15" PLANER
MODEL G0550/G0551
INSTRUCTION MANUAL
Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

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

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.
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SECTION 1: SAFETY

⚠️ WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

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

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

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

⚠️ 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 a 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.

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.


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.

---

Minimum Gauge for Extension Cords

<table>
<thead>
<tr>
<th>AMP RATING</th>
<th>25ft</th>
<th>50ft</th>
<th>100ft</th>
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<tbody>
<tr>
<td>0-6</td>
<td>16</td>
<td>16</td>
<td>16</td>
</tr>
<tr>
<td>7-10</td>
<td>16</td>
<td>16</td>
<td>14</td>
</tr>
<tr>
<td>11-12</td>
<td>16</td>
<td>16</td>
<td>14</td>
</tr>
<tr>
<td>13-16</td>
<td>14</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>17-20</td>
<td>12</td>
<td>12</td>
<td>10</td>
</tr>
<tr>
<td>21-30</td>
<td>10</td>
<td>10</td>
<td>No</td>
</tr>
</tbody>
</table>


**WARNING**

**Additional Safety Instructions For Planers**

1. READ THIS ENTIRE MANUAL BEFORE TURNING THE PLANER ON.

2. ENSURE THAT THE MACHINE IS ON FLAT, STABLE GROUND BEFORE USE. Any “wobbles” must be corrected by shimming or blocking before operation.

3. NEVER PLANE MATERIAL OTHER THAN WOOD STOCK WITH THIS MACHINE.

4. NEVER POSITION FINGERS OR THUMBS NEAR THE INFEED ROLLER.

5. ENSURE THAT THE PLANER IS PROPERLY ADJUSTED AND THAT THERE ARE NO LOOSE PARTS BEFORE OPERATING.

6. PLANE IN THE SAME DIRECTION AS THE GRAIN OF THE WOOD STOCK.

7. ALWAYS STAND TO THE SIDE OF THE PLANER WHILE FEEDING THE WORKPIECE.

8. DO NOT LOOK INSIDE THE PLANER DURING OPERATION!

9. ALWAYS PROVIDE ADEQUATE INFEED AND OUTFEED SPACE WHEN OPERATING THE PLANER. Always support long pieces of stock on both sides of the planer.

10. DO NOT REMOVE MORE THAN 1⁄8" FROM THE SURFACE OF THE WOOD STOCK IN A SINGLE PASS.

11. INSPECT YOUR STOCK BEFORE PLANING. Never plane stock with nails, staples or other foreign objects which may be embedded in the surface. Always properly prepare workpieces before running them through the planer. Do not plane lumber with loose knots or knots that may become loose during planing.

12. DO NOT ATTEMPT TO REMOVE JAMs UNTIL POWER IS DISCONNECTED and all moving parts have come to a complete stop.

13. DO NOT PLANE WORKPIECES LESS THAN 12" LONG AND 1⁄4" THICK.

14. DO NOT OPERATE PLANER WITH DULL OR DAMAGED KNIVES.

15. ALWAYS UNPLUG THE PLANER WHENEVER MAKING ANY ADJUSTMENTS or changing knives.

16. IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE PLANER! Then contact our service department or ask a qualified expert how the operation should be performed.

---

**WARNING**

Like all machines there is danger associated with the Model G0550/G0551. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

---

**CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.
We are proud to offer the Model G0550/G0551 15" Planer. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly’s commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0550/G0551. 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 G0550/G0551 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!

Lack of familiarity with this manual could cause serious personal injury. Become familiar with the contents of this manual, including all the safety warnings.

Commentary
SECTION 3: CIRCUIT REQUIREMENTS

Amperage Draw

The Model G0550/G0551 motor is wired to operate at 220V only. The planer motors draw the following amperage:

Amperage Draw
G0550 2 HP ........................................... 12 Amps
G0551 3 HP ........................................... 18 Amps

Circuit Breaker

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

Circuit Breaker
G0550 ........................................... 15 Amp, 2 Pole
G0551 ........................................... 20 Amp, 2 Pole

Plug-Type

We recommend using a NEMA-style 6-15 plug and outlet with the G0550 as shown in Figure 1a and an L6-20 plug and outlet for the G0551 as shown in Figure 1b. You may also “hard-wire” the planer directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

Figure 1a. NEMA 6-15 plug and receptacle.

Figure 1b. NEMA L6-20 plug and receptacle.
Electrocution or a fire can result if the machine is not grounded correctly. Make sure all electrical circuits are grounded. DO NOT use the machine if it is not grounded.

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.

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 Planer:

- Make sure the cord is rated for Standard Service (grade S) or better.
- The extension cord must also contain a ground wire and plug prong.
- 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.
SECTION 4: MACHINE FEATURES

Figure 2. Machine features.
Common Terms & Definitions

**Work Table:** The wood moves through the planer on the work table.

**Infeed and Outfeed Rollers:** Powered rollers that move the wood through the planer.

**Cutterhead:** The cutterhead holds the knives and spins at 5000 rpm. When wood passes under the cutterhead, material is removed.

**Chip Breaker:** Spring loaded fingers or bar that presses down on the wood in front of the cutterhead. The chip breaker prevents excessive chipping caused by the knives.

**Snipe:** A gouge at the end of the board.

**Pressure Bar:** Rides on the planed surface behind the cutterhead. Prevents vibration, chattering and snipe.

**Bed Rollers:** Located in the work table, the bed rollers help wood move through the planer.

**Dust Hood:** Funnels wood dust and chips into the dust collection system.

**Gibs:** Metal strips that hold the planer knives in place.

**Gib Bolts:** Secures the gib to the knife to keep it in place.
SECTION 5: SET UP

About This Section

The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.

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

⚠️ WARNING
Wear safety glasses during the entire set up process!

Unpacking

The Model G0550/G0551 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

Save the containers and all packing materials for possible inspection by the carrier or its agent. Otherwise, filing a freight claim can be difficult.

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

Parts Inventory

The Model G0550 comes with an open stand that requires assembly, and the Model G0551 comes assembled on a closed cabinet stand.

The following is an inventory of the parts for your new Model G0550/G0551 Planer.

Figure 3. G0550 planer unit.
### G0550 Loose Parts

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Extension Rollers</td>
<td>2</td>
</tr>
<tr>
<td>B. Dust Port</td>
<td>1</td>
</tr>
<tr>
<td>C. Stand Hardware Bag</td>
<td>1</td>
</tr>
<tr>
<td>- Carriage Bolts 5/16&quot;-18 x 1/2&quot;</td>
<td>32</td>
</tr>
<tr>
<td>- Hex Nuts 5/16&quot;-18</td>
<td>36</td>
</tr>
<tr>
<td>- Flat Washers 5/16&quot;</td>
<td>36</td>
</tr>
<tr>
<td>- Lock Washer 5/16&quot;</td>
<td>4</td>
</tr>
<tr>
<td>- Hex Bolts 5/16&quot;-18 x 1&quot;</td>
<td>4</td>
</tr>
<tr>
<td>D. Tool Bag</td>
<td>1</td>
</tr>
<tr>
<td>- Handwheel Handle</td>
<td>1</td>
</tr>
<tr>
<td>- Combo Wrench 8/10mm</td>
<td>1</td>
</tr>
<tr>
<td>- Combo Wrench 12/14mm</td>
<td>1</td>
</tr>
<tr>
<td>- Allen Wrench 6mm</td>
<td>1</td>
</tr>
<tr>
<td>- Allen Wrench 5mm</td>
<td>1</td>
</tr>
<tr>
<td>- Allen Wrench 4mm</td>
<td>1</td>
</tr>
<tr>
<td>- Allen Wrench 3mm</td>
<td>1</td>
</tr>
<tr>
<td>- Allen Wrench 2mm</td>
<td>1</td>
</tr>
<tr>
<td>- Knife Jig Shaft</td>
<td>1</td>
</tr>
<tr>
<td>- Knife Jig Feet</td>
<td>2</td>
</tr>
<tr>
<td>- E-Clips 9mm</td>
<td>4</td>
</tr>
<tr>
<td>E. Handwheel Bag</td>
<td>1</td>
</tr>
<tr>
<td>- Handwheel</td>
<td>1</td>
</tr>
<tr>
<td>- High/Low Label</td>
<td>1</td>
</tr>
<tr>
<td>- Flat Washer 10mm</td>
<td>1</td>
</tr>
<tr>
<td>- Hex Nut M10-1.5</td>
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<tr>
<td>Extension Roller Hardware Bag</td>
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</tr>
<tr>
<td>- Hex Bolt M8-1.25 x 20</td>
<td>6</td>
</tr>
<tr>
<td>- Flat Washer 8mm</td>
<td>6</td>
</tr>
<tr>
<td>- Setscrew M8-1.25 x 12</td>
<td>6</td>
</tr>
<tr>
<td>Dust Port Hardware Bag</td>
<td>1</td>
</tr>
<tr>
<td>- Phillips Head Screw M6-1.0 x 12</td>
<td>6</td>
</tr>
<tr>
<td>F. Legs</td>
<td>4</td>
</tr>
<tr>
<td>G. Lower Braces</td>
<td>4</td>
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<tr>
<td>H. Predrilled Upper Braces</td>
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</table>

### G0551 Loose Parts

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>A. Dust Port</td>
<td>1</td>
</tr>
<tr>
<td>B. Extension Roller Hardware Bag</td>
<td>1</td>
</tr>
<tr>
<td>- Hex Bolts M8-1.25 x 20</td>
<td>6</td>
</tr>
<tr>
<td>- Flat Washers 8mm</td>
<td>6</td>
</tr>
<tr>
<td>- Setscrews M8-1.25 x 12</td>
<td>6</td>
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<tr>
<td>C. Tool Bag</td>
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<td>- Handwheel Handle</td>
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<td>- Combo Wrench 8/10mm</td>
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<td>- Combo Wrench 12/14mm</td>
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<td>- Allen Wrench 6mm</td>
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<td>- Allen Wrench 5mm</td>
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<td>- Allen Wrench 4mm</td>
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<td>- Allen Wrench 3mm</td>
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<tr>
<td>- Knife Jig Shaft</td>
<td>1</td>
</tr>
<tr>
<td>- Knife Jig Feet</td>
<td>2</td>
</tr>
<tr>
<td>- E-Clips 9mm</td>
<td>4</td>
</tr>
<tr>
<td>D. Handwheel Bag</td>
<td>1</td>
</tr>
<tr>
<td>- Handwheel</td>
<td>1</td>
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<td>- High/Low Label</td>
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<td>- Flat Washer 10mm</td>
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<td>- Hex Nut M10-1.5</td>
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<td>Foot Hardware Bag</td>
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<tr>
<td>- Foot</td>
<td>4</td>
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<tr>
<td>- Hex Nut M8-1.25</td>
<td>4</td>
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<tr>
<td>Dust Port Hardware Bag</td>
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<tr>
<td>- Phillips Head Screw M6-1.0 x 12</td>
<td>6</td>
</tr>
<tr>
<td>E. Extension Rollers</td>
<td>2</td>
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</tbody>
</table>
**Hardware Recognition Chart**

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS!

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Description</th>
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</thead>
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<tr>
<td>#10</td>
<td>Thumb Screw</td>
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<tr>
<td>1/4&quot;</td>
<td>Phillips Head Screw</td>
</tr>
<tr>
<td>5/32&quot;</td>
<td>Cap Screw</td>
</tr>
<tr>
<td>3/8&quot;</td>
<td>Washer</td>
</tr>
<tr>
<td>7/16&quot;</td>
<td>Hex Head Bolt</td>
</tr>
<tr>
<td>1/2&quot;</td>
<td>Wing Nut</td>
</tr>
<tr>
<td>5/8&quot;</td>
<td>Slotted Screw</td>
</tr>
<tr>
<td>3/4&quot;</td>
<td>Button Head Screw</td>
</tr>
<tr>
<td>1&quot;</td>
<td>Countersunk Phillips Head Screw</td>
</tr>
<tr>
<td>1 1/4&quot;</td>
<td>Phillips Head Hex Bolt</td>
</tr>
<tr>
<td>1 1/2&quot;</td>
<td>Flange Bolt</td>
</tr>
<tr>
<td>1 3/4&quot;</td>
<td>Phillips Head Sheet Metal Screw</td>
</tr>
<tr>
<td>2&quot;</td>
<td>Washer</td>
</tr>
<tr>
<td>2 1/4&quot;</td>
<td>Washer</td>
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<tr>
<td>2 1/2&quot;</td>
<td>Washer</td>
</tr>
<tr>
<td>2 3/4&quot;</td>
<td>Washer</td>
</tr>
<tr>
<td>3&quot;</td>
<td>Washer</td>
</tr>
</tbody>
</table>

WASHER DIAMETER

- 5/8" WASHER DIAMETER
- 9/16" WASHER DIAMETER
- 1/2" WASHER DIAMETER
- 7/16" WASHER DIAMETER
- 1/4" WASHER DIAMETER
- 5/32" WASHER DIAMETER
- 3/32" WASHER DIAMETER

WASHERS ARE MEASURED BY THE INSIDE DIAMETER

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS!
Site Considerations

Floor Load
The Model G0550 weighs 410 lbs and has a 25" x 25" footprint. The Model G0551 weighs 450 lbs and has a 21" x 21" footprint. Most commercial floors are suitable for the machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances
Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for the machine. See Figure 6 for the overall dimensions of the Model G0550/G0551.

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.

Figure 6. Overall machine dimensions.

WARNING
Gasoline and petroleum products have low flash points and could explode if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.

WARNING
Smoking near solvents could ignite an explosion or fire and cause serious injury. DO NOT smoke while using solvents.

WARNING
Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.

CAUTION
Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.
Beginning Assembly

This section covers the basic assembly and adjustment instructions needed to begin operation. Complete the assembly in the order provided in this manual and then read the remaining portion of the manual before attempting any type of operation.

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

⚠️ WARNING
Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

⚠️ WARNING
 Disconnect power to the machine during the entire assembly process. Failure to do this may result in serious personal injury.

⚠️ CAUTION
Sharp edges on metal parts may cause personal injury. Examine the edges of all metal parts before handling.

G0550 Open Stand

**Components and Hardware Needed:**

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Legs</td>
<td>4</td>
</tr>
<tr>
<td>Lower Braces</td>
<td>4</td>
</tr>
<tr>
<td>Predrilled Upper Braces</td>
<td>4</td>
</tr>
<tr>
<td>Carriage Bolts 5/8&quot;-18 x 1/2&quot;</td>
<td>32</td>
</tr>
<tr>
<td>Hex Nuts 5/16&quot;-18</td>
<td>32</td>
</tr>
<tr>
<td>Flat Washers 5/16&quot;</td>
<td>32</td>
</tr>
</tbody>
</table>

**Tools Needed:**

12/14mm Combo Wrench .....................1

Note—*The following steps are for the G0550 only.*

To assemble the open stand:

1. Connect the lower and upper braces to the legs of the stand with the carriage bolts, hex nuts and flat washers. See **Figure 7**.

![Figure 7. Upper and lower braces connected to leg.](image-url)
2. Connect the remaining legs and braces together. Finger tighten the carriage bolts that connect the legs to the upper braces. The finished stand assembly should look like Figure 8.

![Figure 8. Assembled stand.](image)

### Mounting Planer (G0550)

**Components and Hardware Needed:**

- Planer Unit ....................................................1
- Assembled Stand ..........................................1
- Hex Bolt 5⁄16"-18 x 1" ......................................4
- Hex Nut 5⁄16"-18 ..............................................4
- Flat Washer 5⁄16" ............................................4
- Lock Washer 5⁄16"............................................4

**Tools Needed:**

- 12/14mm Combo Wrench..............................2
- Strong Persons ..............................................4

**To mount the planer:**

1. **Do not connect the planer to a power source!**

2. Place two 2x4 boards under the cutterhead of the planer unit. Note—*Make sure that the boards are long enough so that they protrude from the planer at least 16" on each side.*
Dust Port

Components and Hardware Needed: ....Qty
Dust Port ....................................................1
Phillips Head Screw M6-1 x 12 .......................6

Tools Needed:
Phillips Head Screwdriver ..............................1

It is important to install a dust collection system to the dust port.

To install the dust port:

1. Do not connect the planer to a power source!
2. Place the dust port above the outfeed table. See Figure 9.
3. Secure the dust port with the Phillips head screws provided.

Figure 9. Dust port installed.

Handwheel

Components and Hardware Needed: ....Qty
Handwheel ...................................................1
Handwheel Handle ........................................1
Hex Nut M10-1.5 ...........................................1
Flat Washer 10mm .......................................1
High/Low Label ..........................................1

Tools Needed:
12/14mm Combo Wrench ...............................1

The handwheel is used to raise and lower the planer cutterhead.

To install the handwheel:

1. Do not connect the planer to a power source!
2. Place the handwheel over the keyed shaft shown in Figure 10. Make sure the keyway in the handwheel lines up with the key in the shaft.
3. Secure the handwheel with the hex nut and washer.
4. Attach the handle to the outer edge of the handwheel.
5. Install the High/Low label around the hex nut.

Figure 10. Installing handwheel.
Extension Rollers

Components and Hardware Needed: Qty
Extension Rollers ...........................................2

Tools Needed:
12/14mm Combo Wrench .................................1
Allen Wrench 4mm ........................................1

To install the extension rollers:

1. Do not connect the planer to a power source!

2. Remove the three hex bolts and washers from below the outfeed and infeed tables.

3. Position the extension rollers over the holes.

4. Finger-tighten the hardware removed in step 2 to secure the extension rails to the planer as shown in Figure 11.

5. Loosen the bed roller setscrews and turn the eccentric shaft so the table rollers are beneath the table surface. See Figure 12.

6. Use a straightedge to check table-to-extension roller alignment as shown in Figure 13.

7. Adjust the leveling setscrews shown in Figure 11 if the table and extension rollers are not flush.

Figure 11. Extension rollers.

Figure 12. Bed roller.

Figure 13. Checking extension roller alignment.
Knife Setting Jig

Components and Hardware Needed:  Qty
Knife Jig Shaft ...............................................1
Knife Jig Feet ...............................................2
E-Clips 9mm ...............................................4

To assemble the knife setting jig:

1. Snap one of the E-clips over the notch on one end of the knife setting shaft.

2. Slide the cast aluminum knife setting jig feet onto the rod.

3. Snap the other E-clip onto the notch at the other end of the knife setting jig shaft.

Figure 14. Knife setting jig.
Start Up

WARNING
Loose hair and clothing could get caught in machinery causing serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

WARNING
Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

Starting the machine:
1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Review Section 3: Circuit Requirements (Page 6).
4. Keep your finger on the STOP button at all times during the test run.

Starting the machine:
Press the START button to turn the machine ON. The machine should run smoothly with little or no vibration.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

Step-by-step instructions on verifying these adjustments can be found in Section 8: Service Adjustments.

Factory adjustments that should be verified:
1. Table Adjustment (page 29)
2. Thickness Scale (page 30)
3. Knife Setting (page 32)
4. Chip Breaker (page 33)
5. Feed Roller Height (page 34)
6. Bed Roller (page 35)
7. Feed Roller Pressure (page 36)
8. Chip Deflector (page 37)
SECTION 6: OPERATIONS

General

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

⚠️ WARNING
Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a respirator, and hearing protection while using this machine.

⚠️ WARNING
Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

Cutterhead Locks

There is a cutterhead lock knob on each side of the planer that must be loosened before adjusting the height. Once the height has been set, tighten the lock knobs. See Figure 15.

NOTICE
Lock down the cutterhead with the cutterhead lock knobs before planing or snipe will occur.

Figure 15. Cutterhead lock knob.
Power Feed

The power feed can be set for two feed rates—16 FPM and 20 FPM. While the planer is running the feed rate can be changed by pulling the feed control knob (Figure 16). Press the knob in towards the machine for 20 FPM and pull the knob out for 16 FPM. When the control knob is in the center position, the power feed is in neutral.

Figure 16. Power feed knob.

Handwheel

Turn the handwheel to raise or lower the cutterhead, according to the workpiece thickness.

Each complete revolution of the handwheel moves the table by $\frac{5}{32}$" (4mm).

Make sure the height scale is properly adjusted before making a cut. It is always a good idea to run a test piece through the planer and compare the thickness of the workpiece to the scale reading.

Depth Limiter

The depth limiter, shown in Figure 17, controls the maximum depth of cut to $\frac{1}{8}$". To avoid mechanical damage to the planer and workpiece do not remove the depth limiter.

Figure 17. Depth limiter.

NOTICE

To avoid mechanical damage to the planer, do not remove the depth limiter.
Anti-Kickback

The anti-kickback fingers hang from a rod suspended across the front of the cutterhead casting. Check the fingers to ensure that they swing freely and easily. See Figure 18.

WARNING

DO NOT apply oil or other lubricants to the anti-kickback fingers. Oil or grease will attract dust and restrict movement of the fingers, which could result in damage to your workpiece, the planer, or possibly serious injury to the operator.

Figure 18. Anti-kickback fingers.

Wood Species

The species of wood, as well as its condition, have a dramatic effect on planing ability. The harder the wood (as illustrated by its shear strength), the more difficult it will be to plane. A brief listing of common hard and soft woods in relation to their shear strengths and planing difficulty is listed below.

<table>
<thead>
<tr>
<th>Type</th>
<th>Shear (PSI)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Black Locust</td>
<td>2,480</td>
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<tr>
<td>Sugar Maple</td>
<td>2,330</td>
</tr>
<tr>
<td>Pecan Hickory</td>
<td>2,080</td>
</tr>
<tr>
<td>White Oak</td>
<td>2,000</td>
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<tr>
<td>White Ash</td>
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<tr>
<td>Black Cherry</td>
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<tr>
<td>American Elm</td>
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</tr>
<tr>
<td>Black Walnut</td>
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</tr>
<tr>
<td>Red Alder</td>
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<tr>
<td>Basswood</td>
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<tr>
<td>Cottonwood</td>
<td>930</td>
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</tbody>
</table>

Increasing Difficulty

<table>
<thead>
<tr>
<th>Type</th>
<th>Shear (PSI)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Western Larch</td>
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</tr>
<tr>
<td>Tamarack</td>
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</tr>
<tr>
<td>Douglas Fir</td>
<td>1,160</td>
</tr>
<tr>
<td>Alaska Cedar</td>
<td>1,130</td>
</tr>
<tr>
<td>Sitka Spruce</td>
<td>1,150</td>
</tr>
<tr>
<td>Sugar Pine</td>
<td>1,050</td>
</tr>
<tr>
<td>Cypress</td>
<td>1,000</td>
</tr>
<tr>
<td>Redwood (OG)</td>
<td>940</td>
</tr>
<tr>
<td>Red Cedar</td>
<td>860</td>
</tr>
<tr>
<td>White Pine</td>
<td>850</td>
</tr>
<tr>
<td>Balsam Fir</td>
<td>710</td>
</tr>
</tbody>
</table>
SECTION 7: MAINTENANCE

Maintenance Safety

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

![Warning sign]

**WARNING**
Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

![Warning sign]

**WARNING**
Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

![Warning sign]

**WARNING**
Projectiles from the machine could cause serious eye injury. Wear safety glasses at all times.

General

Regular periodic maintenance on the Model G0550/G0551 will ensure optimum performance. Make a habit of inspecting the machine each time you use it.

**Before each use, look for the following conditions:**

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 machine 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™.
To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition (free from cracks, fraying and wear). Check the V-belts at least every 3 months; more often if the planer is used daily.

Make sure that the motor pulley and cutterhead pulley are aligned and the V-Belts are properly tensioned.

**To align the V-Belt:**

1. **Disconnect the machine from the power source!**

2. Remove the V-Belt cover.

3. Loosen the bolts that mount the motor to the motor mount bracket.

4. Adjust the position of the motor until the pulleys are in line, and check the alignment with a straightedge as shown in Figure 19.

Squeeze the V-Belts at their midpoints with moderate finger pressure. You should be able to deflect each V-Belt about 3/4". Belts will rarely be too tight, but will sometimes be too loose.

**To tension the V-Belt:**

1. **Disconnect the machine from the power source!**

2. Insert a wooden lever between the motor mount and the top of the planer as shown in Figure 20.

3. Loosen the two bolts that hold the motor pulley assembly to the planer (Figure 19).

4. Lift the motor assembly with the wooden lever until the belt is tensioned correctly.

5. Hold the motor in place and secure the bolts loosened in step 3.

6. Squeeze the belts to check the tension and repeat steps 2-5 if necessary.
Gearbox

The gearbox is located just behind the handwheel on the right side of the planer. The gearbox transfers power from the belt-driven cutterhead to the power feed rollers. The two-speed transmission is controlled by a push/pull lever on the right side of the planer. When engaged, the power feed rollers will move lumber through the planer at either 16 or 20 feet-per-minute. The center lever position is neutral.

To inspect the gearbox:

1. Loosen the socket head cap screw on the gearbox cover, and gently pull the cover off the roll pins that hold it in place.

2. Check the bolts that hold the sprockets in place. Inspect the drive chains to ensure that the retaining clips are in place. Replace the clips if necessary. See Figure 21.

Lubrication

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

The following is a list of features and parts that need lubrication:

Columns/Lead Screws—The four columns should be lubricated with light machine oil once a week. The four lead screws should be lubricated with general purpose grease once a month. See Figure 22.

![Figure 21. Gearbox.](image1)

![Figure 22. Columns and lead screws.](image2)
**Worm Gear**—The worm gear should be inspected monthly and lubricated when needed. Remove the worm gear box to inspect. See parts diagram for location.

**Chain**—The table height adjustment chain should be inspected monthly and lubricated when needed. A good quality bicycle chain lubricant works well for periodic lubrication.

**Gear Box**—Gear box oil should be drained after the first 20 hours of operation. See Figure 23 & 24. Replace with 80W-90 gear oil. Inspect levels periodically and change yearly. Replace gear oil more frequently under heavy use. Fill until oil reaches the top of the filler plug port for correct oil level.

**Drive Chain**—The drive chain should be inspected and lubricated monthly. Check the sprocket, the chain and the cotter pin during inspection. Use a general purpose grease. Some chains will have master links instead of cotter pins.

**Feed Rollers**—The infeed/outfeed pressure setscrews double as lubrication ports for the rollers. See Figure 25. Add 1-2 drops of light machine oil to all ports before each use. Daily lubrication of the feed rollers is crucial to the operation of your planer. Lubricate before start-up. Apply a light oil, making sure that the lubricant penetrates the bearing.
Planing Difficulties

The species of wood, as well as condition, will affect planing ability. The harder the wood, the more difficult it will be to plane. Below, we have included below, a list of wood characteristics you may encounter when planing. The following descriptions of defects will give you some possible answers to problems you may encounter while planing different materials. Possible solutions follow the descriptions.

Chipped Grain—Usually a result of cutting against the grain, or planing wood with knots or excessive amount of cross grain. Chipped grain can also be caused by dull knives or misaligned chipbreaker. Often, chipped grain can be avoided by slowing down the feed rate and by taking shallow cuts. If those options do not work, inspect your lumber and determine if its grain pattern is causing the problem. If the wood does not show substantial crossgrain, inspect your knives for sharpness and inspect the chipbreaker for proper alignment. See the Adjustment Section.

Fuzzy Grain—Usually caused by surfacing lumber with too high of a moisture content. Sometimes fuzzy grain is a characteristic of some woods, such as basswood. Fuzzy grain can also be caused by dull knives or an incorrect grinding bevel. Check with a moisture meter. If moisture is greater than 20%, sticker the wood and allow to dry. Otherwise, inspect knife condition.

Glossy Surface—Usually caused by dull knives taking shallow cuts at a slow feed speed. Surface gloss will usually be accompanied by overheating. Often, lumber will be scorched and eventually damage to knives will occur. If knives are sharp on inspection, increase feed speed or cutting depth.

Snipe—Occurs when board ends have more material removed than the rest of the board. Usually caused when one or both of the bed rollers are set too high. Can also be caused by the chipbreaker or pressure bar being set too high. However, small amount of snipe is inevitable. Snipe can be minimized by proper adjustment of the planer components, but complete removal of snipe is extremely unlikely. More likely, you will be able to reduce it to a tolerance of .002". If snipe under that level is a problem, consider planing lumber longer than your intended work length and cut off the excess after planing is completed.

Uneven Knife Marks—Uneven knife marks can occur when the chipbreaker is set too high. Inspect cutterhead bearings if re-adjustment of the chipbreaker fails to remedy the situation.

Chatter Marks—Usually caused by incorrect chipbreaker and pressure bar setting heights. Chatter marks can also be caused by running a narrow wood piece through the planer at either the right or left end of the cutterhead. Chatter, like uneven knife marks, will show in the form of a "washboard" look. Chatter marks are more likely to be inconsistent in appearance than uneven knife marks.

Wavy Surface—Caused by poor knife height adjustment, a wavy surface appears when one knife is taking deeper cuts than the rest of the knives. Remedy by resetting the knives to a tolerance within 0.003" of one another.

Pitch & Glue Build-up—Glue and resin build-up on the rollers and cutterhead will cause overheating by decreasing cutting sharpness while increasing drag in the feed mechanism. The result can include scorched lumber as well as uneven knife marks and chatter.

Chip Marks—Occur when chips are not properly expelled from the cutterhead. The knives catch the chips and drag them across the lumber being planed. Chips tend to be random and non-uniform (as compared to chipped grain). Can be caused by exhaust blockage or too much room between the cutterhead and chip deflector. Using a dust collection system in combination with the planer can help reduce chip marks. Inspect the chip deflector and readjust (as described earlier in the text).
Warning
Always disconnect power to the machine before performing service adjustments. 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 that 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 at (570) 546-9663.

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.

Gauge Blocks

Before attempting to adjust the table, you will need to construct a gauge block. See Figure 26. Do not use common 2x4 material. Use a hard wood material like maple or oak. A pattern for this gauge block has been provided for you on page 48 of this manual.

A good alternative is to use a Rotocator Figure 27. Use the Rotocator whenever the instructions call for use of the gauge block or feeler gauge. Refer to the current Grizzly catalog for rotocators.

Gauge Block Specifications.

Figure 26. Gauge block specifications.

Figure 27. Rotocator.
Table Adjustment

It is important that the cutterhead is parallel to the table to plane stock perfectly square.

To check the table alignment:

1. Disconnect the machine from the power source!
2. Place the gauge block on the table under one end of the cutterhead.
3. Turn the handwheel to raise the table until the block barely touches the cutterhead body. The block should not be touching the knives. See Figure 28.
4. Slide the block toward the opposite side of the cutterhead. Use a feeler gauge to measure the width of the gap, if any, between the top of the block and the bottom of the cutterhead. If there is a gap, make a note, reading the distance from the feeler gauge.
5. If the block wedges tightly between the table and cutterhead when shifting from one side to the other, repeat steps 1 through 3 above, but start from the opposite end of the cutterhead.

— If the gap difference from one side to the other is greater than 0.004", but less than 0.016", go to step 5.

If the gap difference from one side to the other is greater than 0.016", the table raising chain under the planer base will need to be adjusted. Please call our Customer Service number for chain adjustment instructions.

To adjust for gap differences:

6. Determine which side of the table must be raised to correct the gap.
7. Locate the two cap screws in the table casting for each of the columns. See Figure 29. Loosen both sets of cap screws for each column on the side you wish to adjust.
8. Push down or pull up the table in the desired direction. Hold the table in position and retighten the cap screws.
9. Recheck the table to cutterhead parallelism again. Repeat steps 1-8 until the deviation is less than 0.004".
Thickneass Scale

The thickness scale, located below the handwheel, can be adjusted for accuracy. However, material must be run through the machine to adjust the thickness scale. Make certain you have followed the directions in the Operations Section for test running before attempting to make these adjustments.

To adjust the scale:

1. Adjust the cutterhead height to the approximate thickness of your test lumber. Measure the lumber with calipers to determine its exact thickness.

2. Move the cutterhead to $\frac{1}{16}''$ under the thickness of your lumber and feed your test board through the planer.

3. Turn the handwheel one half rotation and run the board through once more. Turn the board over and repeat.

4. Measure the board again and compare your results with the scale. If there is a discrepancy, loosen the scale adjustment screw and correct the position. See Figure 30.
Knife Inspection

The Model G0550/G0551 Planer has a three-knife cutterhead. The cutterhead is located in the head casting and rotates on two sealed bearings. No lubrication is needed for the life of the bearings.

Because of normal use and wear, the knives must be periodically sharpened, replaced or adjusted. Adjustment from the factory must also be checked prior to use due to possible movement during shipment.

To inspect the knives:

1. Disconnect the machine from the power source!

2. Lower the table and place the gauge block or a Rotorator under one end of the cutterhead.

3. Remove the V-Belt cover and carefully rotate the belts to turn the cutterhead until the first knife is at bottom dead center. Adjust the cutterhead height until the knife barely touches the top of gauge block. Note—Rock the cutterhead back and forth to determine bottom dead center.

4. Slide the gauge block to the opposite side of the cutterhead and check the same knife, rocking back and forth to determine bottom dead center.

   — If the knife does not contact the gauge block, use a feeler gauge to determine the difference between one side and the other. See Figure 31.

   — If the knife bottoms out on the gauge block, repeat steps 1-3, but start on the opposite side of the cutterhead.

5. The variation between one side and the other should not be greater than 0.004". Repeat steps 1-4 on the other two knives. Again, the variation between all three knives should not be greater than 0.004".

Once you have completed inspection on all three knives, you will be able to determine whether or not there is a need to adjust the knives in the cutterhead. Proceed to the appropriate section, depending upon whether you are using the jack screws or the springs.

**WARNING**

When making adjustments, all three knives must be adjusted the same. DO NOT adjust one knife without adjusting the others as well. Improper knife height adjustment can result in damage to knives, poor planer performance and possible operator injury.

**NOTICE**

Always adjust the thickness scale after adjusting the knives.
Knife Sharpening

For the best results, it is best to have planer knives sharpened by a professional sharpening service which has the grinding and measurement equipment to assure that the knife cutting geometry is maintained at optimum levels. Knife sharpening is a procedure that requires some care and precision, otherwise, a set of blades can be easily ruined. Knives should always be ground as a set so they can be properly matched. Unequal material removal can result in an unbalanced cutterhead which can affect not only planing surface quality but ultimately the life of the cutterhead bearings.

Your planer knives can be sharpened by a blade hone. See the “Aftermarket Accessories” subsection at the back of this manual for more information.

Knife Setting

The process of setting the knives in the cutterhead will come into play whenever you sharpen or replace, or after determining that setting is necessary during the initial setup.

The knives lock into the cutterhead with wedge type gibs. Springs under each knife provide an upward pressure to help ease the setting process. Jack screws under the knives allow fine tuning to help in the setting process.

To set the knives:

1. **Disconnect the machine from the power source!**
2. Remove the upper cover to expose the cutterhead.
3. Choose a knife to begin with and loosen the gib bolts just enough until the springs push the knife upward.

Figure 32 illustrates the features of the cutterhead that are mentioned in this section.

![Figure 32. Proper knife setting jig placement.](image-url)
4. Place the knife setting jig over the knife on the cutterhead as shown in Figure 33. The knife setting jig will push the knife into position in the cutterhead.

Figure 33. Proper knife setting jig placement.

5. While holding the position of the knife setting jig, adjust the jack screws, located on each end of the knife, until they make contact with the bottom of the knife.

6. While holding the position of the knife setting jig, tighten the gib bolts down again in the cutterhead (Figure 34). Tighten the bolts evenly from the middle, working toward the ends.

7. Repeat these steps for the other two knives.

Figure 34. Tightening gib bolts in cutterhead.

Chip Breaker

The chip breaker is located on the top side of the planer and extends down around the front of the cutterhead. Its function is to prevent tear-out or deep, unregulated gouging as the knives remove material. The chip breaker works by breaking the woodchips as they are being cut by the cutterhead. The chip breaker also deflects and expels the woodchips away from the surface of the board and out of the planer.

To check the chipbreaker:

1. Disconnect the machine from the power source!

2. Ensure that the knives are properly adjusted.

3. Place the gauge block on the table directly under the cutterhead.

4. Using a 1mm feeler gauge between the gauge block and the cutterhead, raise the table until one of the knives just touches the feeler gauge. Rotate the cutterhead by turning the V-belts to be sure the knife is at bottom dead center.

5. Lock the table by tightening the table lock knobs.

6. Remove the feeler gauge and slide the gauge block under the chip breaker. See Figure 35. The chip breaker should just touch the top of the gauge block. Slide the gauge block to the opposite end of the chip breaker and check it in the same manner.
The infeed and outfeed rollers move the lumber through the planer, and press the lumber flat against the planer table.

Set the infeed and outfeed rollers to 0.02"-0.04" below the cutterhead knife edge at bottom dead center.

To check roller height:

1. **Disconnect the machine from the power source!**

2. Lower the table so the gauge block will fit under one side of the infeed roller.

3. Raise the table until the gauge block barely touches the infeed roller. See Figure 37. Do not change the position of the table.

4. Slide the gauge block over so it is under the edge of one of the knives. Turn the cutterhead until one of the knives is at bottom dead center over the gauge block.

5. Measure the clearance between the top of the gauge block and the edge of the knife with a feeler gauge. Note the measurement indicated on the feeler gauge.

---

**Feed Roller Height**

---

**To adjust the chip breaker:**

1. **Disconnect the machine from the power source!**

2. If an adjustment is necessary, loosen the locknuts and turn the setscrews. See Figure 36. Stop turning when the bottom of the chip breaker just touches the gauge block.

3. Tighten both locknuts.

---

**Figure 35.** Gauge block under chip breaker.

**Figure 36.** Chip breaker height adjustment.

**Figure 37.** Feed roller height inspection.
6. Repeat steps 1-5 for the opposite side of the roller. Repeat all steps for the outfeed roller.

Feeler gauge measurement should be between 0.02" - 0.04" on the infeed and outfeed roller at bottom dead center.

To adjust roller height:

1. Remove the drive chain cover to access the roller adjustments on the drive chain side of the planer. A single socket head cap screw holds the drive chain cover on. The belt side adjustments are already accessible.

2. Loosen the roller adjustment check nuts and turn the roller height setscrews to change the height of the roller as needed. See Figure 38.

3. Check the roller height according to the above instructions. Continue turning the setscrew until the roller is properly adjusted.

4. When the roller is set in the correct position, retighten the check nuts you loosened in step 2 above.

5. Check your settings one last time and repeat steps 1-4 if necessary.

To adjust the bed rollers:

1. Ensure that power is disconnected and lay a high quality straightedge across both table rollers. Use a try square to keep the straightedge perpendicular to the table.

2. Use a feeler gauge to measure the clearance between the bottom of the straight edge and the table. Ideal clearance is between 0.006" and 0.002". Measure in several places. This measurement must be consistent across the entire table. See Figure 39.

Figure 38. Feed roller height adjustment.

Figure 39. Inspecting bed roller height.
3. Loosen the setscrews on both sides of each bed roller. See Figure 40.

4. Use a wrench to turn the eccentric shafts that adjust roller height. Stop turning when the table rollers are at the proper height.

5. Once your roller heights are correct, retighten all the setscrews.

6. Check the height of the table rollers. Repeat steps 1-5 until the bed rollers are properly set.

7. Spin the bed rollers to ensure free movement.

---

### Feed Roller Pressure

To be effective, the infeed and outfeed rollers must put pressure on the workpiece as it feeds through the planer. Too little pressure results in slipping boards, too much pressure results in jamming.

Experiment with the best pressure settings for your work situations. Some rough cut lumber will feed through with relatively few problems, while other lumber will have more difficulty.

Adjusting roller pressure does not affect height.

**To adjust roller pressure:**

1. Disconnect the machine from the power source!

2. Ensure that knives and feed rollers are set correctly.

3. Unscrew the three regular pressure setscrews on top of the planer body. See Figure 41.

---

**Figure 40.** Adjusting bed roller height.

**Figure 41.** Roller pressure setscrews.
4. Remove the springs that are in the setscrew holes. See Figure 42.

5. Check for any dirt or grit, and clean the springs and setscrews if dirty.

6. Screw the three regular-pressure setscrews back in until they are flush with the top of the head casting.

7. Screw the light pressure setscrew (Figure 42) until it is approximately \( \frac{1}{4} \)" above the head casting. The feed chain applies additional tension to the right side of the outfeed roller, so the pressure added by the setscrew need not be as high.

---

**Chip Deflector**

The chip deflector keeps chips from falling onto the outfeed roller. It is the orange plastic plate located under the top cover.

The beveled edge of the chip deflector should be properly adjusted according to your dust collection setup. However, if the chip deflector is set too close to the knives, the rotating cutterhead may pull it in and destroy it.

**To adjust the chip deflector:**

1. Disconnect the machine from the power source!

2. Loosen the three deflector mounting bolts. See Figure 43. Make sure the beveled edge of the deflector faces the cutterhead.

3. Tighten the chip deflector mounting bolts and mount the upper cover back onto the planer.

---

**Figure 42.** Roller pressure assembly.

**Figure 43.** Chip deflector access.

— The edge of the chip deflector should be \( \frac{1}{16} \)" away from the knife edge if a dust collection system is not installed on your planer.

— The edge of the chip deflector should be \( \frac{1}{4} \)" away from the knife edge if a dust collection system is in place on your planer.
SECTION 9: REFERENCE INFO

General

This section contains the following subsections for the Model G0550/G0551: aftermarket accessories, data sheets, parts diagrams and list, troubleshooting, wiring diagrams, gauge block design, and warranty/return information.

If you need parts or help in assembling your machine, or if you need operational information, call the service department at (570) 546-9663. 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 Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@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.

**Rotocator—Model G1738**
The Rotacator® has a magnetic base and is used to adjust settings on any planer. Infeed and outfeed rollers, pressure bars, feed-bed rollers, chipbreaker, etc., can be adjusted very quickly and accurately.

**Planer/Joiner Blade Hone—Model G3631**
Add a razor hone to your planer and jointer knives with this hand-held sharpening device.

**Replacement Knives—Model G1196**
Replace your old planer knives and get your machine cutting like new again with these high speed steel replacement knives.

**SHOP FOX® Mobile Base—Model G8683**
Make your planer mobile with this popular patented mobile base.

**Planer Pals—See The Current Grizzly Catalog For Model #s.**
These patented jigs are remarkably simple to use an hold knives securely in place while you tighten them in the cutterhead. They also allow you to shift nicked knives to avoid replacement or removal.
# GRIZZLY MODEL G0550 15" PLANER

Design Type .................................................................Bench Model

## Overall Dimensions:
- Table Size ................................................................. $14^{7/8}$" x 20"
- Height w/ Stand .......................................................... 53"
- Overall Length ............................................................ 48"
- Overall Width ............................................................. 28"
- Shipping Weight .......................................................... 460 lbs.
- Net Weight ................................................................. 410 lbs.
- Foot Print ................................................................. $25^* x 25^*$
- Crate Size ................................................................. $22^{1/2}\text{L} x 30\text{W} x 29\text{H}$

## Capacities:
- Maximum Depth of Cut .............................................. $1/8^\prime$"
- Maximum Width of Cut ............................................. $14^{7/8}\prime$"
- Maximum Cutting Height ........................................... $6^{1/8}\prime$"
- Minimum Stock Thickness ........................................... $3/16$"
- Minimum Stock Length ............................................. 8"
- Cutterhead Speed ..................................................... 5000 RPM
- Cuts per Minute ....................................................... 15,000
- Cuts per Inch .......................................................... 63 & 78
- Feed Speeds ........................................................... 16 & 20 FPM

## Construction:
- Table ................................................................. Precision Ground Cast Iron
- Infeed Roller .......................................................... Spiral Serrated
- Outfeed Roller ....................................................... Machined Steel
- Power Transfer to Feed Rollers: Gearbox & Chain
- Cutterhead Assembly ................................................ Steel
- Cutterhead ........................................................... One piece machined shaft; 3 Knife Slots w/ Sealed Ball Bearings

## Motor:
- Type ................................................................. TEFC Capacitor-Start Induction
- Horsepower ......................................................... 2 HP
- Phase / Voltage ..................................................... Single Phase / 220 V
- Amps ................................................................. 12A
- Cycle / RPM ......................................................... 60 Hertz / 3450 RPM
- Switch ............................................................... Magnetic With Thermal Overload Protector
- Power Transfer to Cutterhead ...................................... Triple V-Belt
- Bearings ........................................................ Sealed & Permanently Lubricated Ball Bearings

## Features:
- Stand ................................................................. Open Style
- Roller Extension Tables ............................................. 3 Adjustable Rollers
- Cutterhead Movement ................................................ Handwheel & 4 Chaindriven Leadscrews
- Table Locks .......................................................... Two Positive
- Chip Chute ............................................................. 4" Outlet
- Bed Rollers ........................................................ 2 Adjustable
- Knife Type / Size / Adjustment .................. 3 HSS / $15\prime$ x 1" x $1/8\prime$ / Jack-screws and Springs
- Drive Gears Run In Oil Bath
- Vertical Scale Calibrations Inch/Metric

Specifications, while deemed accurate, are not guaranteed.
**GRIZZLY MODEL G0551 15" PLANER**

**Design Type** ................................................................. Bench Model

**Overall Dimensions:**
- **Table Size:** 147/8" x 20"
- **Height w/ Stand:** 53"
- **Overall Length:** 48"
- **Overall Width:** 28"
- **Shipping Weight:** 560 lbs.
- **Net Weight:** 450 lbs.
- **Foot Print:** 21" x 21"
- **Crate Size:** 30 3/4"L x 30"W x 48 1/2"H

**Capacities:**
- **Maximum Depth of Cut:** 1/8"
- **Maximum Width of Cut:** 14 7/8"
- **Maximum Cutting Height:** 6 1/8"
- **Minimum Stock Thickness:** 3/16"
- **Minimum Stock Length:** 8"
- **Cutterhead Speed:** 5000 RPM
- **Cuts per Minute:** 15,000
- **Cuts per Inch:** 63 & 78
- **Feed Speeds:** 16 & 20 FPM

**Construction:**
- **Table:** Precision Ground Cast Iron
- **Infeed Roller:** Spiral Serrated
- **Outfeed Roller:** Machined Steel
- **Power Transfer to Feed Rollers:** Gearbox & Chain
- **Cutterhead Assembly:** Steel
- **Cutterhead:** One piece machined shaft; 3 Knife Slots w/ Sealed Ball Bearings

**Motor:**
- **Type:** TEFC Capacitor-Start Induction
- **Horsepower:** 3 HP
- **Phase / Voltage:** Single Phase / 220 V
- **Amps:** 18A
- **Cycle / RPM:** 60 Hertz / 3450 RPM
- **Switch:** Magnetic With Thermal Overload Protector
- **Power Transfer to Cutterhead:** Triple V-Belt
- **Bearings:** Sealed & Permanently Lubricated Ball Bearings

**Features:**
- **Roller Extension Tables:** 3 Adjustable Rollers
- **Cutterhead Movement:** Handwheel & 4 Chaindriven Leadscrews
- **Table Locks:** Two Positive
- **Chip Chute:** 4" Outlet
- **Bed Rollers:** 2 Adjustable
- **Knife Type / Size / Adjustment:** 3 HSS / 15" x 1" x 1/8" / Jack-screws and Springs
- **Drive Gears Run In Oil Bath**
- **Vertical Scale Calibrations Inch/Metric**
- **Powder Coated Paint on Cabinet**

*Specifications, while deemed accurate, are not guaranteed.*
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<td>INT RETAINING RING 38MM</td>
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<td>ELEVATION SPINDLE, LONG</td>
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## Troubleshooting Guide

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<th>SYMPTOM</th>
<th>POSSIBLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor will not start.</td>
<td>1. Low voltage.</td>
<td>1. Check power line for proper voltage.</td>
</tr>
<tr>
<td></td>
<td>2. Open circuit in motor or loose connections.</td>
<td>2. Inspect all lead connections on motor for loose or open connections.</td>
</tr>
<tr>
<td>Motor will not start; fuses or circuit breakers blow.</td>
<td>1. Short circuit in line cord or plug.</td>
<td>1. Inspect cord or plug for damaged insulation and shorted wires.</td>
</tr>
<tr>
<td></td>
<td>2. Short circuit in motor or loose connections.</td>
<td>2. Inspect all connections on motor for loose or shorted terminals or worn insulation.</td>
</tr>
<tr>
<td></td>
<td>3. Incorrect fuses or circuit breakers in power line.</td>
<td>3. Install correct fuses or circuit breakers.</td>
</tr>
<tr>
<td></td>
<td>2. Air circulation through the motor restricted.</td>
<td>2. Clean out motor to provide normal air circulation.</td>
</tr>
<tr>
<td>Motor stalls (resulting in blown fuses or tripped circuit).</td>
<td>1. Short circuit in motor or loose connections.</td>
<td>1. Inspect connections on motor for loose or shorted terminals or worn insulation.</td>
</tr>
<tr>
<td></td>
<td>2. Low voltage.</td>
<td>2. Correct the low voltage conditions.</td>
</tr>
<tr>
<td></td>
<td>3. Incorrect fuses or circuit breakers in power line.</td>
<td>3. Install correct fuses or circuit breakers.</td>
</tr>
<tr>
<td>Machine slows when operating.</td>
<td>1. Feed rate too high.</td>
<td>1. Feed workpiece slower.</td>
</tr>
<tr>
<td></td>
<td>2. Depth of cut too great.</td>
<td>2. Reduce depth of cut.</td>
</tr>
<tr>
<td>Loud, repetitious noise coming from machine</td>
<td>1. Pulley setscrews or keys are missing or loose.</td>
<td>1. Inspect keys and setscrews. Replace or tighten if necessary.</td>
</tr>
<tr>
<td></td>
<td>2. Motor fan is hitting the cover.</td>
<td>2. Tighten fan or shim cover.</td>
</tr>
<tr>
<td>Machine is loud when cutting. Overheats or bogs down in the cut.</td>
<td>1. Excessive depth of cut.</td>
<td>1. Decrease depth of cut.</td>
</tr>
<tr>
<td></td>
<td>2. Knives are dull</td>
<td>2. Sharpen knives.</td>
</tr>
<tr>
<td>Infeed roller marks are left on the workpiece.</td>
<td>1. Depth of cut too shallow.</td>
<td>1. Increase depth of cut.</td>
</tr>
<tr>
<td>Outfeed roller marks are left on right side of workpiece.</td>
<td>1. Too much spring tension on feed roller.</td>
<td>1. Refer to Feed Roller Pressure section for adjustment.</td>
</tr>
<tr>
<td>Cannot control snipe.</td>
<td>1. Long or heavy board sags as it enters and exits.</td>
<td>1. Lift up on unsupported end of board as it enters and exits cutterhead.</td>
</tr>
<tr>
<td>Chip buildup on outfeed roller.</td>
<td>1. Chips working their way back under the chip deflector.</td>
<td>1. Lay duct tape over the mounting bolts along the outside edge to seal any possible gaps.</td>
</tr>
<tr>
<td>Machine howls on startup.</td>
<td>1. Chip deflector too close to the cutterhead.</td>
<td>1. Move chip deflector back $\frac{1}{8}$ to $\frac{1}{4}$ from the cutterhead.</td>
</tr>
<tr>
<td>Table moves down while cutting.</td>
<td>1. Knives dull.</td>
<td>1. Replace knives.</td>
</tr>
<tr>
<td></td>
<td>2. Cutterhead is not locked.</td>
<td>2. Tighten cutterhead lock knobs.</td>
</tr>
</tbody>
</table>
Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury.

**DANGER**

*WARNING*
Gauge Block Measurements

GRAIN

4" 4"

1 1/2"

3"

1/4"

1/2"

2"

45°
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.
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
   - Catalog
   - World Wide Web
   - Other

2. Which of the following magazines do you subscribe to?
   - American Woodworker
   - Cabinetmaker
   - Family Handyman
   - Fine Homebuilding
   - Fine Woodworking
   - Home Handyman
   - Journal of Light Construction
   - Old House Journal
   - Popular Mechanics
   - Popular Woodworking
   - Other

3. Which of the following woodworking/remodeling shows do you watch?
   - Backyard America
   - Home Time
   - The American Woodworker
   - Other

4. What is your annual household income?
   - $20,000-$29,999
   - $30,000-$39,999
   - $40,000-$49,999
   - $50,000-$59,999
   - $60,000-$69,999
   - $70,000-$79,999
   - $80,000-$89,999
   - $90,000 +

5. What is your age group?
   - 20-29
   - 30-39
   - 40-49
   - 50-59
   - 60-69
   - 70 +

6. How long have you been a woodworker?
   - 0 - 2 Years
   - 2 - 8 Years
   - 8 - 20 Years
   - 20+ Years

7. How would you rank your woodworking skills?
   - Simple
   - Intermediate
   - Advanced
   - Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.
   - Air Compressor
   - Bandsaw
   - Drill Press
   - Drum Sander
   - Dust Collector
   - Horizontal Boring Machine
   - Jointer
   - Lathe
   - Mortiser
   - Other

9. How many of your woodworking machines are Grizzly? _____________

10. Which benchtop tools do you own? Check all that apply.
    - 1" x 42" Belt Sander
    - 6" - 8" Grinder
    - 5" - 8" Drill Press
    - 8" jointer
    - 10" - 12" Thickness Planer
    - 8" - 10" Bandsaw
    - Scroll Saw
    - Disc/Belt Sander
    - Spindle/Belt Sander
    - Mini Jointer
    - Other

11. How many of the machines checked above are Grizzly? ____________

12. Which portable/hand held power tools do you own? Check all that apply.
    - Belt Sander
    - Orbitral Sander
    - Biscuit Joiner
    - Palm Sander
    - Circular Saw
    - Portable Planer
    - Detail Sander
    - Saber Saw
    - Drill/Driver
    - Reciprocating Saw
    - Miter Saw
    - Router
    - Other

13. What machines/supplies would you like Grizzly Industrial to carry?
    ____________________________________________________________
    ____________________________________________________________

14. What new accessories would you like Grizzly Industrial to carry?
    ____________________________________________________________
    ____________________________________________________________

15. What other companies do you purchase your tools and supplies from?
    ____________________________________________________________
    ____________________________________________________________

16. Do you think your purchase represents good value?
    ___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?
    ___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? Note: We never use names more than three times.
    ___Yes ___No

19. Comments:
    ____________________________________________________________
    ____________________________________________________________
    ____________________________________________________________
    ____________________________________________________________
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