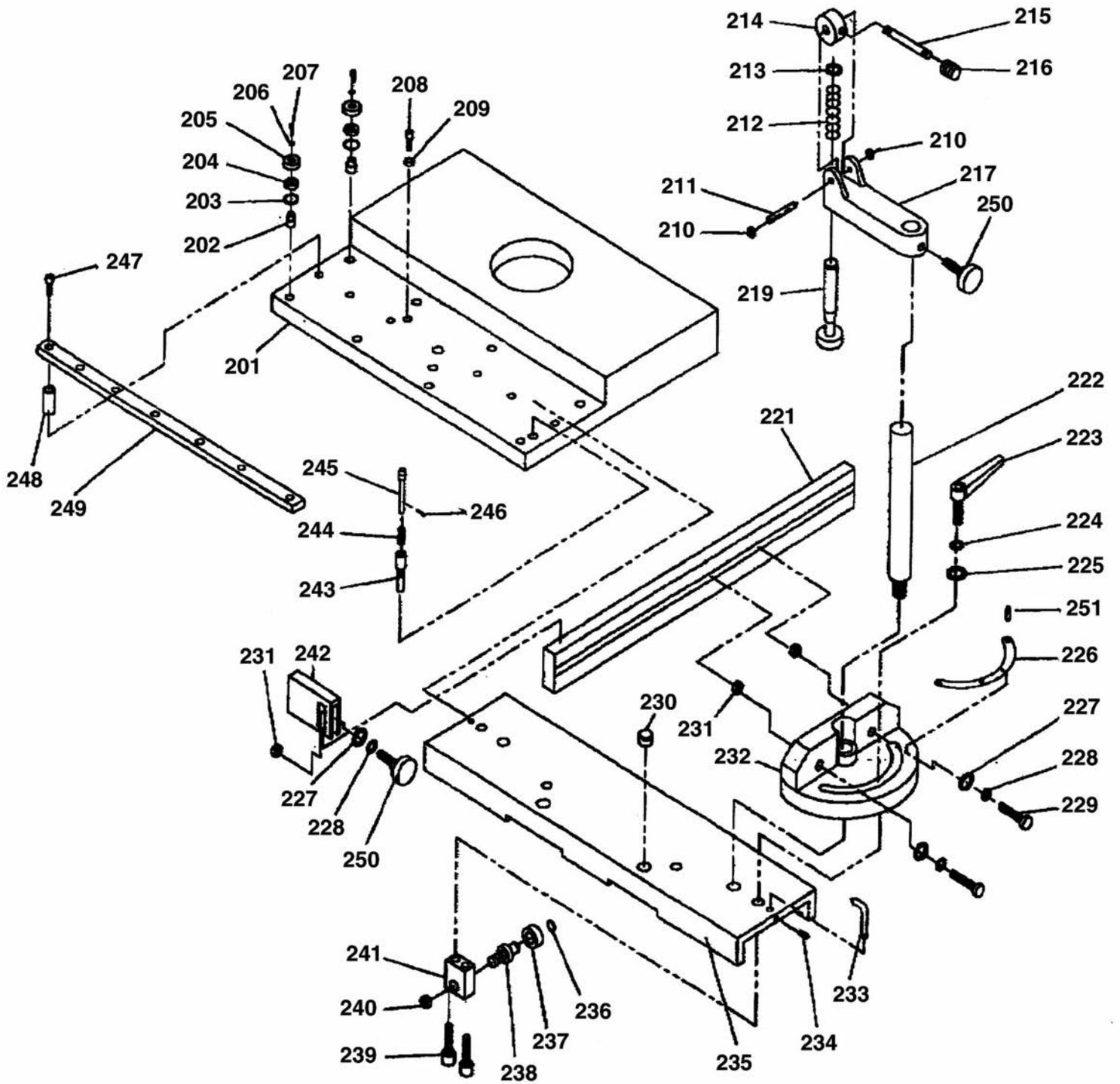
Specifications, while deemed accurate, are not guaranteed.











REF	PART #	DESCRIPTION
1	P8621001	SET SCREW 5/16-24 X 5/8
3	P8621003	INSERT (SMALL) INNER
4	P8621004	INSERT (SMALL) INNER
5	P8621005	INSERT (BIG)
6	P8621006	STAND ASSY
7	P8621007	HEX NUT 3/8"-16
8	P8621008	LOCK WASHER 3/8
9	P8621009	FLAT WASHER 3/8
10	P8621010	TABLE BRACE (R)
11	P8621011	HEX NUT 10-24
12	P8621012	PHLP HD SCR 1/4-20 x 5/8
13	P8621013	REMOVABLE DUST DOOR
14	P8621014	HEX BOLT 3/8-16 X 1-1/4
15	P8621015	HEX BOLT 3/8-16 X 3/4
16	P8621016	MOTOR COVER
17	P8621017	PHLP HD SCR 10-24 X 3/4
18	P8621018	TERMINAL BOX ASSY
19	P8621019	STRAIN RELIEF
21	P8621021	STRAIN RELIEF
22	P8621022	ELECTRICAL BOX ASSY V1.06.98
22A-1	P8621022A-1	CONTACTOR NS-1/06 N.H.D.
22A-2	P8621022A-2	OVERLOAD RELAY NS-1/06 N.H.D.
22B	P8621022B	RED OFF SWITCH (SQUARE) V1.08.03
22C	P8621022C	EMERGENCY SAFETY SWITCH
22E	P8621022E	CONTACTOR
23	P8621023	TABLE BRACE (L)
24	P8621024	MITER GAUGE
28	P8621028	LOCK BOLT 3/8-11
29	P8621029	TAPER LOCK NUT
30	P8621030	BALL BEARING 6008ZZ
31	P8621031	EXT RETAINING RING 40MM
32	P8621032	INT RETAINING RING 80MM
33	P8621033A	PULLEY AND QUILL ASSEMBLY
34	P8621034	STAR WASHER 30MM
35	P8621035	SPANNER NUT
36	P8621036	SPINDLE 1-1/4"
36A	P8621036A	SPINDLE 3/4"
36B	P8621036B	SPINDLE 1"
37A	P8621037A	COMPLETE CARTRIDGE ASSY
38	P8621038	KEY 7 X 7 X 40
39	P8621039	QUILL V2.03.07 8-3/4" LONG
40	P8621040	HEX NUT 3/4-16 LH (FOR 1" AND 1-1/4" SPINDLES)
40A	P8621040A	HEX NUT 5/8-18 LH (FOR 3/4" SPINDLE)
41	P8621041	HEX NUT 1-14 (FOR 1" AND 1-1/4" SPINDLES)
41A	P8621041A	HEX NUT 3/4-16 (FOR 3/4" SPINDLE)
42	P8621042	COLLAR 1-1/4" X 1/4" (1PC)
42A	P8621042A	COLLAR 1" X 1/4"
42B	P8621042B	COLLAR 3/4" X 1/4"
43	P8621043	COLLAR 1-1/4" X 3/8" (1PC)
43A	P8621043A	COLLAR 1" X 3/8"
43B	P8621043B	COLLAR 3/4" X 3/8"
44	P8621044	COLLAR 1-1/4" X 1/2" (2PC)
44A	P8621044A	COLLAR 1" X 1/2"
44B	P8621044B	COLLAR 3/4" X 1/2"

REF	PART #	DESCRIPTION
45	P8621045	COLLAR 1-1/4" X 3/4" (2PC)
45A	P8621045A	COLLAR 1" X 3/4" (2PC)
45B	P8621045B	COLLAR 3/4" X 3/4" (2PC)
46	P8621046	COLLAR 1-1/4" X 1" (2PC)
46A	P8621046A	COLLAR 1" X 1" (2PC)
46B	P8621046B	COLLAR 3/4" X 1" (2PC)
50	P8621050	HEX BOLT 1/4-20 X 5/8
51	P8621051	LOCK WASHER 1/4
52	P8621052	FLAT WASHER 1/4
53	P8621053	HANDWHEEL
54	P8621054	BAR LOCK
55	P8621055	HEX NUT 5/16"-18
56	P8621056	HEX BOLT 5/16-18 X 1
57	P8621057	SCREW LOCK
58	P8621058	WASHER GEAR
59	P8621059	GEAR
60	P8621060	COLLAR
61	P8621061	KEY 4 X 4 X 16
62	P8621062	BASE GEAR SHAFT
63	P8621063	SHAFT GEAR
64	P8621064	BASE SPINDLE
65	P8621065	FLAT WASHER 1/2
66	P8621066	HEX NUT 1/2"-13
67	P8621067	CAP SCREW 3/8-16 X 1-1/4
68	P8621068	SCREW 3/8-16 X 1-1/4
69	P8621069	COLLAR
70	P8621070	V-belt 4I300 (qty 1)
71	P8621071	V-belt 4I280 (qty 1)
72	P8621072	KEY 7 X 7 X 50
73	P8621073	MOTOR PULLEY
74	P8621074	HEX BOLT 3/8-16 X 1-1/2
75	P8621075	FLAT WASHER 5/16
76	P8621076	LOCK WASHER 5/16
77	P8621077	CAP SCREW 5/16-18 X 1
78	P8621078	SPRING 3.4 X 20.3
79	P8621079	KEY 3/8 X 3/4 X 1
80	P8621080	MOTOR 5HP 220V 1PH
81	P8621081	SHAFT
82	P8621082	FLAT WASHER 1/2
83	P8621083	MOTOR BASE
84	P8621084	KNOB
85	P8621085	LOCK WASHER 1/2
86	P8621086	HEX BOLT 1/2-12 X 3/4
87	P8621087	POINTER
88	P8621088	PHLP HD SCR 10-24 X 3/8
89	P8621089	HEX BOLT 5/16-18 X 3/4
90	P8621090	SHAFT GUIDE
91	P8621091	PLATE
92	P8621092	MOTOR PLATE
93	P8621093	SHAFT GEAR
94	P8621094	BASE GEAR SHAFT
95	P8621095	HANDWHEEL-METAL
96	P8621096	HANDLE V1.12.95

REF	PART #	DESCRIPTION
97	P8621097	HEX BOLT 1/4-20 X 1
98	P8621098	HEX NUT 1/4"-20
1000	P86211000	G5912Z MACHINE ID LABEL
1001	P86211001	GRIZZLY NAMEPLATE 8W X 3.5H
1002	P86211002	PULLEY LABEL
1003	P86211003	BELT GUARD LABEL
105	P8621105	RATCHET LOCK HANDLE METAL
106	P8621106	BRACKET SCREW GUIDE
107	P8621107	SCREW GUIDE ASSY
108	P8621108	BALL KNOB 3/8-16 (PLASTIC)
109	P8621109	SHAFT GUIDE
110	P8621110	BAR
111	P8621111	KNOB 5/16-18
112	P8621112	FLAT WASHER 5/16
113	P8621113	PLATE GUARD
114	P8621114	SET SCREW 1/4-20 X 1/4
115	P8621115	BRACKET ASSY FENCE RH
116	P8621116	FENCE WOODEN
117	P8621117	FLAT HD SCR 5/16-18 X 1-1/2
118	P8621118	HOLD DOWN PLATE
119	P8621119	GUARD/DUST HOOD
120	P8621120	BAR
121	P8621121	RETAINER (L) 5/8"
122	P8621122	LOCK HANDLE
122A	P8621122A	KNOB BOLT 10/02 3/8-16 X 1 V2.10.02
124	P8621124	RETAINER
126	P8621126	BRACKET ASSY FENCE LH
127	P8621127	HEX BOLT 1/4-20 X 1-1/2
128	P8621128	*DISCD*RESET SWITCH
129	P8621129	REVERSE LIGHT
130	P8621130	HANDLE WHEEL
161	P8621161	EXT RETAINING RING 50MM
162	P8621162	CAP SCREW M4-.7 X 10
163	P8621163	OUTER DUST COVER
164	P8621164	INNER DUST COVER
165	P8621165	ALTERNATING RING
166	P8621166	WAVY RING
201	P8621201	TABLE
202	P8621202	ECCENT PULLEY SHAFT
203	P8621203	EXT RETAINING RING 35MM
204	P8621204	BALL BEARING 620ZZ
205	P8621205	PULLEY
206	P8621206	LOCK WASHER 5/16
207	P8621207	CAP SCREW 5/16-18 X 1-1/2
208	P8621208	CAP SCREW 1/2-13 X 1-1/2
209	P8621209	HEX NUT 1/2"-13

REF	PART #	DESCRIPTION
210	P8621210	EXT RETAINING RING 8MM
211	P8621211	SHAFT
212	P8621212	SPRING HELICAL 15 X 18
213	P8621213	EXT RETAINING RING 15MM
214	P8621214	PRESS WHEEL
215	P8621215	PRESS SHAFT
216	P8621216	PLASTIC NUT 3/8-16
217	P8621217	PRESS WOOD BASE
218	P8621218	LOCK HANDLE
219	P8621219	SPRING SHAFT & BASE WITH HANDLE
221	P8621221	FENCE
222	P8621222	PUSH SHAFT
223	P8621223	HANDLE LOCK
224	P8621224	LOCK WASHER 1/2
225	P8621225	FLAT WASHER 1/2
226	P8621226	DEGREE TAG
227	P8621227	FLAT WASHER 3/8
228	P8621228	LOCK WASHER 3/8
229	P8621229	PHLP HD SCR 10-24 x 1 1/2
230	P8621230	COVER
231	P8621231	HEX NUT 3/8"-16
232	P8621232	MITER GAUGE
233	P8621233	FINGER
234	P8621234	PHLP HD SCR 10-24 X 1/4
235	P8621235	GLIDE TABLE
236	P8621236	EXT RETAINING RING 10MM
237	P8621237	BALL BEARING 6900ZZ
238	P8621238	ECCENT PULLEY SHAFT
239	P8621239	CAP SCREW 1/4-20 X 1-1/4
240	P8621240	LOCK NUT 3/8-16
241	P8621241	BEARING BASE
242	P8621242	RESIST BASE
243	P8621243	TABLE FIX SHAFT
244	P8621244	SPRING 1.2 X 10.4
245	P8621245	FIX SPRING SHAFT
246	P8621246	ROLL PIN 3 X 16
247	P8621247	CAP SCREW 1/4-20 X 1-1/2
248	P8621248	SPACER
249	P8621249	GUIDE ORBIT
250	P8621250	KNOB 3/8"
251	P8621251	PIVOT
319	P8621319	HOOD
400	P8621400	G5912Z MACHINE ID LABEL
401	P8621401	GRIZZLY NAMEPLATE 8W X 3.5H
402	P8621402	PULLEY LABEL
403	P8621403	SPEED CHANGE LABEL

WARRANTY AND RETURNS

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

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

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

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

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

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

WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone Number _____ E-Mail _____ FAX _____

MODEL #G8621 Heavy-Duty Sliding Table Shaper Order _____

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

1. How did you learn about us?
 Advertisement Friend
 Catalog World Wide Web
 Other _____
2. Which of the following magazines do you subscribe to.
 American Woodworker Practical Homeowner
 Cabinetmaker Shop Notes
 Family Handyman Today's Homeowner
 Fine Homebuilding WOOD
 Fine Woodworking Wooden Boat
 Home Handyman Woodshop News
 Journal of Light Construction Woodsmith
 Old House Journal Woodwork
 Popular Mechanics Woodworker
 Popular Science Woodworker's Journal
 Popular Woodworking Workbench
 Other _____
3. Which of the following woodworking/remodeling shows do you watch?
 Backyard America The New Yankee Workshop
 Home Time This Old House
 The American Woodworker Woodwright's Shop
 Other _____
4. What is your annual household income?
 \$20,000-\$29,999 \$60,000-\$69,999
 \$30,000-\$39,999 \$70,000-\$79,999
 \$40,000-\$49,999 \$80,000-\$89,999
 \$50,000-\$59,999 \$90,000 +
5. What is your age group?
 20-29 50-59
 30-39 60-69
 40-49 70 +
6. How long have you been a woodworker?
 0 - 2 Years 8 - 20 Years
 2 - 8 Years 20+ Years
7. How would you rank your woodworking skills?
 Simple Advanced
 Intermediate Master Craftsman
8. What stationary woodworking tools do you own? Check all that apply.
 Air Compressor Panel Saw
 Band Saw Planer
 Drill Press Power Feeder
 Drum Sander Radial Arm Saw
 Dust Collector Shaper
 Horizontal Boring Machine Spindle Sander
 Jointer Table Saw
 Lathe Vacuum Veneer Press
 Mortiser Wide Belt Sander
 Other _____
9. How many of your woodworking machines are Grizzly? _____
10. Which benchtop tools do you own? Check all that apply.
 1" x 42" Belt Sander 6" - 8" Grinder
 5" - 8" Drill Press Mini Lathe
 8" Table Saw 10" - 12" Thickness Planer
 8" - 10" Bandsaw Scroll Saw
 Disc/Belt Sander Spindle/Belt Sander
 Mini Jointer
 Other _____
11. How many of the machines checked above are Grizzly? _____
12. Which portable/hand held power tools do you own? Check all that apply.
 Belt Sander Orbital Sander
 Biscuit Joiner Palm Sander
 Circular Saw Portable Planer
 Detail Sander Saber Saw
 Drill/Driver Reciprocating Saw
 Miter Saw Router
 Other _____
13. What machines/supplies would you like Grizzly Industrial to carry?
 12" Table Saw Radial Arm Saw
 12" Jointer Panel Saw
 Combination Planer/Jointer Brass Hardware
 Paint & Finishing Supplies Lumber
 Contractor's Supplies
 Other _____
14. What new accessories would you like Grizzly Industrial to carry?
 Builders Hardware Hand Tools
 Fasteners Wood Components
 Other _____
15. What other companies do you purchase your tools and supplies from?

16. Do you think your purchase represents good value?
 Yes No
17. Would you recommend Grizzly Imports to a friend?
 Yes No
18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**
 Yes No
19. Comments: _____

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