MODEL G0500/G1018/G1018HW
8" JOINTER
OWNER'S MANUAL

Model G0500 Shown

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#TR4986 PRINTED IN TAIWAN

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

TABLE OF CONTENTS

PAGE

1. **SAFETY** **3**
   - Safety Instructions For Power Tools 3-4
   - Additional Safety Instructions For Jointers 5
2. **INTRODUCTION** **6**
3. **CIRCUIT REQUIREMENTS** **7**
   - 220V Operation 7
   - 110V Operation 8
   - Grounding 9
   - Extension Cords 9
4. **IDENTIFICATION** **10-11**
   - Common Terms and Definitions 11
5. **SETUP** **12**
   - Unpacking 12
   - G0500 Inventory 12
   - G1018 Inventory 13
   - G1018HW Inventory 13
   - Hardware Recognition Chart 14
   - Clean Up 15
   - Site Considerations 15
   - Beginning Assembly 16
   - Switch Installation 16-17
   - Wiring Connection 17
   - Jointer Stand 18
   - V-Belt 18-19
   - Stand Cover 19
   - Fence to Jointer 20
   - G0500/G1018HW Handwheel Installation 20
   - G1018 Table Lever Installation 21
   - Knife Setting Gauge 21
   - Knife Inspection 22
   - Table Alignment 22-23
   - G1018 Table Stops 24
   - Cutterhead Guard 25
   - Fence Stops 26-27
   - Plug Installation 27
   - Test Run 27
6. **OPERATIONS** **28**
   - Stock Inspection & Requirements 28-29
   - Squaring Stock 29
   - Surface Planing 30
   - Edge Jointing 31
   - Bevel Cutting 32
   - Rabbet Cutting 33

7. MAINTENANCE 34
General 34
Table 34
Lubrication 34
V-Belt 34
Knife Condition 34
Maintenance Log 35
8. SERVICE ADJUSTMENTS 36
About Service 36
Setting Knives 36-37
Adjusting Gibs 37-38
Adjusting V-Belt 38-39
Replacing V-Belt 39
Service Log 40
9. REFERENCE INFO 41
Troubleshooting Guide 42-43
G0500/G1018/G1018HW Wiring Diagram 44
G0500 Machine Data 45
G0500 Parts Breakdown and Parts List 46-51
G1018 Machine Data 52
G1018 Parts Breakdown and Parts List 53-58
G1018HW Machine Data 59
G1018HW Parts Breakdown and Parts List 60-65
Warranty Information 66-67

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.**

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

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

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	16	16	16
7-10	16	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. **DO NOT OVER-REACH.** 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. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **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.

18. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

19. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

20. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

21. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

Additional Safety Instructions For Jointers

1. **JOINTING SAFETY BEGINS** with your lumber. Inspect your stock carefully before you feed it over the cutterhead. If you have any doubts about the stability or structural integrity of your stock, **DO NOT JOINT IT!**

2. **MAINTAIN PROPER RELATIONSHIP** of the outfeed table and the cutterhead knife path.

3. **ALWAYS USE PUSH BLOCKS** whenever surface planing. Never place your hands directly over the cutterhead.

4. **SUPPORT THE WORKPIECE** adequately at all times during operation, maintain control over the work at all times.

5. **WHEN JOINTING**, do not stand directly at the end of either table. Position yourself just to the side of the infeed table to avoid injury from possible kickbacks**.**

6. **NEVER MAKE ANY SINGLE CUT DEEPER THAN ⅛".**

7. **NEVER JOINT A BOARD** that has loose knots. All defects should be cut out of the board before it is planed or jointed.

8. **NEVER JOINT** end grain.

9. **JOINT WITH THE GRAIN**. Jointing against the grain is dangerous and could produce chatter or excessive chip out.

10. **WITH THE EXCEPTION OF RABBETING**, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

11. **NEVER BACK THE WORK** toward the infeed table.

12. **HABITS – GOOD AND BAD** – are hard to break. Develop good habits in your shop and safety will become second-nature to you.

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

14. **BE AWARE THAT CERTAIN WOODS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to and always wear an approved respirator.

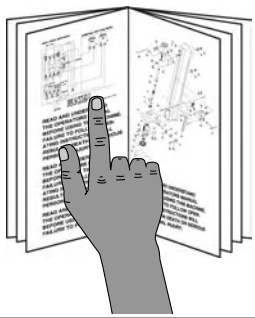
⚠CAUTION

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

⚠WARNING

Like all power tools, there is danger associated with the Grizzly 8" Jointers. 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.

SECTION 2: INTRODUCTION



⚠WARNING

Read the manual before assembly and operation. Serious personal injury may result if safety or operational information is not understood or followed.

We are proud to offer the Model G0500/G1018/G1018HW. These 8" jointers are part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The main differences in the three models are shown in the chart below. All three machines are built with rugged steel cabinets and precision ground cast-iron tables and fence assemblies. For more complete information about each machine, see *Section 9: Reference Info*.

We are pleased to provide this manual with the Model G0500/G1018/G1018HW. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

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

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

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

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

The specifications, drawings, and photographs illustrated in this manual represent the Model G0500/G1018/G1018HW 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. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Description	G0500	G1018	G1018HW
Motor	2 HP	1½ HP	1½ HP
Cutterhead	4 Knife	3 Knife	3 Knife
Table Size	75"	65"	65"
Table Adjustment	Handwheels	Table Levers	Handwheels

SECTION 3: CIRCUIT REQUIREMENTS

220V Operation

Amperage Draw
The Model G0500/G1018/G1018HW motors are prewired at 220V and will draw the following load:

G0500.....12 amps
G1018.....9 amps
G1018HW.....9 amps

Plug Type
The cord set enclosed does not have a plug as the style of plug you require will depend upon the type of service you currently have or plan to install. We recommend using the following plugs for your machine on a dedicated circuit only (see **Figure 1** for an example):

G0500.....6-15 or L6-15
G1018.....6-15 or L6-15
G1018HW.....6-15 or L6-15

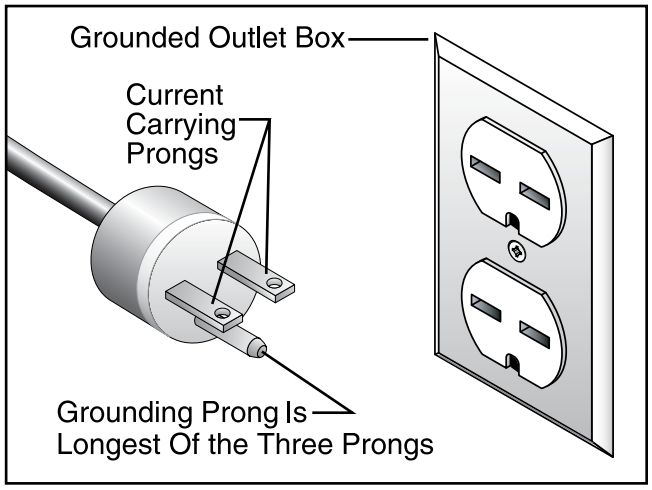


Figure 1. 6-15 plug and outlet.

Circuit Breaker Requirements
We recommend that the circuit you use your machine on should be dedicated. Because the machine motors are different sizes, please use the following guidelines when choosing a circuit breaker for your machine (circuit breakers rated any higher are not adequate to protect the circuit):

G0500 .....15 amp
G1018 .....10 amp
G1018HW .....10 amp

Your Circuit Capacity
Always check to see if the wires in your circuit are capable of handling the amperage load from your machine. If you are unsure, consult a qualified electrician.

If you operate your jointer on any circuit that is already close to its capacity, it might blow a fuse or trip a circuit breaker. However, if an unusual load does not exist and a power failure still occurs, contact a qualified electrician or our Service Department.

⚠WARNING
DO NOT connect your machine to the power source until you have completed the assembly process and have been instructed to do so in this manual. Otherwise, serious personal injury could occur.

110V Operation

NOTICE

The Model G0500/G1018/G1018HW is prewired for 220V operation. If you plan to rewire your machine for 110V, you must use a different switch. Consult a licensed electrician before attempting to rewire your machine!

110V Amperage Draw

The Model G0500/G1018/G1018HW motors can be rewired for 110V if you use a different switch. If you rewire your machine for 110V, the motors will draw the following load:

G0500.....24 amp
G1018.....18 amp
G1018HW.....18 amp

Plug Type

The cord set enclosed does not have a plug as the style of plug you require will depend upon the type of service you currently have or plan to install. We recommend using the following plugs for your machine on a dedicated circuit only (see **Figures 2 & 3** for examples):

G0500.....5-30 or L5-30
G1018.....5-20 or L5-20
G1018HW.....5-20 or L5-20

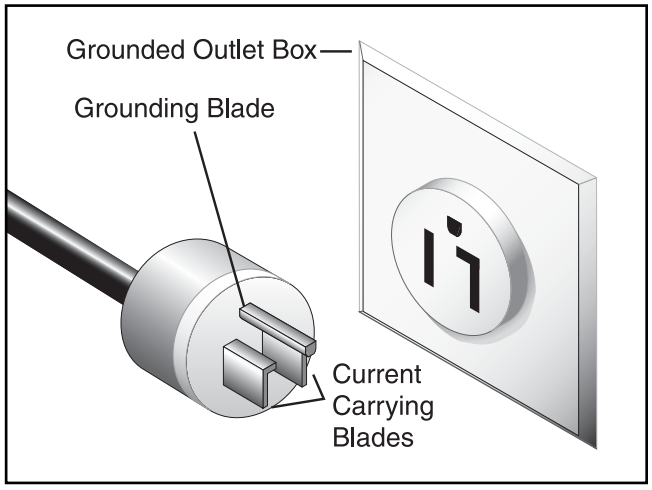


Figure 2. 5-30 plug and outlet.

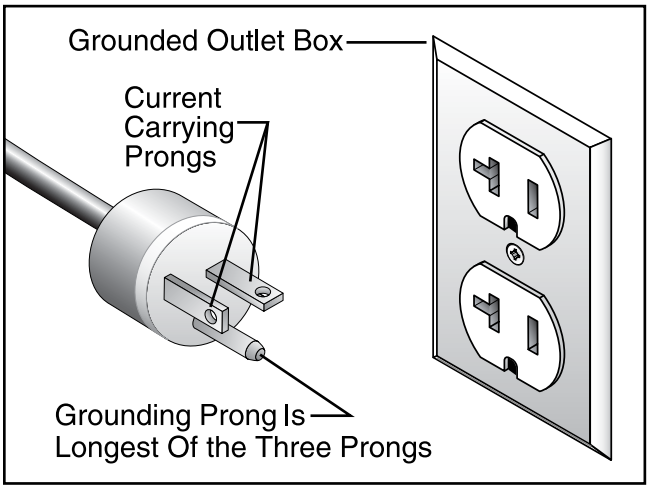


Figure 3. 5-20 plug and outlet.

110V Circuit Breaker Requirements

Use the following guidelines when choosing a circuit breaker (circuit breakers rated any higher are not adequate to protect the circuit):

G0500.....25 amp
G1018.....20 amp
G1018HW.....20 amp

Your Circuit Capacity

Always check to see if the wires in your circuit are capable of handling the amperage load from your machine. If you are unsure, consult a qualified electrician.

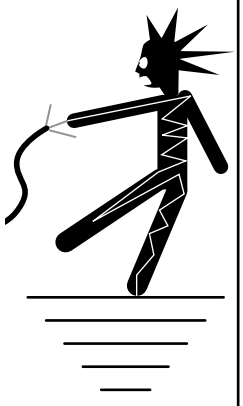
If you operate your jointer on any circuit that is already close to its capacity, it might blow a fuse or trip a circuit breaker. However, if an unusual load does not exist and a power failure still occurs, contact a qualified electrician or our Service Department.

⚠WARNING

DO NOT connect your machine to the power source until you have completed the assembly process and have been instructed to do so in this manual. Otherwise, serious personal injury could occur.

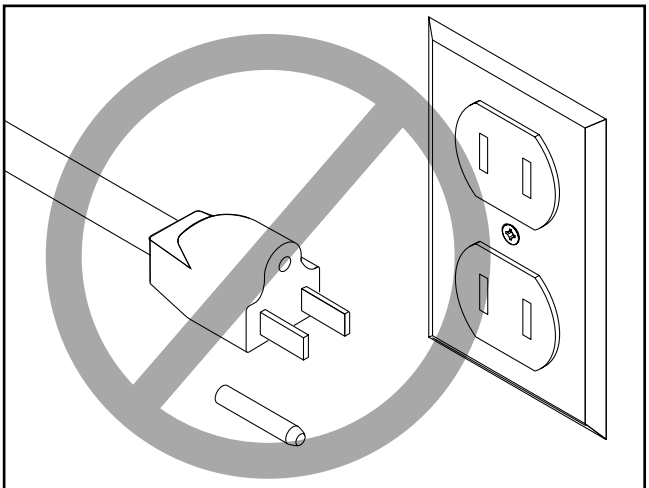
Grounding

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 a power cord that has an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.



⚠WARNING

Verify that any existing electrical outlet and circuit you use is actually grounded. If not, it will be necessary to run a separate 12 A.W.G. copper grounding wire from the outlet to a known ground. If not grounded properly, serious personal injury could occur.



⚠CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. DO NOT remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

220V Operation
We do not recommend the use of extension cords on 220V equipment. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you find it absolutely necessary to use an extension cord at 220V with your Grizzly 8" Jointer:

- Make sure the cord is rated for Standard Service (grade S) or better.
- The extension cord must also contain a ground wire and plug pin.
- Use at least a 16 gauge cord if the cord is 50 feet long or less.
- Use at least a 14 gauge cord if the cord is between 51-100 feet.

110V Operation
If you find it necessary to use an extension cord at 110V with your Grizzly 8" jointer:

- Make sure the cord is rated Standard Service (grade S) or better.
- The extension cord must also contain a ground wire and plug pin.
- Use at least a 10 gauge cord if the cord is 50 feet long or less.
- DO NOT use a cord longer that 50 feet!

SECTION 4: IDENTIFICATION

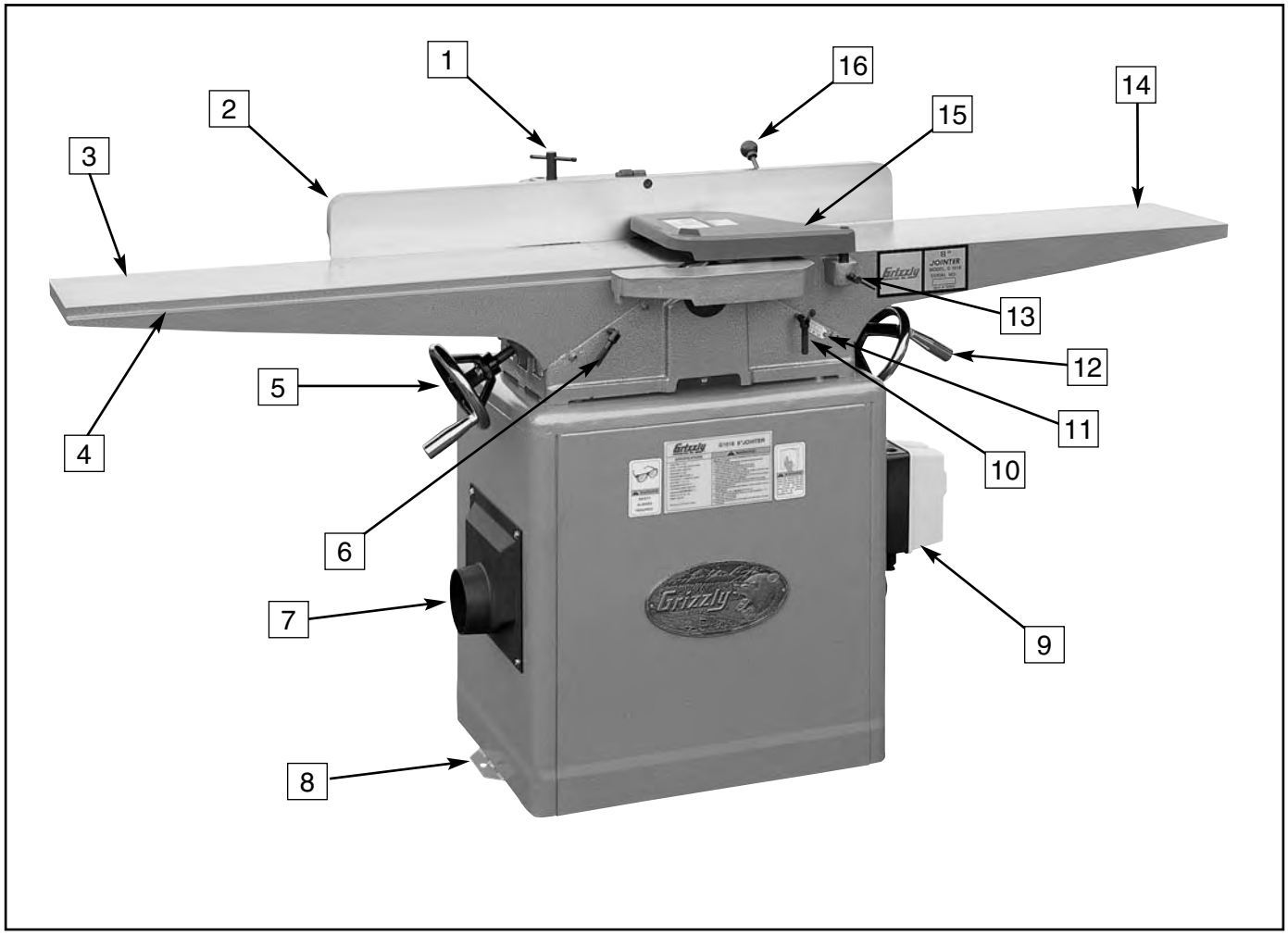


Figure 4. The following is a list of controls and components on the Model G0500/G1018/G1018HW. Please take time to become familiar with each item and its location. These items will be used throughout the manual and knowing them is essential to understanding the instructions and terminology used in this manual.

1. Fence Lock
2. Fence
3. Outfeed Table
4. Rabbeting Edge
5. Outfeed Handwheel
6. Outfeed Table Lock
7. Dust Port (optional for G1018/G1018HW)
8. Stand Mounting Hole
9. ON/OFF Switch
10. Infeed Table Lock
11. Depth Scale
12. Infeed Table Handwheel
13. Cutterhead Guard Shaft Lock
14. Infeed Table
15. Cutterhead Guard
16. Fence Tilt Handle

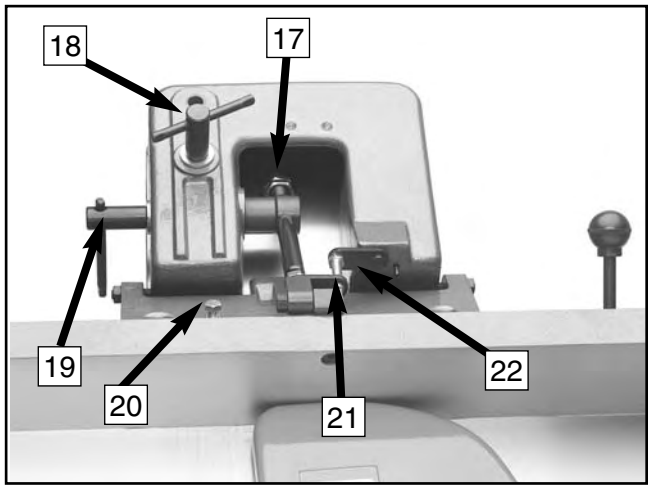


Figure 5. Fence controls.

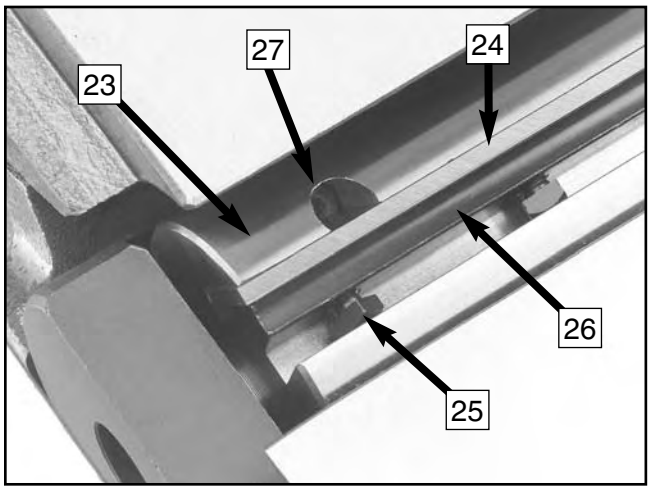


Figure 6. Cutterhead details.

17. 45˚L Stop Nut
18. Fence Lock
19. Fence Tilt Lock
20. 45˚R Stop Bolt
21. 90˚ Stop Bolt
22. 90˚ Stop Tab

23. Cutterhead
24. Cutterhead Knife
25. Gib Bolt
26. Gib
27. Jack Screw Access Hole

Common Terms and Definitions

Infeed Table: The infeed table is the table where the cutting operation begins. When facing the front of the jointer, it is on the right-hand side. The wood travels right to left; from the infeed table, across the cutterhead, and onto the outfeed table.

Outfeed Table: The outfeed table is the table where the cutting operation ends. When facing the front of the jointer, it is on the left-hand side.

Cutterhead: The cutterhead is the cylindrical assembly that holds each of the jointer knives. It spins on a horizontal axis between the infeed and outfeed table, and is covered by the cutterhead guard.

Fence: The jointer fence is the adjustable cast iron surface that the wood stock runs along when jointing and surface planing. The fence is adjustable from 45°-90° to the infeed and outfeed tables.

Adjustment Levers and Handwheels: Controls the height of the infeed and outfeed tables.

Table Lock Handles: The threaded handles that must be loosened before the height of the tables can be adjusted. They are then tightened after the height is properly set.

Rabbet Cut: A rabbet cut is a groove cut along the long edge of the wood stock, usually used for making simple joints. The cutterhead guard must be removed for this operation, so great care is needed for safe operation.

Surface Planing: Surface planing is running the face of the wood stock over the jointer. This provides one flat side that is ready to be run through a dedicated planing machine.

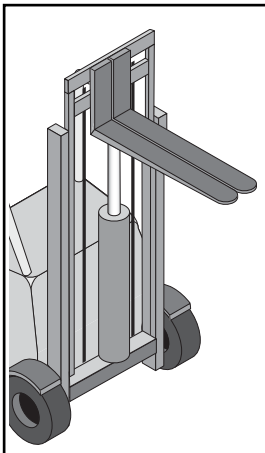
Edge Jointing: Edge jointing is running the long edge of the wood stock over the jointer. This provides one flat edge that is ready to be run against the table saw rip fence or edge glued.

Cutterhead Guard: The metal guard that covers the cutterhead and automatically moves out of the way during operation, then automatically moves back into place after the operation.

SECTION 5: SET UP

Unpacking

The Grizzly 8" Jointers are shipped from the manufacturer in a carefully packed crate and a cardboard box. 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 8" Jointer is a heavy machine at approximately 460 lbs. shipping weight. DO NOT move the machine by yourself – you will need assistance and power equipment. Serious personal injury may occur if safe moving methods are not followed.

⚠CAUTION

Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

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

G0500 Inventory

- Jointer Assembly w/Fence 1
- Infeed Extension 1
- Outfeed Extension 1
- V-Belt M52 2
- Handwheel 2
- Handle 2
- Dust Port 4" 1
- Hardware Bag #1
  - —Combo Wrench 8/10MM 1
  - —Combo Wrench 12/14MM 1
  - —Allen Wrench 3MM 1
  - —Allen Wrench 4MM 1
  - —Allen Wrench 5MM 1
  - —Phillips Head Screw ¼"-20 X ½" 4
  - —Flat Washer ¼" 4
  - —E-Clip 4
  - —Jig Feet 2
  - —Jig Rod 1
- Hardware Bag #2
  - —Lock Washers ⅜" 3
  - —Hex Bolt 5⁄16"-18 x 1" 4
  - —Flat Washer 5⁄16" 4
  - —Special Mounting Bolts 3
- Cutterhead Guard 1
- Push Block 2
- Stand Assembly w/Motor 1
- Stand Door Assembly w/Knob 1
- Strain Relief 1
- Phillips Head Screw #10-24 x 1¼" 2
- Flat Washers #10 2
- Hex Nuts #10-24 2

Figure 7. G0500 Inventory.

G1018 Inventory

- Jointer Assembly w/Fence 1
- V-Belt M52.....2
- Table Lever 2
- Hardware Bag #1
  —Combo Wrench 8/10MM 1
  —Combo Wrench 12/14MM 1
  —Allen Wrench 3MM 1
  —Allen Wrench 4MM 1
  —Allen Wrench 5MM 1
  —E-Clip 4
  —Jig Feet 2
  —Jig Rod.....1
- Hardware Bag #2
  —Lock Washers ⅜".....3
  —Special Mounting Bolts 3
- Cutterhead Guard 1
- Push Block.....2
- Stand Assembly w/Motor.....1
- Stand Door Assembly w/Knob.....1
- Strain Relief.....2
- Phillips Head Screw #10-24 x 1¼" 2
- Flat Washers #10 2
- Hex Nuts #10-24 2

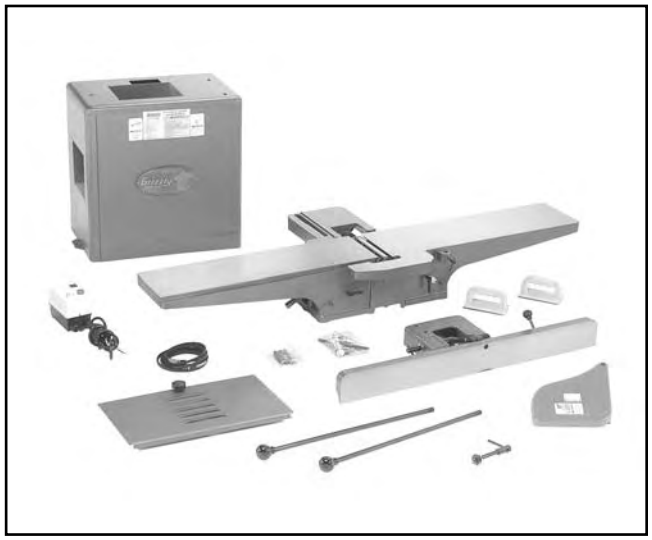


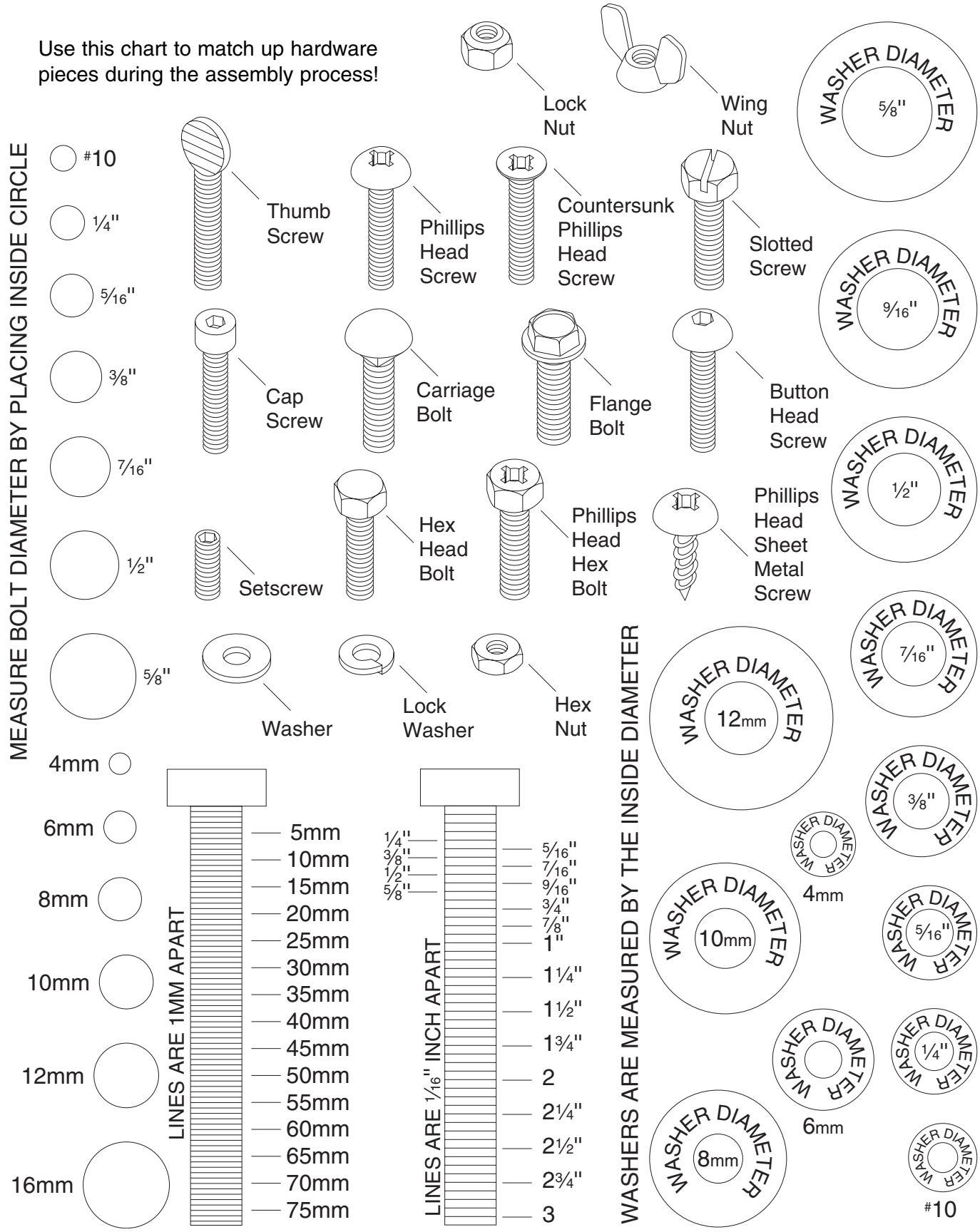
Figure 8. G1018 Inventory.

G1018HW Inventory

- Jointer Assembly w/Fence 1
- V-Belt M52.....2
- Handwheel.....2
- Handle 2
- Hardware Bag #1
  —Combo Wrench 8/10MM 1
  —Combo Wrench 12/14MM 1
  —Allen Wrench 3MM 1
  —Allen Wrench 4MM 1
  —Allen Wrench 5MM 1
  —E-Clip 4
  —Jig Feet 2
  —Jig Rod.....1
- Hardware Bag #2
  —Lock Washers ⅜".....3
  —Special Mounting Bolts 3
- Cutterhead Guard 1
- Push Block.....2
- Stand Assembly w/Motor.....1
- Stand Door Assembly w/Knob.....1
- Strain Relief.....2
- Phillips Head Screw #10-24 x 1¼" 2
- Flat Washers #10 2
- Hex Nuts #10-24 2

Figure 9. G1018HW Inventory.

Hardware Recognition Chart



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. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.

To access all surfaces, remove the fence lock nut and handle (see **Figure 10**), and remove the fence from the jointer unit.

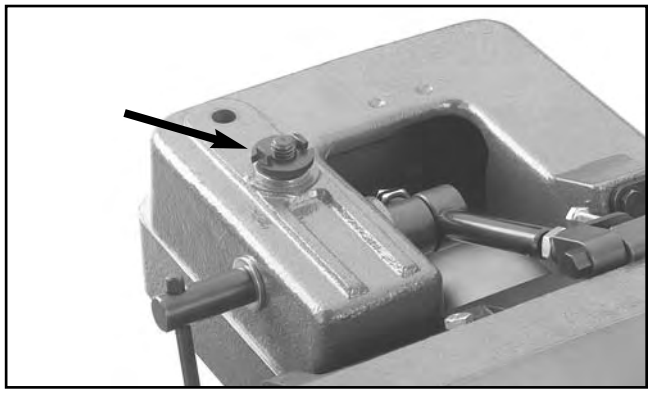


Figure 10. Jointer fence lock nut (the handle is attached directly underneath nut).

⚠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.

⚠WARNING

Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.

Site Considerations

FLOOR AND WORKBENCH LOAD

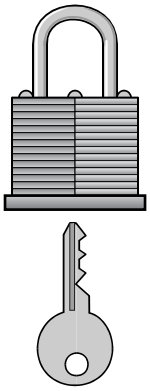
Your Model G0500/G1018/G1018HW represents a medium weight load. Most commercial or garage shop floors should be sufficient to carry the weight. **Before** moving the jointer onto a residential floor, inspect it carefully to determine that it will be sufficient to carry the load of the machine, the device for moving it and its operators. If you question the strength of your floor, you should consider having it inspected for possible reinforcement.

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.

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 amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.



⚠CAUTION

Make your shop "child safe." Ensure that your workplace is inaccessible to youngsters by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting or operating equipment.

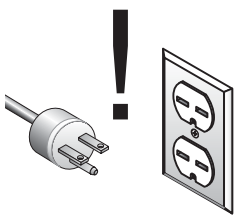
Beginning Assembly

This section will cover the minimum assembly and adjustment instructions needed to begin operation. For best results, complete the assembly in the order provided in this manual and then read the remaining portion of the manual before attempting any type of operations.

Safety must come first! Read and follow these instructions before beginning assembly:

⚠WARNING

Wear safety glasses during the entire assembly process. Failure to comply may result in serious personal injury.



⚠WARNING

Disconnect power to the machine when performing all assembly steps. Failure to do this may result in serious personal injury.

⚠CAUTION

Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

Most of your 8" Jointer has been assembled at the factory, but some parts must be assembled or installed after delivery.

TOOLS REQUIRED: You will need a high quality square, a Phillips screwdriver, a long straightedge, 10mm, 12mm and 14mm open-end wrenches, and a 3mm Allen wrench.

Switch Installation

To install the switch:

1. Locate the #10-24 x 1½" Phillips head screws that are included in the hardware bag with the switch.

2. Remove the switch cover by unthreading the two plastic screws from the front of the switch.

3. Position the switch over the holes and secure it to the stand with the #10-24 x 1½" Phillips head screws, as shown **Figure 11**.

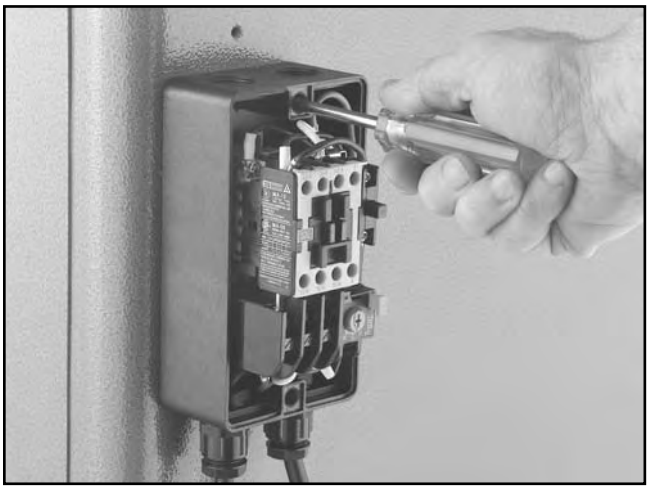


Figure 11. Fastening switch to stand.

4. Place the cover back on the switch and secure it to the switch body with the two plastic screws.

5. Locate the shortest length cord (motor cord) and close a grommet around the wire, so the larger end of the grommet is toward the switch.

6. Thread the motor cord through the access hole in the stand, which is located just below the switch.

7. Snap fit the grommet into the opening as shown in **Figure 12**. Make sure there is enough slack in the wire between the switch and the grommet before snapping the grommet into position.

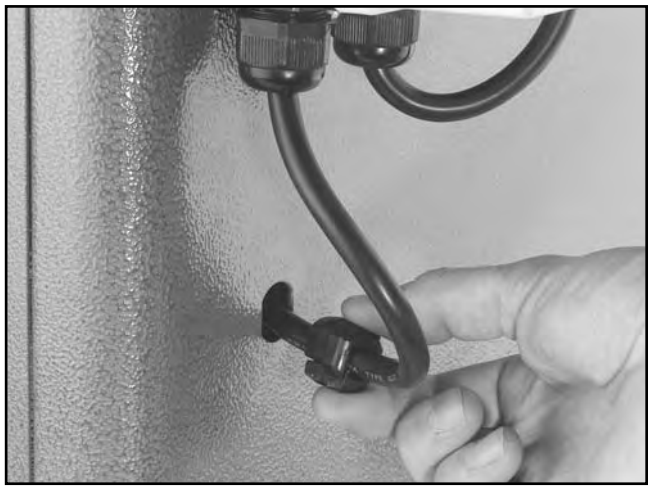


Figure 12. Installing grommet.

Wiring Connection

To connect the motor cord to the motor:

1. Remove three of the four motor mounting bolts and swing the motor toward the rear stand opening, as shown in **Figure 13**.

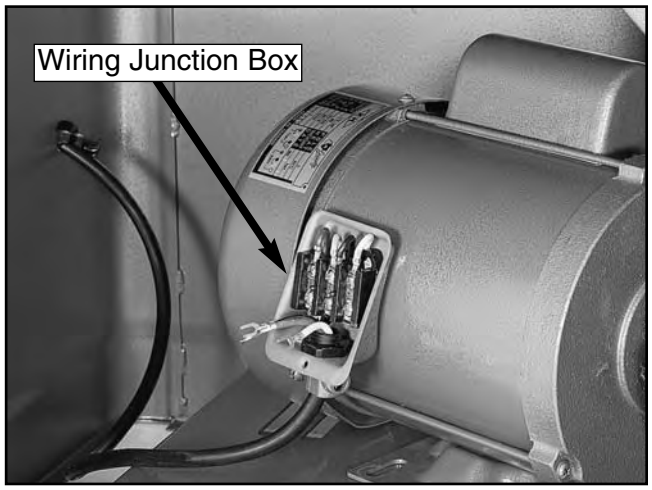


Figure 13. Motor positioned for easy access.

2. Remove the cover from the wiring junction box.

3. Make the motor connections in accordance with the wiring schematics that are located on the motor label or those shown below in **Figure 14** or **Figure 15**, depending on which voltage you decide to use.

NOTICE

If you plan to rewire your machine for 110V, you must use a different switch!

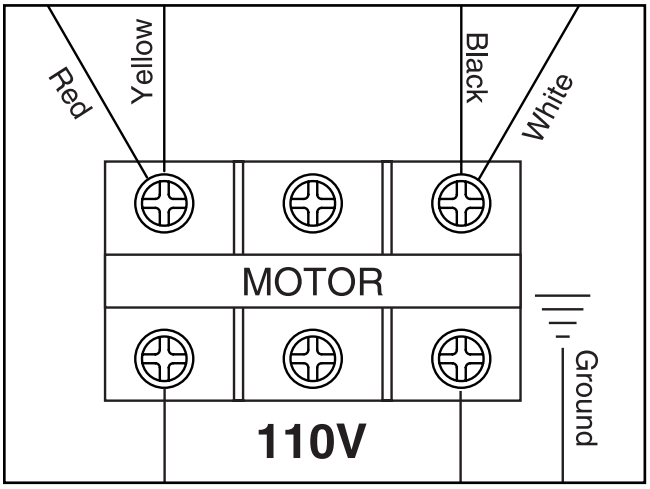


Figure 14. 110V motor wiring schematic.

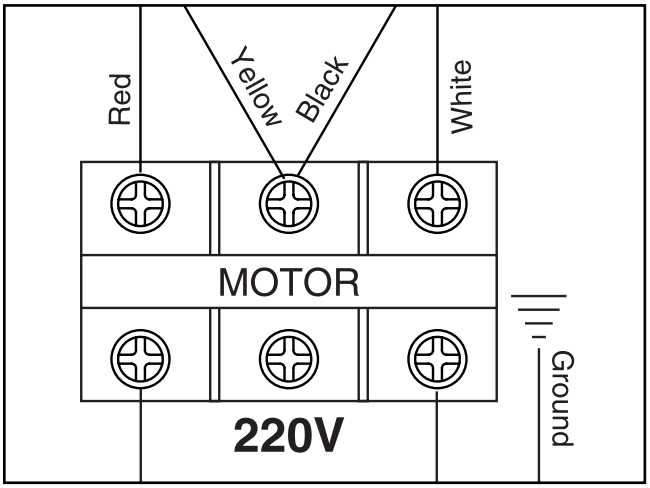


Figure 15. 220V motor wiring schematic.

4. Make sure the wiring connections are secure, then replace the wiring junction box cover.

5. Swing the motor back into position and replace the motor mounting bolts, but leave them finger tight for now.

Jointer to Stand

If you will be placing the jointer on a mobile base, set the stand on the mobile base before installing the jointer unit onto the stand.

If you will be bolting the stand to the floor, position the stand in its proper location and secure it to the floor, using fasteners through the mounting flanges shown in **Figure 16**, before installing the jointer unit on the stand.

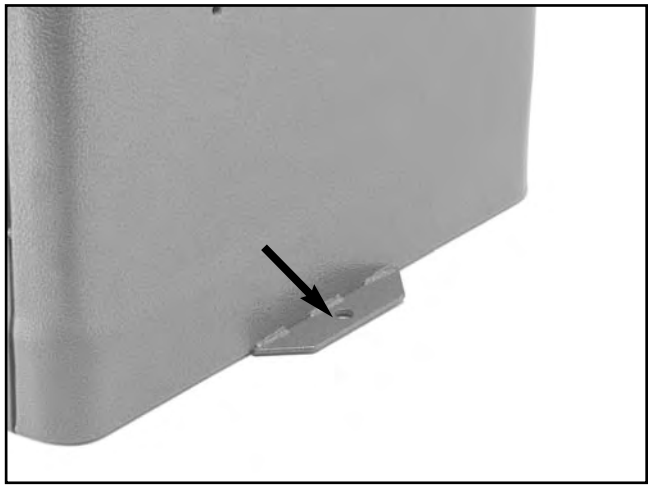


Figure 16. Jointer stand floor mounting flanges.

⚠CAUTION

The jointer unit is very heavy—get assistance when lifting it onto the stand. Serious personal injury may occur if safe moving methods are not followed.

To mount the jointer to the stand:

1. Lift the main unit onto the stand and position the cutterhead pulley over the pulley slot in the top of the stand.

2. Carefully align the mounting holes in the stand (shown in **Figure 17**) with the threaded holes in the base of the jointer.

3. Secure the jointer to the stand using the (3) ⅜"-16 x ¾" hex bolts and ⅜" flat washers provided. Be sure not to over-tighten!

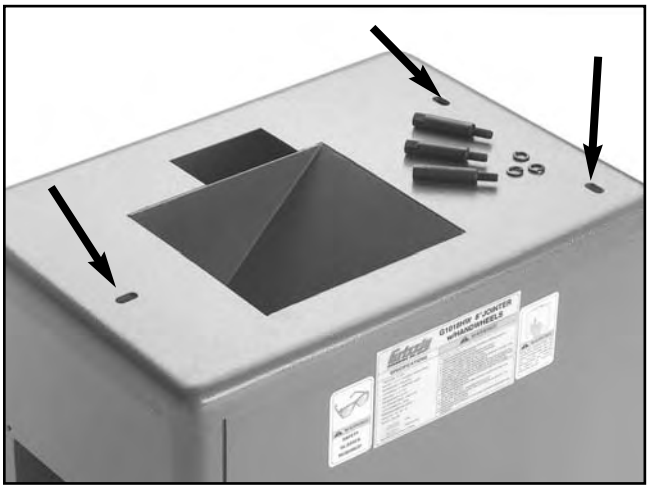


Figure 17. Jointer unit mounting holes.

V-Belt

To install the V-belt:

1. Open the stand cover to access the motor adjustment bolts.

2. Loosen the motor adjustment bolts shown in **Figure 18**, and slide the motor up until you can attach the V-belts to the pulleys.

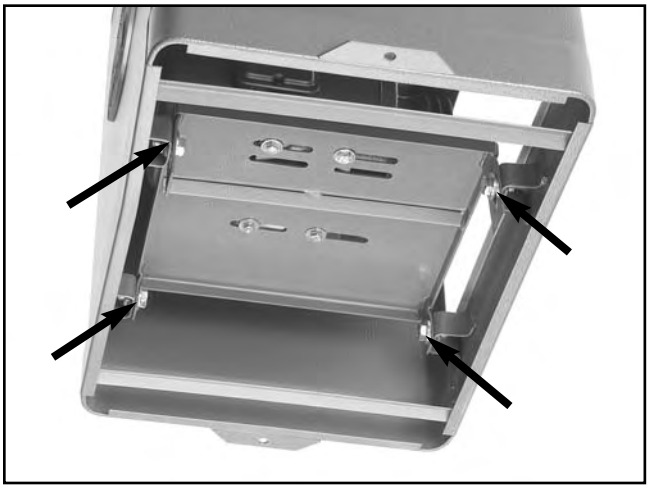


Figure 18. Motor adjustment bolts (shown underneath stand for clarity).

3. Allow the weight of the motor to rest against the V-belts.

4. Loosen the motor mount bolts shown in **Figure 19**.

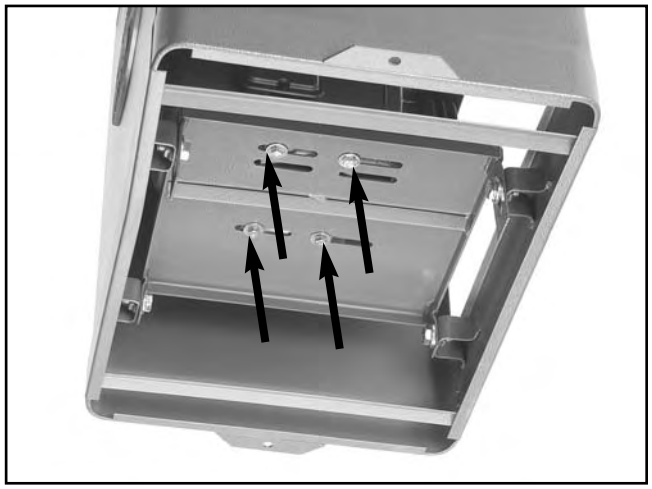


Figure 19. Motor mount bolts (shown underneath stand for clarity).

5. Move the motor on the mounting plate to align the motor and cutterhead pulleys with each other (See **Figure 20**). Visually confirm the pulley alignment from above (for the best accuracy use a straightedge for alignment confirmation).

6. Tighten the motor mount bolts.

7. If necessary, the pulley alignment can be fine tuned by loosening the motor pulley setscrews and moving the pulley in or out as necessary.

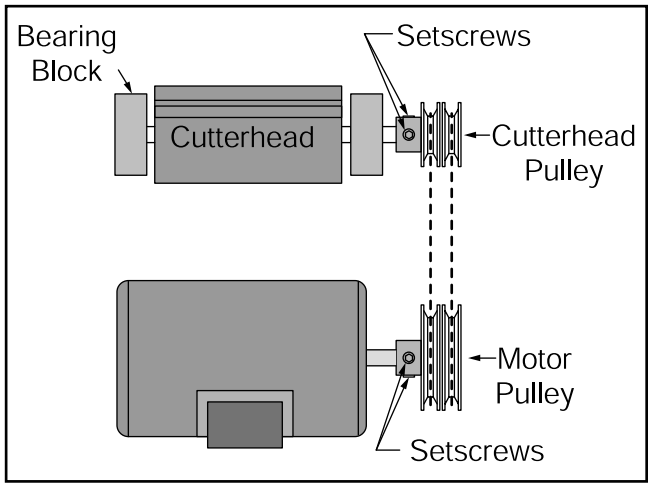


Figure 20. Pulley and V-belt alignment.

8. Place firm tension on the motor and tighten the motor adjustment bolts. Note—*Only use your hands to place tension on the motor. DO NOT use a pry bar or any other device to place added leverage on the motor.*

9. Check the V-belts for proper tension by lightly squeezing both sides together. If the belts can be easily squeezed together more than ½" on each side, increase the tension. If the pulley seems tight enough, continue with the assembly process. (You can always go back and make adjustments after the initial operation of the jointer.

Stand Cover

To install the stand cover:

1. Place the inset edge of the stand cover against the bottom edge of the stand opening.

2. Close the stand cover against the stand as shown in **Figure 21**, and turn the knob to secure the stand cover to the stand.

Figure 21. Closing stand cover.

Fence to Jointer

To install the fence on the jointer unit:

1. Place the fence on the jointer unit as it was before you removed it for clean up. Make sure the key on the fence support lines up with the keyway on the fence.

2. Install the fence lock the opposite way that you removed it before clean up, with the handle on top and the tabs of the nut facing up as shown in **Figure 22**.

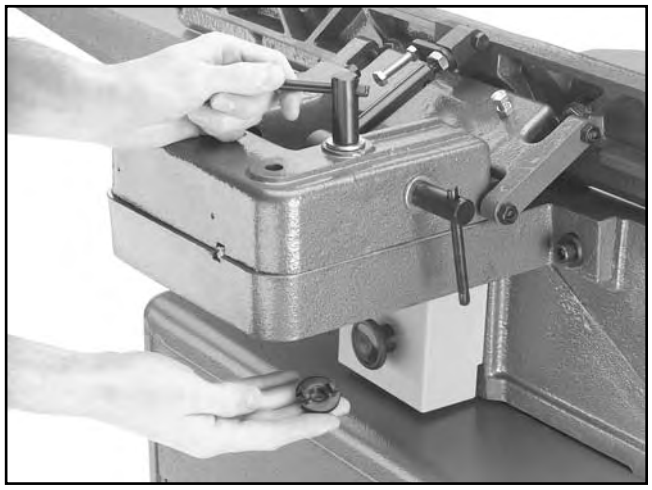


Figure 22. Installing fence lock with the tabs on the nut facing up.

3. Lock the fence in place by tightening the fence lock.

NOTICE

The fence can easily scratch the table while you are adjusting the fence position. To avoid scratches, loosen the fence lock enough to permit an easy adjustment and always use care when moving the fence.

G0500/G1018HW Handwheel Installation

To install the handwheels on the Model G0500/G1018HW:

1. Remove the screw and washer from the end of the leadscrew under each table, as shown in **Figure 23**.

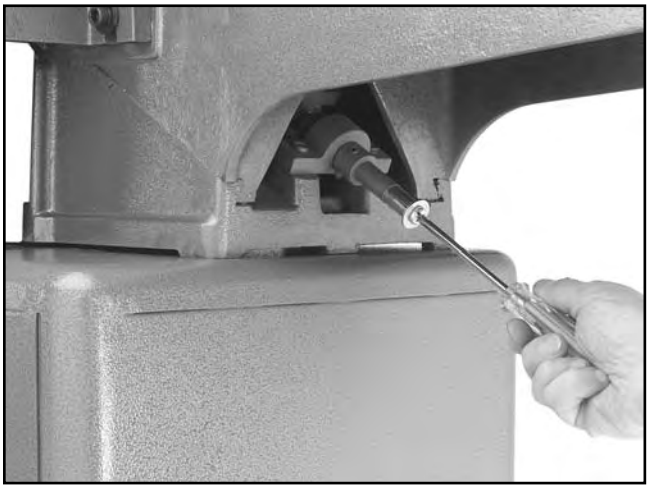


Figure 23. Removing screw from leadscrew.

2. On each leadscrew, install a handwheel, and secure it with the phillips head screw and washer that you removed in **step 1**.

3. Install a handle into each handwheel, as shown in **Figure 24**.

Figure 24. Installing handle into handwheel.

G1018 Table Lever Installation

To install the table levers on the Model G1018HW:

1. Thread a table lever into the adjustment block below each table, as shown in **Figure 25**.

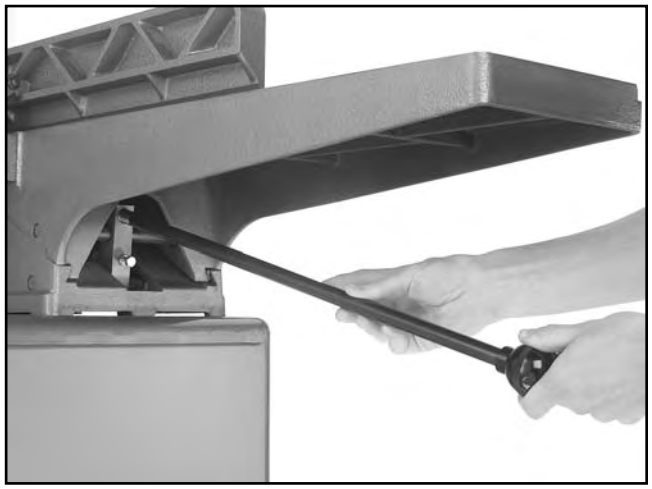


Figure 25. Installing table lever into adjustment block.

Knife Setting Gauge

To assemble the knife setting gauge:

1. Insert the steel rod through the hole in each adjuster arm until the notches for the E-clips extend past the adjustment arms on both sides.

2. Attach the E-clips to the notches to lock adjustment arms onto the steel rod. The adjustment arms are symmetrical, so the placement is not a concern. See **Figure 26**.

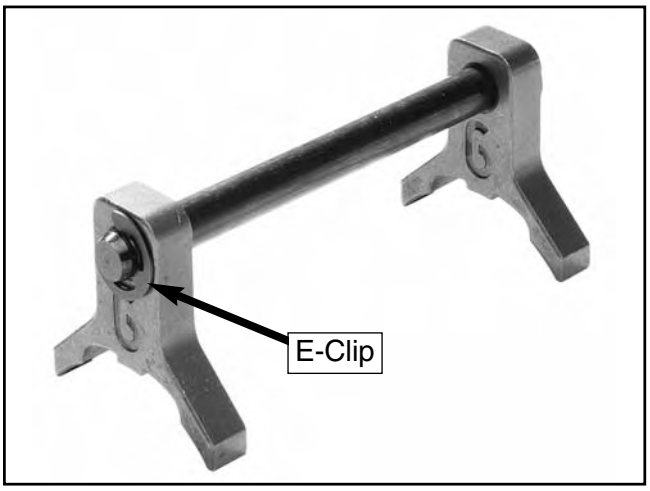


Figure 26. Assembled knife setting gauge.

Knife Inspection

The knives were set to their proper height at the factory, but we recommend that you inspect them to ensure proper operation and table setup.

To inspect the knife height:

1. Make sure that the power has not been connected to the machine at this point in the setup process!

2. Remove the belt guard shown in **Figure 27**.

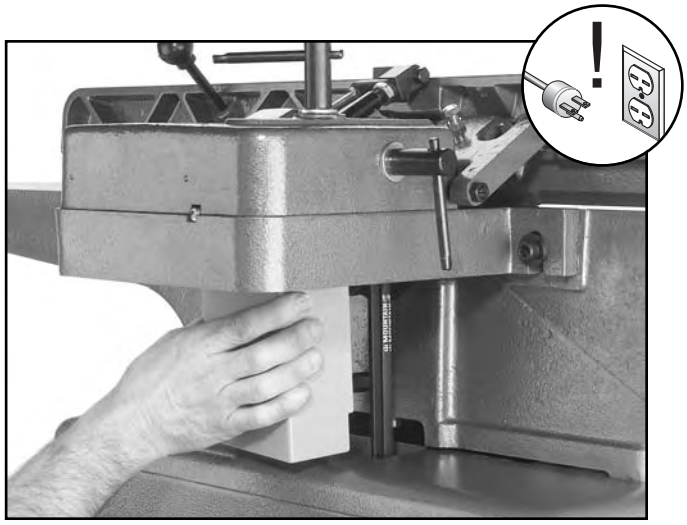


Figure 27. Removing belt guard.

3. Using the cutterhead pulley, rotate the cutterhead to make one of the knives accessible to the knife jig. Lower the tables if it is necessary to make more room.

4. Place the jig over the knife as illustrated in **Figure 28**.

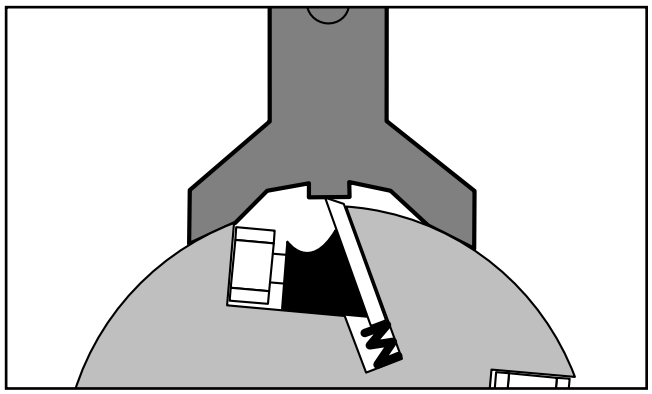


Figure 28. Jig placement on cutterhead.

5. Make sure that the middle pad of the jig is barely touching the knife and that the pads on the ends of the jig are resting firmly on the cutterhead.

6. Repeat **step 5** on all knives. If you find that any knives are out of adjustment, correct them as discussed in *Section 7: Service Adjustments*.

Table Alignment

Both tables can be adjusted by unlocking the table locks (see **Figure 29**) and rotating the handwheels. To accurately joint or plane a piece of stock, both tables must be aligned correctly, beginning with the outfeed table.

Figure 29. Jointer.

To align the outfeed table:

1. Remove the belt guard so you can rotate the cutterhead safely.

2. Rotate the cutterhead so that one of the knives is at top dead center. Note—*A knife is at top dead center when it is at its highest point during the rotation. See* ***Figure 30*** *for an illustration of a knife at top dead center.*

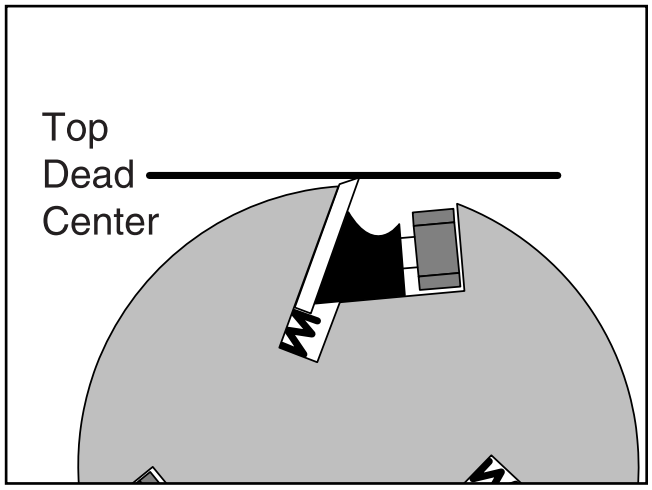


Figure 30. Cutterhead knife at top-dead-center.

3. Place a straightedge across the outfeed table, so the end of the straightedge is directly over the knife.

4. If the outfeed table is set correctly, the straightedge will lay across the table and barely touch the knife when it is at top dead center (see illustration in **Figure 31**). Verify that the outfeed table height reflects this condition.

5. If the outfeed table needs to be adjusted, release the outfeed table lock and adjust the height by rotating the handwheel that is located below the table.

6. When you have the outfeed table properly adjusted, lock the table height in place.

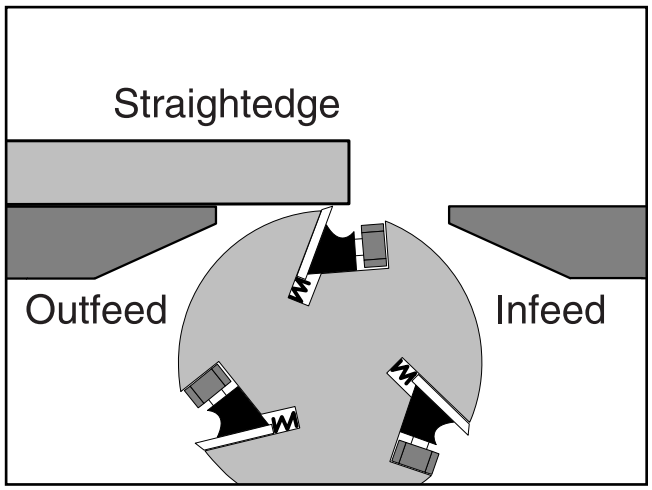


Figure 31. Outfeed table check.

To adjust the infeed table:

1. Make sure the outfeed table is adjusted as previously described.

2. Place a straightedge half way on the outfeed table and halfway over the infeed table.

3. Release the infeed table lock and adjust the infeed table flush with the outfeed table as illustrated in **Figure 32**. The infeed table should be exactly the same height as the outfeed table.

4. Lock the infeed table in place.

5. Set the pointer shown in **Figure 33** to *0* on the depth indicator scale.

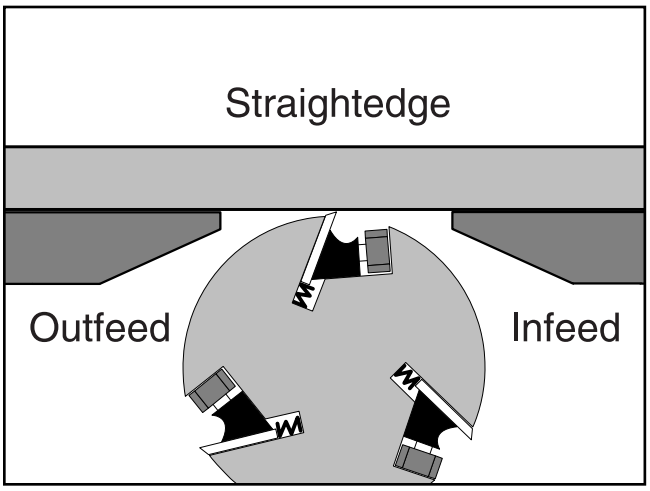


Figure 32. Infeed table even with outfeed table.

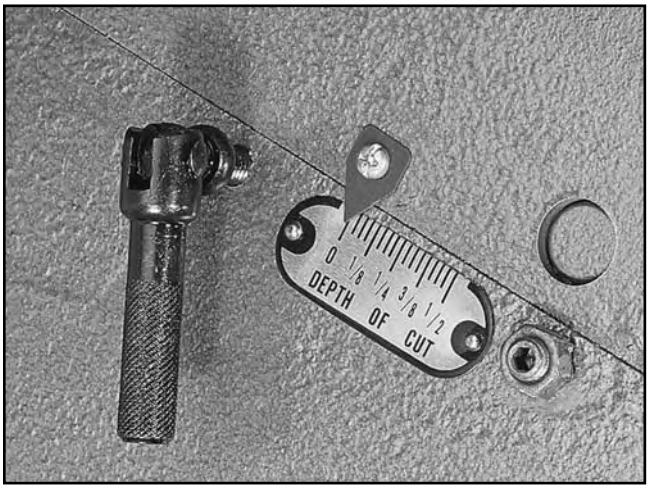


Figure 33. Pointer set to *0*.

G1018 Table Stops

The Model G1018 has table stop bolts (see **Figure 34**) that can be set to repeatedly bring the table back to *0* on the depth indicator scale. These table stop bolts are located directly under both table adjustment levers. If you do not have the Model G1018, skip these instructions.

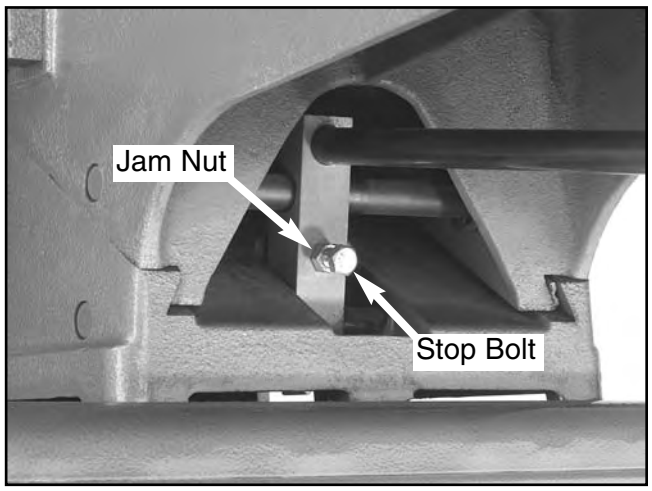


Figure 34. Model G1018 table stop bolt (only one side shown).

To set the Model G1018 outfeed table stop bolt:

1. Make sure the outfeed table has been adjusted as previously described.

2. Loosen the jam nut on the stop bolt, shown in **Figure 34**.

3. Turn the stop bolt clockwise until it makes contact with the table base behind the adjustment block.

4. Loosen the table lock and move the table down, then move it up until it stops. Make certain the table returns to its correct height by verifying that the outfeed table is even with one of the knife blades at top dead center.

5. Adjust and check as necessary, then tighten the jam nut on the stop bolt when the table will return to its correct position.

6. Lock the table in place.

To set the Model G1018 infeed table stop bolt:

1. Make sure that the infeed table has been adjusted and that the pointer on the depth indicator scale has been calibrated as previously described.

2. Loosen the jam nut on the stop bolt.

3. Turn the stop bolt clockwise until it makes contact with the table base behind the adjustment block.

4. Loosen the table lock and move the table down, then return it to the *0* setting. Make certain the table returns to the *0* point while using the stop bolt.

5. Adjust and check as necessary, then tighten the jam nut on the stop bolt when the table will return to its correct position.

6. Lock the table in place.

Cutterhead Guard

To install the cutterhead guard:

1. Locate the spring tang on the cutterhead guard that is shown in **Figure 35**.

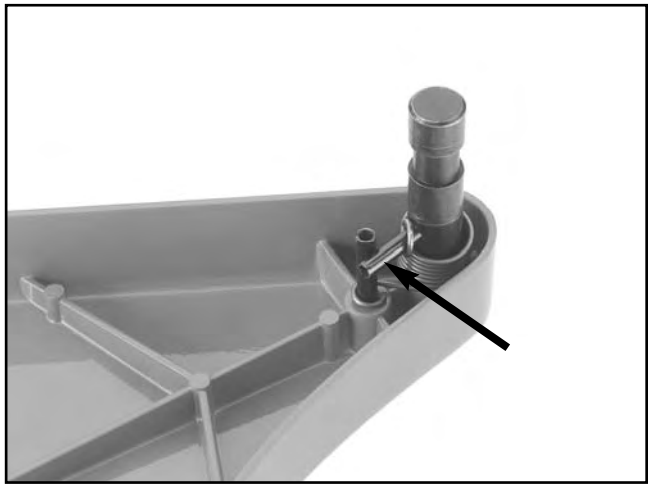


Figure 35. Spring tang on cutterhead guard.

2. Rotate the spring tang approximately half of a turn.

3. Keep tension on the spring tang and install the shaft into the shaft housing on the front of the infeed table as shown in **Figure 36**.

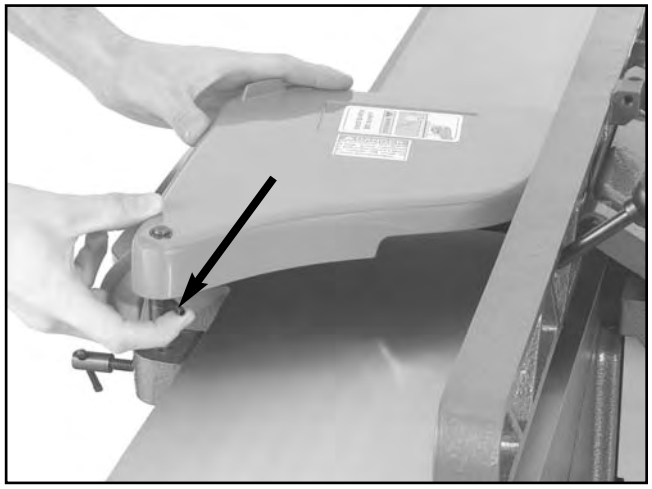


Figure 36. Installing cutterhead guard while holding spring tang.

4. Lower the shaft into the shaft housing far enough that the spring tang will rest against the edge of the infeed table when released, as shown in **Figure 37**.

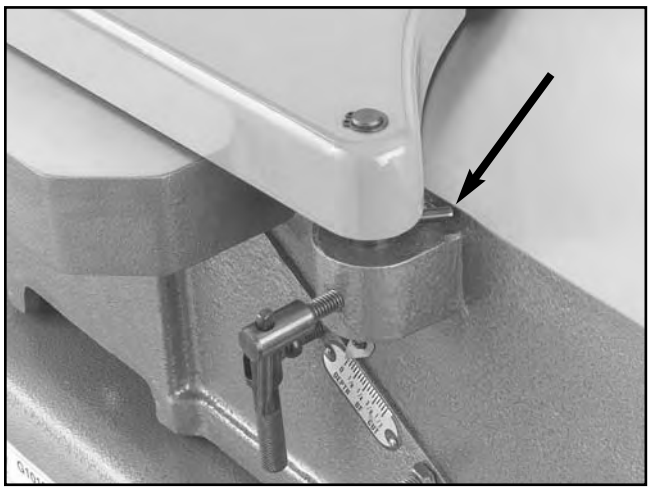


Figure 37. Spring tang against infeed table.

5. Tighten the lock at the front of the housing.

6. Test the cutterhead guard by moving it toward the front of the jointer and then letting it go. The guard should return back to its original position against the fence and over the cutterhead, or as shown in **Figure 38**. **This operation is extremely important for operator safety!**

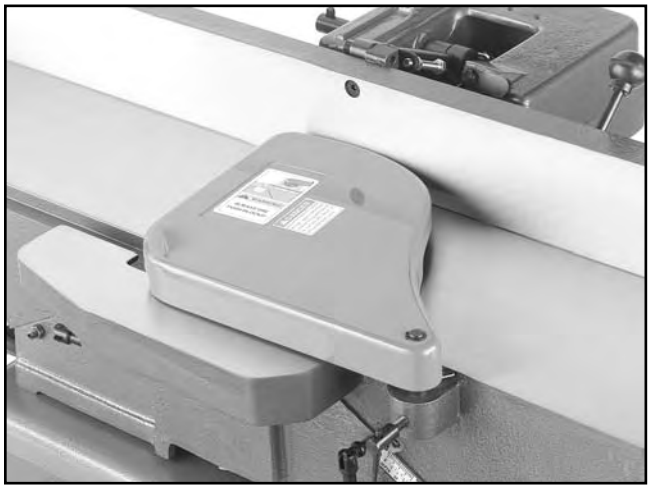


Figure 38. Cutterhead guard properly positioned over cutterhead and against fence.

7. If the guard drags across either table, release the lock at the shaft housing and move the guard up a little.

Fence Stops

The Grizzly 8" Jointers have three fence stops at 45˚ R, 90˚, and 45˚L (see **Figure 39**). It is important to check and adjust these stops to ensure proper operation and quality results.

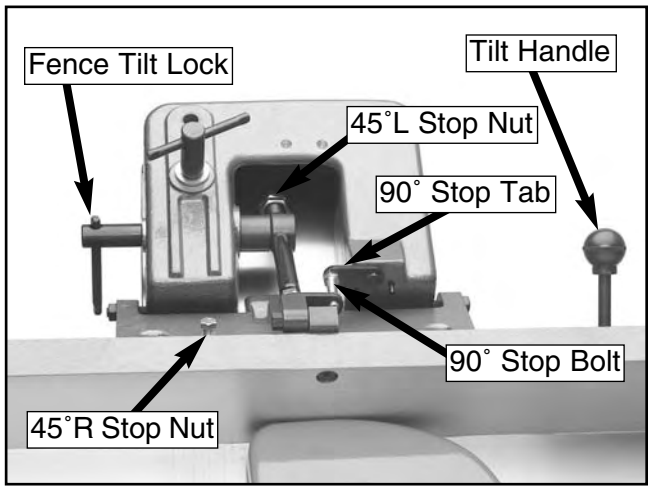


Figure 39. Fence stops, controls & components.

To check and adjust the 45˚ R fence stop:

1. Loosen the fence tilt lock handle.

2. Rotate the 90˚ stop tab out of the way and ease the fence back with the tilt handle, until it comes to rest on the 45˚ R stop bolt.

3. Use a bevel gauge that is set to 135˚, and place it on the table so the angled portion is against the fence as shown in **Figure 40**.

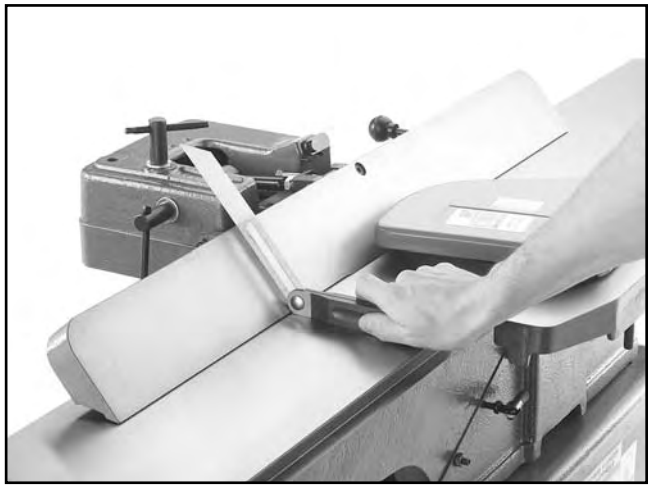


Figure 40. Checking the fence at 45˚R with a bevel gauge.

4. Check the current position of the fence. If it fits the angle of the bevel gauge, the fence is already set correctly. If it does not, then the fence needs to be adjusted.

5. Loosen the jam nut on the 45˚R fence stop bolt.

6. Adjust the 45˚R fence stop bolt until the fence angle matches the bevel gauge.

7. Tighten the jam nut on the 45˚R stop bolt to secure it in place. The 45˚R fence stop should now be correctly adjusted.

To check and adjust the 90˚ fence stop:

1. Loosen the fence tilt lock handle.

2. Place a 90˚ square on the table and against the fence as shown in **Figure 41**.

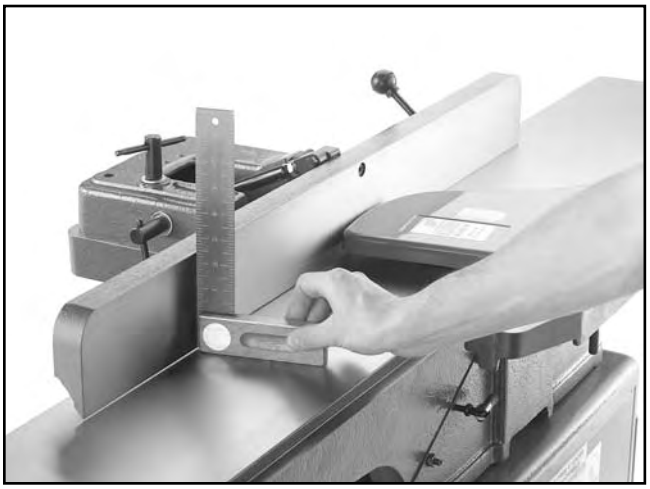


Figure 41. Checking the fence with a 90˚ square.

3. Check the current position of the fence. If it fits the 90˚ square, the fence is already set correctly. If it does not, then the fence needs to be adjusted.

4. Loosen the jam nut on the 90˚ stop bolt.

5. Adjust the 90˚ stop bolt until the fence angle matches the 90˚ square.

6. Tighten the jam nut on the 90˚ stop bolt to secure it in place. The 90˚ stop bolt should now be correctly adjusted.

To check and adjust the 45˚L fence stop:

1. Loosen the fence tilt lock handle.

2. Using the tilt handle, slowly tilt the fence toward the front of the jointer until it stops.

3. Set your bevel gauge to 45˚, and place it on the table so the angled portion is against the fence as shown in **Figure 42**.

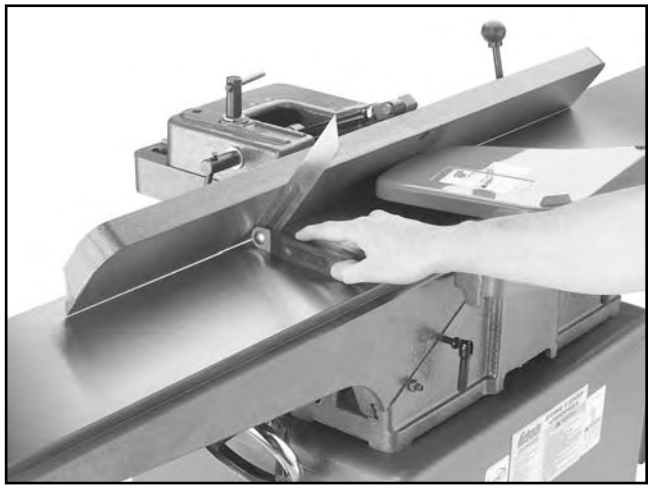


Figure 42. Checking the fence at 45˚ L with a 45˚ square.

4. Check the current position of the fence. If it fits the angle of the bevel gauge, the fence is already set correctly. If it does not, then the fence needs to be adjusted.

5. Loosen the jam nut on the 45˚L fence stop nut.

6. Adjust the 45˚L stop nut until the fence angle matches the bevel gauge.

7. Tighten the jam nut against the 45˚ L stop nut to secure it in place. The 45˚L fence stop should now be correctly adjusted.

Plug Installation

To install a plug on your power cord:

1. Refer to *Section 3: Circuit Requirements* to determine the correct plug and receptacle for your particular setup.

2. Have the plug and receptacle installed by a licensed electrician.

Test Run

Once assembly is complete, you are ready to test run the machine.

⚠WARNING

DO NOT attempt to investigate or adjust the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a complete stop before you do anything! Otherwise serious personal injury may occur.

Connect the power to the power supply. Press the START button. Make sure that your finger is poised on the STOP button, just in case there is a problem. The jointer 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 jointer seems to be running correctly, let it run 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.

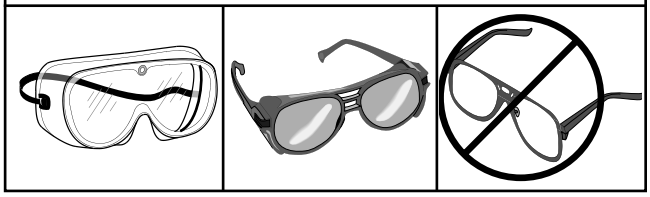
If you cannot locate the source of unusual noises, feel free to contact our service department for help.

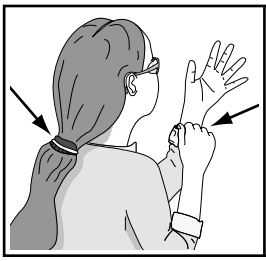
SECTION 6: OPERATIONS

Your safety is important! Please follow the warnings below during this entire section:

⚠WARNING

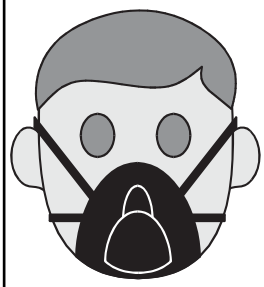
Operating this equipment creates the potential for flying debris to cause eye injury. Always wear safety glasses when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards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





⚠WARNING

Keep loose clothing out of the way of machinery and keep hair pulled back during operations.



⚠CAUTION

Using this machine produces sawdust that may cause short and long-term respiratory illness. Always wear a dust mask when operating this machine.

Stock Inspection & Requirements

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

- If the stock has large or loose knots, find another workpiece. Knots in a workpiece can be dangerous to the operator, as well as destructive to equipment.

- When jointing, always cut WITH the grain rather than AGAINST it. Cutting against the grain (going against the pattern of the wood's growth rings) chips the wood instead of cutting it, making the workpiece rough and irregular and increasing the chances that a kickback will occur.

  To check the grain direction, look at the side of your board. If the direction of the grain structure facing the cutterhead runs toward the cutterhead as it sits on the infeed table, your cut will be WITH the grain. See **Figure 43**.

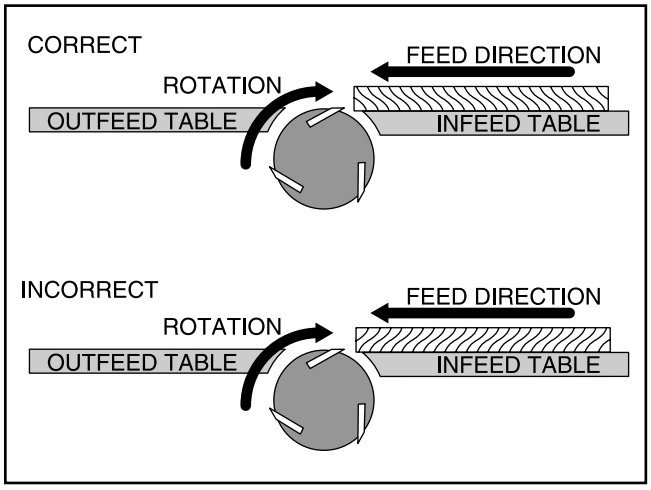


Figure 43. Correct and incorrect grain alignment to cutterhead.

- Make sure that any stock you process with the jointer is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects that may damage the jointer blades.

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

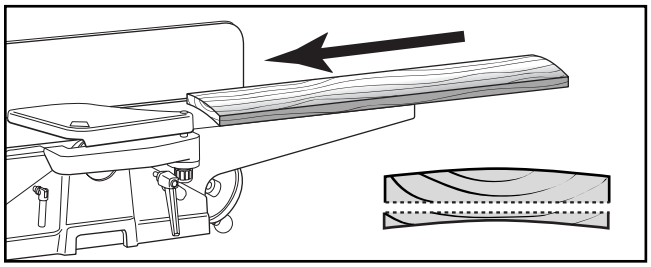
- Make sure any stock you joint is properly dried. Wood with a moisture content over 20% will cause unnecessary wear on the knives and will produce undesirable results.

NOTICE

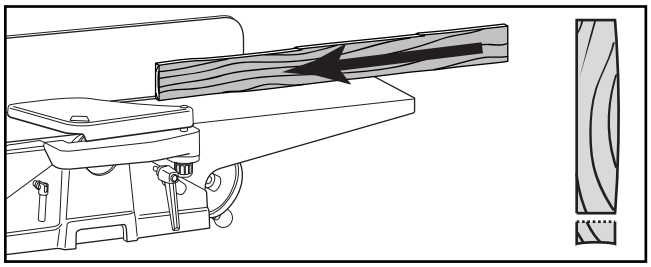
Occasionally, you will find woods that defy all rules. In those rare cases, it is best to feed the workpiece slowly and take several shallow cuts. A few extra passes will hurt much less than a ruined workpiece.

Squaring Stock

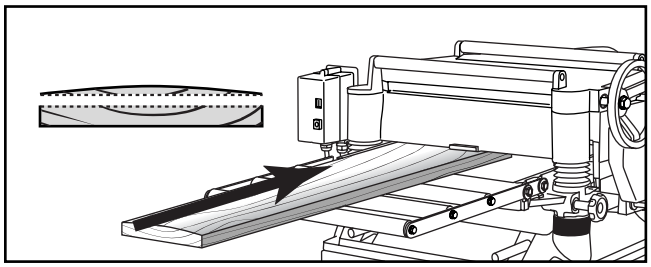
The jointer performs two of the four required operations for squaring up stock—surface planing and edge jointing. To help you understand these two operations better, we quickly describe the squaring process below:



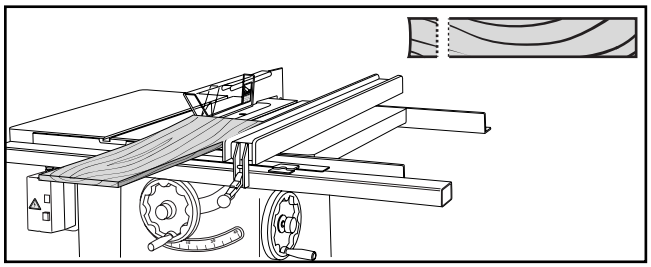
Step 1. Surface plane the concave face with a JOINTER to make it flat.



Step 2. Edge joint the best edge with a JOINTER to make it flat.



Step 3. Plane the second face with a THICKNESS PLANER to make it parallel to the first face.



Step 4. Rip the second edge with a TABLE SAW to make it parallel to the first edge.

Surface Planing

The purpose of surface planing is to make a flat face on a piece of stock to prepare it for planing on a thickness planer. See **Figure 44.**

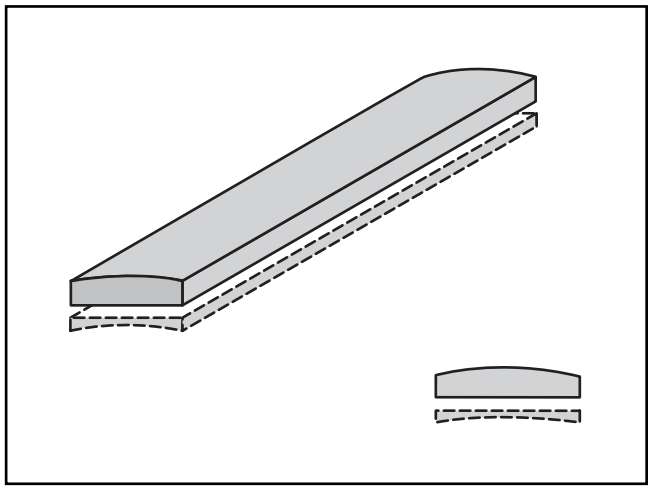


Figure 44. Illustration of surface planing effects.

NOTICE

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

To surface plane on the jointer:

1. Make sure that you have read and understand all safety instructions in *Section 1: Safety* and that your stock has been inspected for safe operation as described in the "Stock Inspection" instructions earlier in this section.

2. Make sure your workpiece is within the minimum and maximum stock dimensions that your Grizzly 8" Jointer can safely process. (Check the data sheet in the back of this manual for your particular model.)

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

4. Make sure your fence is set to 90˚

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

6. Start the jointer.

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

8. Feed the workpiece over the cutterhead as shown in **Figure 45**. Note—*When your leading hand (with push block) gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is over the outfeed table. At this point, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

9. Repeat **steps 7-8** until the entire surface is flat.

Figure 45. Surface planing the face of a workpiece.

Edge Jointing

The purpose of edge jointing is to produce a finished, flat-edged surface that is suitable for joinery or finishing. It is also a necessary step in the squaring process of rough or warped stock. **See Figure 46.**

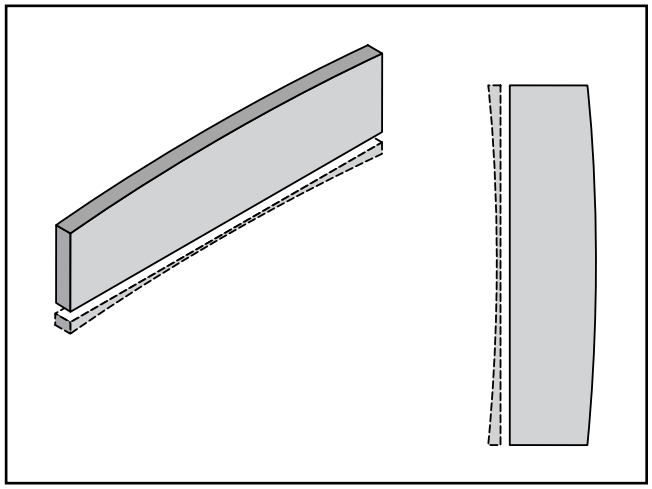


Figure 46. Illustration of edge jointing effects.

NOTICE

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

To edge joint on the jointer:

1. Make sure that you have read and understand all safety instructions in *Section 1: Safety* and that your stock has been inspected for safe operation as described in the "Stock Inspection" instructions earlier in this section.

2. Make sure your workpiece is within the minimum and maximum stock dimensions that your Grizzly 8" Jointer can safely process. (Check the data sheet in the back of this manual for your particular model.)

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

4. Make sure the fence is set to 90˚.

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

6. Start the jointer.

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

8. Feed the workpiece over the cutterhead as shown in **Figure 47**. Note—*If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place it on the portion of the workpiece that is over the outfeed table. At this point, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

9. Repeat **steps 7-8** until the entire edge is flat.

Figure 47. Edge jointing a workpiece.

Bevel Cutting

The purpose of bevel cutting is to cut a specific angle into the edge of a workpiece. See **Figure 48.**

The Grizzly 8" Jointers have preset fence stops at 45˚ to the left and 45˚ to the right. If your situation requires a different angle, the preset fence stops can be easily adjusted for your needs.

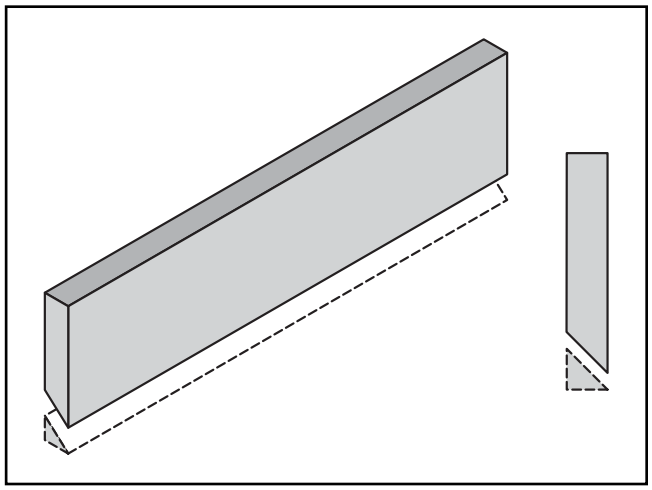


Figure 48. Illustration of bevel cutting effects.

NOTICE

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

To bevel cut on the jointer:

1. Make sure that you have read and understand all safety instructions in *Section 1: Safety* and that your stock has been inspected for safe operation as described in the "Stock Inspection" instructions earlier in this section.

2. Make sure your workpiece is within the minimum and maximum stock dimensions that your Grizzly 8" Jointer can safely process. (Check the data sheet in the back of this manual for your particular model.)

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

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

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

6. Start the jointer.

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

8. Feed the workpiece over the cutterhead as shown in **Figure 49**. Note—*If your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is over the outfeed table. At this point, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

9. Repeat **steps 7-8** until the angled cut is satisfactory to your needs.

Figure 49. Bevel cutting with the fence at 45˚.

Rabbet Cutting

The purpose of rabbet cutting is to remove a section of the workpiece edge. When combined with another rabbet cut edge, the rabbet joints create a simple, yet strong method of joining stock. See **Figure 50.**

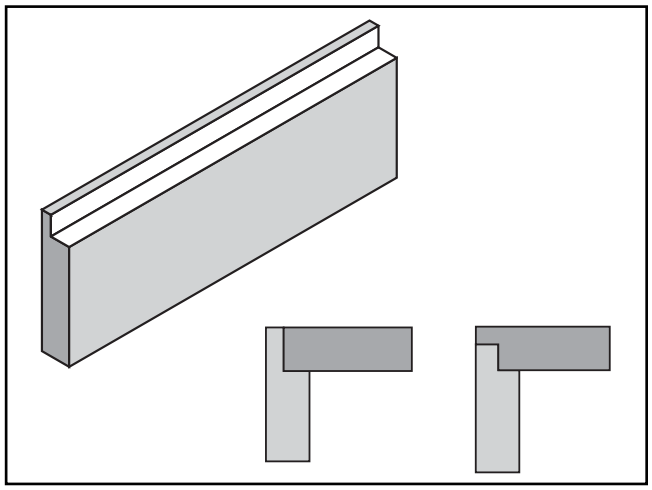


Figure 50. Illustration of rabbet cutting effects and a few sample joints.

NOTICE

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

To rabbet cut on the jointer:

1. Make sure you have read and understand all safety instructions in *Section 1: Safety* and that your stock has been inspected for safe operation as described in the "Stock Inspection" instructions earlier in this section.

2. Make sure your workpiece is within the minimum and maximum stock dimensions that your Grizzly 8" Jointer can safely process. (Check the data sheet in the back of this manual for your particular model.)

3. If your workpiece is cupped (warped), it should be straightened out before you attempt to make a rabbet cut.

4. Set the cutting depth for your operation. (We suggest between 1/16" and 1/8" for rabbet cutting, using a more shallow depth for harder wood species or for wider stock.)

5. Make sure your fence is moved forward, so the amount of infeed/outfeed table exposed is the same as the size of your rabbet. Also, make sure your fence is set to 90˚

6. Start the jointer.

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

8. Feed the workpiece over the cutterhead as shown in **Figure 51**. Note—*When your leading hand gets within 4" of the cutterhead, lift it up and over the cutterhead, and place the push block on the portion of the workpiece that is over the outfeed table. At this point, focus your pressure on the outfeed end of the workpiece while feeding, and repeat the same action with your trailing hand when it gets within 4" of the cutterhead. To keep your hands safe, DO NOT let them get closer than 4" from the cutterhead when it is moving!*

9. Repeat **steps 7-8** until the your rabbet is cut to depth.

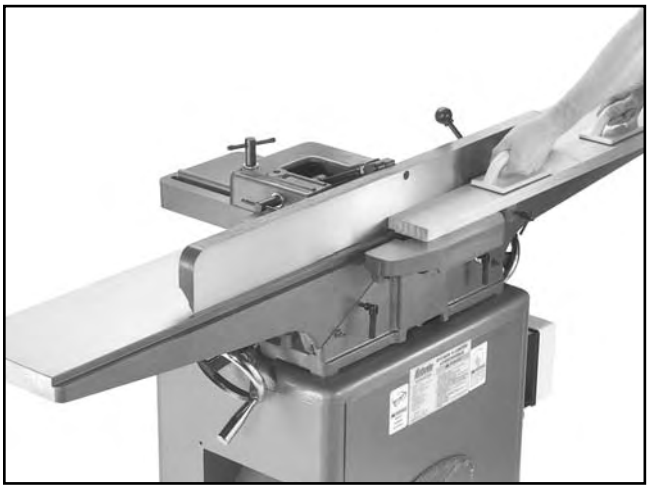
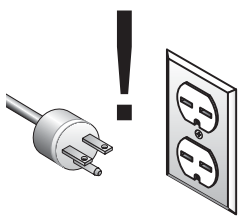


Figure 51. Rabbet cutting a workpiece.

SECTION 7: MAINTENANCE



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

General

Regular periodic maintenance on your Grizzly 8" jointer will ensure its optimum performance. Make a habit of inspecting your jointer 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

The table and other non-painted surfaces on your Grizzly 8" Jointer should be protected against rust and pitting. Wiping the table clean after every use ensures that moisture from wood dust does not remain on bare metal surfaces.

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

Lubrication

Since all bearings are shielded and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them. Table ways and the fence assembly should not be lubricated. If the tables appear to be stuck, disassemble and clean any foreign materials from the ways. Re-assemble and reset the gibs.

V-Belt

Inspect regularly for tension and wear. Check the V-belt tension by squeezing them in the center. If you can squeeze them more than ½" on both sides, using moderate pressure, then they need to be tightened. Check pulleys to ensure that they are properly aligned. To replace or adjust the V-belts, see *Section 8: Service Adjustments*.

Knife Condition

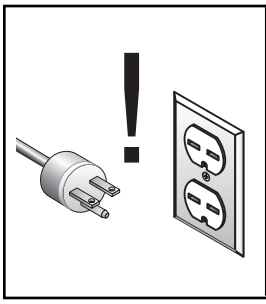
Using sharp knives is one of the most important factors involved with the operation of the jointer. A good maintenance procedure is to hone the knives to keep them in top shape. A knife hone will polish and finely sharpen jointer knives quickly and easily without removing them.

For damaged or extra dull knives, have them resharpened by a professional grinder. To avoid downtime from resharpening, we recommend having an extra set of knives on hand.

Maintenance Log

Date	Approximate Hours Of Use	Maintenance Performed

SECTION 8: SERVICE ADJUSTMENTS



⚠WARNING

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

About Service

This section is designed to help the operator with adjustments that were made at the factory and might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Setting Knives

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

The knives on your Grizzly 8" Jointer should be set .051" (1.3MM)-.060" (1.5MM) higher than the cutterhead. The knife jig included with the jointer is designed to set the knives within this height.

The Grizzly 8" Jointers come with both jack screws and springs to provide you with two options for cutterhead adjustments (see **Figure 52**). Note—*Only one of these options is needed to set the knives—see* ***step 5**** *for clarification.*

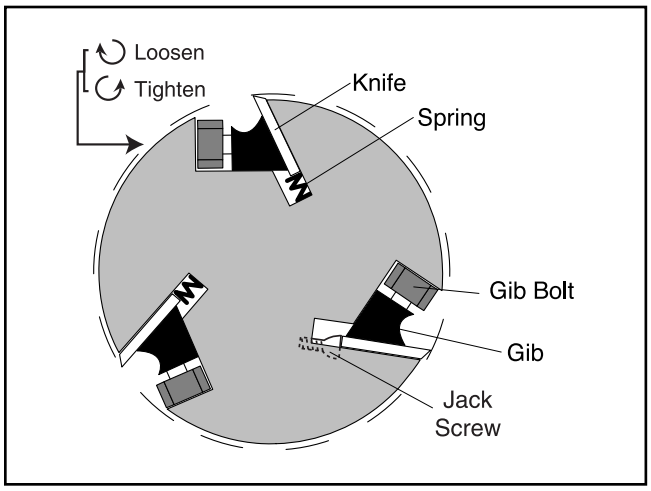


Figure 52. Cutterhead profile.

To set the knives:

1. Disconnect the jointer from the power source!

2. Remove the cutterhead guard from the table and lower the infeed and outfeed tables as far as they go. This will give you unrestricted access to the cutterhead.

3. Remove the belt guard to expose the cutterhead pulley.

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

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

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

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

6. Position the knife gauge over the knife as shown in **Figure 53** and loosen the gib bolts until the knife is completely loose.

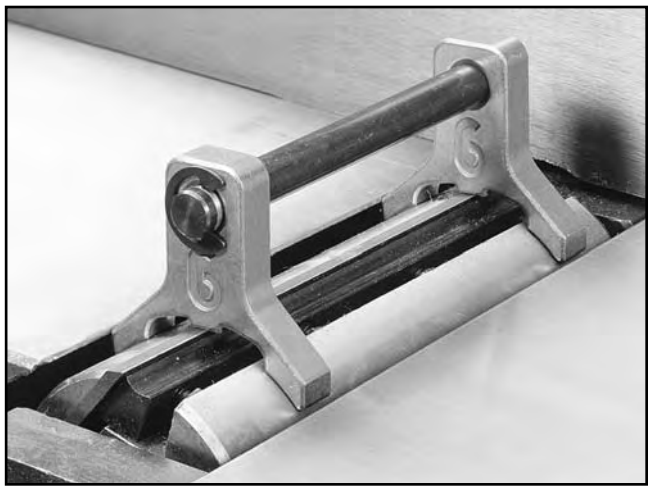


Figure 53. Jig placement on cutterhead.

7. **Jack Screws**—Using a 3MM allen wrench, find the jack screws through the access holes in the cutterhead (**Figure 54**) and rotate the jack screws to raise or lower the knife. When the knife is set correctly, it will barely touch the middle pad of the knife setting jig. Snug the gib bolts tight enough to just hold the knife in place. Repeat **steps 5-7** with the rest of the knives.

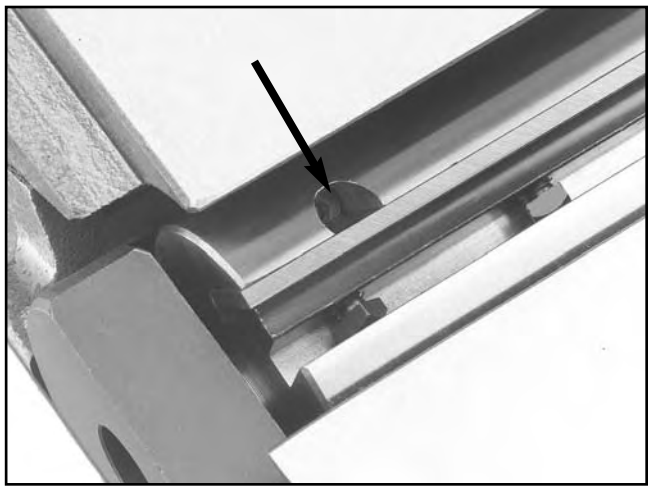


Figure 54. Jack screw access hole.

Springs—Push the knife down with the jig so that the knife edge is touching the middle pad of the jig. Hold the jig down and tighten the gib bolts just tight enough to hold the knife in place. Repeat **steps 5-7** with the rest of the knives.

8. Rotate the cutterhead to the first knife you started with. Slightly tighten all the gib bolts, starting at the ends and working your way to the middle by alternating left and right. Repeat this step on the rest of the knives.

9. Repeat **step 8**.

10. Repeat **step 8**, but final tighten each gib bolt.

Adjusting Gibs

The function of the table gibs (shown in **Figure 55**) is to eliminate excessive play in the table movement. The gibs also control how easy it will be to move the tables up and down.

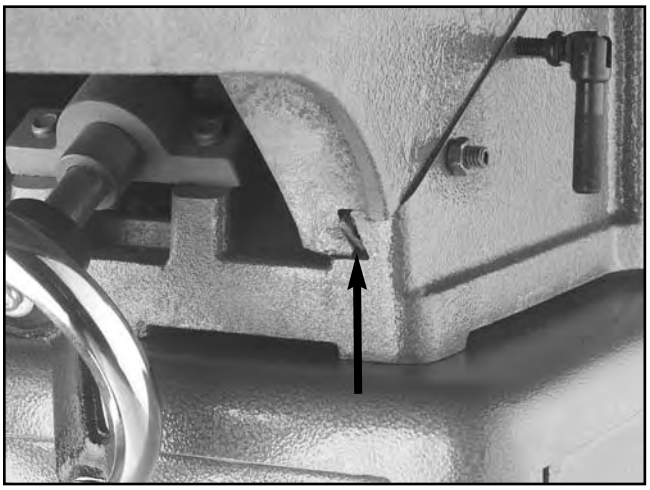


Figure 55. Table gibs.

To adjust the table gibs:

1. Loosen the table lock.

2. Loosen the lock nuts and setscrews shown in **Figure 56** on the next page. Make sure you support the table as you loosen it to prevent it from dropping to the end of its travel.

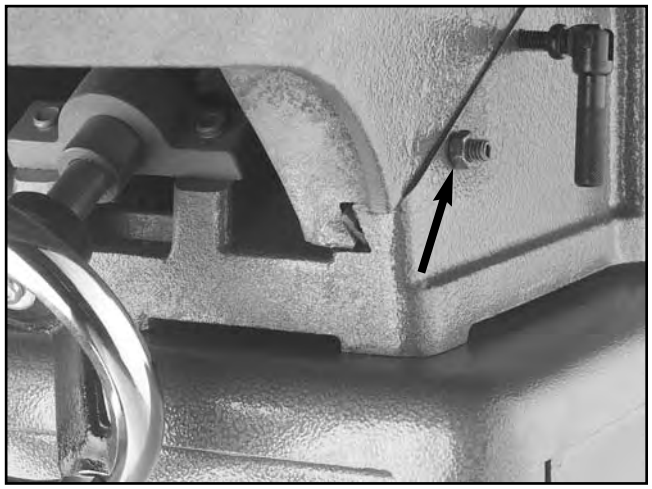


Figure 56. Table gib lock nuts and setscrews.

5. Evenly tighten both gib setscrews a small amount, then check the table by moving it up and down. Adjust the setscrews as needed until the friction of the table movement is balanced between minimal play and ease of movement. Note—*Tighter gibs reduce play but make it harder to adjust the tables.*

6. Repeat **steps 1-5** with the other table.

7. Adjust the table height of both tables before resuming with any operations.

Adjusting V-Belts

In order for your jointer to perform at its best, you should check (and adjust if necessary) the V-belt tension and alignment.

To adjust the V-belt tension:

1. Disconnect the jointer from the power source!

2. Remove the stand door to gain access to the V-belts.

3. Loosen the motor adjustment bolts shown in **Figure 57**.

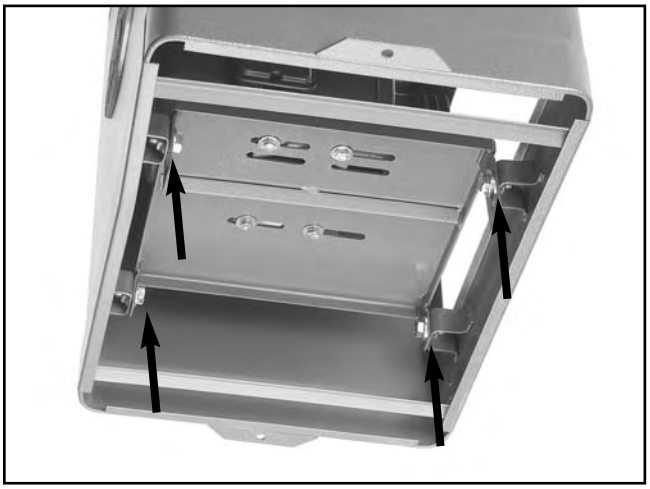


Figure 57. Motor adjustment bolts (shown underneath stand for clarity).

4. Push down on the motor with one hand and tighten the motor adjustment bolts with the other hand.

5. Check the V-belt tension by squeezing them in the center, as shown in **Figure 58**. If you can squeeze the V-belts more than ½" on both sides, using moderate pressure, then they need to be tighter—repeat **steps 3-5**.

6. When the V-belt tension is correct, replace the stand door.

Figure 58. Checking V-belt tension.

To adjust the V-belt alignment:

1. Disconnect the jointer from the power source!

2. Remove the stand door to gain access to the V-belts.

3. Loosen the motor mount bolts shown in **Figure 59**.

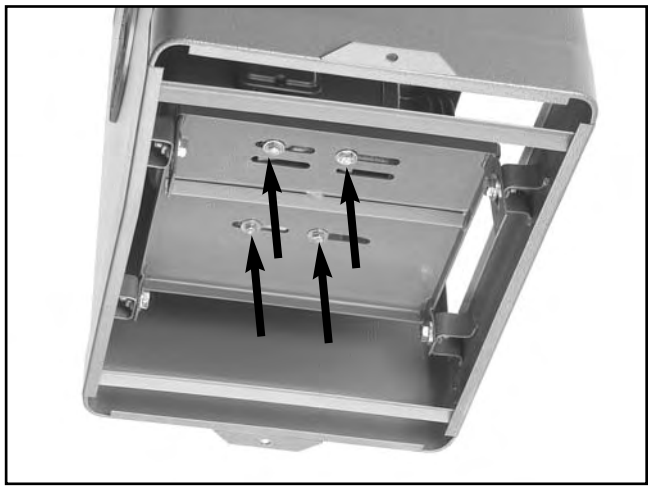


Figure 59. Motor mount bolts(shown underneath stand for clarity).

4. Use a straightedge to align the motor and cutterhead pulleys.

5. Tighten the motor mount bolts. Note—*Minor alignment changes can be made by loosening the setscrew on the pulleys and adjusting them on their shaft.* Replace the stand door.

Replacing V-Belt

During the life of your jointer, you will need to replace the V-belts when they become cracked or damaged.

To replace the V-belts:

1. Disconnect the jointer from the power source!

2. Remove the stand door to gain access to the V-belts.

3. Loosen the motor adjustment bolts shown in **Figure 60**.

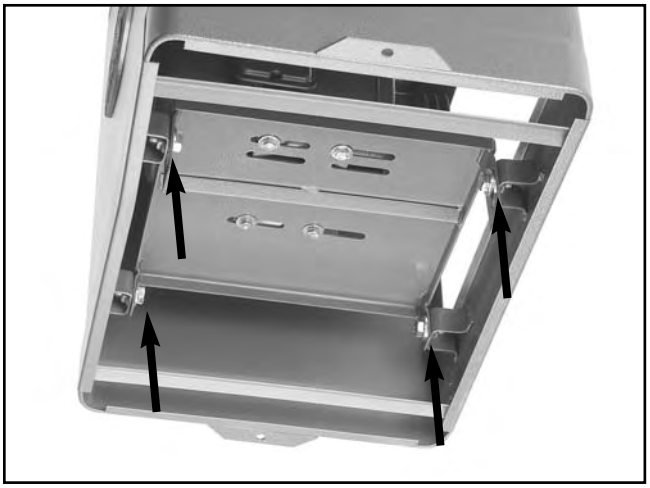


Figure 60. Motor adjustment bolts (shown underneath stand for clarity).

4. Move the motor up to loosen and remove the V-belts from the motor and cutterhead pulleys.

5. Install the new V-belts on the motor and cutterhead pulleys.

6. Adjust the V-belts to their proper tension.

7. Replace the stand door.

Service Log

Date	Approximate Hours Of Use	Service Performed

SECTION 9: REFERENCE INFO

The following pages contain aftermarket accessories, troubleshooting, the wiring diagram, general machine data, parts diagrams, parts lists and Warranty/Return information for your Model G0500/G1018/G1018HW.

If you need parts or help in assembling your machine, or if you need operational information, call the Grizzly Service Department. Trained service technicians will be glad to help you.

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

Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

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 at the location listed below.

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

Aftermarket Accessories

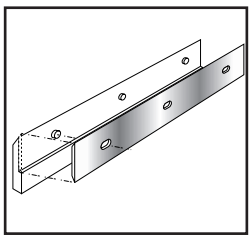
To order any of the aftermarket accessories below, find the model number in bold and call our customer service line 24 hours a day at 1-800-523-4777.

Set of 3 High-Speed Steel Knives..... **G6698**
Small Push Block **G2405**
Large Push Block **G2406**
4" Dust Exhaust Hood..... **G1841**

Jointer Pal® Magnetic Knife Setting Jigs
These patented jigs are remarkably simple to use and hold the blades precisely while you tighten them in to the cutterhead. They also allow you to shift nicked knives to avoid replacement or removal!

Steel Body..... **G1753**
Brass Body (for Carbide Knives)..... **G1756**

DISPOZ-A-BLADE®
Once you install this system, you never have to worry about setting knives again! Just remove the lock plate, snap replacement knives in position, and replace the lock plate. That's all there is to it!

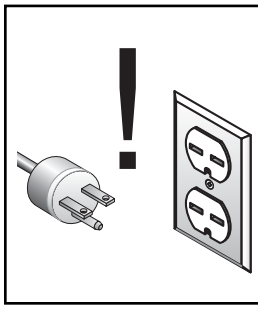


Holder & Knives System **G6661**
Replacement Knives Only..... **G6666**

Heavy-Duty SHOP FOX® Mobile Base
Make your jointer mobile with this popular patented mobile base..... **G7314**

TROUBLESHOOTING GUIDE

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.	1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2 Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows when operating.	1. Applying too much pressure to workpiece. 2. V-belts loose.	1. Feed workpiece slower. 2. Adjust V-belts. See **page 38-39**.
Loud, repetitious noise coming from machine.	1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective.	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Tighten fan or shim cover. 3. Replace V-belts. See **page 39**.
Snipe (gouge in the end of the board that is uneven with the rest of the cut)	1. Outfeed table is set too low	1. Align outfeed table with cutterhead knife at top dead center. See **page 22-23**.
Workpiece stops in the middle of the cut	1. Outfeed table is set too high.	1. Align outfeed table with cutterhead knife at top dead center. See **page 22-23**.
Chipping	1. Knots or conflicting grain direction in wood. 2. Dull knives. 3. Feeding too fast. 4. Taking too deep of a cut.	1. Inspect stock for knots and grain. 2. Inspect and sharpen cutterhead knives. 3. Slow down the rate that you feed the wood into the cutterhead. 4. Raise the infeed table to take a smaller depth of cut. Never exceed ⅛" per pass when edge jointing or 1/32" when surface planing. Reduce cutting depth for harder woods.
Fuzzy grain	1. Wood may have high moisture content or surface wetness. 2. Dull knives.	1. Check moisture content and allow to dry if moisture is too high. 2. Inspect and sharpen cutterhead knives.

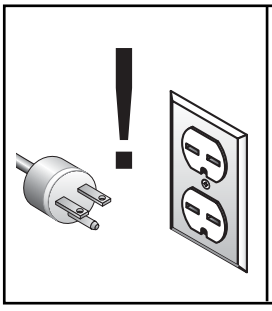


⚠WARNING

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

TROUBLESHOOTING GUIDE

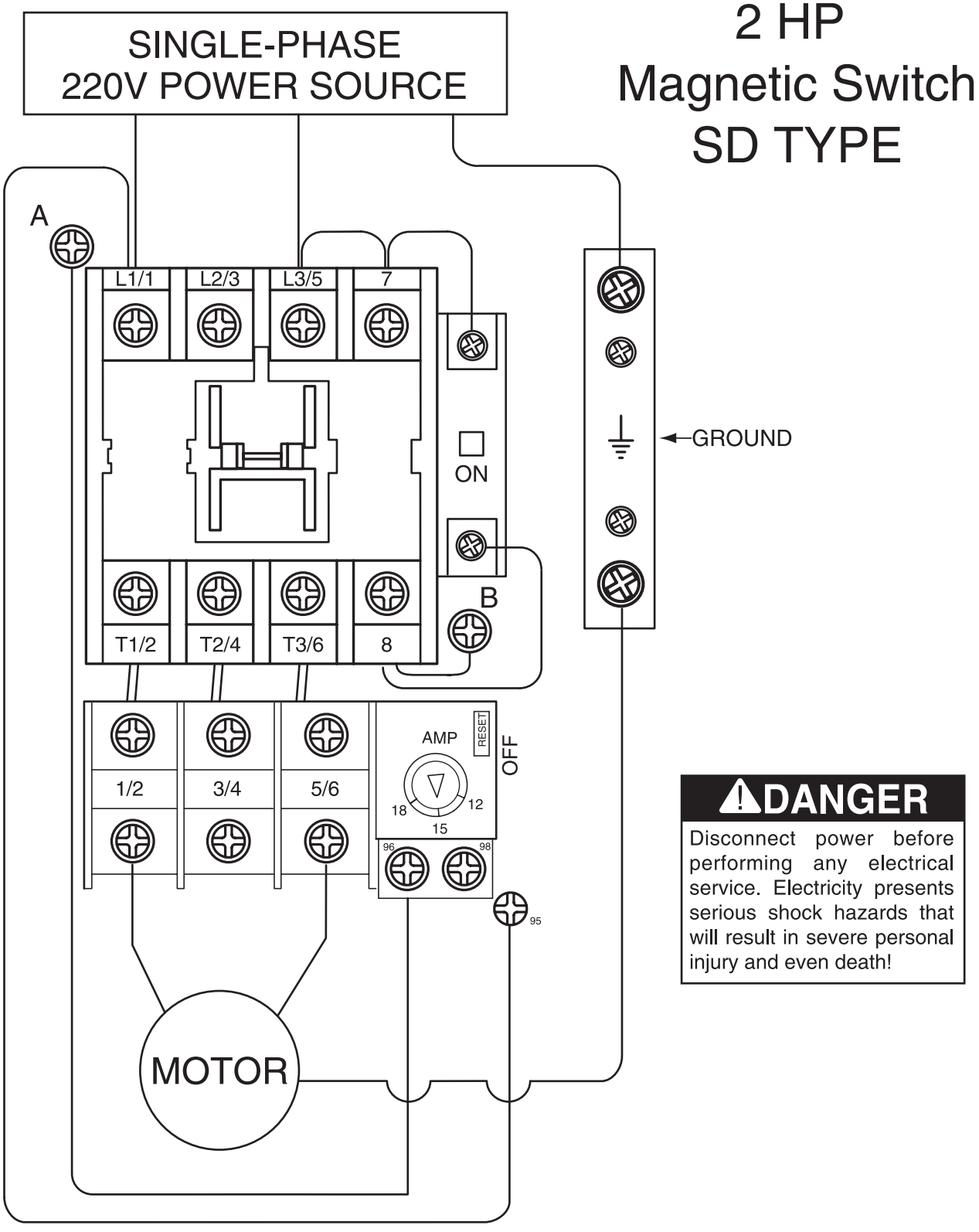
SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Lines or ridges in on board	1. Nicked or chipped knives.	1. Inspect and sharpen the cutterhead knives.
Uneven knife marks on board	1. One or more knives out of alignment.	1. Reset the knives in the cutterhead, using the knife setting jig. See **page 36-37**.
Wavy surface or chatter marks on board	1. Board being fed too fast. 2. Knives set incorrectly.	1. Slow down the feed rate and feed consistently. DO NOT stop or hesitate during feeding. 2. Inspect and sharpen the cutterhead knives. Reset knives in cutterhead, using the knife setting jig. See **page 36-37**.
Board edge is concave or cr convex after jointing	1. Board not held with even pressure on infeed and outfeed table. 2. Board was too uneven start. 3. Board has excessive bow or twist along its length. 4. Insufficient number of passes.	1. Hold board with even pressure as it moves through the cutterhead. See **page 31** for more details about the proper method for edge jointing. 2. Take partial cuts to remove the extreme high spots before doing a full pass. 3. Surface plane one face so there is a good surface to position against the fence. 4. It may take 3 to 5 passes to achieve a perfect edge, depending on the starting condition of the board and the depth of cut.
Uneven cut or breakout when rabbeting	1. Uneven feed rate. 2. Depth of cut too deep. 3. Dull knives. 4. Improper end grind.	1. Feed the board evenly and smoothly during the cut. 2. Raise the infeed table to take a smaller depth of cut. Never exceed 1/16" per pass when rabbeting. 3. Inspect and sharpen the cutterhead knives. 4. Grind a bevel on the end face of the knife to allow a relief, or take your knives to a professional and have this service performed.
Tables are hard to adjust.	1. Table lock is partially engaged. 2. Table gibs are too tight.	1. Completely loosen the table lock. 2. Re-adjust the table gibs. See **page 37-38**.
Excessive play in table movement.	1. Table gibs are too loose.	1. Re-adjust the table gibs. See **page 37-38**.



WARNING

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

G0500/G1018/G1018HW Wiring Diagram



⚠DANGER

Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

MACHINE DATA SHEET

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

MODEL G0500 8" X 75" JOINTER W/4-BLADE CUTTERHEAD

Design Type: .....Cabinet

Overall Dimensions:

- Table Size.....9" W x 75" L
- Height (from floor to table) .....31¼"
- Overall Length .....75"
- Overall Width .....24"
- Shipping Weight .....461 lbs.
- Net Weight .....310 lbs.
- 1st Box Size .....67" L x 25" W x 25" H
- 2nd Box Size .....26¼" L x 18½" W x 25" H
- Foot Print .....23½" x 16½"
- Cutterhead Diameter .....3"

Capacities:

- Maximum Depth of Cut.....½"
- Maximum Width of Cut .....8"
- Cutterhead Speed .....5500 RPM
- Cuts Per Minute.....22,000

Construction:

- Tables .....Independently Adjustable, Precision Ground Cast Iron
- Stand.....Preformed Steel
- Ways .....Dovetailed, Adjustable
- Fence Assembly.....Cast Iron
- Body Assembly.....Cast Iron
- Base .....One Piece Steel Cabinet
- Cutterhead .....4 Knife Slots w/ Jack Screws and Springs
- Guard .....Die Cast Metal
- Bearings.....Shielded and Lubricated

Motor:

- Type .....TEFC Capacitor Start Induction
- Horsepower.....2 HP
- Phase / Voltage .....Single-Phase 110V/220V
- Amps.....24A / 12A
- Cycle / RPM .....60 Hertz / 3450 RPM
- Switch .....Magnetic w/Thermal Overload Protector
- Power Transfer .....Double V-Belt Drive
- Bearings .....Shielded & Lubricated Ball Bearings

Features:

- Fence .....Center Mounted, Positive Stops at 45° and 90°
- Table Movement.....Handwheels
- Infeed & Outfeed Tables .....Rabbeting Capacity Built-In
- Dust Chute .....Built-In
- Knives .....(4) 8" x ⅛" x ¾"

Specifications, while deemed accurate, are not guaranteed.

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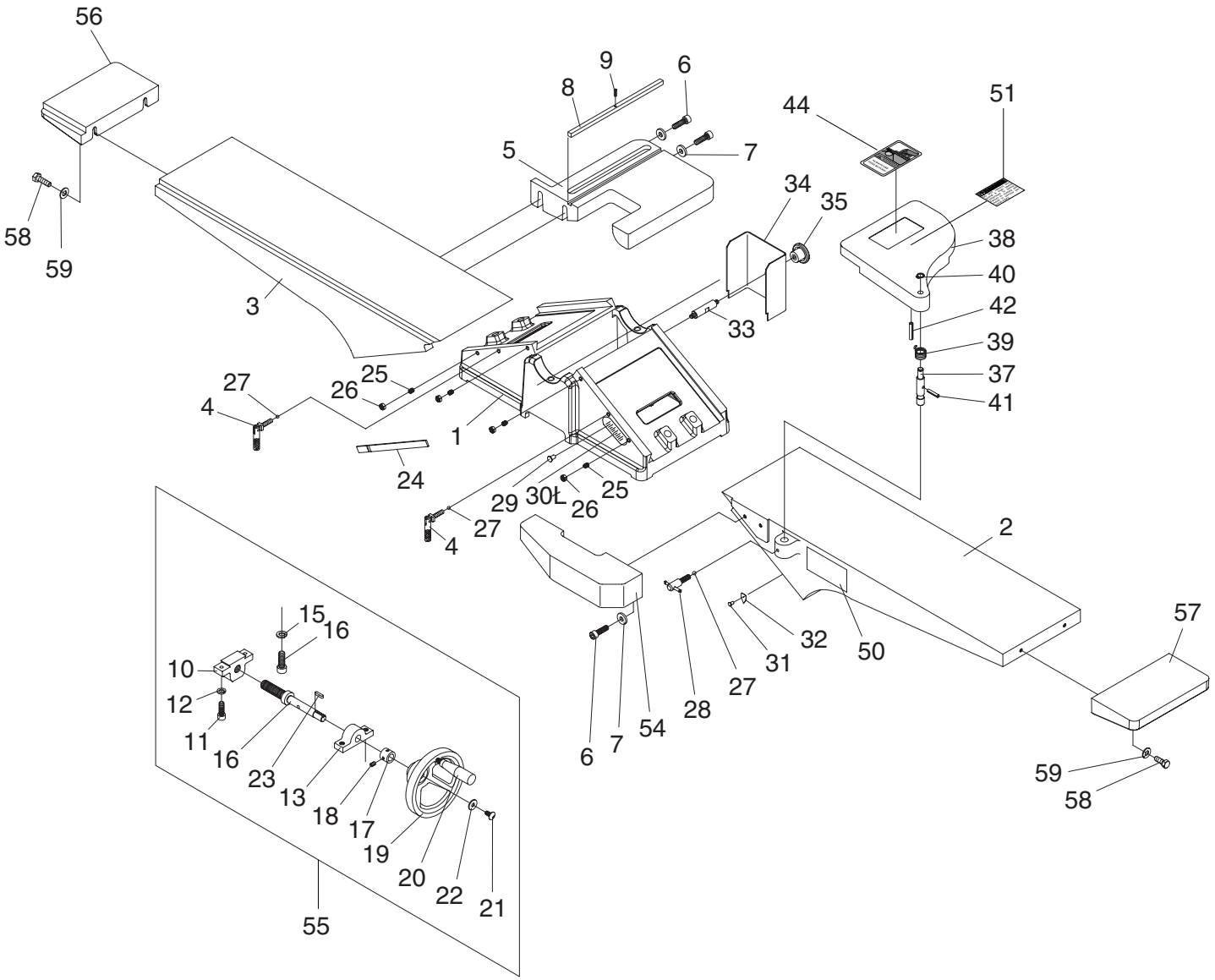
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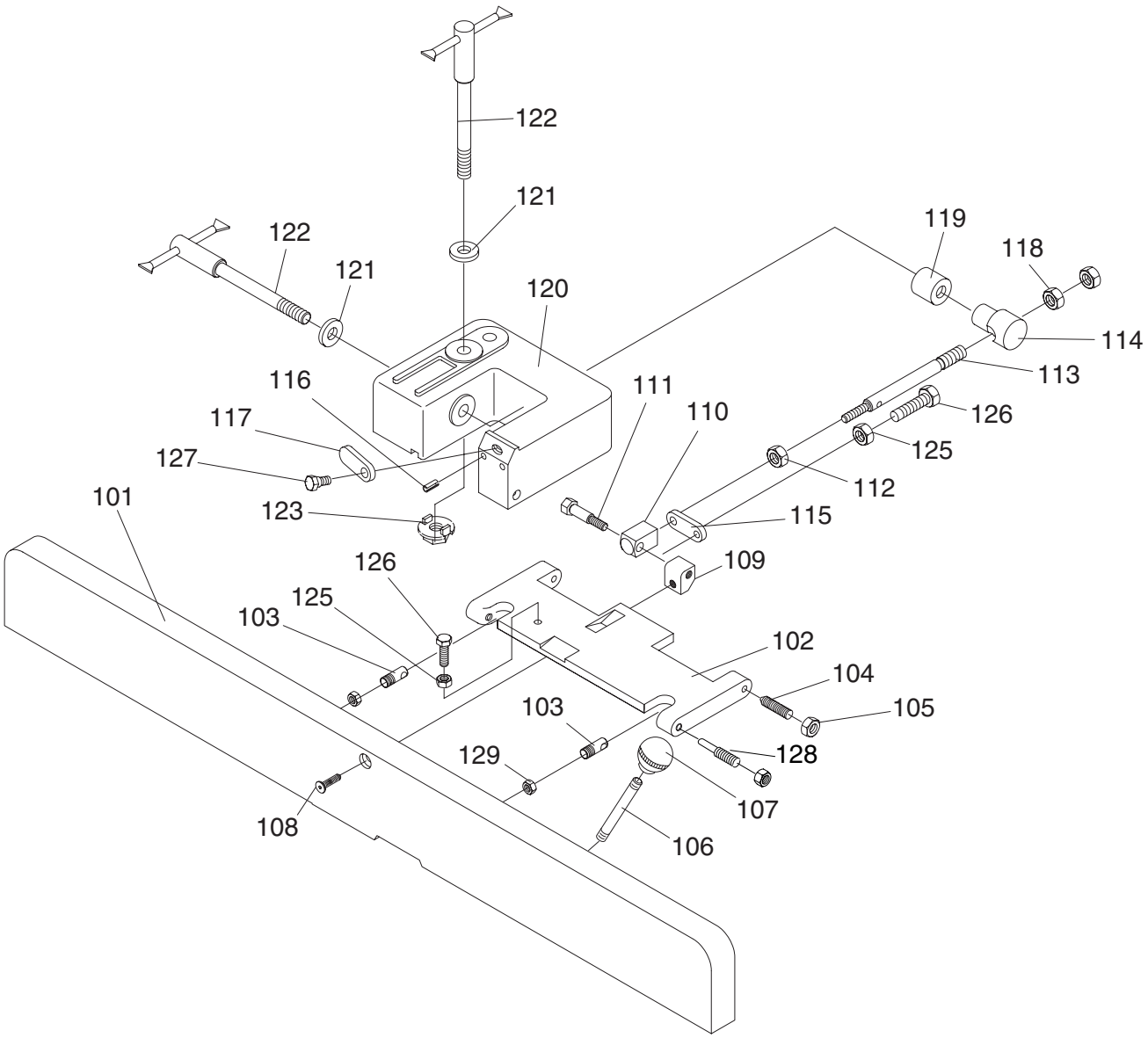
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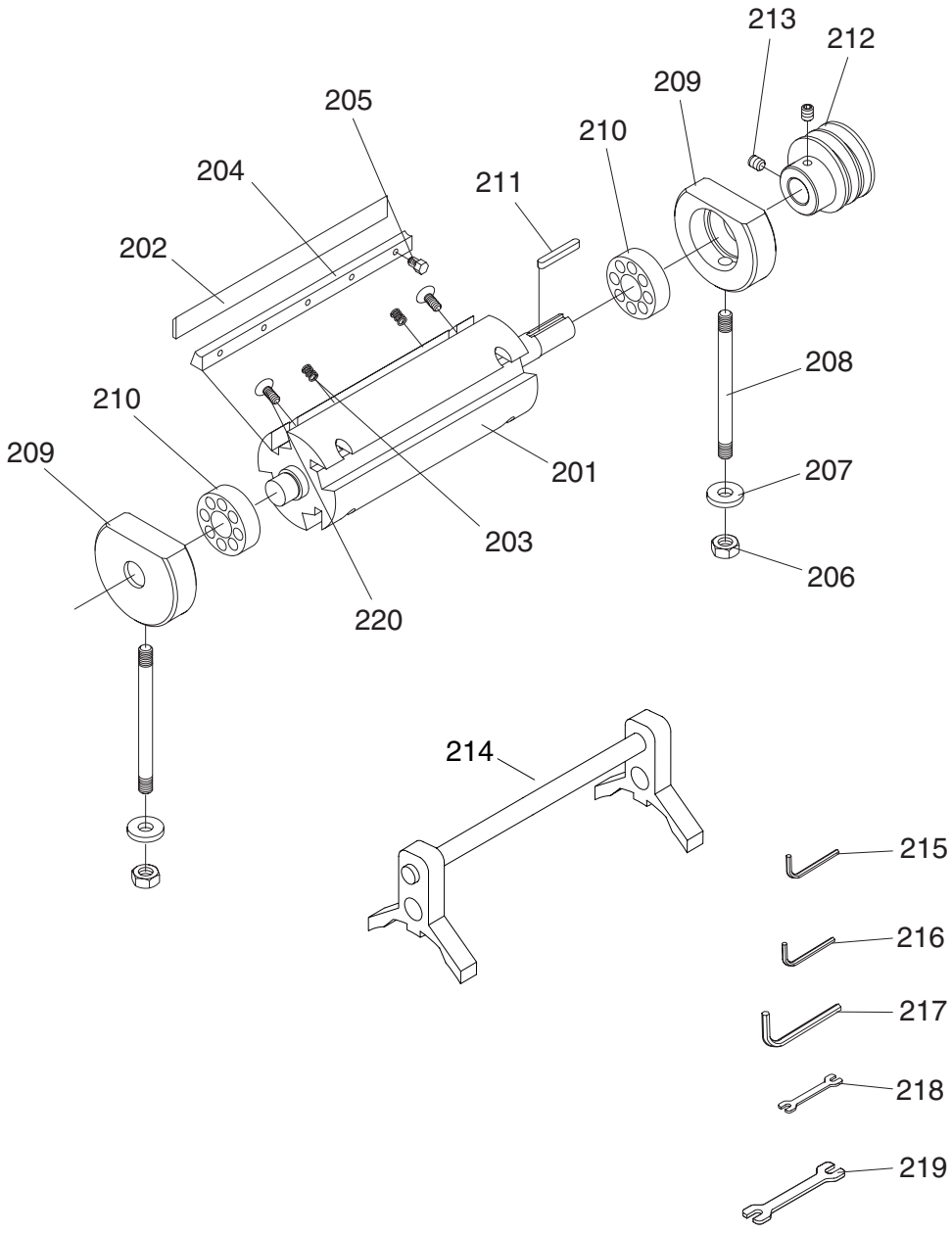
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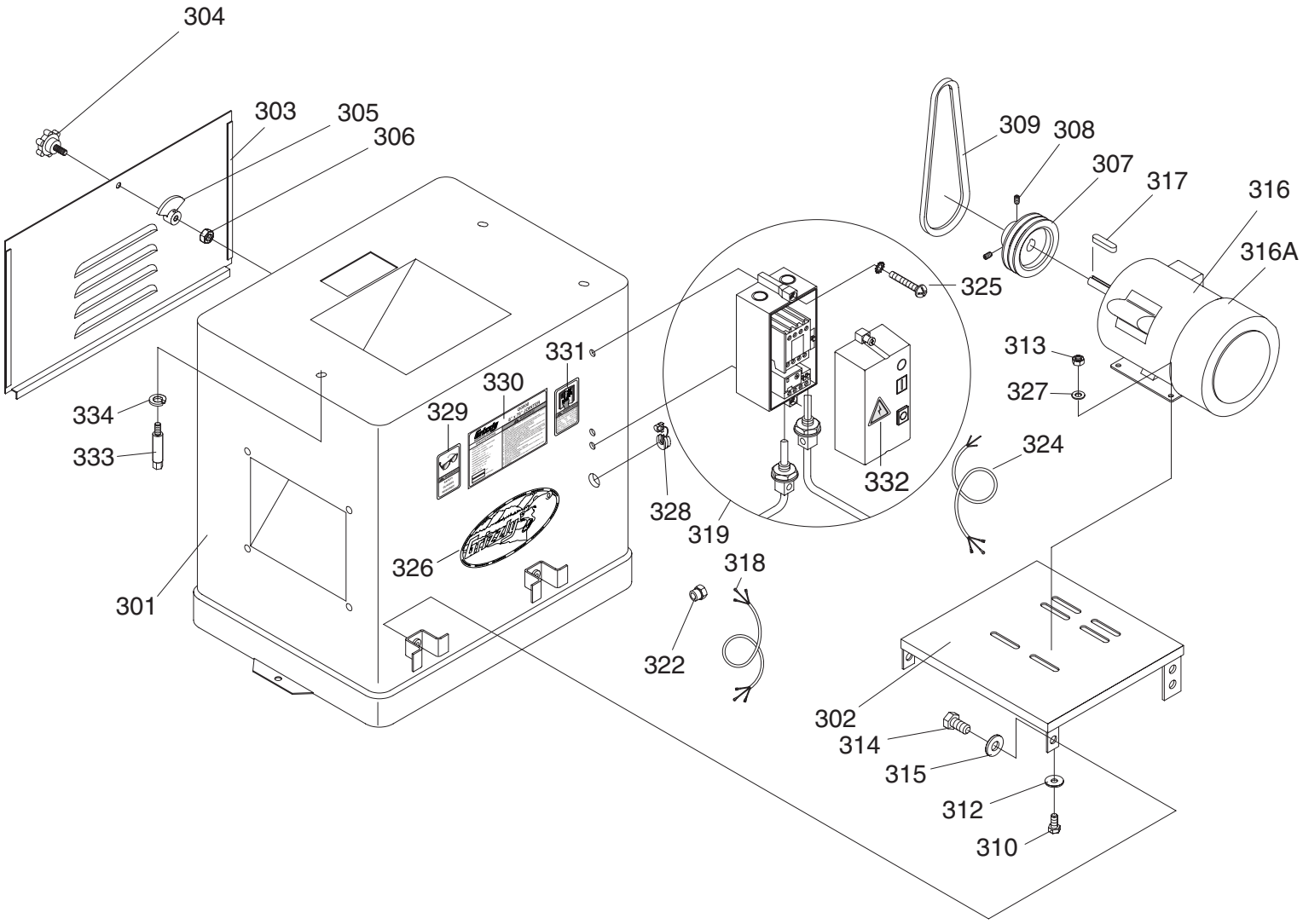
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REF	PART #	DESCRIPTION
1	PG1018HW001	BASE
2	P0500002	INFEED TABLE
3	P0500003	OUTFEED TABLE
4	PG1018004	LOCK HANDLE
5	PG1018033	FENCE SUPPORT
6	PSB26	CAP SCREW 3/8"-16 X 1 1/2"
7	PW02	FLAT WASHER 3/8"
8	PG1018034	KEY
9	PRP19M	ROLL PIN 4 X 14
10	PG1018HW010	FEED SCREW BRACKET
11	PSB19	CAP SCREW 3/8"-16 x 1 1/4"
12	PLW04	LOCK WASHER 3/8"
13	PG1018HW013	BRACKET
15	PLW07	LOCK WASHER 1/2"
16	PG1018HW016	HANDWHEEL SHAFT
17	PG1018HW017	RING
18	PSS03	SET SCREW 1/4"-20 X 3/8"
19	PG1018HW019	HANDWHEEL
20	PG1018HW020	HANDLE
21	PS38	PHLP HD SCR 5/16"-18 X 1/2"
22	PW07	FLAT WASHER 5/16"
23	PK21M	KEY 5 X 5 X 23MM
24	PG1018005	GIB
25	PSS01	SET SCREW 5/16"-18 X 1
26	PN02	HEX NUT 5/16"-18
27	PG1018HW027	BALL 6MM
28	PG1018037	GUARD LOCK HANDLE
29	PG1182028	RIVET 2 X 5
30	PG1018027	SCALE
31	PS41	PHLP HD SCR #6-32 X 1/4"
32	PG1182027	DEPTH POINTER
33	PG1018039	SPEC DBL END STUD
34	PG1018014	BELT GUARD
35	PG1018016	KNOB
37	PG1018022	GUARD PIVOT SHAFT
38	PG10180018	CUTTERHEAD GUARD
39	PG1018025	SPRING
40	PR48M	EXT RETAINING RING 11MM
41	PRP27M	ROLL PIN 5 X 28
42	PRP31M	ROLL PIN 6 X 36
44	PLABEL-29	CUTTERHEAD WARNING
50	P0500050	METAL NAME PLATE
51	PG1018017A	USE PUSH BLOCKS LABEL
54	PG1018HW054	RABBET ARM
55	PG1018HW055	HANDWHEEL ASSEMBLY
56	P0500056	OUTFEED EXTENSION
57	P0500057	INFEED EXTENSION
58	PB03	HEX BOLT 5/16"-18 X 1"
59	PW07	FLAT WASHER 5/16"

REF	PART #	DESCRIPTION
101	PG1018101	FENCE
102	PG1018102	FENCE HINGE
103	PG1182102	PIVOT STUD
104	PG1182104	SPECIAL SCREW
105	PN08	HEX NUT 3/8"-16
106	PG1182106	TILT LEVER
107	PG1182107	TILT LEVER KNOB
108	PG1182108	SPECIAL SCRW 5/16"-18 X 1 5/8"
109	PG1182109	FENCE BRACKET
110	PG1018110	FENCE STOP BRACKET
111	PG1182111	SPECIAL CAP SCREW
112	PN10	HEX NUT 7/16"-20
113	PG1018113	FENCE ADJUSTMENT ROD
114	PG1182114	FENCE TILT CLAMP
115	PG1182115	90° STOP TAB
116	PRP18M	ROLL PIN 4 x 12MM
117	PG1182118	STOP TAB
118	PN09	HEX NUT 5/8"-18
119	PG1182120	FENCE TILT SLEEVE
120	PG1018120	FENCE BASE
121	PW01	FLAT WASHER 1/2"
122	PG1182123	LOCKING SCREW
123	PG1182124	SPECIAL NUT
125	PN02	HEX NUT 5/16"-18
126	PB22	HEX BOLT 5/16"-18 x 1 3/4"
127	PG1182117	SPECIAL BOLT
128	PG1018128	SPECIAL SETSCREW
129	PN01	HEX NUT 1/2"-20 X 1/4"

G0500

REF	PART #	DESCRIPTION
201	P0500201	CUTTERHEAD
202	H4982	KNIVES, SET OF FOUR
203	P1021103	SPRING
204	PG1018204	KNIFE GIB
205	P1017117	HEX HD GIB BOLT
206	PN11	HEX NUT 3/8"-24
207	PLW04	LOCK WASHER 3/8"
208	PG1018208	STUD
209	PG1018209	BEARING BLOCK
210	P6204ZZ	BALL BEARING 6204ZZ
211	PK01M	KEY 5 x 5 x 22MM
212	PG1018212	PULLEY
213	PSS17	SETSCREW 5/16" - 18 x 5/16"
214	PG1018214A	KNIFE SETTING GAUGE
215	PAW03M	HEX WRENCH 3MM
216	PAW04M	HEX WRENCH 4MM
217	PAW05M	HEX WRENCH 5MM
218	PWR810	OPEN WRENCH 8 X 10
219	PWR1214	OPEN WRENCH 12 X 14
220	P0500220	JACK SCREW

REF	PART #	DESCRIPTION
301	PG1018301	STAND
302	PG1018302	MOTOR MOUNT
303	PG1018303	DOOR
304	PG1018304	KNOB
305	PN1018305	LATCH
306	PN08	HEX NUT 3/8"-16
307	PG1018307	MOTOR PULLEY
308	PSS15	SETSCREW 3/8"-16 x 3/8"
309	PVM52	V-BELT M52
310	PB07	HEX BOLT 5/16"-18 x 3/4"
312	PW02	FLAT WASHER 3/8"
313	PN02	HEX NUT 5/16"-18
314	PB53	HEX BOLT 1/2"-12 x 1"
315	PW01	FLAT WASHER 1/2"
316	P0500316	MOTOR 2HP, 110/220
316A	P0500316A	FAN COVER FOR MOTOR
317	PK12M	KEY 5 X 5 X 30MM
318	PWRCRD220S	POWER CORD
319	P0500319	MAG SWITCH SDE
320	PS18	PHLP HD SCR 10-24 x 1/2"
322	P1071075	STRAIN RELIEF
324	PWRCRD220L	POWER CORD
325	PSW01-1	SWITCH COVER SCREW
326	G8588	GRIZZLY LOGO PLATE
327	PLW06	LOCK WASHER 5/8"
328	P0500328	STRAIN RELIEF 2-PC
329	PLABEL-11	SAFETY GLASSES LABEL
330	P0500330	ID/WARNING LABEL
331	PLABEL-12	READ MANUAL LABEL
332	PLABEL-14	ELECTRICITY LABEL
333	PG1018031	MOUNTING BOLT
334	PLW04	LOCK WASHER 3/8"

MACHINE DATA SHEET

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

MODEL G1018 8" JOINTER

Design Type: .....Cabinet

Overall Dimensions:

- Table Size.....9" W x 65" L
- Height (from floor to table) .....31¼"
- Overall Length .....65"
- Overall Width .....24"
- Shipping Weight.....439 lbs.
- Net Weight .....385 lbs.
- 1st Box Size .....67" L x 25" W x 12" H
- 2nd Box Size .....26¼" L x 18½" W x 24" H
- Foot Print .....23½" x 16½"
- Cutterhead Diameter .....3"

Capacities:

- Maximum Depth of Cut.....½"
- Maximum Width of Cut .....8"
- Cutterhead Speed .....5500 RPM
- Cuts Per Minute.....16,500

Construction:

- Tables .....Independently Adjustable, Precision Ground Cast Iron
- Ways .....Dovetailed, Adjustable
- Fence Assembly.....Cast Iron
- Body Assembly.....Cast Iron
- Base .....Welded Steel Cabinet
- Cutterhead .....3 Knife Slots w/ Jack Screws and Springs
- Guard .....Aluminum
- Bearings .....Shielded and Permanently Lubricated

Motor:

- Type .....TEFC Capacitor Start Induction
- Horsepower .....1½ HP
- Phase / Voltage .....Single-Phase / 110V/220V
- Amps.....18A/9A
- Cycle / RPM.....60 Hertz / 3450 RPM
- Switch .....Magnetic w/ Thermal Overload Protector
- Power Transfer .....Double V-Belt Drive
- Bearings.....Shielded & Lubricated Ball Bearings

Features:

- Fence .....Center Mounted, Positive Stops at 45° and 90°
- Table Movement.....Lever Action
- Infeed & Outfeed Tables .....Rabbeting Capacity Built-In
- Dust Chute .....Built-In
- Knives .....(3) 8" x ⅛" x 1"

Specifications, while deemed accurate, are not guaranteed.

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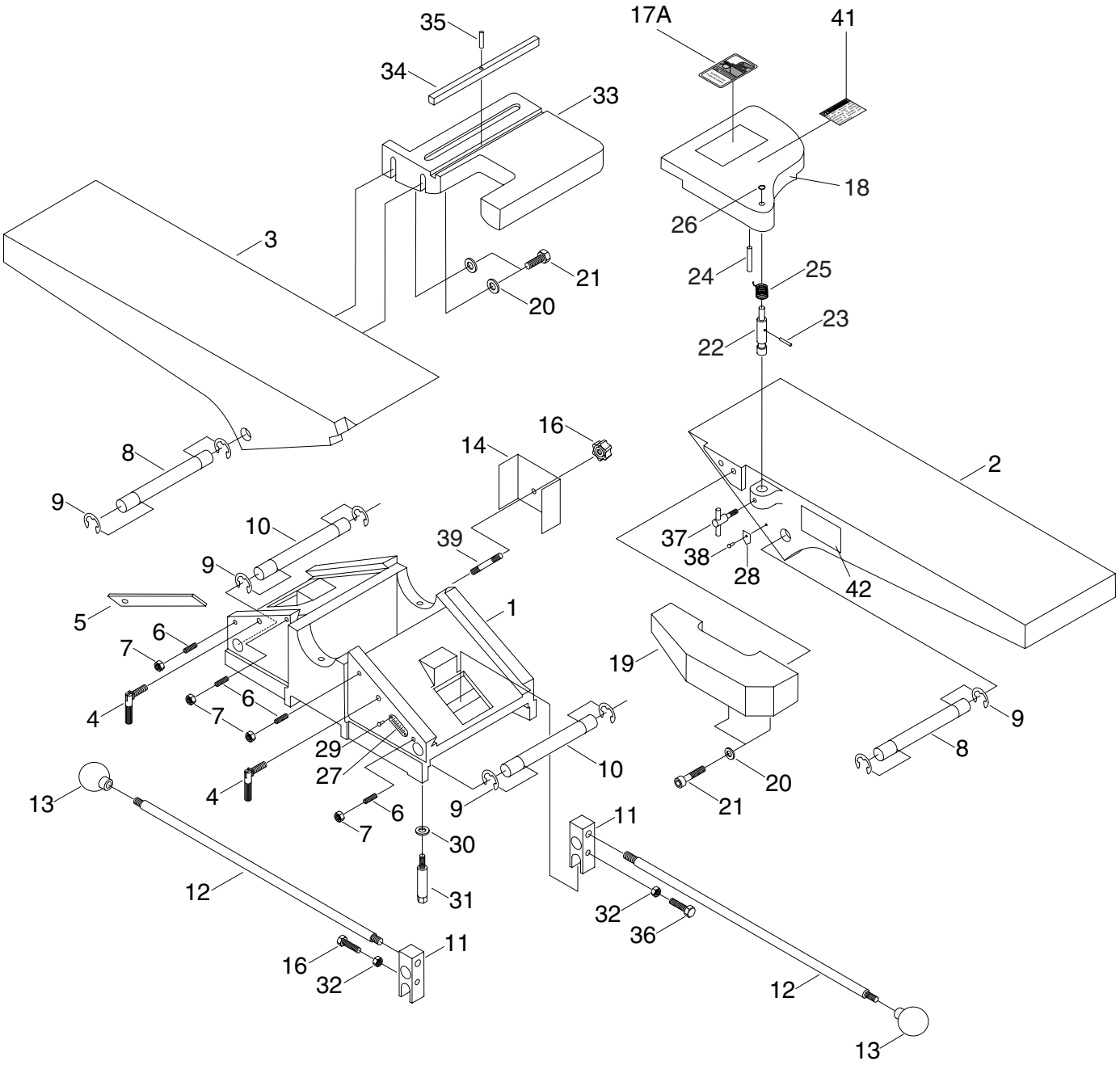
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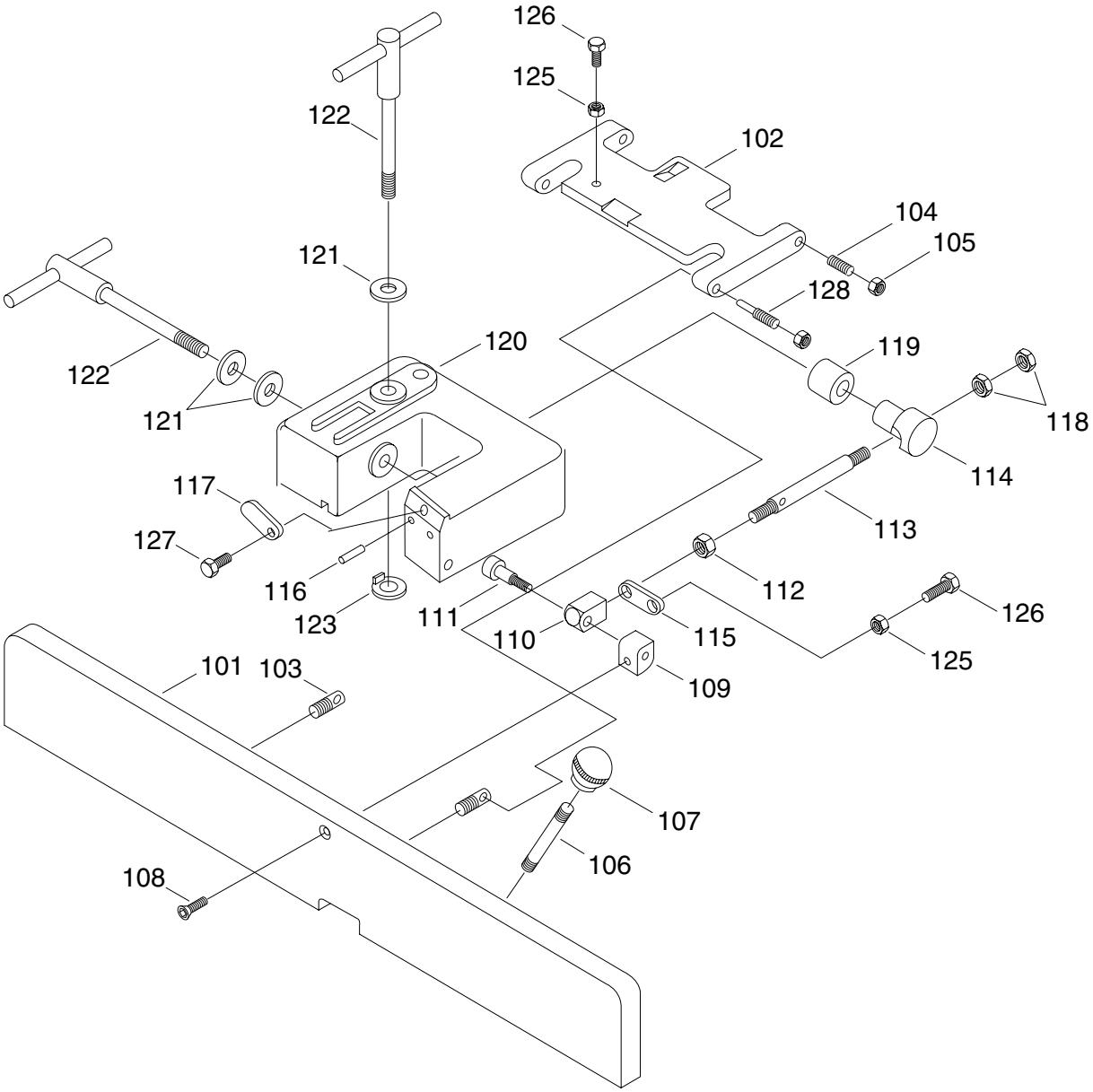
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REF	PART #	DESCRIPTION
1	PG1018001	BASE
2	PG1018002	INFEED TABLE
3	PG1018003	OUTFEED TABLE
4	PG1018004	LOCK HANDLE
5	PG1018005	GIB
6	PSS01	SETSCREW 5/16"-18 x 1"
7	PN02	HEX NUT 5/16" - 18
8	PG1018008	TABLE ADJ ROD
9	PEC08M	E-CLIP 16MM
10	PG1018008	TABLE ADJ ROD
11	PG1018011	TABLE ADJ BLOCK
12	PG1018012	TABLE ADJ LEVER
13	PG1018013	KNOB
14	PG1018014	BELT GUARD
17A	PG1018017A	USE PUSH BLOCKS LABEL
18	PG1018018	CUTTERHEAD GUARD
19	PG1018019	RABBET LEDGE
20	PW02	FLAT WASHER 3/8"
21	PSB19	CAP SCREW 3/8" - 16 x 1 1/4"
22	PG1018022	GUARD PIVOT SHAFT
23	PRP27M	ROLL PIN 5 X 28
24	PRP32M	ROLL PIN 6 X 40
25	PG1018025	SPRING
26	PR04	EXT RETAINING RING 7/16"
27	PG1018027	SCALE
28	PG1182027	POINTER
29	PG1182028	RIVET
30	PLW04	LOCK WASHER 3/8"
31	PG1018031	SPECIAL MOUNTING BOLT
32	PN02	HEX NUT 5/16"-18
33	PG1018033	FENCE SUPPORT
34	PG1018034	KEY
35	PRP19M	ROLL PIN 4 X 14
36	PB04	HEX BOLT 5/16" - 18 x 3"
37	PG1018037	GUARD LOCK HANDLE
38	PS41	PHLP HD SCR #6 - 32 X 1/4"
39	PG1018039	SPEC DBL END STUD
41	PLABEL-29	CUTTERHEAD WARNING
42	PG1018042	METAL NAME PLATE

REF	PART #	DESCRIPTION
101	PG1018101	FENCE
102	PG1018102	FENCE HINGE
103	PG1182102	PIVOT STUD
104	PG1182104	SPECIAL SCREW
105	PN08	HEX NUT 3/8"-16
106	PG1182106	TILT LEVER
107	PG1182107	TILT LEVER KNOB
108	PG1182108	SPECIAL SCREW
109	PG1182109	FENCE BRACKET
110	PG1018110	FENCE STOP BRACKET
111	PG1182111	SPECIAL CAP SCREW
112	PN10	HEX NUT 7/16"-20
113	PG1018113	FENCE ADJUSTMENT ROD
114	PG1182114	FENCE TILT CLAMP
115	PG1182115	90° STOP TAB
116	PRP18M	ROLL PIN 4 x 12MM
117	PG1182118	STOP TAB
118	PN09	HEX NUT 5/8"-18
119	PG1182120	FENCE TILT SLEEVE
120	PG1018120	FENCE BASE
121	PW01	FLAT WASHER 1/2"
122	PG1182123	LOCKING SCREW
123	PG1182124	SPECIAL NUT
125	PN02	HEX NUT 5/16"-18
126	PB22	HEX BOLT 5/16"-18 x 1 3/4"
127	PG1182117	SPECIAL BOLT
128	PG1018128	SPECIAL SETSCREW

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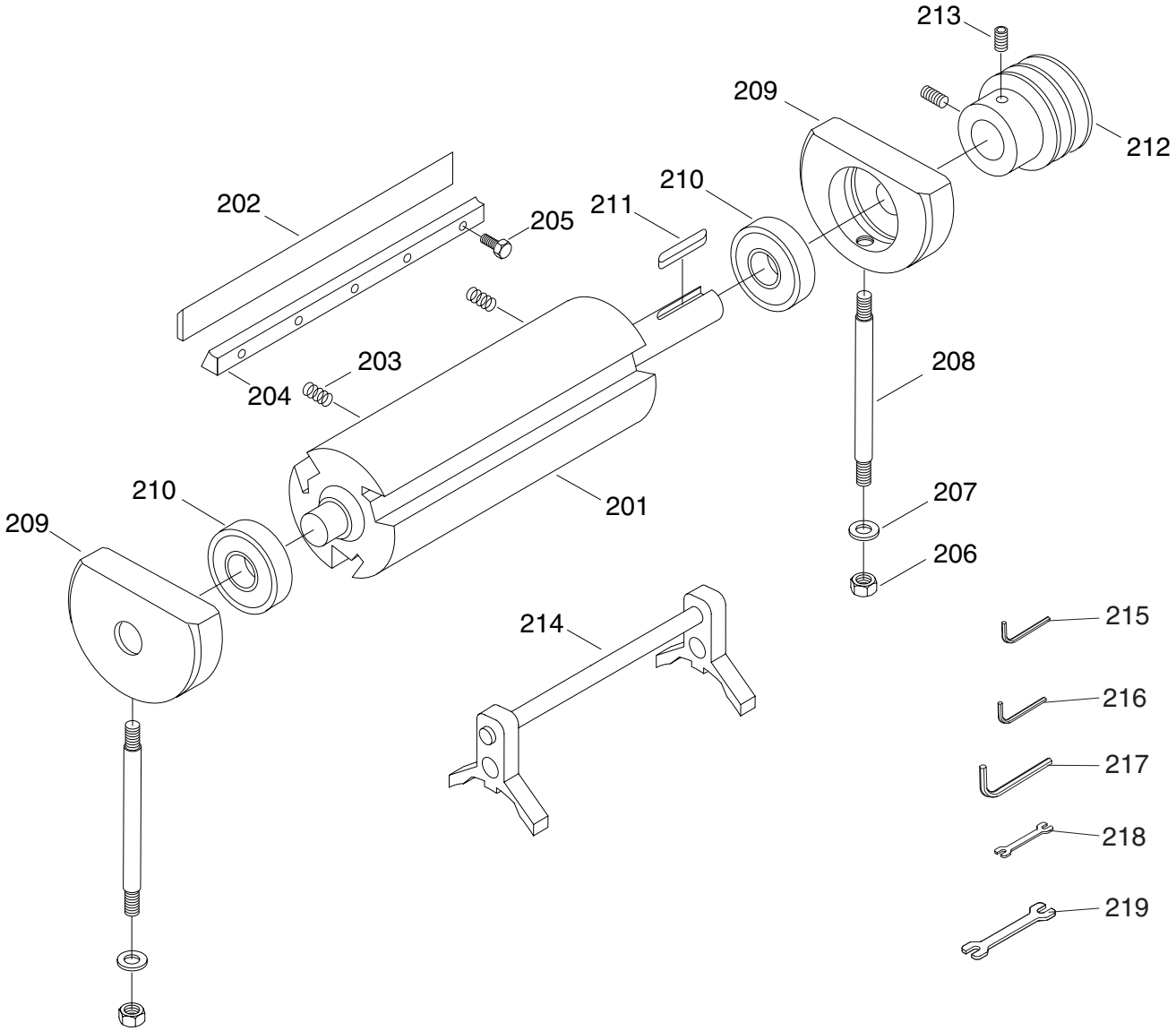
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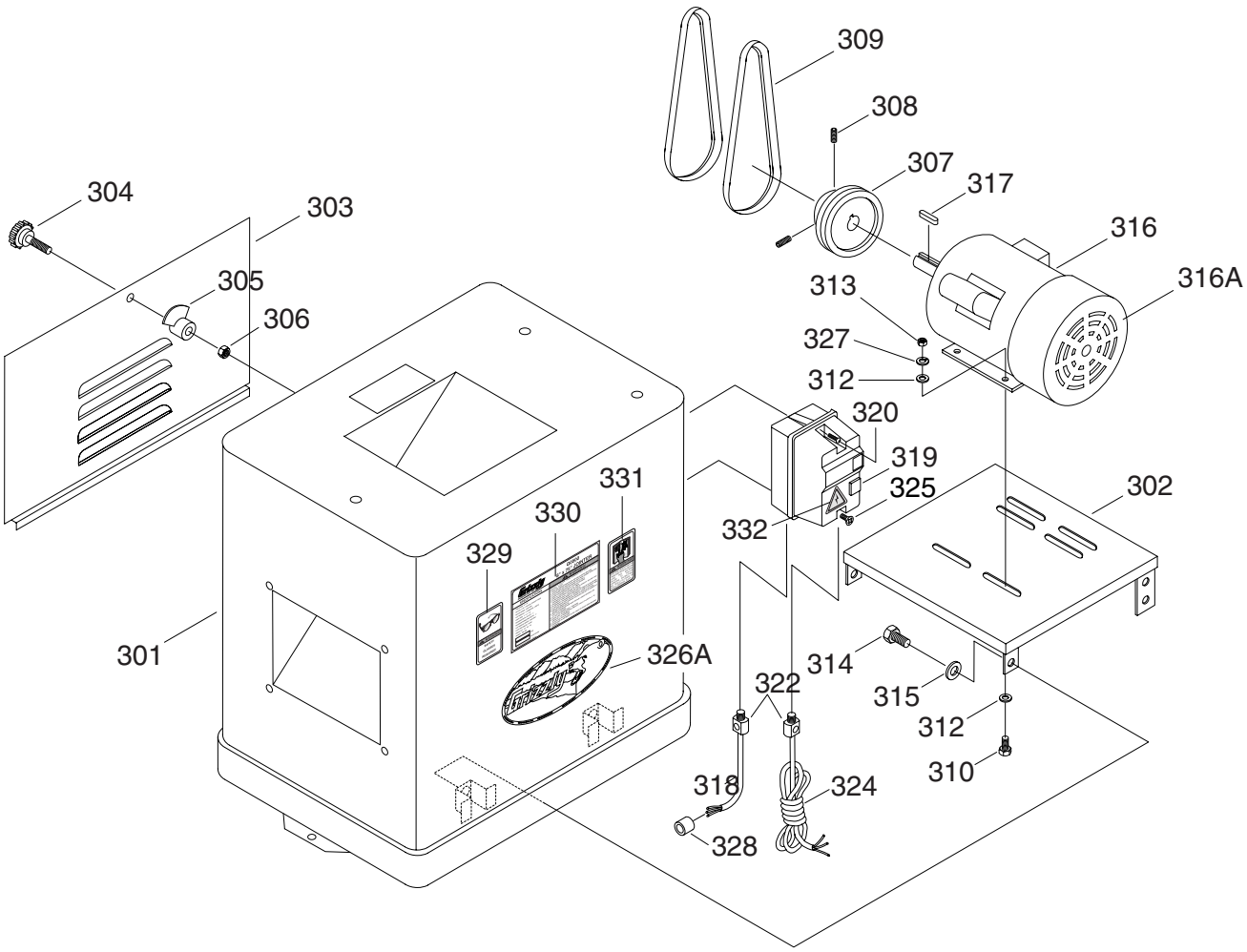
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REF	PART #	DESCRIPTION
201	PG1018201	CUTTERHEAD
202	G6698	KNIVES, SET OF THREE
203	P1021103	SPRING
204	PG1018204	KNIFE GIB
205	P1017117	HEX HD GIB BOLT
206	PN11	HEX NUT 3/8"-24
207	PLW04	LOCK WASHER 3/8"
208	PG1018208	STUD
209	PG1018209	BEARING BLOCK
210	P6204ZZ	BALL BEARING 6204ZZ
211	PK23M	KEY 5 x 5 x 25MM
212	PG1018212	PULLEY
213	PSS17	SETSCREW 5/16"-18 x 5/16"
214A	PG1018214A	KNIFE SETTING GAUGE
215	PAW03M	HEX WRENCH 3MM
216	PAW04M	HEX WRENCH 4MM
217	PAW05M	HEX WRENCH 5MM
218	PWR810	OPEN WRENCH 8 X 10
219	PWR1214	OPEN WRENCH 12 X 14

REF	PART #	DESCRIPTION
301	PG1018301	STAND
302	PG1018302	MOTOR MOUNT
303	PG1018303	DOOR
304	PG1018304	KNOB
305	PN1018305	LATCH
306	PN08	HEX NUT 3/8"-16
307	PG1018307	MOTOR PULLEY
308	PSS15	SETSCREW 3/8"-16 x 3/8"
309	PVM52	V-BELT M52 3L520
310	PB07	HEX BOLT 5/16"-18 x 3/4"
312	PW02	FLAT WASHER 3/8"
313	PN02	HEX NUT 5/16"-18
314	PB53	HEX BOLT 1/2"-12 x 1"
315	PW01	FLAT WASHER 1/2"
316	PG1018316	1 1/2 HP MOTOR
316A	PG1018316A	FAN COVER FOR MOTOR
317	PK12M	KEY 5 X 5 X 30MM
318	PWRCRD220S	POWER CORD
319	P0500319	SWITCH
320	PS01	PHLP HD SCR 10-24 x 1/2"
321	P1071075	STRAIN RELIEF
322	P1071075	STRAIN RELIEF
324	PWRCRD220L	POWER CORD
325	PSW01-1	SWITCH COVER SCREW
326A	G8588	GRIZZLY LOGO PLATE
327	PLW06	LOCK WASHER 5/8"
328	PG1018328	CLAMP-ON GROMMET
329	PLABEL-11	SAFETY GLASSES LABEL
330	PG1018330	ID/WARNING LABEL
331	PLABEL-12	READ MANUAL LABEL
332	PLABEL-14	ELECTRICITY LABEL

MACHINE DATA SHEET

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

MODEL G1018HW
8" JOINTER W/ HANDWHEELS

Design Type: .....Cabinet

Overall Dimensions:

- Table Size.....9" W x 65" L
- Height (from floor to table) .....31¼"
- Overall Length .....65"
- Overall Width .....24"
- Shipping Weight .....450 lbs.
- Net Weight .....400 lbs.
- 1st Box Size .....67" L x 25" W x 12" H
- 2nd Box Size .....26" L x 18" W x 24" H
- Foot Print .....23½" x 16½"
- Cutterhead Diameter .....3"

Capacities:

- Maximum Depth of Cut.....½"
- Maximum Width of Cut .....8"
- Cutterhead Speed .....5500 RPM
- Cuts Per Minute.....16,500

Construction:

- Tables .....Independently Adjustable, Precision Ground Cast Iron
- Ways .....Dovetailed, Adjustable
- Fence Assembly.....Cast Iron
- Body Assembly.....Cast Iron
- Base .....Welded Steel Cabinet
- Cutterhead .....3 Knife Slots w/ Jack Screws and Springs
- Guard .....Aluminum
- Bearings .....Shielded and Permanently Lubricated

Motor:

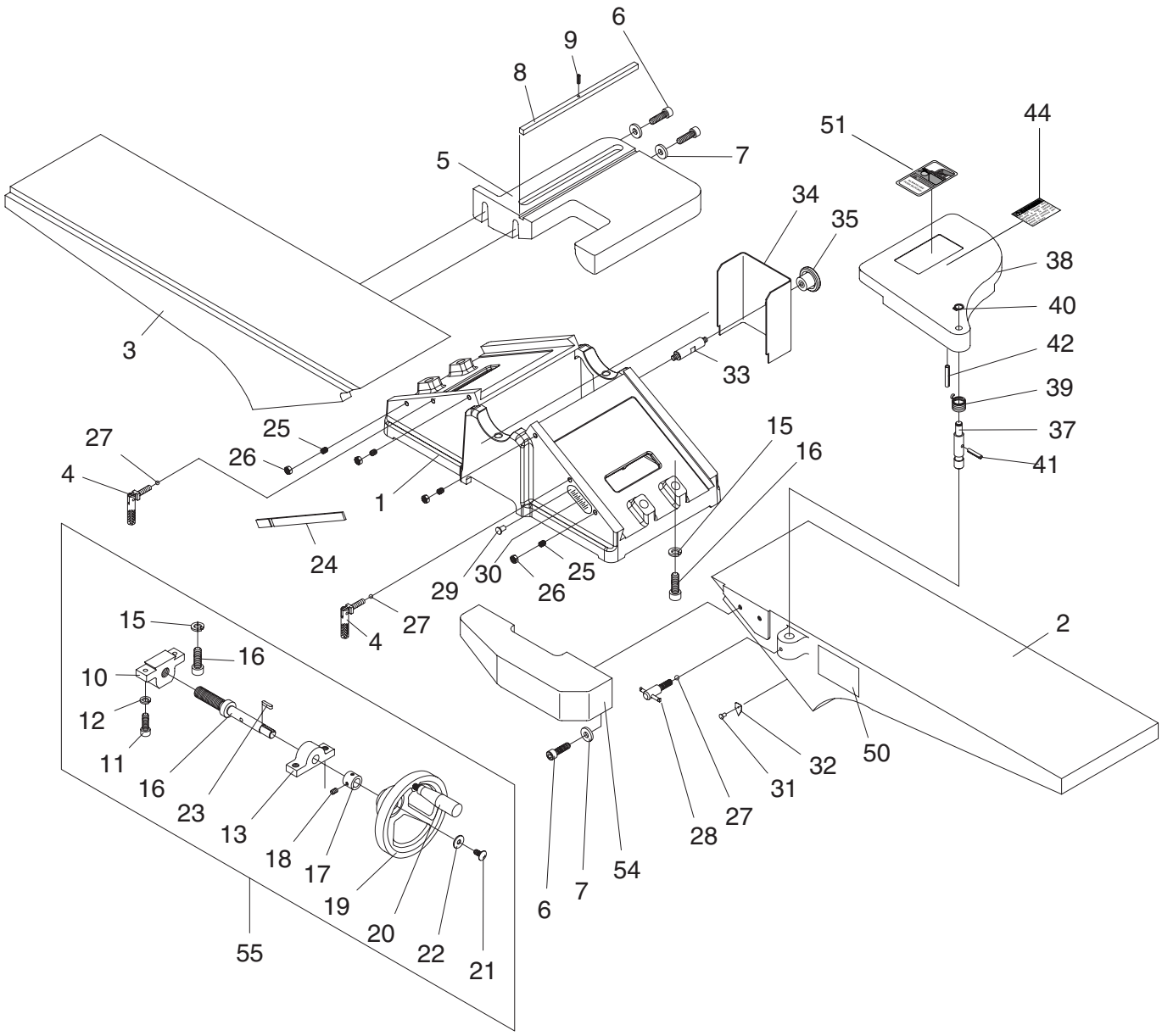
- Type .....TEFC Capacitor Start Induction
- Horsepower .....1½ HP
- Phase / Voltage Single-Phase110V/220V
- Amps.....18A/9A
- Cycle / RPM.....60 Hertz / 3450 RPM
- Switch .....Magnetic w/ Thermal Overload Protector
- Power Transfer .....Double V-Belt Drive
- Bearings.....Shielded & Lubricated Ball Bearings

Features:

- Fence .....Center Mounted, Positive Stops at 45° and 90°
- Table Movement.....Handwheels
- Infeed & Outfeed Tables .....Rabbeting Capacity Built-In
- Dust Chute .....Built-In
- Knives.....3 - 8" x ⅛" x 1"

Specifications, while deemed accurate, are not guaranteed.

G1018HW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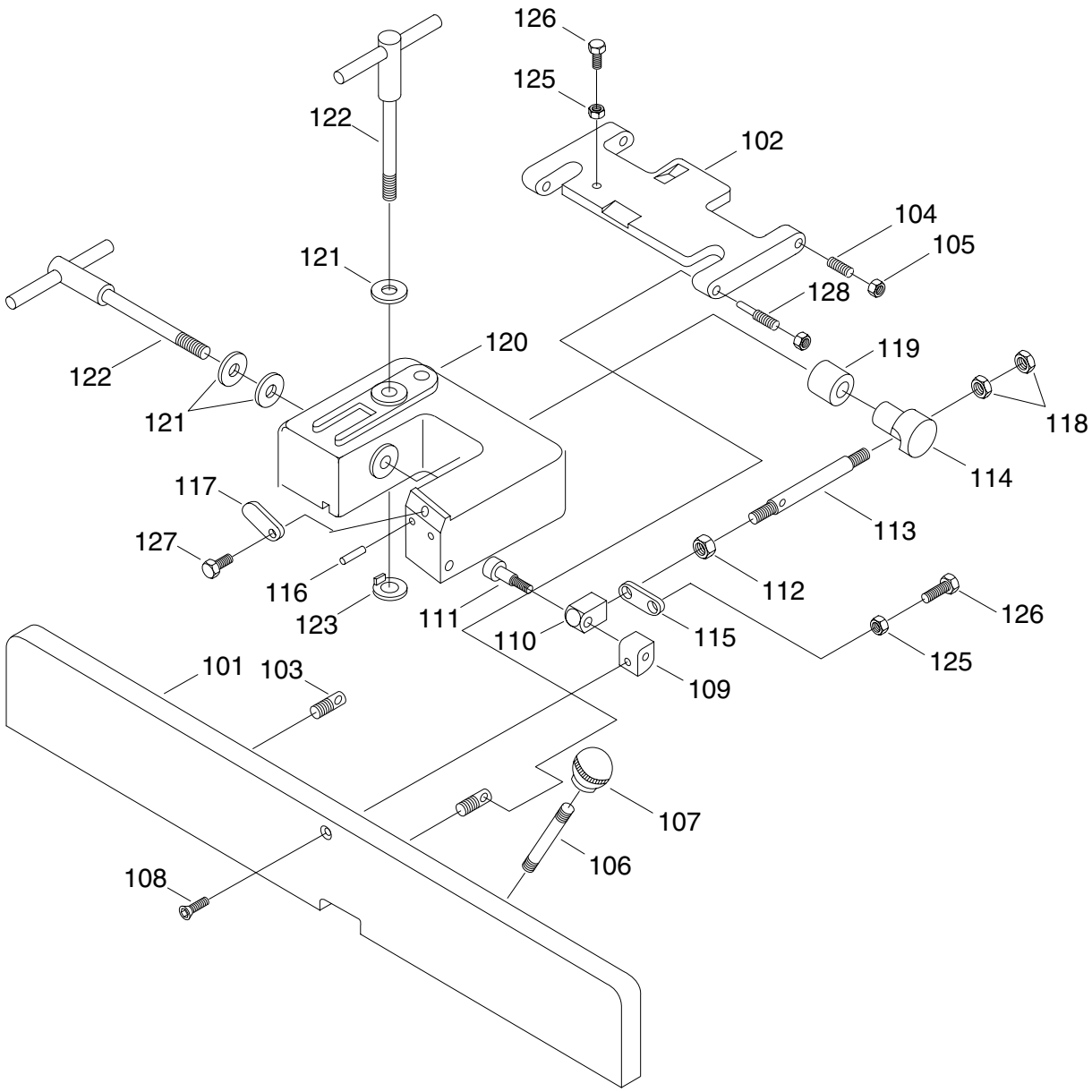
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REF	PART #	DESCRIPTION
1	PG1018HW001	BASE
2	PG1018HW002	INFEED TABLE
3	PG1018HW003	OUTFEED TABLE
4	PG1018004	LOCK HANDLE
5	PG1018033	FENCE SUPPORT
6	PSB26	CAP SCREW 3/8"-16 x 1 1/2"
7	PW02	FLAT WASHER 3/8"
8	PG1018034	KEY
9	PRP19M	ROLL PIN 4 X 14
10	PG1018HW010	FEED SCREW BRACKET
11	PSB19	CAP SCREW 3/8"-16 x 1 1/4"
12	PLW04	LOCK WASHER 3/8"
13	PG1018HW013	BRACKET
14	PSB26	CAP SCREW 3/8"-16 x 1 1/4"
15	PLW07	LOCK WASHER 1/2"
16	PG1018HW016	HANDWHEEL SHAFT
17	PG1018HW017	RING
18	PSS03	SET SCREW 1/4"-20 X 3/8"
19	PG1018HW019	HANDWHEEL
20	PG1018HW020	HANDLE
21	PS38	PHLP HD SCR 5/16"-18 X 1/2"
22	PW07	FLAT WASHER 5/16"
23	PK21M	KEY 5 X 5 X 23MM
24	PG1018005	GIB
25	PSS01	SETSCREW 5/16"-18 x 1"
26	PN02	HEX NUT 5/16"-18
27	PG1018HW027	BALL 6MM
28	PG1018037	GUARD LOCK HANDLE
29	PG1182028	RIVET 2 X 5MM
30	PG1018027	SCALE
31	PS41	PHLP HD SCR #6-32 X 1/4"
32	PG1182027	DEPTH POINTER
33	PG1018039	SPEC DBL END STUD
34	PG1018014	BELT GUARD
35	PG1018HW016	KNOB
37	PG1018022	GUARD PIVOT SHAFT
38	PG10180018	CUTTERHEAD GUARD
39	PG1018025	SPRING
40	PR48M	EXT RETAINING RING 11MM
41	PRP27M	ROLL PIN 5 X 28MM
42	PRP32M	ROLL PIN 6 X 40MM
44	PLABEL-29	CUTTERHEAD WARNING
50	PG1018HW050	METAL NAME PLATE
51	PG1018017A	USE PUSH BLOCKS LABEL
53	PRP06M	ROLL PIN 5 X 24MM
54	PG1018HW054	RABBET ARM
55	PG1018HW055	HANDWHEEL ASSEMBLY

REF	PART #	DESCRIPTION
101	PG1018101	FENCE
102	PG1018102	FENCE HINGE
103	PG1182102	PIVOT STUD
104	PG1182104	SPECIAL SCREW
105	PN08	HEX NUT 3/8"-16
106	PG1182106	TILT LEVER
107	PG1182107	TILT LEVER KNOB
108	PG1182108	SPECIAL SCRW 5/16"-18 X 1 5/8"
109	PG1182109	FENCE BRACKET
110	PG1018110	FENCE STOP BRACKET
111	PG1182111	SPECIAL CAP SCREW
112	PN10	HEX NUT 7/16"-20
113	PG1018113	FENCE ADJUSTMENT ROD
114	PG1182114	FENCE TILT CLAMP
115	PG1182115	90° STOP TAB
116	PRP18M	ROLL PIN 4 x 12MM
117	PG1182118	STOP TAB
118	PN09	HEX NUT 5/8"-18
119	PG1182120	FENCE TILT SLEEVE
120	PG1018120	FENCE BASE
121	PW01	FLAT WASHER 1/2"
122	PG1182123	LOCKING SCREW
123	PG1182124	SPECIAL NUT
125	PN02	HEX NUT 5/16"-18
126	PB22	HEX BOLT 5/16"-18 x 1 3/4"
127	PG1182117	SPECIAL BOLT
128	PG1018128	SPECIAL SETSCREW

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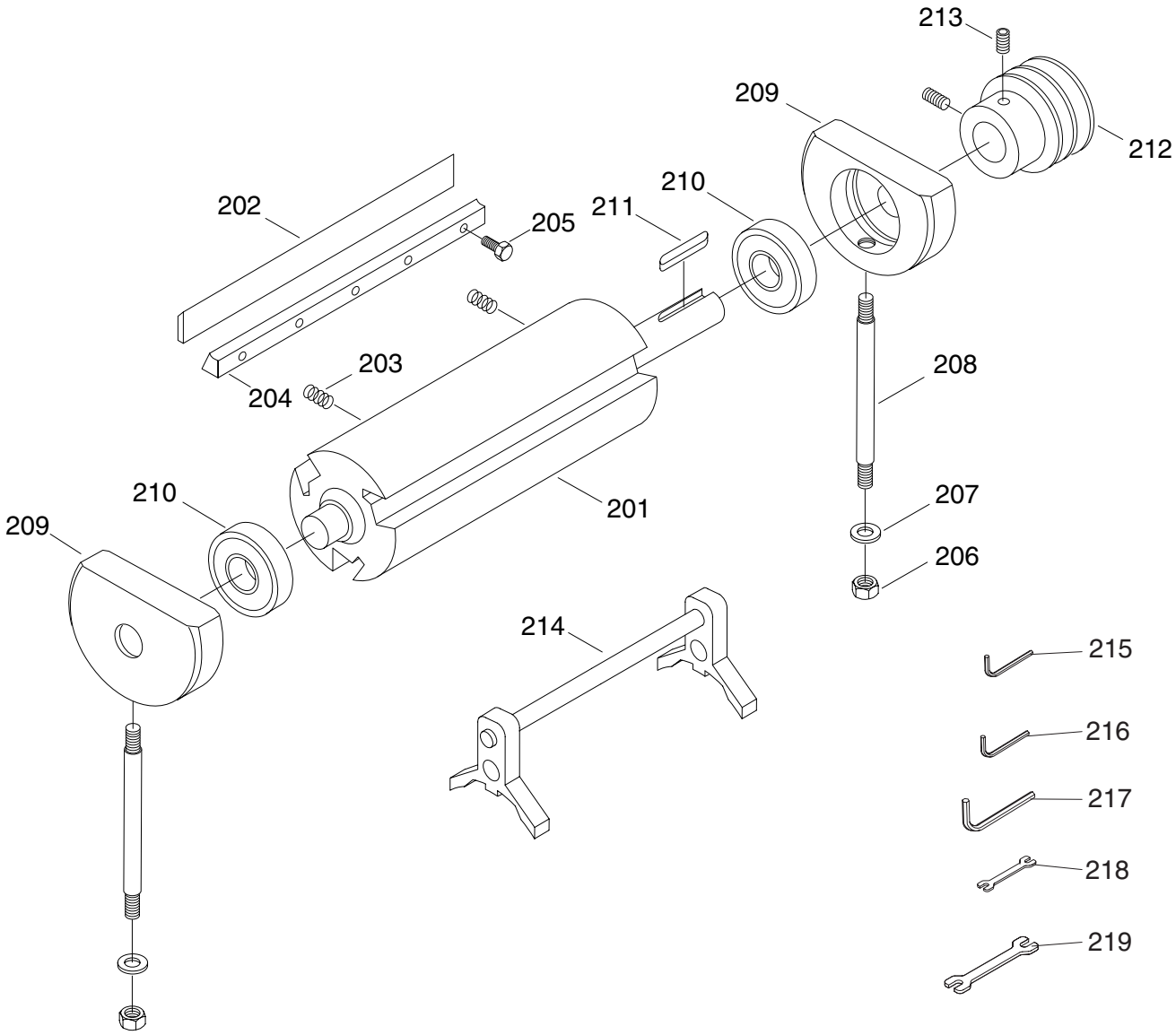
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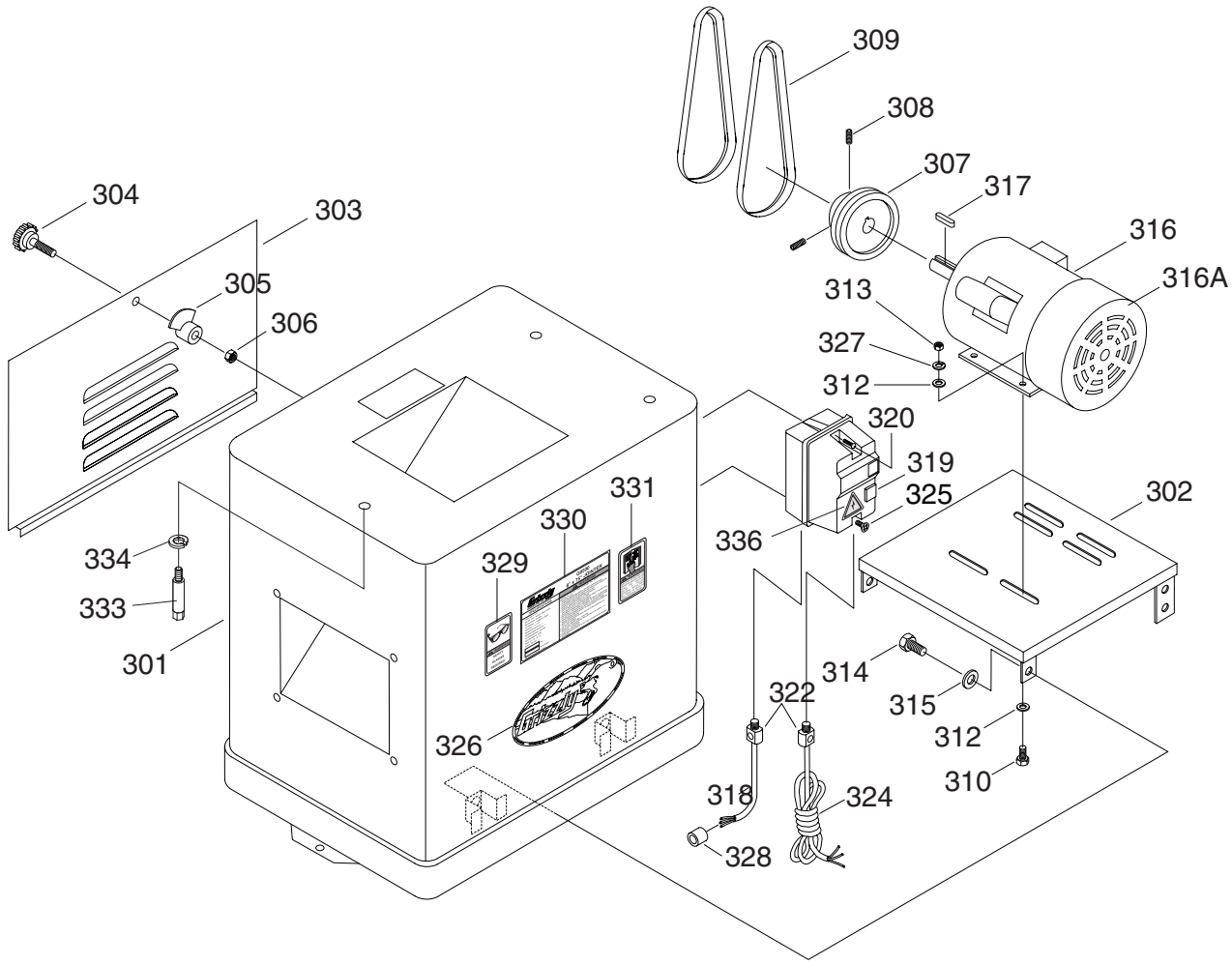
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G1018HW

REF	PART #	DESCRIPTION
201	PG1018201	CUTTERHEAD
202	G6698	KNIVES, SET OF THREE
203	P1021103	SPRING
204	PG1018204	KNIFE GIB
205	P1017117	HEX HD GIB BOLT
206	PN11	HEX NUT 3/8"-24
207	PLW04	LOCK WASHER 3/8"
208	PG1018208	STUD
209	PG1018209	BEARING BLOCK
210	P6204ZZ	BALL BEARING 6204ZZ
211	PK23M	KEY 5 x 5 x 25MM
212	PG1018212	PULLEY
213	PSS17	SETSCREW 5/16"-18 x 5/16"
214	PG1018214A	KNIFE SETTING GAUGE
215	PAW03M	HEX WRENCH 3MM
216	PAW04M	HEX WRENCH 4MM
217	PAW05M	HEX WRENCH 5MM
218	PWR810	OPEN WRENCH 8 X 10
219	PWR1214	OPEN WRENCH 12 X 14

REF	PART #	DESCRIPTION
301	PG1018301	STAND
302	PG1018302	MOTOR MOUNT
303	PG1018303	DOOR
304	PG1018304	KNOB
305	PN1018305	LATCH
306	PN08	HEX NUT 3/8"-16
307	PG1018307	MOTOR PULLEY
308	PSS15	SETSCREW 3/8"-16 x 3/8"
309	PVM52	V-BELT M52 3L520
310	PB07	HEX BOLT 5/16"-18 x 3/4"
312	PW02	FLAT WASHER 3/8"
313	PN02	HEX NUT 5/16"-18
314	PB53	HEX BOLT 1/2"-12 x 1"
315	PW01	FLAT WASHER 1/2"
316	PG1018316	1 1/2 HP MOTOR
316A	PG1018316A	FAN COVER FOR MOTOR
317	PK12M	KEY 5 X 5 X 30MM
318	PWRCRD220S	POWER CORD
319	P0500319	SWITCH
320	PS01	PHLP HD SCR 10-24 x 1/2"
321	P1071075	STRAIN RELIEF
322	P1071075	STRAIN RELIEF
324	PWRCRD220L	POWER CORD
325	PSW01-1	SWITCH COVER SCREW
326	G8588	GRIZZLY LOGO PLATE
327	PLW06	LOCK WASHER 5/8"
328	P1071075	STRAIN RELIEF
329	PLABEL-11	SAFETY GLASSES LABEL
330	PG1018HW330	ID/WARNING LABEL
331	PLABEL-12	READ MANUAL LABEL
332	PLABEL-14	ELECTRICITY LABEL
333	PG1018031	MOUNTING BOLT
334	PLW04	LOCK WASHER 3/8"

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____

Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

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

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

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

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

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

7. Do you think your machine represents a good value? _____Yes _____No

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

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

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY & 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.

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