



MODEL H7655/H7656 15" & 20" INDEXABLE INSERT SPIRAL CUTTERHEADS INSTRUCTION SHEET

These indexable insert spiral cutterheads are designed to replace both straight-knife and spiral-knife cutterheads from most Grizzly 15" and 20" planers. The Model H7655 15" cutterhead fits Grizzly planer Models G1021, G1021Z, G1021X, G0550, G0551, and G0453. The Model H7656 20" cutterhead fits Grizzly planer Models G1033, G1033Z, G1033ZX, G1033X, and G0454.

The total procedure of changing the cutterhead and setting up the planer takes approximately three hours. These instructions make reference to many procedures detailed in your planer manual. Always consult your manual for these procedures. Call Technical Support at (570) 546-9663 if you need help.

Recommended Tools

Hex Wrench 5mm.....	1
2x4 x 4" Wooden Blocks	6
Pair of Heavy Leather Gloves	1 per person
Wooden or Rubber Mallet	1
Steel Hammer	1
M6-1 x 25 Screw or Bolt.....	1
Open-End Wrench 12 x 14.....	1
Shop Rags (as needed)	1
Drain Pan	1
80-90W Sprocket Oil	As Needed
Oil Funnel	1
Assistants	1-2
Sprocket/Pulley Puller	1
Open-End Wrench to Fit Pulley Puller	1
Heavy Cardboard	As Needed
Heavy Tape	As Needed

!WARNING

Cutterhead knives and inserts are razor sharp! Always wear heavy leather gloves when handling cutterheads, and avoid contact with cutters whenever possible. Failure to comply can result in serious personal injury!

Inventory (Figure 1)

A. Spiral Cutterhead	1
B. T-Handle Socket Driver.....	1
C. Torx Drivers T20 1/2"	5
D. Flat Head Torx Screws M6-1 x 15	20
E. Cutterhead Inserts 14 x 14 (30° bevel)	5

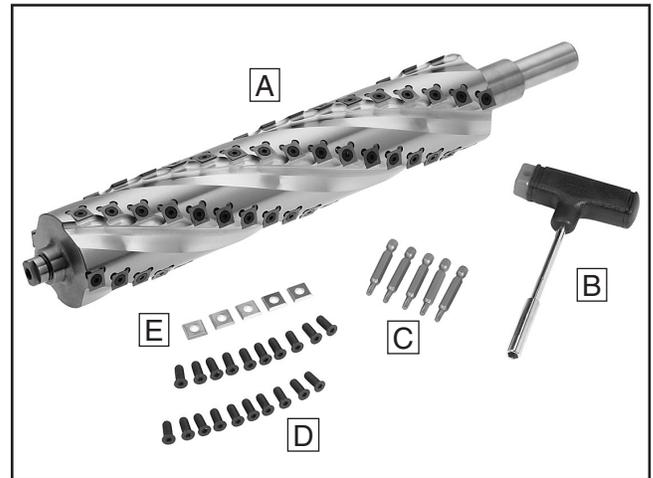


Figure 1. Model H7655/H7656 inventory.

Cutterhead Removal

1. DISCONNECT THE PLANER FROM THE POWER SOURCE!
2. Remove the top cover and dust port to expose the cutterhead.
3. Remove the knives from the existing cutterhead.
4. Remove the belt cover, and then remove the V-belts from the pulleys.

Note: This may require loosening the belt tension. This procedure is outlined in the SERVICE section of your planer manual.

5. Remove the hex bolt that holds the cutterhead pulley in place.
6. Rotate the cutterhead until the cutterhead pulley key is at an upright position.
7. Remove the pulley and key. If the pulley is difficult to remove, use a pulley puller, as shown in **Figure 2** (see Page 7 of this instruction sheet if you do not have a pulley puller).

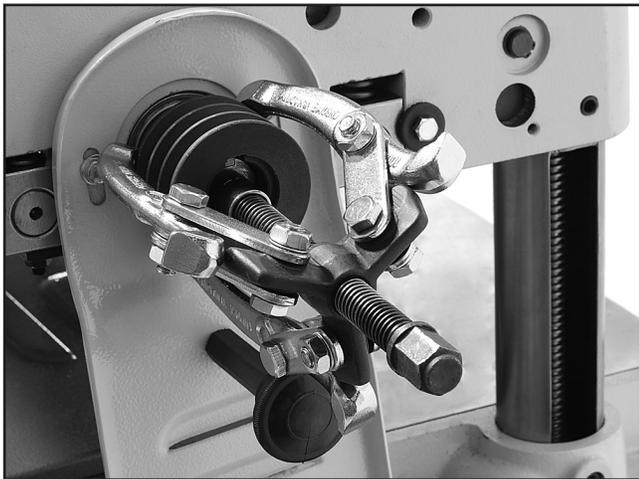


Figure 2. Using a pulley puller.

8. Remove the table elevation handwheel and key.
9. Remove both rear guards from the sprocket cover, as shown in **Figure 3**.

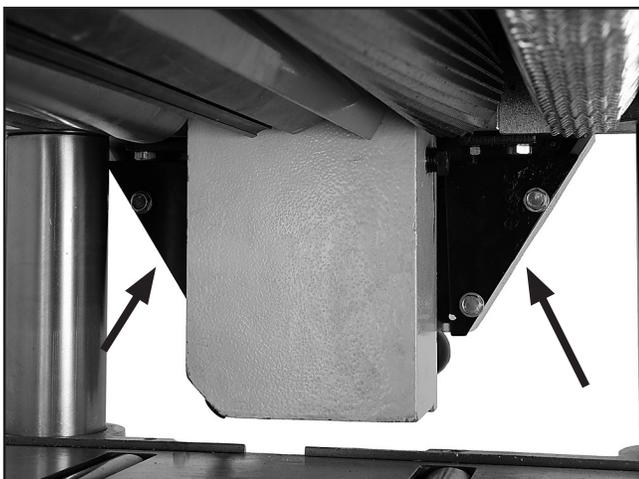


Figure 3. Sprocket cover rear guards.

10. Remove the sprocket cover cap screw and the sprocket cover.

11. Remove the hex bolts and washers from the three sprockets, shown in **Figure 4**, to expose the sprocket keys.

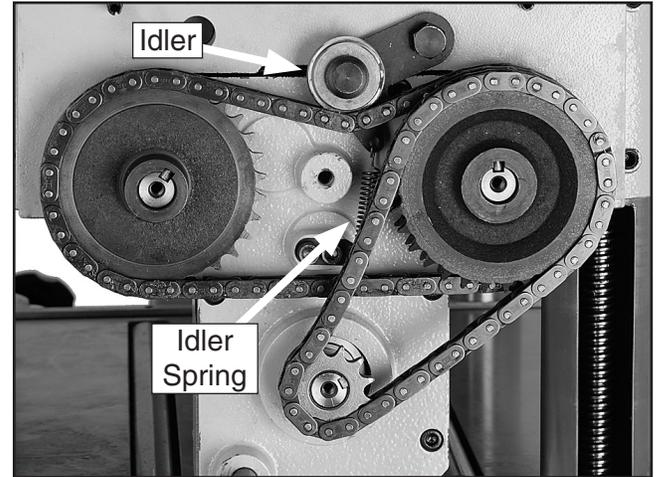


Figure 4. Sprockets and chains.

12. Unhook the idler spring shown in **Figure 4** and move the idler up out of the way.
13. Rotate the cutterhead so that the sprocket keys are in a generally upright position.
14. Mark the outside of the sprockets with correction fluid as a way of remembering which side of each sprocket faces outwards.
15. Remove the sprockets, keys and chains all at once, taking care to keep the chains unbroken.
16. Thoroughly drain the planer gearbox into the drain pan by removing the drain plug shown in **Figure 5**.

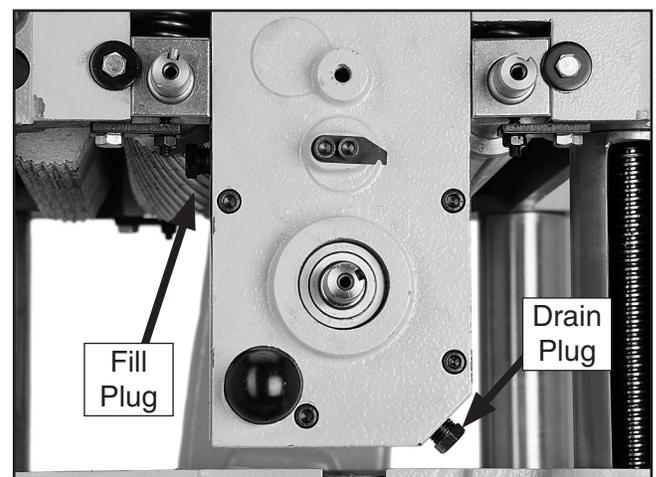


Figure 5. Drain and fill plug location.

17. Insert six 4" 2x4 blocks directly beneath the cutterhead, as shown in **Figure 6**.

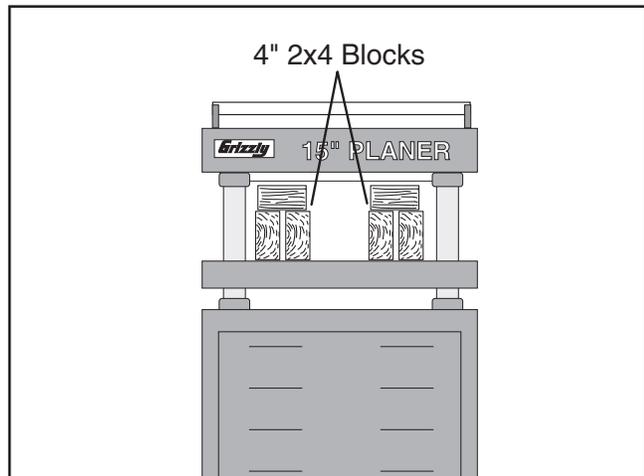


Figure 6. Support block location.

18. Reinstall the handwheel and key, and carefully raise the table so the cutterhead just touches the blocks.
19. Remove the four cap screws at the top of the gearbox, shown in **Figure 7**.

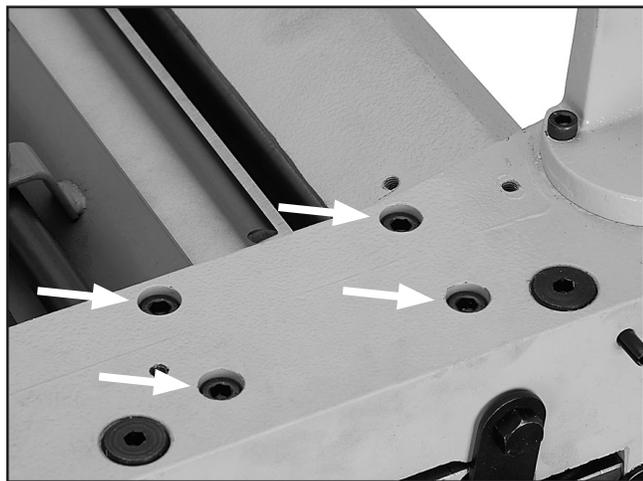


Figure 7. Gearbox cap screw location.

20. Have an assistant hold the gearbox steady while you use a rubber or wooden mallet to unseat the cutterhead out from the headstock, as shown in **Figure 8**.



Figure 8. Unseating the cutterhead.

21. Rest the gearbox-cutterhead assembly on a flat, stable surface for the following steps.
22. Remove the five cap screws from the front of the gearbox cover.
23. Separate the gearbox cover by gently tapping near the gasket using a mallet and flat head screwdriver.
24. Remove the cap screw from inside of helical gear shown in **Figure 9**, and remove the sprocket.

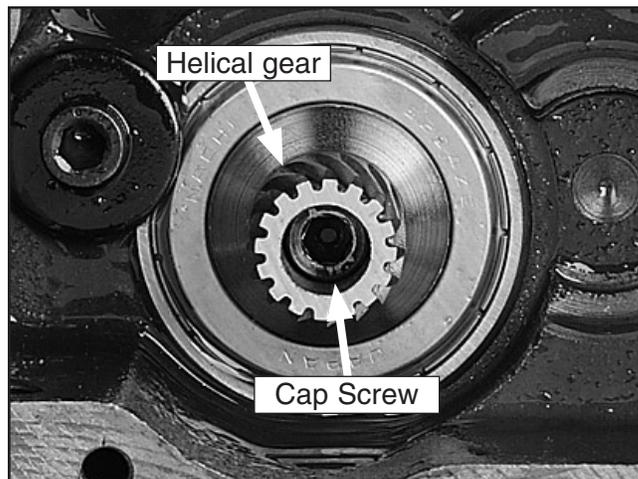


Figure 9. Helical gear and cap screw.

25. Insert the spare M6-1 screw or bolt into the hole at the gearbox end of the cutterhead shown in **Figure 10**.

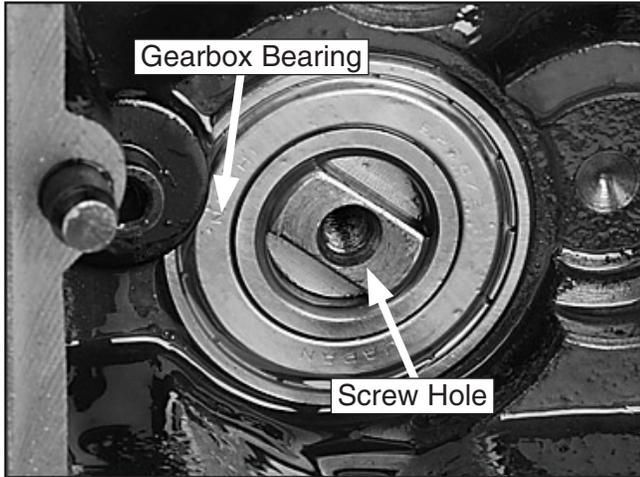


Figure 10. Cutterhead screw hole.

26. While supporting the gearbox, remove the cutterhead by tapping on the screw or bolt with a hammer, as shown in **Figure 11**. It may also be necessary to tap on the back of the gearbox with a rubber or wooden mallet.

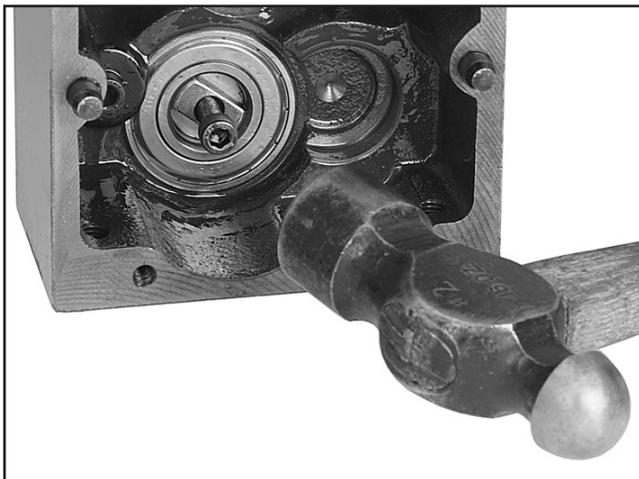


Figure 11. Cutterhead removal.

27. Visually inspect all bearing bores, both on the headstock and in the gearbox, and remove any burrs or rough spots that are present.

Spiral Cutterhead Installation

We recommend that all gearbox seals and gaskets are replaced before cutterhead installation, even if the seals or gaskets appear to be in good condition.

NOTICE

Before removing any seals, note their orientation and how far they are driven into the bore (typically the lip of a seal will face inward towards the oil reservoir or body of liquid). This will aid in the replacement process. Failure to heed this notice can lead to fluid leakage and gearbox failure.

1. Wrap the new cutterhead in the cardboard and securely fasten it with heavy tape.
2. Install a new bearing on the cutterhead by very gently tapping it on using a mallet and a 4" length of 1" inside diameter pipe, as shown in **Figure 12**.

Tip: Place the wrapped cutterhead in a freezer overnight before installing a new bearing. This will cause the cutterhead metal to contract, making the bearing easier to install.

Important: The pipe should contact the inside race of the bearing only, as shown in **Figure 12**. Force on any other portion of the bearing WILL ruin the bearing!

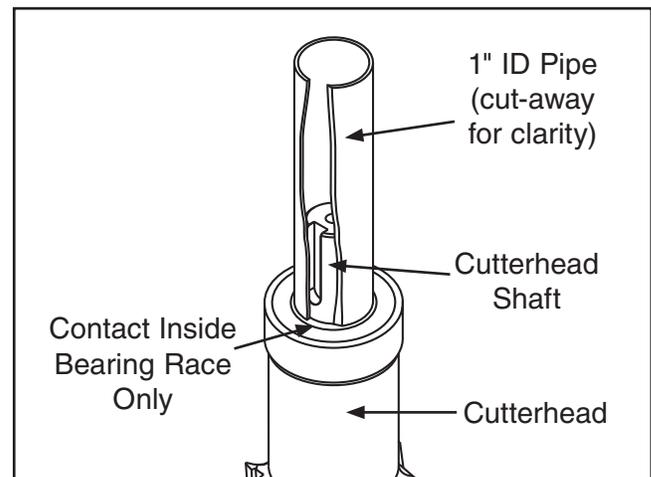


Figure 12. Close-up of cutterhead bearing installation.

3. Install the cutterhead in the gearbox by fitting it into place, and seat it by tapping on the pulley end with a wooden or rubber mallet. Ensure the cutterhead end is flush with the inside face of the gearbox bearing, as previously shown in **Figure 10**.
4. Reinstall the helical gear and cap screw, ensuring the helical gear and the cutterhead are engaged.
5. Ensure that gasket surfaces are clean and free of oil, grit or contaminants.
6. Re-assemble the gearbox, taking care to seat the rubber gasket in alignment with the gearbox covers.
7. Re-fill the gearbox with clean 80-90W sprocket oil via the fill plug shown in **Figure 5**.
8. Install the cutterhead-gearbox assembly into the planer. Seat the cutterhead shaft bearing by tapping on the gearbox with a rubber or wooden mallet, as shown in **Figure 13**. Ensure the face of the new cutterhead bearing is flat and flush with the headstock casting.

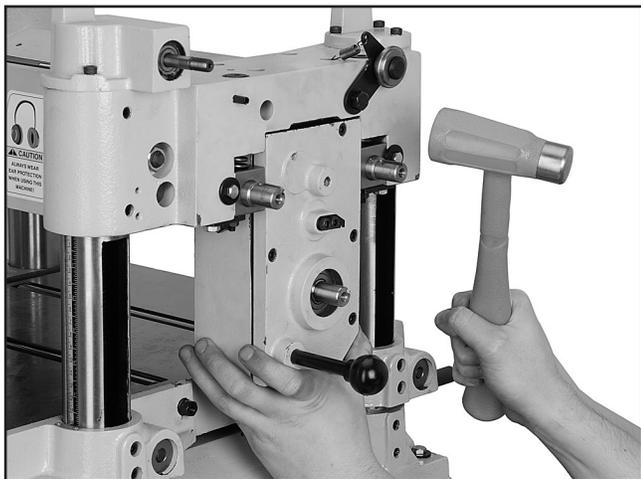


Figure 13. Seating cutterhead-gearbox assembly.

9. Secure the gearbox in place using the cap screws removed in **Step 19** of the **Cutterhead Removal** instructions.
10. Rotate all sprocket shafts so that the keyways are in a generally upwards position.

11. Re-install the sprockets, chains and idler. Fasten the sprockets using the washers and bolts removed in **Step 11** of the **Cutterhead Removal** instructions.
12. Re-install the sprocket cover, including both rear guards on the sprocket cover.
13. With the cutterhead shaft keyway in an upright position, install the cutterhead pulley key into the keyway.
14. Slide the cutterhead pulley onto the shaft, and secure with the hex bolt removed in **Step 5** of the **Cutterhead Removal** instructions.
15. Remove the protective cardboard and tape from around the cutterhead.
16. Re-install all belts and the belt cover. Readjust the belt tension if it was loosened in **Step 4** of the **Cutterhead Removal** instructions.
17. Re-install all remaining covers and guards.
18. Follow the procedures outlined in your planer manual for the adjustment and calibration of your planer.

Rotating/Changing Carbide Cutters

Tools Needed:	Qty
T-Handle Wrench w/T20 Torx Bit.....	1

The 15" cutterhead is equipped with 72 indexable carbide cutters; the 20" cutterhead has 96. Each cutter can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge (**Figure 14**).

In addition, each cutter has a reference dot on one corner. As the cutter 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 cutter should be replaced.

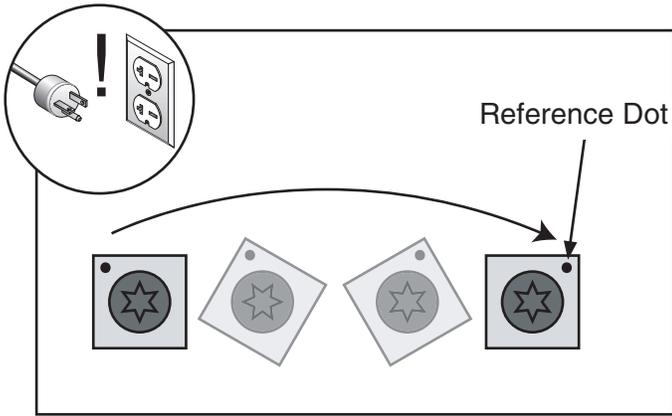


Figure 14. Cutter rotating sequence.

To rotate or change a carbide cutter:

1. DISCONNECT THE PLANER FROM THE POWER SOURCE!
2. Remove any sawdust from the head of the carbide cutter Torx screw.

3. Remove the Torx screw and carbide cutter.
4. Clean all dust and dirt off the cutter and the cutterhead pocket from which the cutter was removed, and replace the cutter so a fresh, sharp edge is facing outward.

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

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

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

ACCESSORIES

G8995—4" Heavy-Duty Pulley Puller

Indispensable for pulling sprockets or pulleys off press-fit shafts. Can be used in either a 2 or 3 jaw configuration. The 4" jaw fingers are also reversible so they can grab an outside or inside diameter. The forcing screw has a live center and is made of tough hardened steel.

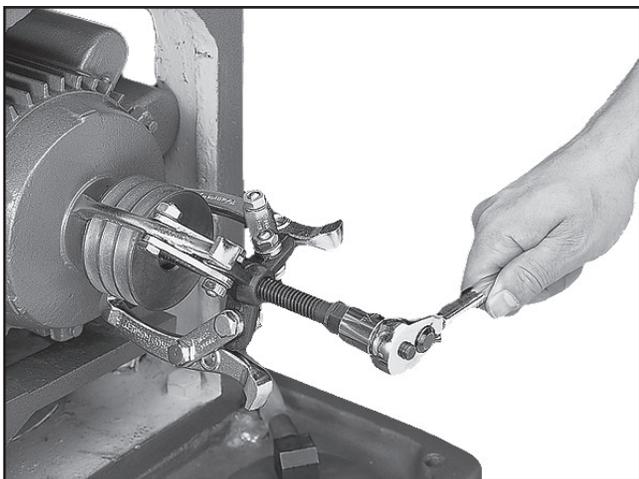


Figure 15. G8995 4" Heavy-Duty Pulley Puller.

H7319—10 Pack of Indexable Carbide Inserts

Replacement carbide inserts for H7655 and H7656 cutterheads.

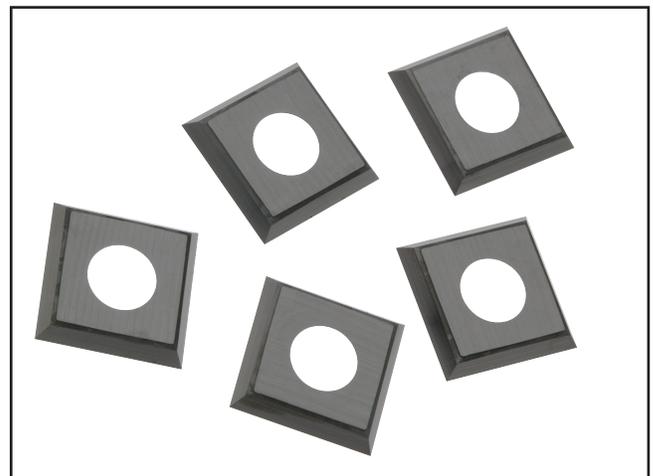
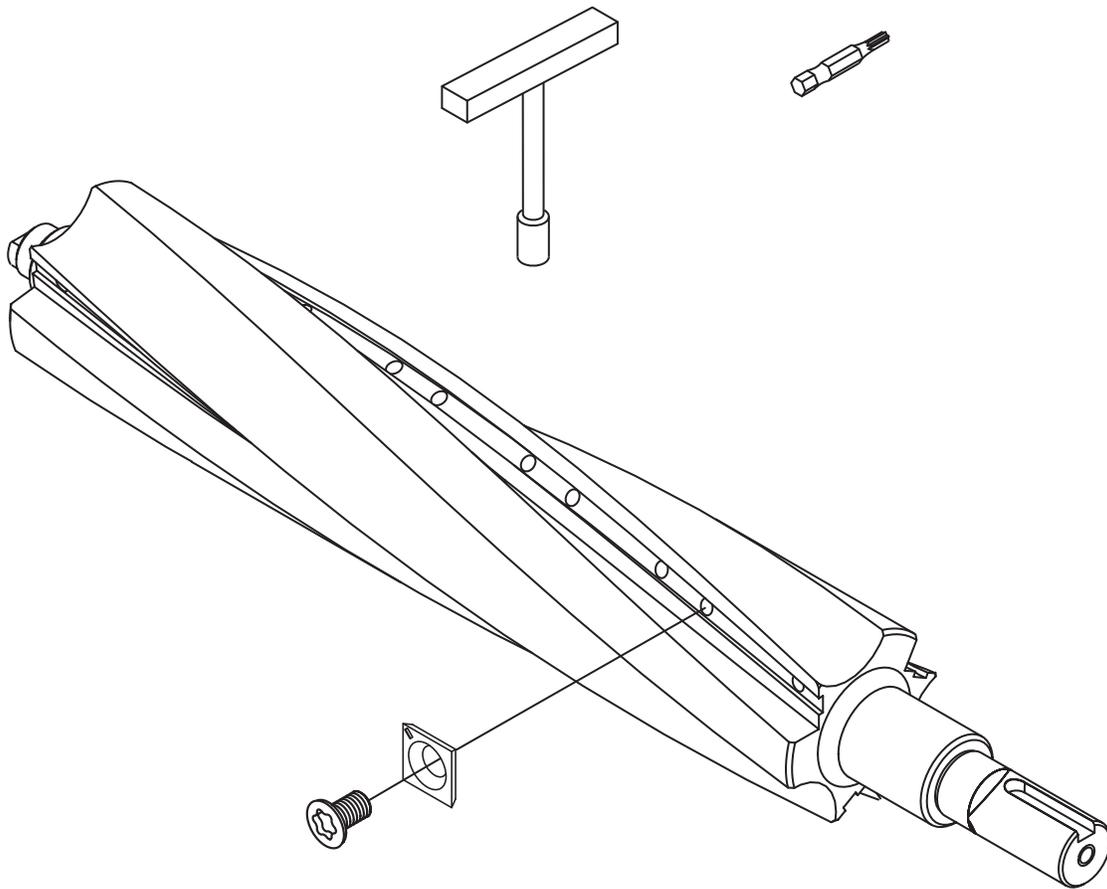


Figure 16. H7319 Indexable Carbide Inserts.

Call 1-800-523-4777 To Order

H7655/H7656 Breakdown



H7655 Parts

REF	PART #	DESCRIPTION
1	PH7655001	SPIRAL CUTTERHEAD 15"
2	PH7653002	INDEXABLE INSERT 14 x 14 x 2
3	PFH35M	FLAT HD TORX SCR T20 M6-1 X 15

REF	PART #	DESCRIPTION
4	PH7653015	TORX BIT T20
5	PH7653014	T-HANDLE DRIVER 1/4"

H7656 Parts

REF	PART #	DESCRIPTION
1	PH7656001	SPIRAL CUTTERHEAD 20"
2	PH7653002	INDEXABLE INSERT 14 x 14 x 2
3	PFH35M	FLAT HD TORX SCR T20 M6-1 X 15

REF	PART #	DESCRIPTION
4	PH7653015	TORX BIT T20
5	PH7653014	T-HANDLE DRIVER 1/4"

WARRANTY AND RETURNS

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

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

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

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

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

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