



MODEL G0939/G0940 13" 2 HP BENCHTOP PLANER

OWNER'S MANUAL

(For models manufactured since 12/22)



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*****Keep for Future Reference*****



WARNING!

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

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

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

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



WARNING!

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

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

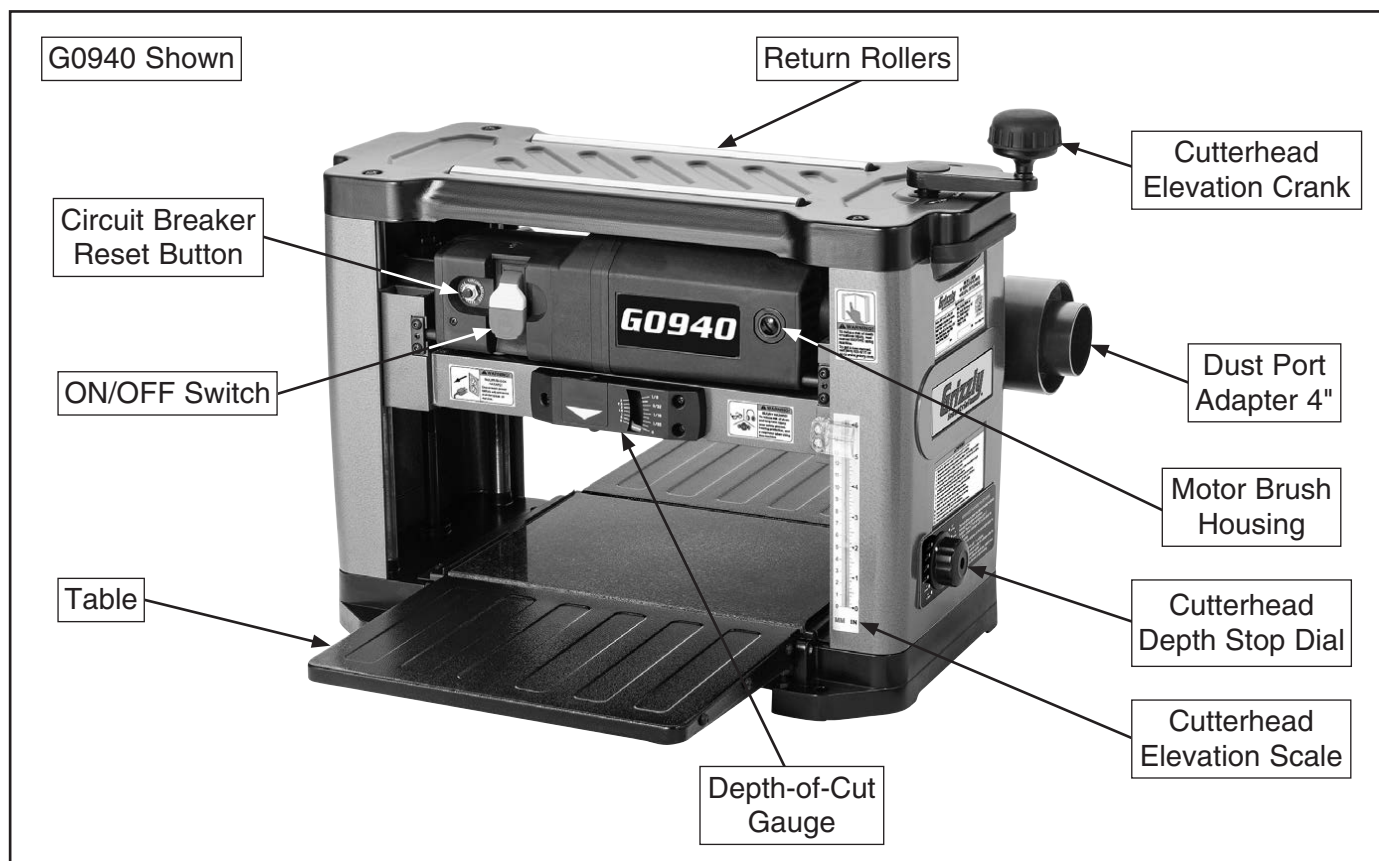
Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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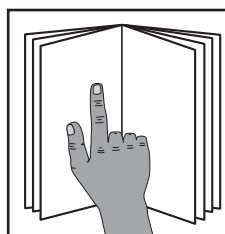
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Identification

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



Controls & Components



! WARNING

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

Refer to **Figures 1–3** and the following descriptions to become familiar with the basic controls of this machine.

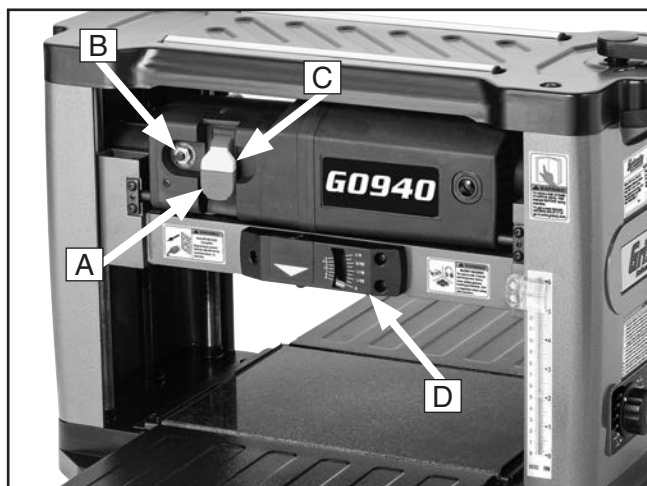


Figure 1. ON/OFF switch and reset button.

- A. ON/OFF Switch:** Turns motor **ON** when moved up; turns motor **OFF** when moved down.
- B. Reset Button:** Allows machine to be restarted after thermal overload protection has tripped. To reset, place ON/OFF switch in OFF position, wait a few minutes for motor to cool, then press reset button. If button does not *stay* depressed, allow motor to cool longer, then try again.
- C. ON/OFF Switch Disabling Key:** Disables switch when yellow key is removed to prevent unauthorized operation of planer.
- D. Depth-of-Cut Gauge:** Shows depth of cut (from 0"– $\frac{1}{8}$ ") when workpiece contacts indicator at bottom of gauge.

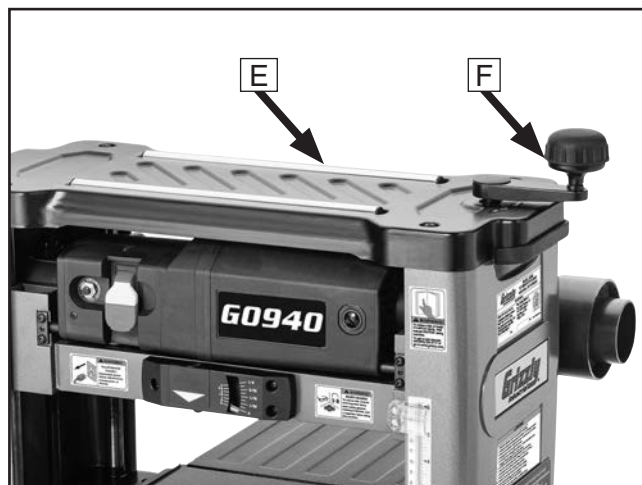


Figure 2. Elevation controls and return rollers.

- E. Return Rollers:** Assist sliding workpiece back to operator following planing operation.
- F. Cutterhead Elevation Crank:** Raises and lowers cutterhead. Rotate clockwise to raise cutterhead; rotate counterclockwise to lower it. Each full rotation changes elevation $\frac{1}{16}$ ".

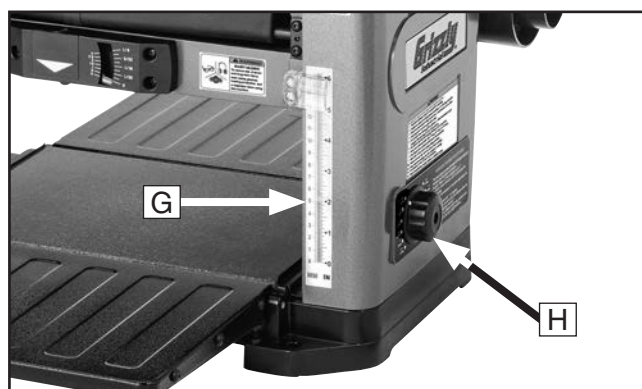


Figure 3. Depth stop dial and elevation scale.

- G. Cutterhead Elevation Scale:** Shows elevation of cutterhead above table. The measurement indicated along top edge of red indicator shows effective thickness of board *after* planing.
- H. Cutterhead Depth Stop Dial:** Allows operator to pre-set desired finished workpiece thickness from $\frac{1}{8}$ "– $1\frac{1}{4}$ " (G0940 Only).



Internal Components

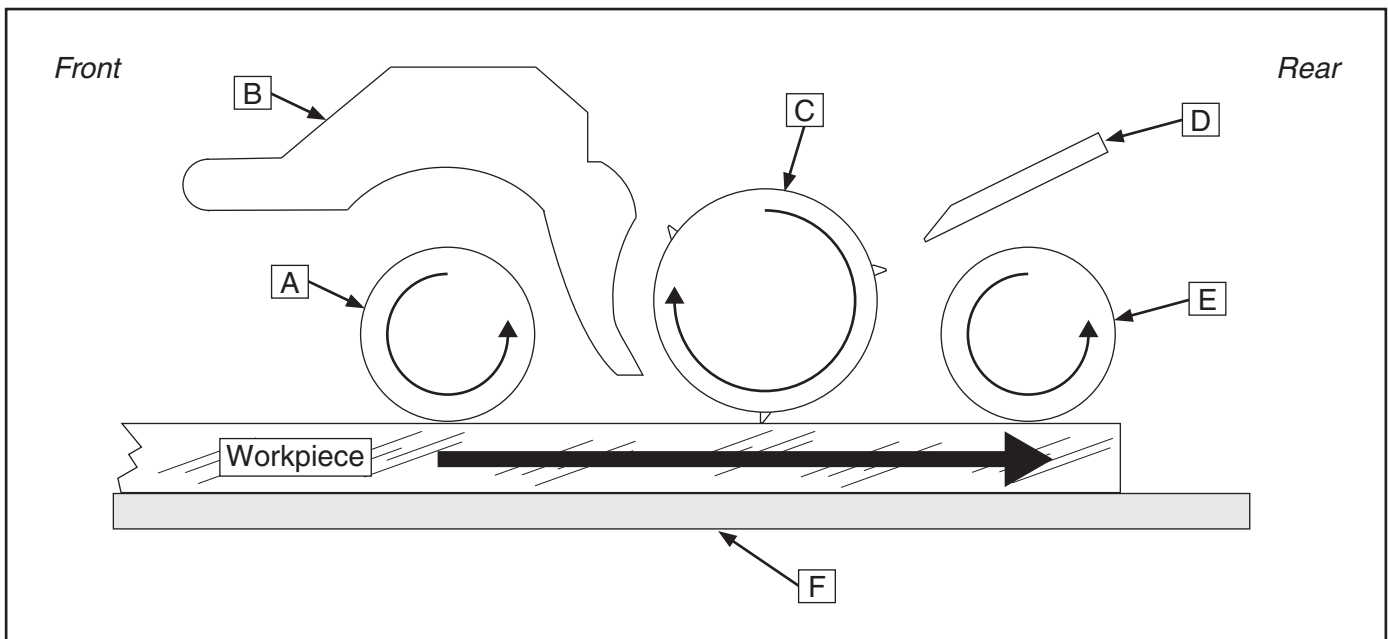


Figure 4. Workpiece path and major planing components (side cutaway view).

- A. Infeed Roller:** Rotates with the direction of feed to pull the workpiece toward the cutterhead.
- B. Chip Breaker:** Breaks off chips created by the cutterhead to prevent tear out and diverts the chips to the dust port.
- C. Cutterhead:** Holds the knives/inserts that remove material from the workpiece. Rotates opposite the direction of feed.
- D. Chip Deflector:** Directs chips into the dust port.
- E. Outfeed Roller:** Rotates with the direction of feed to pull the workpiece through the planer.
- F. Planer Table:** Provides a smooth, flat surface for the workpiece to slide against as it moves through planer. Planer extension tables fold up and down for mobility.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.





MACHINE DATA SHEET

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

MODEL G0939 13" 2 HP BENCHTOP PLANER

Product Dimensions:

Weight..... 67 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 25-1/2 x 25 x 19 in.
Footprint (Length x Width)..... 22-1/2 x 13 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 73 lbs.
Length x Width x Height..... 25 x 17 x 19 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 15A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 2 HP
Phase..... Single-Phase
Amps..... 15A
Speed..... 21,000 RPM
Type..... Universal (DC)
Power Transfer..... Belt
Bearings..... Sealed & Permanently Lubricated

Main Specifications:

Main Specifications

Planer Size..... 13 in.
Max. Cut Width..... 13 in.
Min. Stock Length..... 6 in.
Min. Stock Thickness..... 1/8 in.
Max. Stock Thickness..... 6 in.
Number of Cuts Per Inch..... 85
Number of Cuts Per Minute..... 25,500
Cutterhead Speed..... 8500 RPM
Planing Feed Rate..... 25 FPM
Max. Cut Depth Planing Full Width..... 1/32 in.
Max. Cut Depth Planing 6-Inch Wide Board..... 3/32 in.



Cutterhead Info

Cutterhead Type.....	Straight Knife
Cutterhead Diameter	2 in.
Number of Knives.....	3
Knife Type.....	SK5, Double Sided, Solid
Knife Size Length.....	13 in.
Knife Size Width.....	12 mm
Knife Size Thickness.....	1/16 in.

Table Info

Table/Headstock Movement.....	6 in.
Table Bed Size Length.....	25 in.
Table Bed Size Width.....	13 in.

Construction

Table.....	Stainless Steel
Body.....	Die-Cast Aluminum
Cutterhead Assembly.....	Steel
Infeed Roller.....	Rubber
Outfeed Roller.....	Rubber
Paint Type/Finish.....	Urethane

Other

Measurement Scale.....	Inch & Metric
Number of Dust Ports.....	1
Dust Port Size.....	2 in.

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Min.
Serial Number Location	Machine ID Label
Sound Rating	83 - 85 dB
ISO 9001 Factory	Yes

Features:

2 HP Universal Motor
13" Wide Planing Capacity
SK5 Double-Sided Knives
3-Knife Cutterhead
25,500 Cuts Per Minute
Stainless Steel Main Table
Built-In Dust Collection System with 2" Port
Convenient Grab Handles for Mobility
4" Dust Port Adapter
Steel Extension Wings





MACHINE DATA SHEET

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

MODEL G0940 13" 2 HP BENCHTOP PLANER WITH HELICAL CUTTERHEAD

Product Dimensions:

Weight..... 78 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 25-1/2 x 28 x 19 in.
Footprint (Length x Width)..... 21-1/2 x 13 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 82 lbs.
Length x Width x Height..... 26 x 15 x 19 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 15A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 2 HP
Phase..... Single-Phase
Amps..... 15A
Speed..... 21,000 RPM
Type..... Universal (DC)
Power Transfer Belt
Bearings..... Sealed & Permanently Lubricated

Main Specifications:

Main Specifications

Planer Size..... 13 in.
Max. Cut Width..... 13 in.
Min. Stock Length..... 6 in.
Min. Stock Thickness..... 1/8 in.
Max. Stock Thickness..... 6 in.
Number of Cuts Per Inch..... 57
Number of Cuts Per Minute..... 17,000
Cutterhead Speed..... 8500 RPM
Planing Feed Rate..... 25 FPM
Max. Cut Depth Planing Full Width..... 1/32 in.
Max. Cut Depth Planing 6-Inch Wide Board..... 3/32 in.



Cutterhead Info

Cutterhead Type.....	Helical
Cutterhead Diameter	2 in.
Number of Cutter Rows.....	2
Number of Indexable Cutters.....	30
Cutter Insert Type.....	Indexable Carbide
Cutter Insert Size Length.....	15mm
Cutter Insert Size Width.....	15mm
Cutter Insert Size Thickness.....	2.5mm

Table Info

Table/Headstock Movement.....	6 in.
Table Bed Size Length.....	28 in.
Table Bed Size Width.....	13 in.

Construction

Table.....	Granite
Body.....	Die-Cast Aluminum
Cutterhead Assembly.....	Steel
Infeed Roller.....	Rubber
Outfeed Roller.....	Rubber
Paint Type/Finish.....	Urethane

Other

Measurement Scale.....	Inch & Metric
Number of Dust Ports.....	1
Dust Port Size.....	2 in.

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Min.
Serial Number Location	Machine ID Label
Sound Rating	83 - 85 dB
ISO 9001 Factory	Yes

Features:

Granite Table
Adjustable Depth Stop
Helical Cutterhead with 30 Indexable Carbide Inserts
13" Wide Planing Capacity
Dual Roller Returns
Built-In Dust Collection System with 2" Port
Convenient Grab Handles for Mobility
4" Dust Port Adapter



SECTION 1: SAFETY

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

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



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



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



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

NOTICE

Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery



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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Planers

WARNING

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

KICKBACK. Know how to reduce risk of kickback and kickback-related injuries. “Kickback” occurs during operation when the workpiece is ejected back through infeed side of machine at a high rate of speed. Kickback is commonly caused by poor workpiece selection, unsafe feeding techniques, or improper machine setup/maintenance. Kickback injuries typically occur as follows: (1) operator/bystanders are struck by workpiece, resulting in impact injuries (i.e., blindness, broken bones, bruises, death); (2) operator’s hands are pulled into blade from outfeed side, resulting in amputation or severe lacerations.

AVOID CONTACT WITH MOVING PARTS. Never remove guards/covers or reach inside planer during operation or while connected to power. You could be seriously injured if you accidentally touch spinning cutterhead or get entangled in moving parts. If a workpiece becomes stuck or sawdust removal is necessary, turn planer **OFF**, allow cutterhead to stop, disconnect power before clearing.

DULL/DAMAGED KNIVES/INSERTS. Only use sharp, undamaged knives/inserts. Dull or damaged knives/inserts increase the risk of kickback.

INSPECTING STOCK. To reduce the risk of kickback injuries or machine damage, thoroughly inspect and prepare the workpiece before cutting. Verify workpiece is free of nails, staples, loose knots, or foreign material. Workpieces with minor warping should be jointed first or planed with the cupped side facing the table.

BODY PLACEMENT. Stand to one side of planer during entire operation to avoid getting hit if kickback occurs.

GRAIN DIRECTION. Planing across grain is hard on planer and may cause kickback. Plane in same direction or at a slight angle with wood grain.

PLANING CORRECT MATERIAL. Only plane natural wood stock with this planer. DO NOT plane MDF, OSB, plywood, laminates or other synthetic materials that can break up inside the planer and be ejected towards the operator.

LOOKING INSIDE PLANER. Wood chips fly around inside the planer at a high rate of speed during operation. To avoid injury from flying material, DO NOT look inside planer during operation.

CUTTING LIMITATIONS. To reduce the risk of kickback hazards or damage to the machine, do not exceed the maximum depth of cut or minimum board length and thickness found in the **Data Sheet**. Only feed one board at a time.

INFEED ROLLER CLEARANCE. The infeed roller is designed to pull material into the spinning cutterhead. To reduce the risk of entanglement, keep hands, clothing, jewelry, and long hair away from the infeed roller during operation.

FEED WORKPIECE PROPERLY. To reduce the risk of kickback, never start planer with workpiece touching cutterhead. Allow cutterhead to reach full speed before feeding, and do not change feed speed during cutting operation.

WORKPIECE SUPPORT. To reduce the risk of kickback, always make sure workpiece can move completely across table without rocking or tipping. Use auxiliary support stands for long stock.

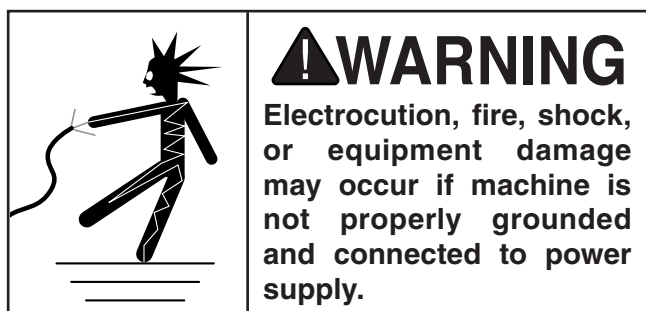
SECURE KNIVES/INSERTS. Loose knives or improperly set inserts can become dangerous projectiles or cause machine damage. Always verify knives/inserts are secure and properly adjusted before operation.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 120V 15 Amps

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

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

! WARNING

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

Circuit Requirements

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

Nominal Voltage 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps

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

! CAUTION

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

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



Grounding & Plug Requirements

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

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

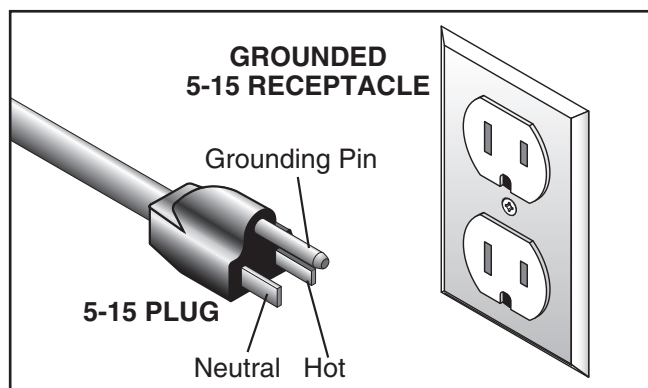
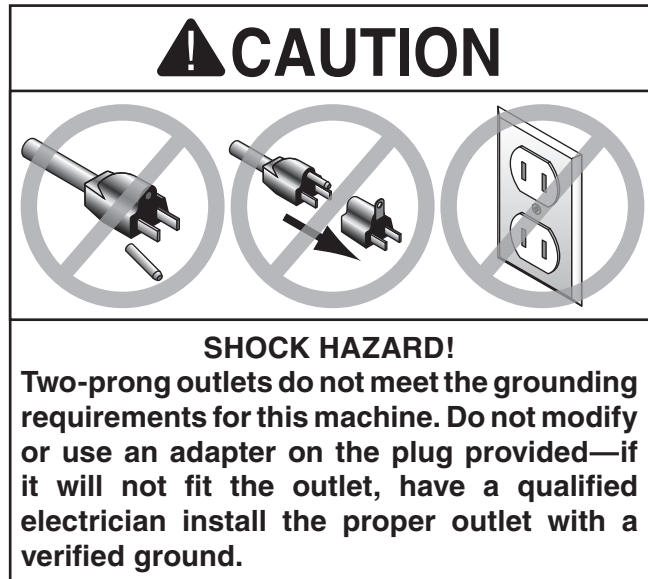


Figure 5. Typical 5-15 plug and receptacle.



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

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

Extension Cords

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

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

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

Minimum Gauge Size 14 AWG
Maximum Length (Shorter is Better).....50 ft.



SECTION 3: SETUP

Unpacking

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

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

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Hex Wrench 4mm.....	1
• Screwdriver Phillips #2	1
• Dust Collection System	1

Inventory

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

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

NOTICE

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

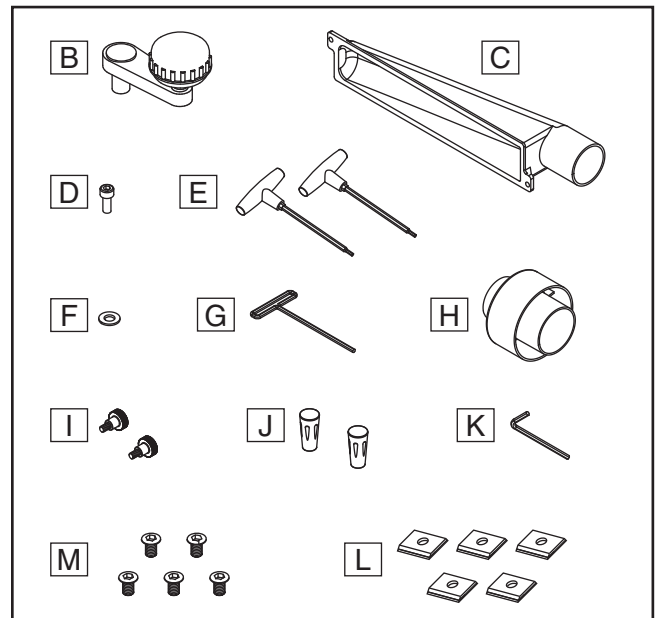


Figure 6. Model G0939/G0940 inventory.

Box 1 (Figure 6)	Qty
A. 13" Planer (not shown)	1
B. Cutterhead Elevation Crank	1
C. Dust Chute	1
D. Cap Screw M5-.8 x 25 (Elevation Crank)...	1
E. T-Handle Torx Wrenches T-20 (G0940)	2
F. Flat Washer 5mm (Elevation Crank)	1
G. T-Handle Hex Wrench 4mm (G0939).....	1
H. Dust Port Adapter 4"	1
I. Knob Bolts M6-1 x 14 (Dust Chute).....	2
J. Magnets (G0939).....	2
Magnet (G0940)	1
K. Hex Wrench 4mm (G0940)	1
L. Indexable Carbide Inserts 15 x 15 x 2.5mm (G0940)	5
M. Flat Head Torx Screws T-20 M5-.8 x 12 (G0940)	5



Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE INVENTORY
AND ASSEMBLY PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

#10

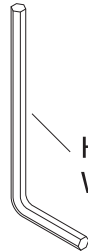
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5/16"

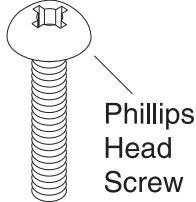
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7/16"

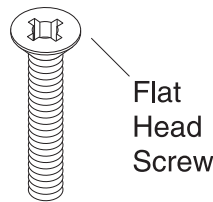
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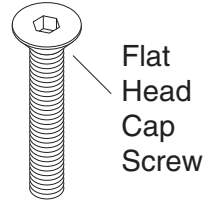
Hex
Wrench



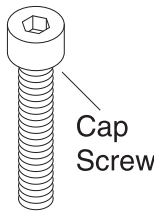
Phillips
Head
Screw



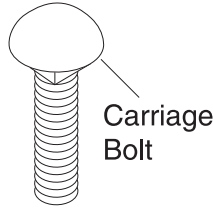
Flat
Head
Screw



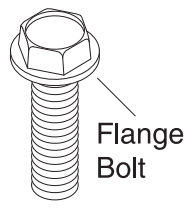
Flat
Head
Cap
Screw



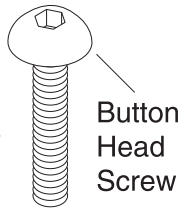
Cap
Screw



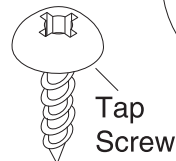
Carriage
Bolt



Flange
Bolt



Button
Head
Screw



Tap
Screw



External
Retaining
Ring



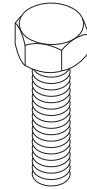
Internal
Retaining
Ring



E-Clip



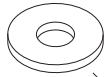
Set
Screw



Hex
Bolt



Key



Flat Washer



Lock
Washer



Hex
Nut

4mm

5mm

6mm

8mm

10mm

12mm

16mm

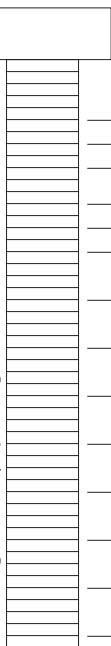
LINES ARE 1MM APART



5mm
10mm
15mm
20mm
25mm
30mm
35mm
40mm
45mm
50mm
55mm
60mm
65mm
70mm
75mm

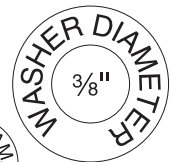
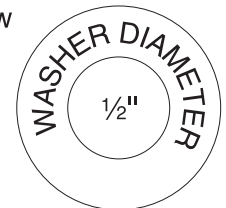
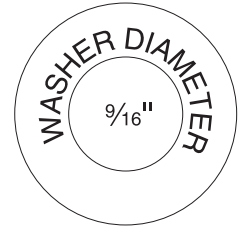
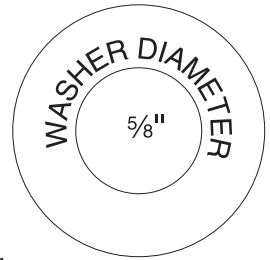
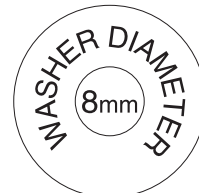
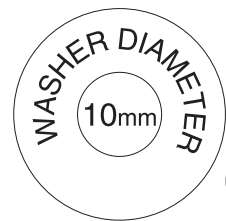
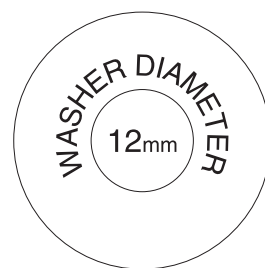
1/4"
3/8"
1/2"
5/8"

LINES ARE 1/16" INCH APART



5/16"
7/16"
9/16"
3/4"
7/8"
1"
1 1/4"
1 1/2"
1 3/4"
2
2 1/4"
2 1/2"
2 3/4"
3

WASHERS ARE MEASURED BY THE INSIDE DIAMETER



4mm



5mm



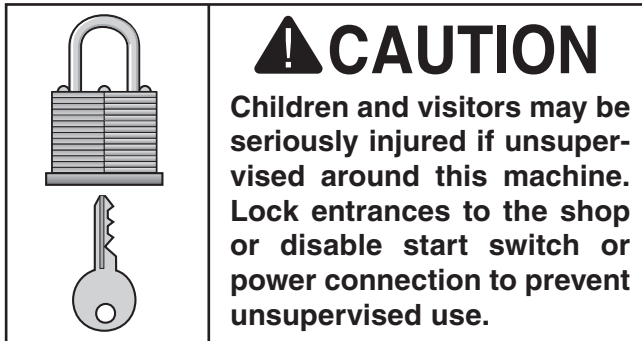
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Site Considerations

Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.



Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

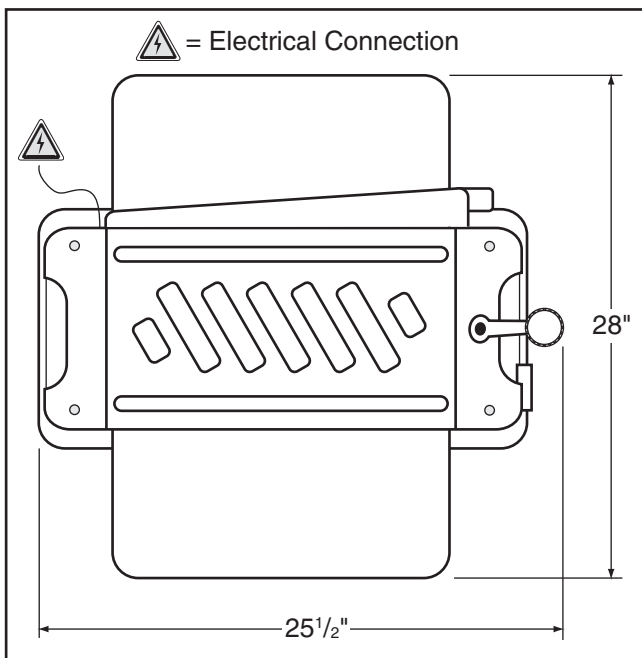


Figure 7. Minimum working clearances.

Bench Mounting

Number of Mounting Holes 4
Dia. of Mounting Hardware Needed 3/8"

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

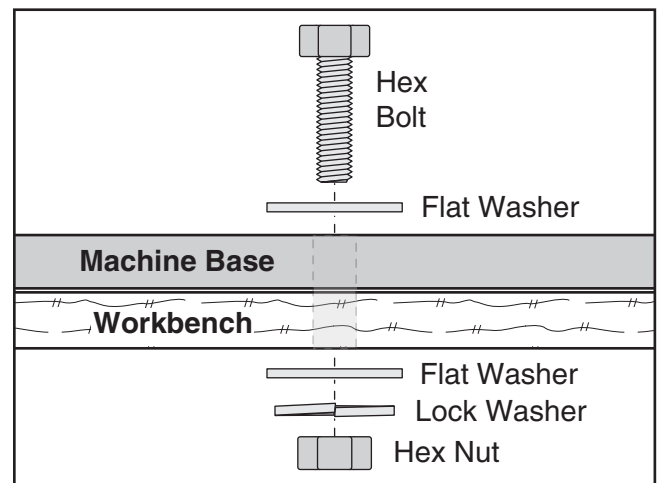


Figure 8. Typical "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

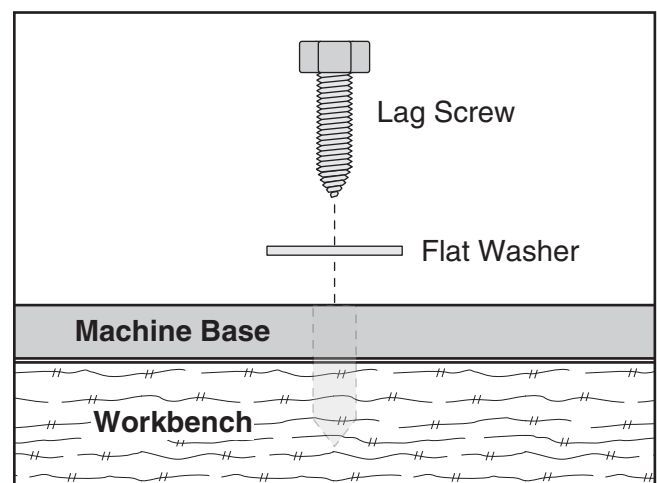


Figure 9. Typical "Direct Mount" setup.



Assembly

The Model G0939/G0940 comes partially assembled. The cutterhead elevation crank and dust chute must be installed before operating the planer.

To assemble planer:

1. Remove plastic cap from cutterhead elevation crank, then place crank on elevation shaft (see **Figure 10**). Secure crank with M5-.8 x 25 cap screw and 5mm flat washer. Do not over-tighten.
2. Press plastic cap onto crank to cover cap screw.

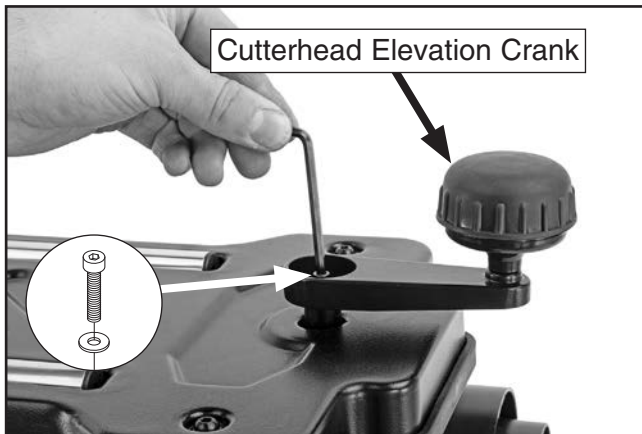


Figure 10. Installing cutterhead elevation crank.

3. Rotate cutterhead elevation crank as needed to remove foam packing from underneath cutterhead assembly.
4. Install dust chute on fan housing, and secure with (2) M6-1 x 14 knob bolts (see **Figure 11**).

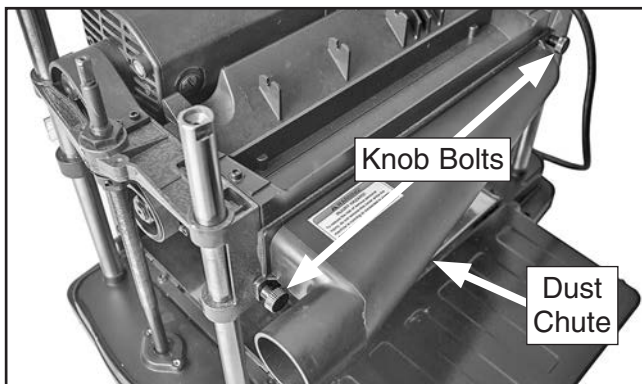


Figure 11. Dust port installed on fan housing.

Dust Collection

⚠ CAUTION

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

Recommended CFM at Dust Port: 150 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit 2" dust hose over dust port and secure with hose clamp (see **Figure 12**).

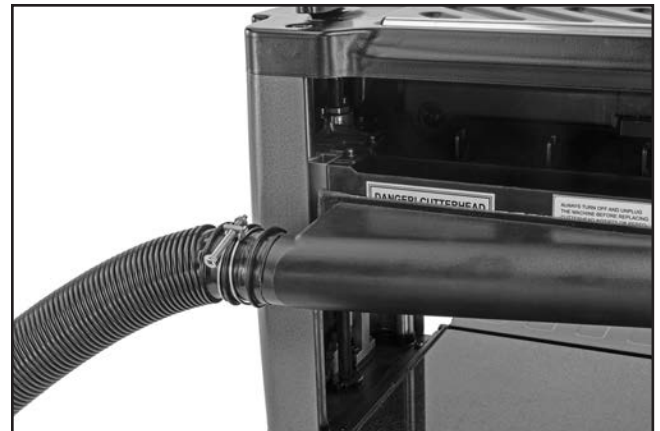


Figure 12. Dust hose installed onto dust port.

2. Tug hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.



Test Run

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

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

The test run consists of verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the safety disabling mechanism on the switch works correctly.

WARNING

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

WARNING

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

To test run machine:

1. Make sure all tools and objects used during setup are cleared away from machine.
2. Connect machine to power source.
3. Turn machine **ON**, verify motor operation, then turn machine **OFF**. Motor should run smoothly and without unusual problems or noises.
4. Remove switch disabling key, as shown in **Figure 13**.

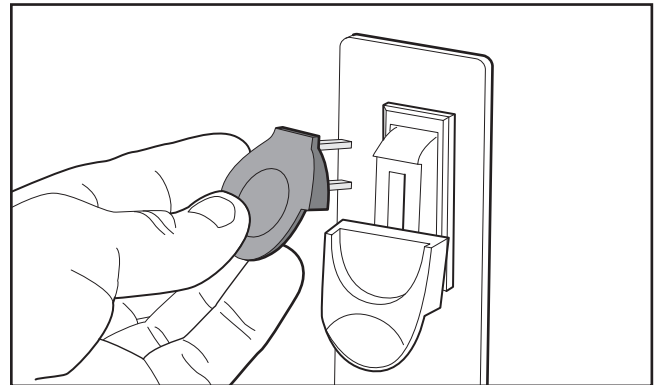


Figure 13. Removing key from paddle switch to disable switch and prevent unauthorized use.

5. Try to start machine with paddle switch.
 - If machine does *not* start, switch disabling feature is working as designed. Congratulations, test run is now complete!
 - If machine starts, immediately turn machine **OFF** and disconnect from power. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

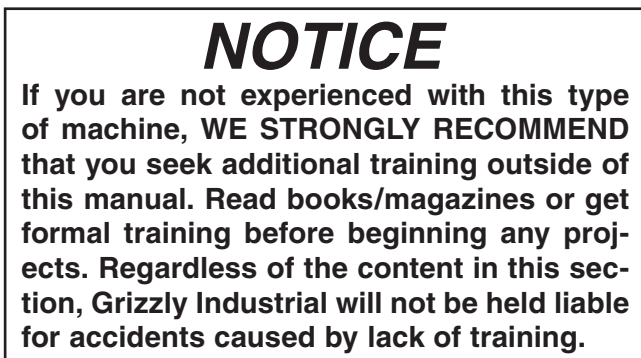
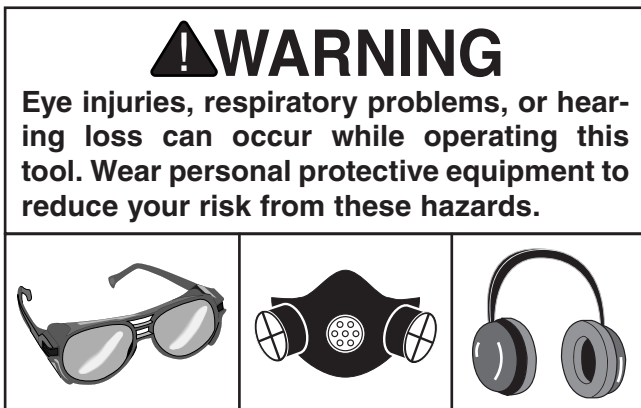


SECTION 4: OPERATIONS

Operation Overview

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

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



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

1. Examines workpiece to make sure it is suitable for planing.
2. Puts on safety glasses or face shield, a respirator, and ear protection.
3. Places workpiece on table with flat side down and correctly adjusts cutterhead height for workpiece thickness and depth of cut.
 - If workpiece is bowed, operator surface planes workpiece on a jointer until one side is flat. Doing so ensures that it will sit solidly on planer table during operation.
4. When all safety precautions have been taken, turns planer **ON**.
5. Stands to one side of planer path to reduce risk of kickback injuries, then feeds workpiece into planer until infeed roller grabs it.

Note: *Infeed and outfeed rollers control feed rate of workpiece as it passes through planer. Operator does not push or pull on workpiece.*

 - If cut is too deep and bogs down planer, operator immediately reduces depth of cut.
6. Once workpiece is clear of outfeed roller and stops moving, operator removes workpiece from outfeed table and measures workpiece thickness. If further planing is required, operator typically lowers cutterhead approximately $\frac{1}{4}$ to $\frac{1}{2}$ turn of the elevation crank, then feeds workpiece into front of planer again.
7. Operator continues process until desired thickness is achieved, then turns machine **OFF**.



Workpiece Inspection

Some workpieces are not safe to use or may require modification before they are. **Before cutting, inspect all workpieces for the following:**

- **Material Type:** This machine is only intended for workpieces of natural wood fiber. Attempting to use workpieces of any other material that may break apart during operation could lead to serious personal injury and property damage.
- **Foreign Objects:** Inspect lumber for defects and foreign objects (nails, staples, embedded gravel, etc.). If you have any questions about the quality of your lumber, DO NOT use it. Remember, wood stacked on a concrete floor can have small pieces of stone or concrete pressed into the surface.
- **Large/Loose Knots:** Loose knots can become dislodged during operation. Large knots can cause kickback and machine damage. Always use workpieces that do not have large/loose knots.
- **Wet or "Green" Stock:** Avoid using wood with a high water content. Wood with more than 20% moisture content or wood exposed to excessive moisture (such as rain or snow), will plane poorly and cause excessive wear to the machine. Excess moisture can also hasten rust and corrosion of the machine and/or individual components.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to plane because they are unstable and often unpredictable when being planed. DO NOT use workpieces with these characteristics!
- **Minor Cupping:** Always true a cupped workpiece with a jointer prior to planing. Workpieces with slight cupping can be safely supported if the cupped side is facing the table. Avoid planing a workpiece bowed side-down, which can cause rocking during planing and potential kickback.

Wood Types

The species of wood, as well as its condition, greatly affects the depth of cut the planer can effectively take with each pass.

The chart in the figure below shows the Janka Hardness Rating for a number of commonly used species. The higher the number, the harder the workpiece, and the less material should be removed in any one pass for good results.

Note: *The Janka Hardness Rating is expressed in pounds of force required to embed a 0.444" steel ball into the surface of the wood to a depth equal to half the ball's diameter.*

Species	Janka Hardness
Ebony	3220
Red Mahogany	2697
Rosewood	1780
Red Pine	1630
Sugar Maple	1450
White Oak	1360
White Ash	1320
American Beech	1300
Red Oak	1290
Black Walnut	1010
Teak	1000
Black Cherry	950
Cedar	900
Sycamore	770
Douglas Fir	660
Chestnut	540
Hemlock	500
White Pine	420
Basswood	410
Eastern White Pine	380
Balsa	100

Figure 14. Janka Hardness Rating for some common wood species.



Planing Tips

- Inspect your lumber for twisting or cupping, and surface one face on a jointer if necessary before planing workpiece.
- Scrape off all glue when planing glued-up panels. Dried glue can quickly dull knives.
- DO NOT plane more than one piece at a time.
- Never remove more than the recommended amount of material on each pass. Only remove a small amount of material on each pass when planing wide or dense stock.
- Support the workpiece on both ends. Get assistance from another person if you are planing long lumber, or use roller stands to support the workpiece.
- Measure the workpiece thickness with calipers to get exact results.
- Carefully inspect all stock to make sure it is free of large knots or foreign objects that may damage your knives, cause kickback, or be ejected from the planer.
- When possible, plane equal amounts on each side of the board to reduce the chance of twisting or cupping.
- Use the entire width of the planer to wear knives evenly. With narrow workpieces, alternate between far left, far right, and the middle of the table. Your knives will remain sharp much longer.
- To avoid "chip marks," always plane WITH the grain direction of the wood. Never plane cross-grain or end-grain.
- Plane ONLY natural wood fiber. Do not plane wood composites or other materials that could break up in the planer and cause operator injury or damage to planer.
- Always true cupped or warped stock on a jointer before planing.

Cutting Problems

Below is 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

Problem: Usually a result of cutting against the grain, planing lumber with knots or excessive amount of cross grain, or using dull knives/inserts.

Solution: Decrease the depth of cut. Inspect your lumber and determine if its grain pattern is causing the problem. If the lumber does not show substantial cross grain, inspect your knives/inserts.

Fuzzy Grain

Problem: Usually caused by planing lumber containing too much moisture. Sometimes fuzzy grain is an unavoidable characteristic of some woods, such as basswood. Fuzzy grain can also be caused by dull knives/inserts.

Solution: Check the lumber with a moisture meter. If moisture is greater than 20%, sticker the lumber and allow it to dry. Otherwise, inspect the knife condition.

Snipe

Problem: Occurs when board ends have more material removed than the rest of the board. Usually caused when the workpiece is not properly supported as it goes through the machine. In many cases, however, a small amount of snipe is inevitable.

Solution: The best way to deal with snipe is by planing lumber longer than your intended work length and then cutting off the excess after planing is completed.



Pitch & Glue Build-up

Problem: Glue and resin buildup 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, uneven knife/insert marks, and chatter.

Solution: Clean the rollers and cutterhead.

Chip Marks or Indentations

Problem: Chip indentation or chip bruising is the result of wood chips not being thrown away from the cutterhead and out of the machine. Instead they are carried around the cutterhead, deposited on the planed surface and crushed by the outfeed roller. Some of the causes of chip indentation are:

- Wood chips/sawdust not being properly expelled from the cutterhead.
- The type of lumber being planed. Certain species have a tendency to chip bruise.
- A high moisture content (over 20%) or surface moisture (refer to **Page 21**).
- Dull knives/inserts.
- Excessive depth of cut.

Solution:

- Use a proper dust collection system; adjust chip deflector in or out as necessary.
- Lumber must be completely dry, preferably kiln-dried (KD). Air-dried (AD) lumber must be seasoned properly and have no surface moisture. DO NOT surface partially-air-dried (PAD) lumber.
- Make sure planer knives/inserts are sharp.
- Reduce depth of cut.

Rippled Cut

Problem: Regularly spaced indentations across face of workpiece are caused by excessive outfeed roller pressure or excessive feed rate.

Solution: Reduce outfeed roller pressure; reduce feed rate.

Setting Depth of Cut

Table Movement per Handwheel Revolution

One Full Revolution $\frac{1}{16}"$

The depth of cut on a planer means the amount of material that is removed from the top of the workpiece as it passes underneath the cutterhead.

The depth of cut is set by adjusting the distance of the cutterhead above the table. This distance is the thickness of the workpiece minus the depth of cut. The planing depth of cut is controlled by using the cutterhead elevation crank on the right side of the machine. Rotating the crank clockwise raises the headstock.

Although the correct depth of cut varies according to wood hardness and workpiece width, we recommend the maximum depth of cut (per pass) be no more than $\frac{1}{16}"$. A series of light cuts will give better end results and put less stress on the planer than trying to take off too much material in a single pass.

The depth-of-cut scale functions as a general guide only, and is not intended for low-tolerance, precision results. A small amount of backlash may be present with the cutterhead elevation crank after switching height directions. Switching height direction may cause slightly less than $\frac{1}{16}"$ backlash during the first crank turn. As the crank is turned more rotations in the same direction, backlash will not be a factor.

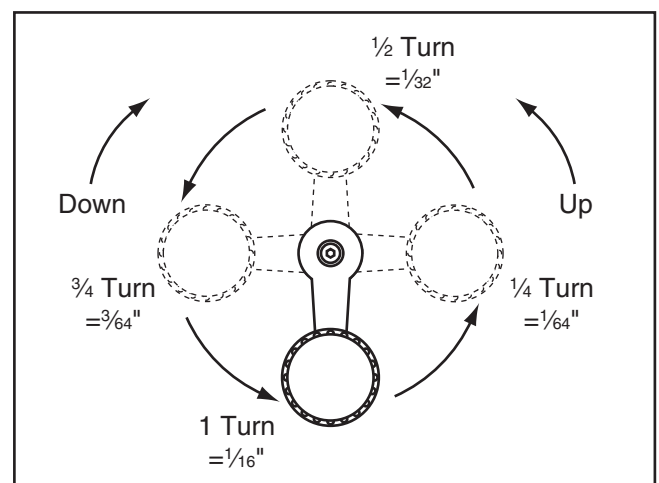


Figure 15. Crank elevation increments.



Elevation Scale

The elevation scale (see **Figure 16**) on the right-hand side cover at the front of the machine shows workpiece thickness after it leaves the planer. The thickness measurement is indicated by the top edge of the red Line.

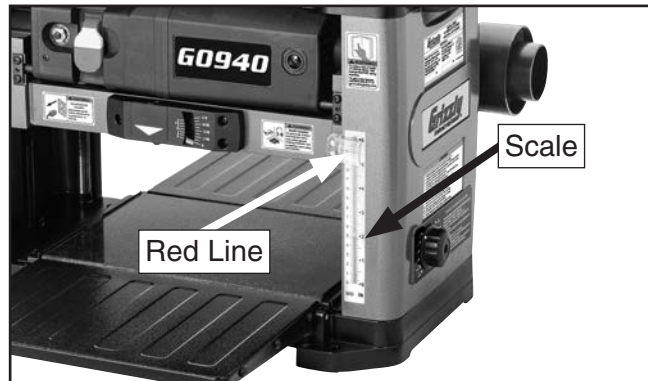


Figure 16. Positioning elevation scale.

Note: The cutterhead elevation scale does not provide a precise measurement and should only be used for approximate measurements. If precise workpiece thicknesses are needed, use calipers to ensure your workpieces meet your standards.

Depth Stop Dial (G0940)

The depth stop dial (see **Figure 17**) on the right-hand side of the machine allows the operator to pre-set workpiece thickness. The workpiece thickness is indicated by the white dot on the depth stop dial pointing to the thickness scale.

To adjust the dial, rotate the cutterhead elevation crank to raise the cutterhead assembly, rotate the dial to the preferred thickness, then lower the cutterhead assembly until it gently rests on the depth stop.

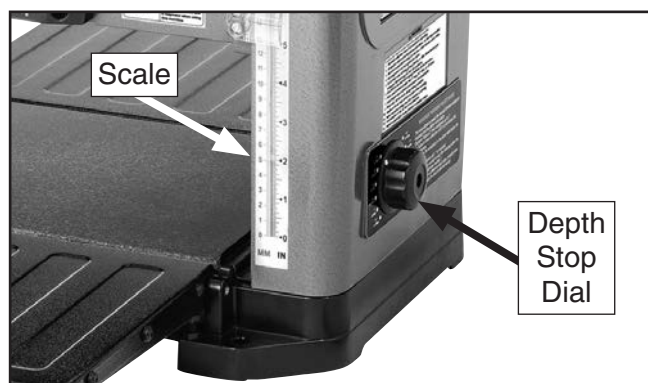


Figure 17. Depth stop dial and scale.

Feeding Workpiece

The feed rate on this planer is automatically set at 25 FPM. Infeed and outfeed rollers move the workpiece through the planer while keeping it firmly against the table and providing a consistent rate of movement.

To feed workpiece into planer:

1. Place workpiece on table with side to be planed facing *up* toward cutterhead.

Note: Boards more than 24" long should be supported on both sides of planer.

2. Lower cutterhead until depth bar (see **Figure 18**) just touches workpiece.

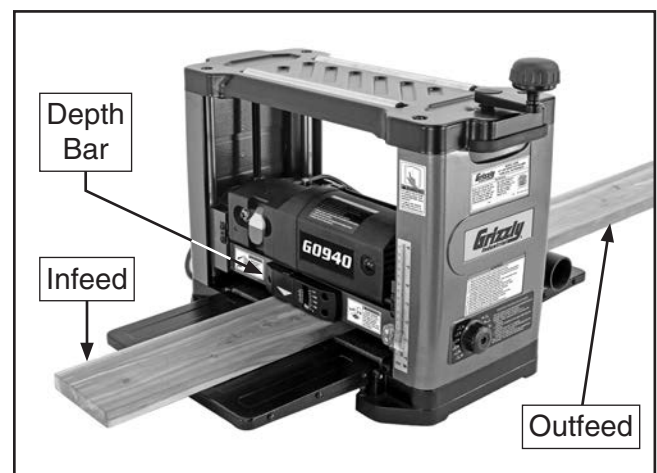


Figure 18. Basic planing operation setup.

Note: Any time you switch directions with cutterhead elevation handle, there will be a small amount of backlash—so the first full crank of the handle after switching directions will be slightly less than $\frac{1}{16}$ ". However, as long as you move the handle in the same direction during operation, backlash will not be a factor.



3. Rotate cutterhead elevation crank $\frac{1}{4}$ turn clockwise to raise cutterhead approximately $\frac{1}{64}$ ". This will set depth of cut to $\frac{1}{32}$ ". Remove workpiece from planer.
4. Turn planer **ON**.
5. Feed workpiece into front of planer, making sure not to stand directly in front of or behind workpiece to reduce the risk of a kickback injury.
 - If cut is too deep and bogs down planer, turn planer **OFF** immediately and allow it to stop. Raise cutterhead, remove workpiece, reduce depth of cut, then repeat **Step 5**.

Note: *Infeed and outfeed rollers will automatically pull workpiece through planer during operation. Do not push or pull on workpiece once feed rollers have engaged it.*

6. Once workpiece is clear of outfeed roller, measure workpiece thickness. If further planing is needed, lower cutterhead another $\frac{1}{2}$ turn ($\frac{1}{32}$ ") of the elevation crank handle, and repeat cutting operation.
7. Continue the process described above until desired workpiece thickness is reached. Elevation scale shows approximate thickness of workpiece after it has been cut. Use this indicator to judge when thickness is approximately correct. For more precise applications, measure workpiece thickness with calipers during cutting operation.

Adjusting Table Alignment

The front and rear table heights are adjustable for proper workpiece contact throughout the cut.

Tools Needed	Qty
Open-End Wrench 10mm.....	2
Precision Straightedge 24".....	1
Phillips Head Screwdriver #2	1

To adjust extension table height:

1. To check alignment, lay a straightedge across bed and both wings (see **Figure 19**).



Figure 19. Aligning extension wings.

2. Loosen stop nut and adjustment bolt underneath each extension wing (see **Figure 20**).

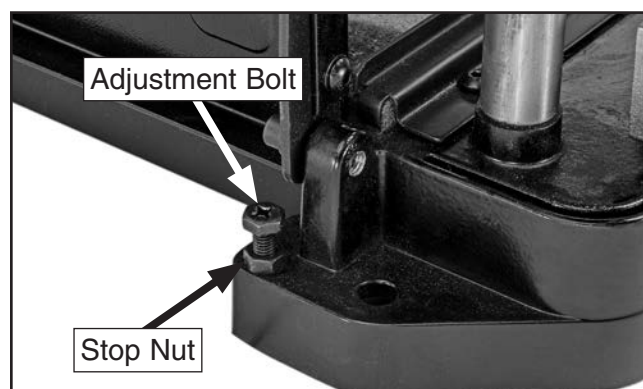


Figure 20. Location of components for adjusting table.

3. Rotate adjustment bolts so wings and table are on the same plane.

Note: *No gap should be visible beneath straightedge when tables are properly aligned.*

4. Use one wrench to prevent adjustment bolt from rotating while using other wrench to tighten. Recheck table height from side to side, then tighten stop nut to secure the setting.



Adjusting/Replacing Knives (G0939)

⚠ CAUTION

The knives on this planer are extremely sharp and can quickly cause serious injury to your hands or fingers. Always wear heavy leather gloves when handling these knives to reduce the risk of cutting injuries.

NOTICE

To maintain accurate and consistent planing results, we do not recommend sharpening knives yourself. Instead, just replace dull knives or have them professionally sharpened.

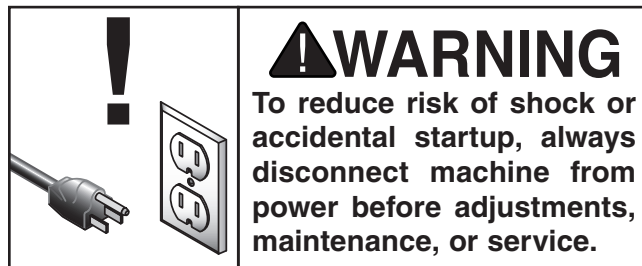
The knives on the Model G0939 Planer are reversible and should always be reversed or replaced as a matched set. To avoid downtime, we recommend having an extra set of knives for your planer.

Before re-installing the knives, the cutterhead, gib, and knives must be inspected. Neglecting to inspect these components may result in damage to the planer.

The condition of the knives on the Model G0939 will affect the precision of the cut. During operation, watch for the following signs of dulled knives:

- Raised grain occurs as a result of dull knives hammering at the surface of the wood.
- A "fuzzy" appearance on the surface of the wood occurs as a result of dull knives tearing, rather than cutting the wood fibers.
- Ridges occur as a result of nicks along the knife edge.
- Difficulty feeding the workpiece into the planer.

If any of these signs become apparent during use, the knives should be reversed or replaced.



Tools Needed

	Qty
Hex Wrench 4mm.....	1
Leather Gloves	1 Pair
Phillips Head Screwdriver #2	1
Magnet (for knife removal/installation).....	1

Removing Knives

1. DISCONNECT MACHINE FROM POWER!
2. Lower cutterhead as far as it will go, then remove dust chute and dust shroud from headstock (see **Figure 21**).

Note: Rotate cutterhead to orient knife pointing upward. Cutterhead should lock in place once dust shroud is removed.

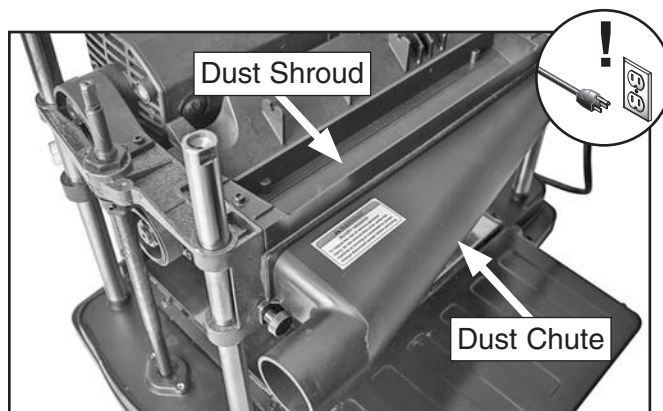


Figure 21. Components to be removed to access cutterhead.



3. Loosen six gib screws securing first knife (see **Figure 22**).

Tip: When loosening gib screws, insert hex wrench firmly into screw head, then twist wrench with a powerful turn. This method will break the screw free and help prevent stripping the head.



Figure 22. Example of removing screws securing knife to cutterhead.

4. Use magnets to carefully slide knife out of cutterhead.
5. Press safety latch to disengage cutterhead lock (see **Figure 23**), then carefully rotate cutterhead approximately ¼-turn. Release safety latch and continue rotating cutterhead until next knife slot is exposed and safety latch again engages.



Figure 23. Disengaging cutterhead lock.

6. Repeat **Steps 3–4** to remove remaining knives.

Inspecting Cutterhead, Gib, and Knives

1. DISCONNECT MACHINE FROM POWER!
2. Carefully clean the cutterhead with a rag, and with a flashlight inspect the following:
 - Make sure the threaded screw holes do not contain wood material or sawdust.
 - Make sure that the hex socket and the threads of all cap screws are in good condition. Replace if questionable.
 - Make sure any resin or glue buildup on the cutterhead, gib, and knives is removed so the knife and gib will sit flat on the cutterhead.
 - Make sure the knives are free of cracks. If any cracks exist, replace both knives.

Installing Knives

1. DISCONNECT MACHINE FROM POWER!
2. Using included magnets, align knife with two pins on cutterhead. Be sure knife is oriented with beveled edge up, as shown in **Figure 24**.

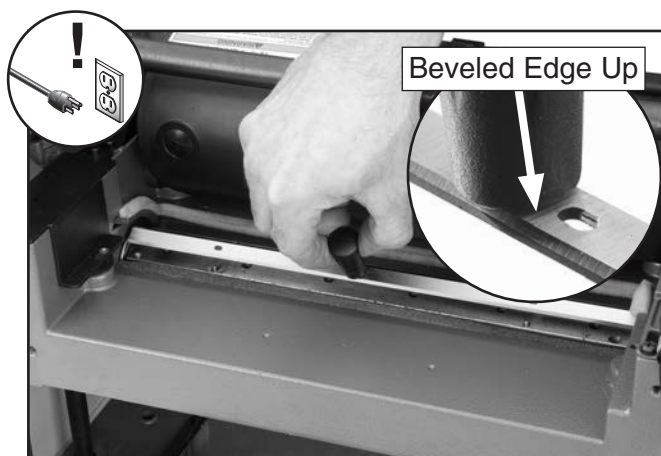


Figure 24. Example of installing knife with magnet.



3. Install gib over knife, and slightly tighten gib screws, starting at middle and working your way to ends by alternating left and right, as shown in **Figure 25**.

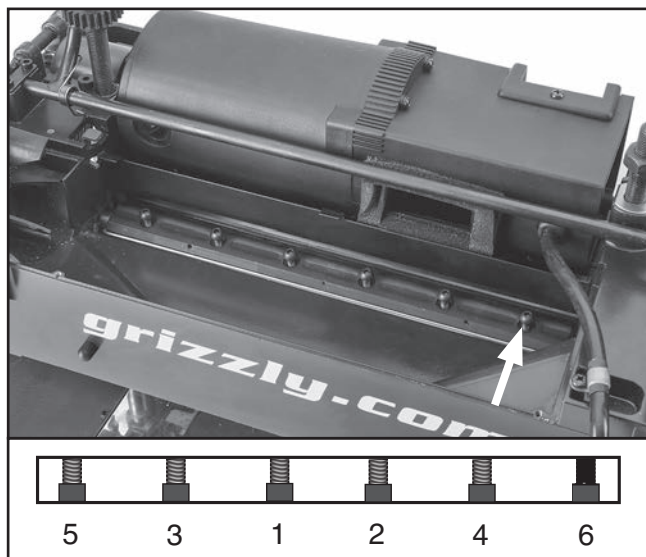


Figure 25. Gib screw tightening sequence.

4. Press safety latch to disengage cutterhead lock (see **Figure 23**), then carefully rotate cutterhead approximately ¼-turn. Release safety latch and continue rotating cutterhead until next knife slot is exposed and safety latch again engages.
5. Repeat **Steps 2–3** for remaining knives, then replace dust shroud and dust chute.

Rotating/Replacing Cutterhead Inserts (G0940)

The helical cutterhead is equipped with indexable carbide inserts that can be rotated to reveal any one of their four cutting edges. If one edge of the insert becomes dull or damaged, simply rotate it 90° to reveal a fresh cutting edge, as shown in **Figure 26**.

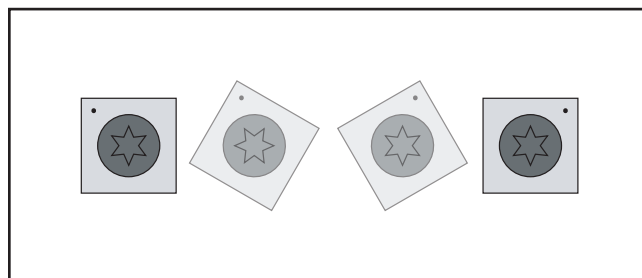


Figure 26. Insert rotating sequence.

Items Needed	Qty
Torque Wrench	1
T-Handle Torx Wrench T-20	1
Heavy Leather Gloves	1 Pair
Light Machine Oil	As Needed

To rotate or replace a helical cutterhead insert:

1. DISCONNECT MACHINE FROM POWER!
2. Remove dust chute and dust shroud (see **Figure 27**).

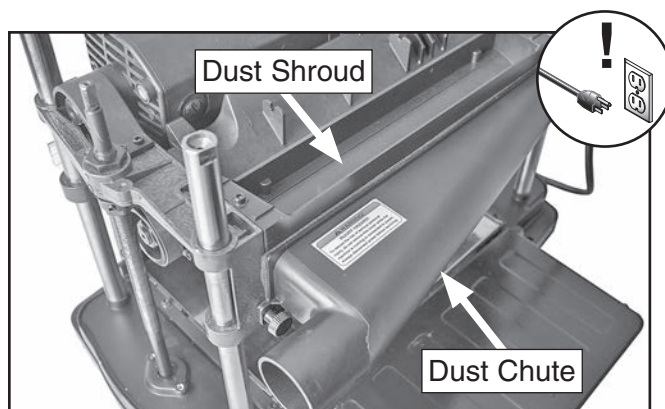


Figure 27. Components to be removed to access helical cutterhead.

3. Put on heavy leather gloves to protect your fingers and hands.

CAUTION

The carbide inserts are very sharp and can quickly cut your hands. **ALWAYS** use caution and heavy leather gloves when handling these parts to reduce the risk of personal injury.

4. Remove any sawdust or debris from head of insert, Torx screw, and surrounding area.
5. Remove Torx screw and insert, then clean all dust and debris from both parts and pocket they were removed from.

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

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

6. Rotate insert 90° and install so that a fresh cutting edge faces outward (see **Figure 26**).

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

7. Lubricate Torx screw threads with a very small amount of light machine oil, wipe excess off, and torque screw to 50–55 inch/pounds.

Note: *If too much oil is applied to the threads, excess oil will attempt to squeeze out of the threaded hole and raise insert during installation, bringing it out of height alignment.*

8. When finished, re-install dust shroud and dust hood.



SECTION 5: ACCESSORIES

! WARNING

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

NOTICE

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

T24736—Carbide Replacement Inserts

Solid carbide indexable inserts for G0940.
Size: 15 x 15 x 2.5mm (10 pack).

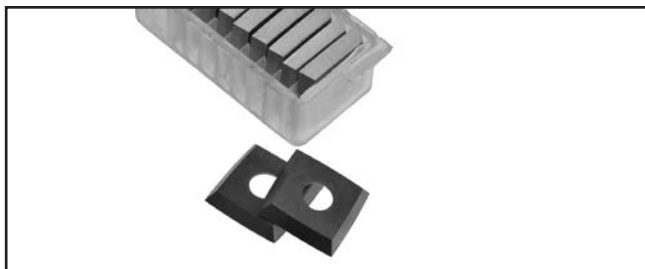


Figure 28. Replacement inserts for Model G0940.

T32549—Set of 3 Planer Knives

These steel knives measure 13" x 1/2" x 1/16" and are designed to fit the G0939.

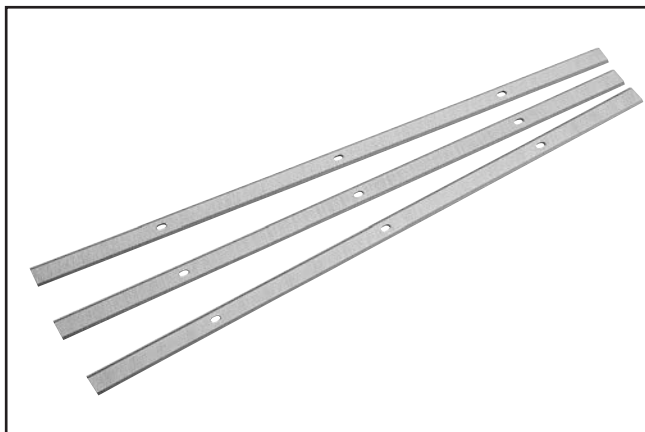


Figure 29. HSS Planer Knives for Model G0939.

Basic Eye Protection

T32323—Woodturners Face Shield

T32401—EDGE Brazeau Safety Glasses, Clear

T32402—EDGE Khor G2 Safety Glasses, Tint

T32404—EDGE Mazeno Safety Glasses, Clear



Figure 30. Assortment of basic eye protection.

G4682—Dry Coating Lube

Spray on saw blades, router bits, shaper cutters — even table tops — to form a low-friction coating that works great, even under high temperature and pressure. Contains no silicone or oil, so it won't stain or damage paint or wood finishes. 9.5 oz.



Figure 31. G4682 Dry Coating Lube.

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



D3640—Shop Fox Tool Table Plus

This tool table was designed to answer customer requests for a slightly wider and taller table to accommodate a variety of benchtop machines. The table top is 1¼" thick and measures 14" x 40". The table stands 33" tall and has a maximum capacity of 700 lbs.



Figure 32. D3640 Shop Fox Tool Table Plus.

T30673—Heavy-Duty Roller Stand

This stand comes with 2" steel ball bearing rollers that assist with infeed and outfeed support. With the heavy-duty cast-iron base, this stout roller stand helps support lumber, piping, and more up to 2000 pounds! With three holes on the base, it can even be bolted to the floor for increased stability. Height can be easily adjusted from 24" to 38", and the stand measures 14" wide.



Figure 33. T30673 Heavy-Duty Roller Stand.

T10456—Heavy-Duty Anti-Fatigue Mat 3' x 5'

This Heavy-Duty Anti-Fatigue Mat features beveled edges and no-slip tread for safety and comfort. Open-hole design allows liquid to drain through, so it's perfect for wet or oily conditions. Measures 3' wide x 5' long x ¾" thick.

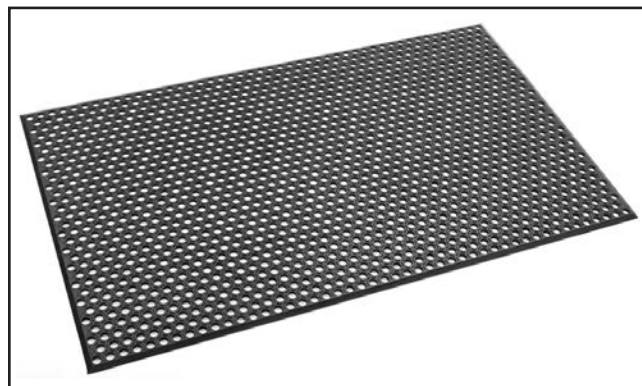


Figure 34. T10456 Anti-Fatigue Mat.

G0944—1½ HP Wall-Mount Dust Collector

With an airflow capacity of 1250 CFM and a canister filter with a 1-micron filtration rating, this is the beast you need for all your small shop dust-capturing needs. The easy-to-hang French cleat-style mount makes hanging this unit quick, and clears up floor space in a small shop.

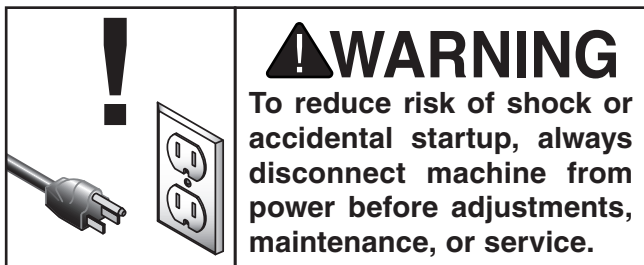


Figure 35. G0944 1½ HP Wall-Mount Dust Collector with Canister Filter.

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



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations

- Loose mounting bolts.
- Damaged knives/inserts.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check

- Clean chains and sprockets of dust, wood chips, and old grease.
- Lightly coat chains and sprockets with NLGI#2 grease (see **Page 33**).
- Lubricate elevation leadscrews with spray lubricant.
- Check belt for tension, damage, or wear (see **Page 36**). Also, ensure belt is clean and free of oil or grease that could cause it to slip.
- Remove dust hood, and thoroughly clean built-up sawdust and chips.

Cleaning & Protecting

Cleaning the Model G0939/G0940 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it.

Lubrication

There are four primary systems that require periodic lubrication: the cutterhead elevation leadscrews, the feed roller chain drive, the table height chain, and columns. Clean the components in this section with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

Items Needed	Qty
Stiff Brush.....	1
Shop Rags.....	As Needed
Mineral Spirits.....	As Needed
Grease T26419 or NLGI#2 or Equiv. .	As Needed
Hex Wrench 4mm.....	1

Elevation Leadscrews & Columns

Grease Type..... G4682 Dry Coating Lube
Frequency..... Monthly

To lubricate elevation leadscrews & columns:

1. DISCONNECT MACHINE FROM POWER!
2. Lower headstock fully and remove top and side covers to expose (2) leadscrews.



3. Vacuum chips and dust off leadscrews (see **Figure 36**).

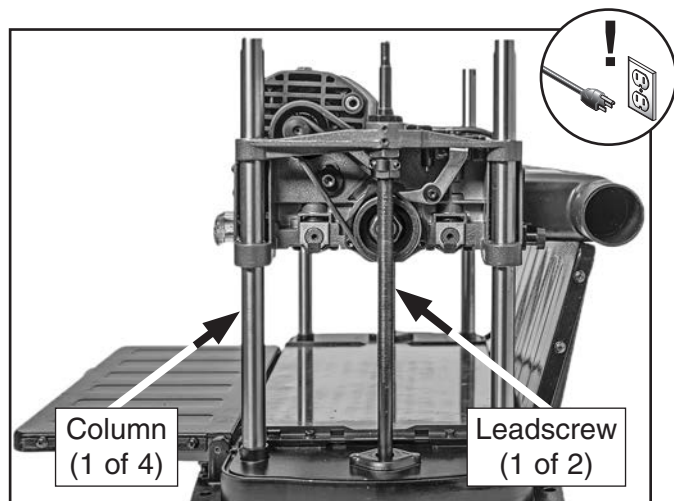


Figure 36. Location of cutterhead elevation leadscrews (G0939 shown).

4. Use mineral spirits, stiff brush, and shop rags to remove old lubricant.
5. Spray lubricant onto each leadscrew and column (see **Figure 36**), taking care to keep it off the belt. Move cutterhead up and down to evenly distribute.

Feed Roller Chain Drive

Grease Type T26419 or NLGI#2 Equivalent
Frequency.....Monthly

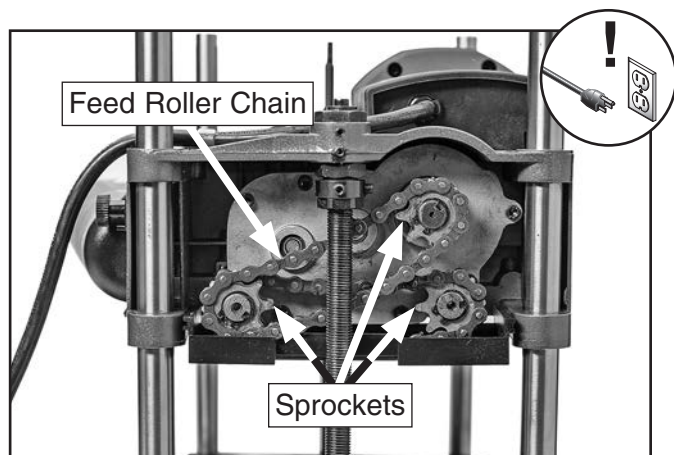


Figure 37. Cutterhead elevation leadscrews and feed roller drive chain exposed for lubricating.

To lubricate feed roller chain drive:

1. DISCONNECT MACHINE FROM POWER!
2. Remove top and side covers to expose sprockets and chains (see **Figure 37**).
3. Use mineral spirits, stiff brush, and shop rags to clean old grease from chains.
4. Apply light coating of grease to chain linkage and sprockets.
5. Re-install covers.

Headstock Height Pinion Gears

Oil Type T27914 or ISO 68 Equivalent
Frequency.....Monthly

To lubricate table height gears:

1. DISCONNECT MACHINE FROM POWER!
2. Gently tilt machine onto its back (see **Figure 38**) to expose gears.

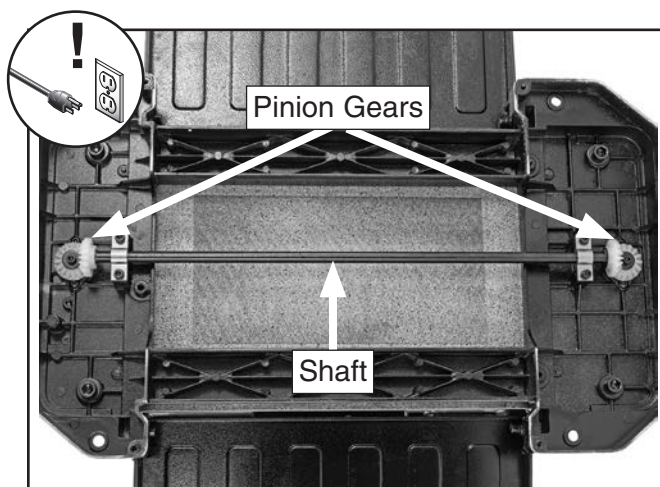


Figure 38. Headstock height pinion gears exposed for lubricating.

3. Use mineral spirits and shop rags to clean pinion gears and shaft.
4. Allow mineral spirits to dry, then apply light coat of oil to surfaces.
5. Tilt machine back onto base.
6. Move cutterhead up and down to evenly distribute oil.



Replacing Motor Brushes

The motor on the G0939/G0940 is equipped with two long-life carbon brushes—one on the front and one on the back of the motor. The brush life is affected by motor loads and usage. Worn brushes will result in intermittent operation and difficulty starting the motor. If either brush is worn down to 1/4" (6mm) or less, replace both brushes as a set.

Tools Needed	Qty
Flat Head Screwdriver	1
Motor Brushes (PN P0939077)	2

To check/replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Unscrew plastic brush covers, and remove motor brush assemblies (see **Figure 39**).

Note: As you remove brush assembly, make note of carbon tip orientation. If found acceptable, re-install in same way.

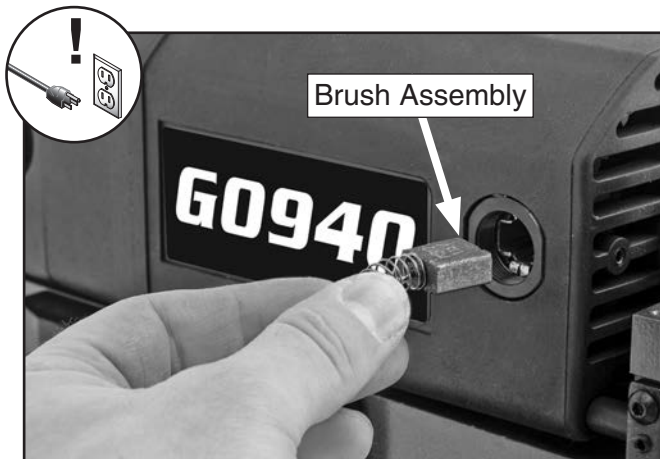


Figure 39. Removing front motor brush.

3. Measure length of carbon tip. If carbon tip is worn down to 1/4" (6mm) or less, replace both brush assemblies with new ones.
4. Insert brush assemblies back into motor, and re-install plastic caps.

Cleaning Infeed & Outfeed Rollers

Saw dust and workpiece grime can accumulate on the infeed and outfeed rollers, creating inconsistent pressure on the workpiece as it is fed through the cutterhead.

To clean infeed & outfeed rollers:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock completely to expose infeed and outfeed rollers (see **Figure 40**).
3. Clean rubber infeed and outfeed rollers with solvent to remove any pitch or stuck-on chips.



Figure 40. Cleaning infeed roller.

4. Use a vacuum and clean brush to remove any trapped material from between roller and headstock.



Cleaning Feed Rollers

The feed rollers rotate in bushing blocks that are spring loaded. The feed rollers ride up on the board so that the roller pressure is maintained. If chips or sawdust build up between the bracket and bushing block (see **Figure 41**), the amount of roller vertical travel will be reduced, potentially causing improper feeding of workpiece through the machine.

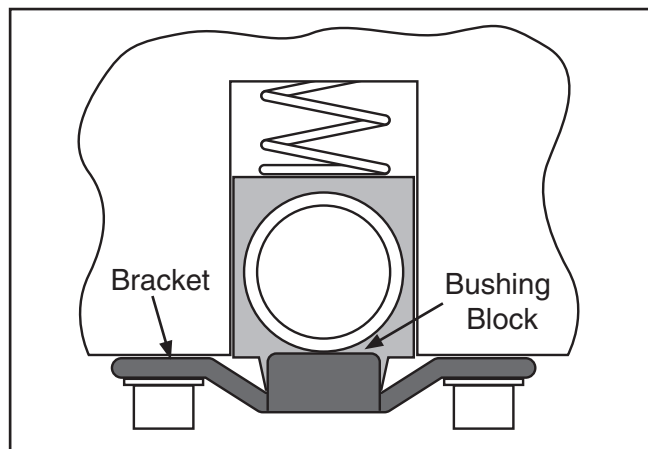


Figure 41. Sawdust can get trapped between the bushing block and the bracket.

Periodically check and clean chips and sawdust from between the bushing blocks and brackets.

Items Needed

Qty

4" Tall Block of Wood..... 1

To clean feed rollers:

1. DISCONNECT MACHINE FROM POWER!
2. Place a 4" tall block of wood between one feed roller and planer table. Ensure block of wood is not under cutterhead.
3. Lower cutterhead assembly just enough so roller is pushed up against spring and pressure is off of two brackets.
4. Remove any trapped material from between roller assembly and bracket.



Tensioning/ Replacing Drive Belt

The drive belt transfers power from the motor to the cutterhead, and to the infeed and outfeed rollers. To ensure efficient transfer of power to these systems, make sure the belt is always properly tensioned and in good condition.

If the belt is worn, cracked, or damaged, replace it immediately.

Tools Needed	Qty
Hex Wrenches 4, 6mm.....	1

To tension/replace drive belt:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock completely.
3. Remove top and right-hand covers.
4. Remove cutterhead depth stop dial (see **Figure 17** on **Page 24**).
5. Lift side cover up and away from machine to expose drive belt and pulleys, as shown in **Figure 42**.

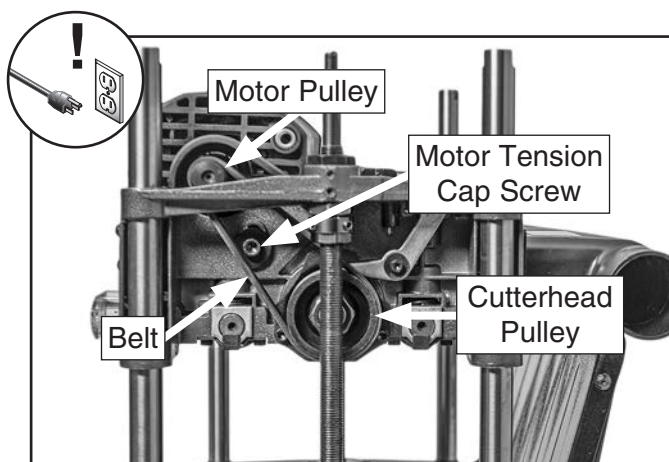


Figure 42. Drive belt and pulleys (G0939 shown).

6. Loosen motor tension cap screw (see **Figure 42**) to reduce belt tension, and roll old belt off pulleys.
7. Loop new belt completely around motor pulley but only halfway on cutterhead pulley.
8. While applying pressure to belt with one hand, slowly rotate motor pulley to fully seat belt in grooves.

Note: Belt is correctly tensioned when there is approximately $\frac{3}{8}$ " deflection when moderate pressure is applied midway between pulleys, as illustrated in **Figure 43**. Lift motor to adjust deflections, then tighten motor tension cap screw.

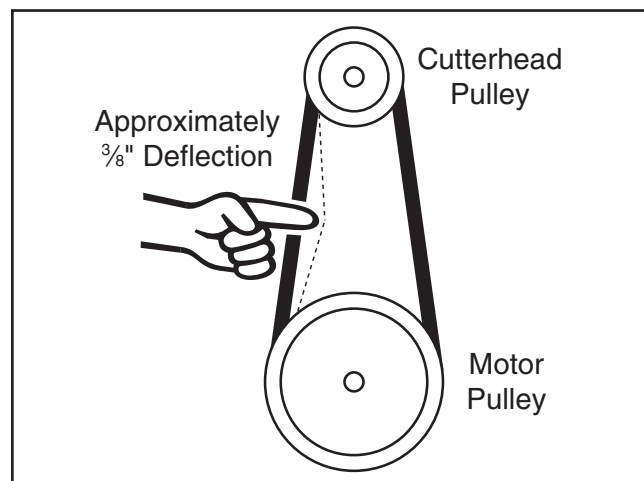


Figure 43. Correct amount of belt deflection.

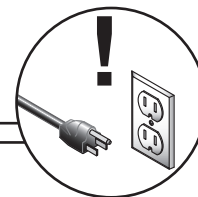
9. When belt is fully on both pulleys, rotate it several times to make sure belt ribs are properly seated in pulley grooves.
 - If belt ribs are not properly seated, roll belt off pulleys and repeat **Steps 6–8** until they are.
10. Replace side cover, secure top cover, and re-install cutterhead depth stop dial.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Switch disabling key removed. 2. Machine circuit breaker tripped or at fault. 3. Incorrect power supply voltage or circuit size. 4. Power supply circuit breaker tripped or fuse blown. 5. Wiring broken, disconnected, or corroded. 6. Motor brushes worn out. 7. ON/OFF or circuit breaker switch at fault. 8. Motor or motor bearings at fault.	1. Install switch disabling key. 2. Reset circuit breaker on switch (Page 4). 3. Ensure correct power supply voltage and circuit size (Page 13). 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Fix broken wires or disconnected/corroded connections. 6. Remove/replace brushes (Page 34). 7. Replace switch/circuit breaker. 8. Replace motor.
Machine stalls or is underpowered.	1. Workpiece material not suitable for machine. 2. Machine undersized for task. 3. Dull knives/inserts. 4. Belt slipping; improper belt tension or oil/grease on belts. 5. Motor brushes worn out. 6. Dust collection problem causing internal components to clog up with shavings. 7. Pulley/sprocket slipping on shaft. 8. Motor overheated, tripping machine circuit breaker. 9. Motor or motor bearings at fault.	1. Only cut wood/ensure moisture is below 20% (Page 21). 2. Use correct blades/inserts or reduce depth of cut (Page 23). 3. Use sharp knives/inserts. 4. Clean/tension/replace belt (Page 36). 5. Replace motor brushes (Page 34). 6. Clear blockages in dust chute/ducting. Ensure dust collector is operating efficiently. 7. Tighten/replace loose pulley/shaft. 8. Clean motor/let cool, and reduce workload. Reset breaker. 9. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Planer not resting evenly on stand/workbench. 3. V-belt worn/loose, pulleys misaligned, or belt slapping cover. 4. Knives/gibs at fault. 5. Pulley loose. 6. Cutterhead bearings at fault. 7. Motor bearings at fault.	1. Inspect/tighten loose bolts/nuts; replace damaged components. 2. Shim under planer. 3. Tension/replace belt (Page 36). Re-align pulleys if necessary. 4. Resharpen/replace knives; set knife alignment correctly (Page 26). 5. Secure pulley on shaft. 6. Replace bearing(s). 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Operation

Symptom	Possible Cause	Possible Solution
Excessive snipe (gouge at the end of the workpiece that is uneven with the rest of the cut). Note: A small amount of snipe is inevitable with all types of planers—the key is to minimize it.	1. Table extension wings (or aftermarket support table) not aligned with main table. 2. Workpiece not properly supported as it leaves planer. 3. Some snipe is inevitable.	1. Adjust rear extension wing hex bolts to align extension wing with main table (Page 25). 2. Hold workpiece up slightly as it leaves outfeed end of planer. 3. Plane lumber longer than your intended workpiece length, then cut off excess after planing complete.
Workpiece stops/slow in middle of cut.	1. Excessive depth of cut. 2. Feed rollers too low or too high. 3. Pitch and glue build up on planer components.	1. Reduce depth of cut (Page 23). (Reduce cutting depth when planing hard woods.) 2. Raise/lower feed rollers (Page 35). 3. Clean internal planer components with a pitch/resin dissolving solvent.
Chipping (consistent pattern).	1. Knots or conflicting grain direction in wood. 2. Taking too deep of a cut. 3. Nicked or chipped knife/insert.	1. Inspect workpiece for knots and grain direction; only use clean stock, and cut WITH the grain. 2. Reduce depth of cut (Page 23). (Reduce cutting depth when planing hard woods.) 3. Replace affected knife (Page 26) or have it sharpened; rotate/replace inserts (Page 28).
Fuzzy grain.	1. Wood may have high moisture content or surface wetness. 2. Dull knives/inserts.	1. Check moisture content is below 20% and allow to dry if moisture is too high (Page 21). 2. Replace knives (Page 26) or have them professionally sharpened; rotate/replace inserts (Page 28).
Long lines or ridges that run along length of board.	1. Nicked or chipped knife/inserts.	1. Replace knives (Page 26) or have them professionally sharpened; rotate/replace inserts (Page 28).
Glossy surface.	1. Dull knives/inserts. 2. Cutting depth too shallow.	1. Replace knives (Page 26) or have them professionally sharpened; rotate/replace inserts (Page 28). 2. Increase depth of cut (Page 23).
Infeed/outfeed rollers not rotating.	1. Chain and sprockets are worn, misadjusted, disconnected, or broken.	1. Adjust chain and sprockets; replace if necessary.



Calibrating Headstock Elevation Scale

Although correctly set at the factory, the scale can be adjusted for accuracy if it becomes necessary.

Tools Needed	Qty
Phillips Screwdriver #2	1
Scrap Piece of Stock.....	1
Calipers	1

To calibrate scale:

1. Plane scrap piece of stock until it is flat on both sides and has even thickness along its length.

Note: Turn scrap board over between each pass to make surfaces parallel.

2. Use calipers to measure board thickness.
3. If there is a discrepancy between board thickness and reading on elevation scale, loosen Phillips head screws shown in **Figure 44**, adjust position of red line to indicate correct thickness, then tighten screws.

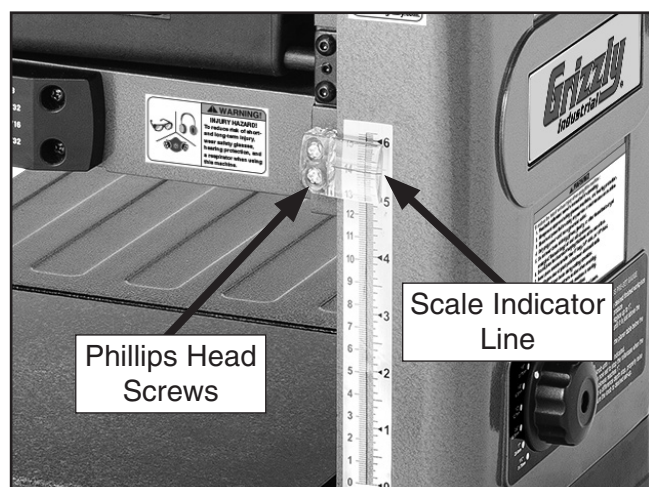


Figure 44. Elevation scale components used to calibrate thickness reading.

Adjusting Cutterhead/ Table Parallelism

The cutterhead/table parallelism has been correctly set at the factory. However, it can be re-adjusted for accuracy if the cutterhead assembly shifts over time.

Tools Needed	Qty
Hex Wrenches 2.5, 3, 4mm.....	1 Ea.
Open-End Wrenches 22, 24mm.....	1 Ea.
1½" x 12" Piece of Stock.....	2

To adjust cutterhead/table parallelism:

1. DISCONNECT MACHINE FROM POWER!
2. Ensure knives (G0939) are adjusted properly. (Refer to **Adjusting/Replacing Knives** on **Page 26** for detailed instructions.)
3. Place both pieces of stock on either side of table, and lower headstock until cutterhead just touches (see **Figure 45**).

Note: Having wood blocks at an even height is critical to the accuracy of your overall adjustments. For best results, square stock with a jointer and table saw before using as a gauge.

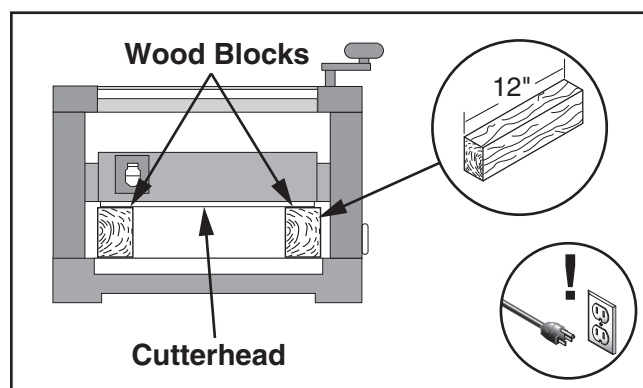


Figure 45. Checking cutterhead parallelism.



4. Check cutterhead contact with wood blocks.
 - If cutterhead makes even contact between wood blocks, no adjustment is needed.
 - If cutterhead only touches one wood block, continue to **Step 5**.
5. Remove top assembly and side covers.
6. On side of headstock to be adjusted, loosen (2) set screws (see **Figure 46**).
7. Loosen (3) set screws in collar nut (see **Figure 46**), then thread collar nut down leadscrew approximately $\frac{1}{8}$ ".
8. Rotate elevation adjustment nut (see **Figure 46**) to raise or lower headstock until cutterhead evenly touches wood blocks.
9. Thread collar nut tightly against bottom of hex nut (see **Figure 46**). *Do not overtighten.*
10. Tighten (3) set screws in collar nut (see **Figure 46**).
11. Tighten (2) set screws in side of headstock (see **Figure 46**).

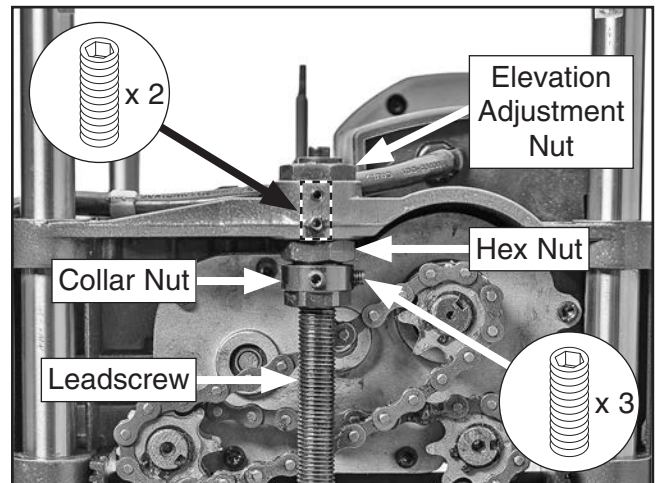


Figure 46. Location of headstock adjustment components. (Top assembly and side covers removed for clarity.)

12. Install side covers and top assembly.
13. Raise headstock slightly, then lower until it just contacts wood blocks. Contact should be even across blocks. If contact is not even, repeat **Steps 5–11** until cutterhead is parallel.
14. Plane a test piece to confirm even cut depth across width of workpiece.

Calibrating Depth Stop Dial (G0940)

The settings on the depth stop dial indicator are pre-set by the factory to match the corresponding measurements on the elevation scale. Over time, the dial may need to be adjusted to maintain accuracy. To ensure accurate depth of cut, always follow the directions in **Calibrating Headstock Elevation Scale** before performing the steps outlined below.

Tools Needed	Qty
Open-Ended Wrench 14mm.....	1
Hex Wrench 4mm.....	1

To calibrate depth stop dial:

1. DISCONNECT MACHINE FROM POWER!
2. Remove depth stop dial from machine (see **Figure 47**).

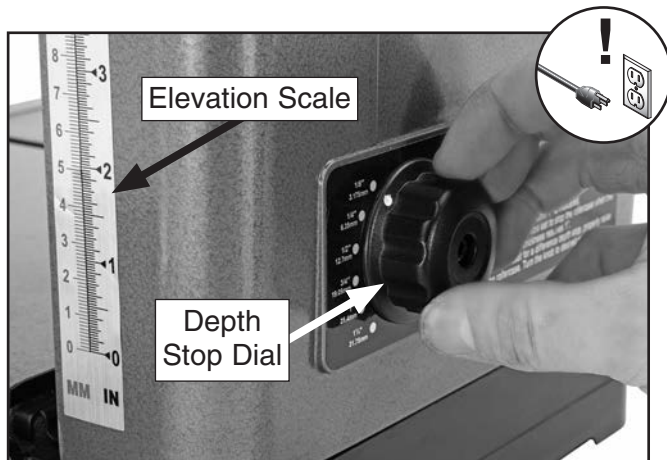


Figure 47. Removing dial from machine body.

3. Remove top assembly and side covers.

4. Loosen hex nut (see **Figure 48**) and adjust height stop bolt up or down to increase or decrease depth of cut.

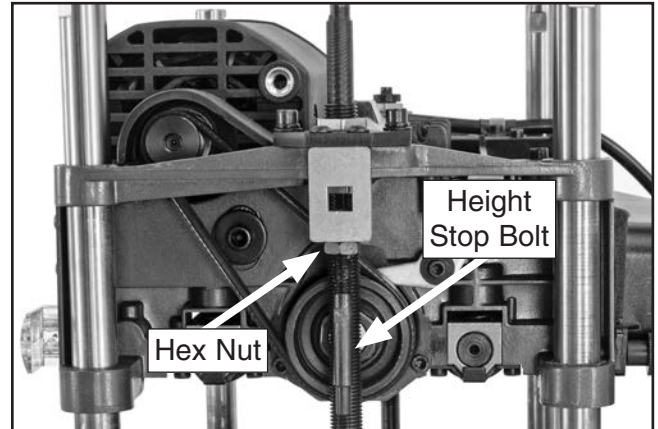


Figure 48. Components to adjust depth stop height.

5. Tighten hex nut to secure setting.
6. Install side cover, top assembly, and dial, and turn cutterhead elevation crank until cutter assembly rests gently on depth stop. Compare depth stop dial scale to cutterhead elevation scale.
7. Repeat **Steps 2–6** as needed until both scales match.



Replacing Table Height Pinion Gears

The table height pinion gears transfer movement from the cutterhead elevation crank to the lead-screws that control cutterhead height. Replace the gears if they wear down or break.

Tools Needed

Hex Wrench 4mm..... 1

Qty

To replace table height pinion gears:

1. DISCONNECT MACHINE FROM POWER!
2. Gently tilt machine onto its back to expose table height gears and shaft (see **Figure 49**).

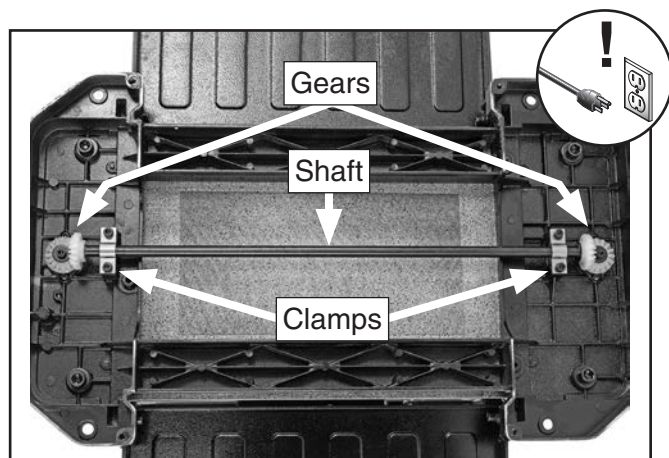


Figure 49. Table height pinion gears.

3. Remove clamps securing shaft to base.
4. Remove cap screw and flat washer securing gear to shaft or leadscrew (see **Figure 49**).
5. Install new gear with fasteners removed in **Step 4**, ensure gear teeth mesh correctly, and re-install shaft clamps.
6. Gently roll machine back onto its base, and turn elevation crank to ensure gears turn smoothly.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

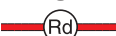
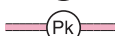
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

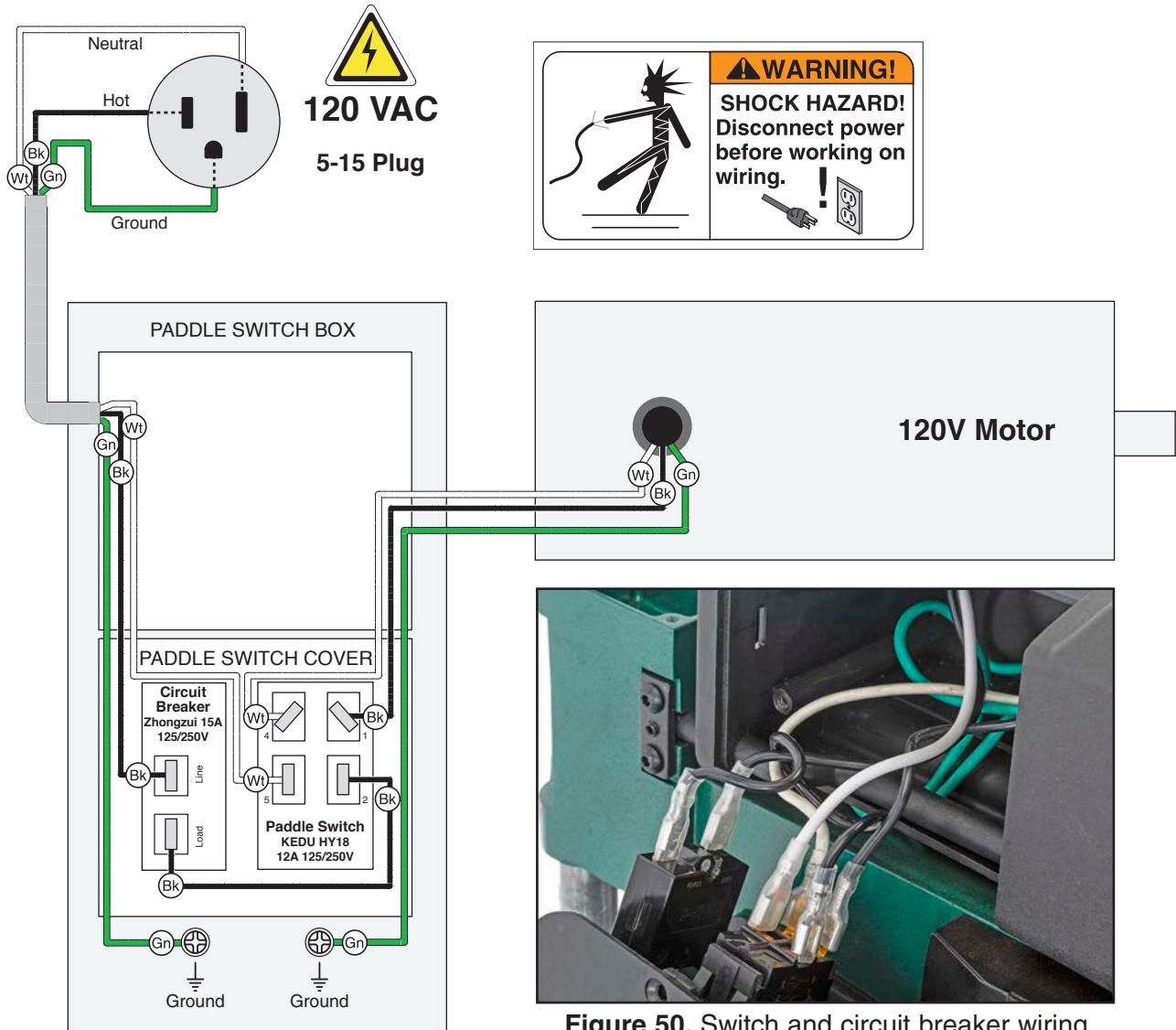
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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

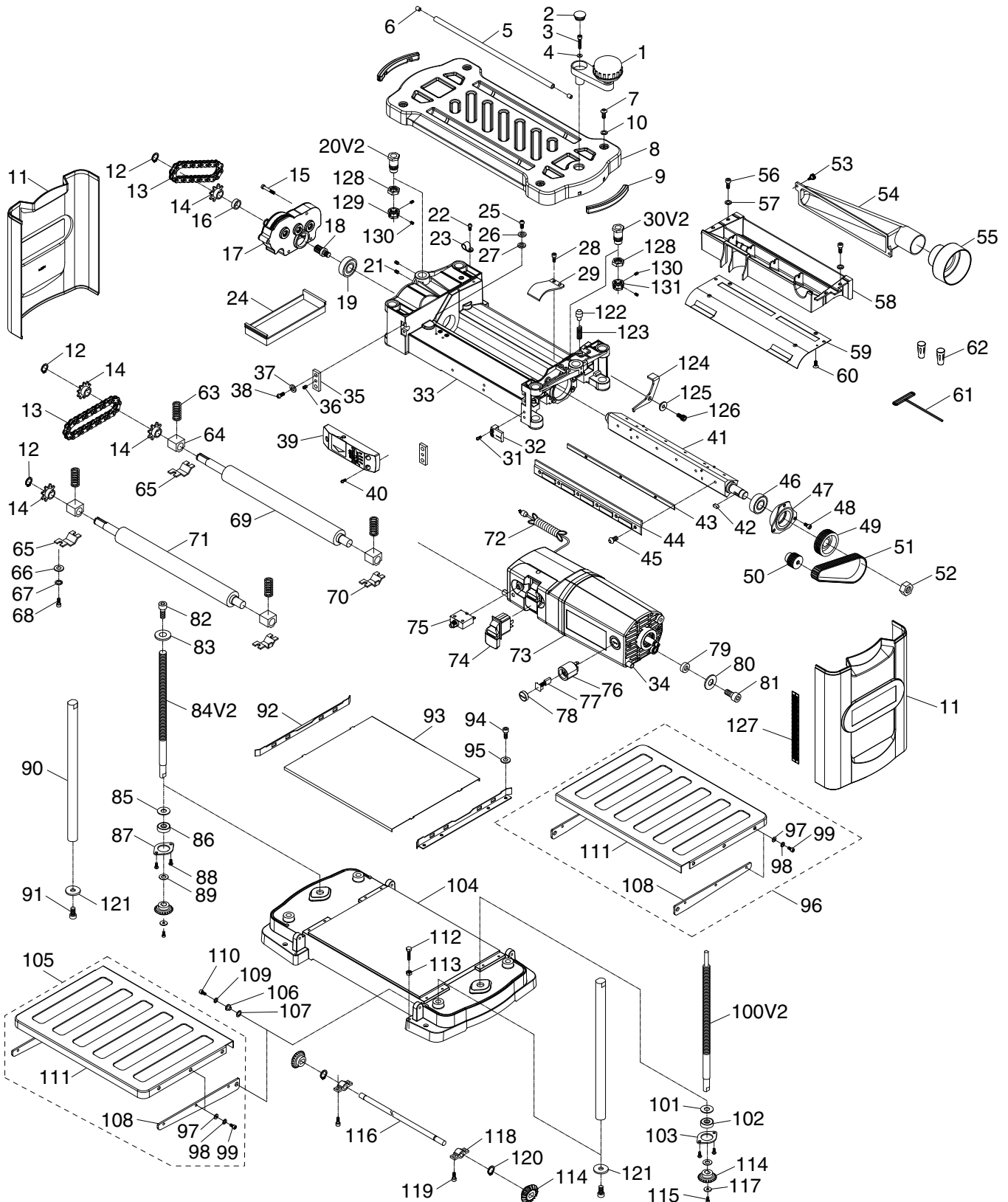


Wiring Diagram



SECTION 9: PARTS

G0939 Main



G0939 Main Parts List

REF	PART #	DESCRIPTION
1	P0939001	CUTTERHEAD ELEVATION CRANK
2	P0939002	CAP
3	P0939003	CAP SCREW M5-.8 X 25
4	P0939004	FLAT WASHER 5MM
5	P0939005	RETURN ROLLER
6	P0939006	ROLLER END CAP
7	P0939007	BUTTON HD CAP SCR M6-1 X 12
8	P0939008	TOP COVER
9	P0939009	HANDLE GRIP
10	P0939010	FLAT WASHER 6MM
11	P0939011	SIDE COVER
12	P0939012	EXT RETAINING RING 15MM
13	P0939013	CHAIN
14	P0939014	SPROCKET 8T
15	P0939015	SHOULDER SCREW M5-.8 X 35, 6 X 25
16	P0939016	BUSHING
17	P0939017	GEARBOX
18	P0939018	PINION
19	P0939019	BALL BEARING 6203ZZ
20V2	P0939020V2	ELEVATION NUT (LEFT) V2.12.22
21	P0939021	SET SCREW M5-.8 X 6
22	P0939022	PHLP HD SCR M5-.8 X 10
23	P0939023	CABLE CLAMP
24	P0939024	CHAIN COVER
25	P0939025	PHLP HD SCR M5-.8 X 8
26	P0939026	LOCK WASHER 5MM
27	P0939027	EXT TOOTH WASHER 5MM
28	P0939028	CAP SCREW M5-.8 X 10
29	P0939029	BELT COVER
30V2	P0939030V2	ELEVATION NUT (RIGHT) V2.12.22
31	P0939031	PHLP HD SCR M4-.7 X 16
32	P0939032	POINTER
33	P0939033	HEADSTOCK
34	P0939034	MOTOR PIVOT ROD
35	P0939035	ROD CLAMP PLATE
36	P0939036	SET SCREW M5-.8 X 6
37	P0939037	LOCK WASHER 5MM
38	P0939038	BUTTON HD CAP SCR M5-.8 X 10
39	P0939039	DEPTH-OF-CUT GAUGE
40	P0939040	PHLP HD SCR M4-.7 X 12
41	P0939041	CUTTERHEAD 13" 3-KNIFE
42	P0939042	KEY 5 X 5 X 12 RE
43	P0939043	KNIVES 13" X 12MM X 1/16" (3-PC)
44	P0939044	KNIFE CLAMP
45	P0939045	BUTTON HD CAP SCR M6-1 X 16
46	P0939046	BALL BEARING 6203ZZ
47	P0939047	BEARING COVER
48	P0939048	CAP SCREW M5-.8 X 12
49	P0939049	CUTTERHEAD PULLEY
50	P0939050	MOTOR PULLEY

REF	PART #	DESCRIPTION
51	P0939051	POLY-V BELT 135J
52	P0939052	HEX NUT M16-1.5 LH
53	P0939053	KNOB BOLT M6-1 X 14, D18 KD
54	P0939054	DUST CHUTE
55	P0939055	DUST PORT ADAPTER 4"
56	P0939056	CAP SCREW M5-.8 X 10
57	P0939057	FLAT WASHER 5MM
58	P0939058	DUST SHROUD
59	P0939059	DUST PLATE
60	P0939060	TAP SCREW M4.2 X 13
61	P0939061	HEX WRENCH 4MM
62	P0939062	MAGNET
63	P0939063	COMPRESSION SPRING
64	P0939064	BEARING BLOCK
65	P0939065	RETAINER (LEFT)
66	P0939066	FLAT WASHER 5MM
67	P0939067	LOCK WASHER 5MM
68	P0939068	CAP SCREW M5-.8 X 12
69	P0939069	OUTFEED ROLLER
70	P0939070	RETAINER (RIGHT)
71	P0939071	INFEED ROLLER
72	P0939072	POWER CORD 14G 3W 72" 5-15P
73	P0939073	MOTOR 2HP 120V 1-PH
74	P0939074	PADDLE SWITCH KEDU HY18 12A 125/250V
75	P0939075	CIRCUIT BREAKER ZHONGZUI 15A 125/250V
76	P0939076	BRUSH HOUSING
77	P0939077	CARBON BRUSH (2-PK)
78	P0939078	BRUSH CAP
79	P0939079	SPACER
80	P0939080	FLAT WASHER 8MM
81	P0939081	CAP SCREW M8-1.25 X 25
82	P0939082	CAP SCREW M5-.8 X 16
83	P0939083	FLAT WASHER 5MM
84V2	P0939084V2	LEADSCREW (LEFT) V2.12.22
85	P0939085	FLAT WASHER 10MM
86	P0939086	BALL BEARING 6000ZZ
87	P0939087	BEARING CLAMP PLATE
88	P0939088	BUTTON HD CAP SCR M5-.8 X 10
89	P0939089	FLAT WASHER 10MM
90	P0939090	COLUMN
91	P0939091	CAP SCREW M10-1.5 X 35
92	P0939092	GUIDE RAIL
93	P0939093	TABLE
94	P0939094	CAP SCREW M5-.8 X 8
95	P0939095	FLAT WASHER 5MM
96	P0939096	OUTFEED EXTENSION TABLE
97	P0939097	FLAT WASHER 5MM
98	P0939098	LOCK WASHER 5MM
99	P0939099	CAP SCREW M5-.8 X 8
100V2	P0939100V2	LEADSCREW (RIGHT) V2.12.22



G0939 Main Parts List (Cont.)

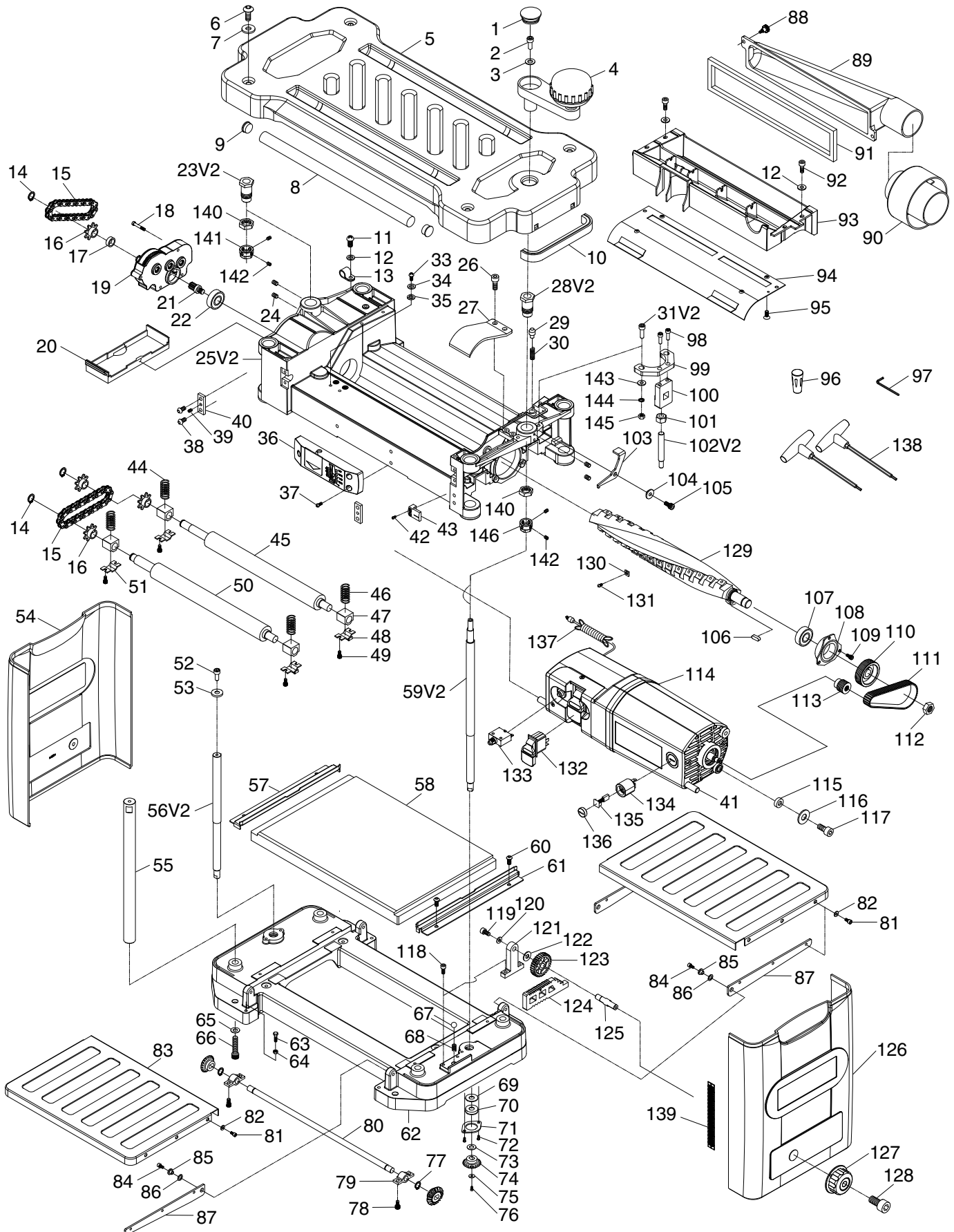
REF	PART #	DESCRIPTION
101	P0939101	FLAT WASHER 10MM
102	P0939102	BALL BEARING 6000ZZ
103	P0939103	BEARING CLAMP PLATE
104	P0939104	BASE
105	P0939105	INFEED EXTENSION TABLE
106	P0939106	BUSHING
107	P0939107	LOCK WASHER 4MM
108	P0939108	TABLE SUPPORT ARM
109	P0939109	LOCK WASHER 6MM
110	P0939110	CAP SCREW M6-1 X 20
111	P0939111	EXTENSION TABLE
112	P0939112	HEX BOLT M6-1 X 20
113	P0939113	HEX NUT M6-1
114	P0939114	PINION GEAR
115	P0939115	CAP SCREW M5-.8 X 12
116	P0939116	SHAFT

REF	PART #	DESCRIPTION
117	P0939117	FLAT WASHER 5MM
118	P0939118	SUPPORT CLAMP
119	P0939119	CAP SCREW M5-.8 X 12
120	P0939120	EXT RETAINING RING 10MM
121	P0939121	FLAT WASHER 10MM
122	P0939122	PUSH ROD
123	P0939123	COMPRESSION SPRING
124	P0939124	CUTTERHEAD LOCK LATCH
125	P0939125	SPACER
126	P0939126	CAP SCREW M5-.8 X 12
127	P0939127	CUTTERHEAD ELEVATION SCALE
128	P0939128	HEX NUT M20-1.5
129	P0939129	COLLAR NUT W/SET SCREWS (LEFT)
130	P0939130	SET SCREW M5-.8 X 6
131	P0939131	COLLAR NUT W/SET SCREWS (RIGHT)

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call **(800) 523-4777** or visit our online parts store at **www.grizzly.com** to check for availability.



G0940 Main



G0940 Main Parts List

REF	PART #	DESCRIPTION
1	P0940001	CAP
2	P0940002	CAP SCREW M5-.8 X 25
3	P0940003	FLAT WASHER 5MM
4	P0940004	CUTTERHEAD ELEVATION CRANK
5	P0940005	TOP COVER
6	P0940006	BUTTON HD CAP SCR M6-1 X 12
7	P0940007	FLAT WASHER 6MM
8	P0940008	RETURN ROLLER
9	P0940009	ROLLER END CAP
10	P0940010	HANDLE GRIP
11	P0940011	PHLP HD SCR M5-.8 X 10
12	P0940012	FLAT WASHER 5MM
13	P0940013	CABLE CLAMP
14	P0940014	EXT RETAINING RING 15MM
15	P0940015	CHAIN
16	P0940016	SPROCKET 8T
17	P0940017	BUSHING
18	P0940018	SHOULDER SCREW M5-.8 X 35, 6 X 25
19	P0940019	GEARBOX
20	P0940020	CHAIN COVER
21	P0940021	PINION
22	P0940022	BALL BEARING 6203ZZ
23V2	P0940023V2	ELEVATION NUT (LEFT) V2.12.22
24	P0940024	SET SCREW M5-.8 X 6
25V2	P0940025V2	HEADSTOCK V2.12.22
26	P0940026	CAP SCREW M5-.8 X 10
27	P0940027	BELT COVER
28V2	P0940028V2	ELEVATION NUT (RIGHT) V2.12.22
29	P0940029	PUSH ROD
30	P0940030	COMPRESSION SPRING
31V2	P0940031V2	CAP SCREW M6-1 X 30 V2.12.22
33	P0940033	PHLP HD SCR M5-.8 X 10
34	P0940034	LOCK WASHER 5MM
35	P0940035	EXT TOOTH WASHER 5MM
36	P0940036	DEPTH-OF-CUT GAUGE
37	P0940037	PHLP HD SCR M4-.7 X 12
38	P0940038	BUTTON HD CAP SCR M5-.8 X 10
39	P0940039	SET SCREW M5-.8 X 6
40	P0940040	ROD CLAMP PLATE
41	P0940041	MOTOR PIVOT ROD
42	P0940042	PHLP HD SCR M4-.7 X 16
43	P0940043	POINTER
44	P0940044	BEARING BLOCK COMPRESSION SPRING (LH)
45	P0940045	OUTFEED ROLLER
46	P0940046	BEARING BLOCK COMPRESSION SPRING (RH)
47	P0940047	BEARING BLOCK
48	P0940048	RETAINER (RIGHT)
49	P0940049	CAP SCREW M5-.8 X 12
50	P0940050	INFEED ROLLER
51	P0940051	RETAINER (LEFT)

REF	PART #	DESCRIPTION
52	P0940052	CAP SCREW M5-.8 X 16
53	P0940053	FLAT WASHER 5MM
54	P0940054	SIDE COVER (LEFT)
55	P0940055	COLUMN
56V2	P0940056V2	LEADSCREW (LEFT) V2.12.22
57	P0940057	TABLE CLAMP PLATE (LEFT)
58	P0940058	GRANITE TABLE
59V2	P0940059V2	LEADSCREW (RIGHT) V2.12.22
60	P0940060	BUTTON HD CAP SCR M5-.8 X 10
61	P0940061	TABLE CLAMP PLATE (RIGHT)
62	P0940062	BASE
63	P0940063	HEX BOLT M6-1 X 20
64	P0940064	HEX NUT M6-1
65	P0940065	FLAT WASHER 10MM
66	P0940066	CAP SCREW M10-1.5 X 40
67	P0940067	STEEL BALL 8MM
68	P0940068	COMPRESSION SPRING
69	P0940069	FLAT WASHER 16MM
70	P0940070	BALL BEARING 6000ZZ
71	P0940071	BEARING CLAMP PLATE
72	P0940072	BUTTON HD CAP SCR M5-.8 X 10
73	P0940073	FLAT WASHER 10MM
74	P0940074	PINION GEAR
75	P0940075	FLAT WASHER 5MM
76	P0940076	CAP SCREW M5-.8 X 12
77	P0940077	EXT RETAINING RING 10MM
78	P0940078	CAP SCREW M5-.8 X 12
79	P0940079	SUPPORT CLAMP
80	P0940080	SHAFT
81	P0940081	CAP SCREW M5-.8 X 8
82	P0940082	FLAT WASHER 5MM
83	P0940083	EXTENSION TABLE
84	P0940084	CAP SCREW M6-1 X 16
85	P0940085	BUSHING
86	P0940086	LOCK WASHER 6MM
87	P0940087	TABLE SUPPORT ARM
88	P0940088	KNOB BOLT M6-1 X 14, D18 KD
89	P0940089	DUST CHUTE
90	P0940090	DUST PORT ADAPTER 4"
91	P0940091	GASKET
92	P0940092	CAP SCREW M5-.8 X 10
93	P0940093	DUST SHROUD
94	P0940094	DUST PLATE
95	P0940095	TAP SCREW M4.2 X 13
96	P0940096	MAGNET
97	P0940097	HEX WRENCH 4MM
98	P0940098	CAP SCREW M5-.8 X 16
99	P0940099	MOUNTING ARM
100	P0940100	SUPPORT BLOCK
101	P0940101	HEX NUT M8-1.25



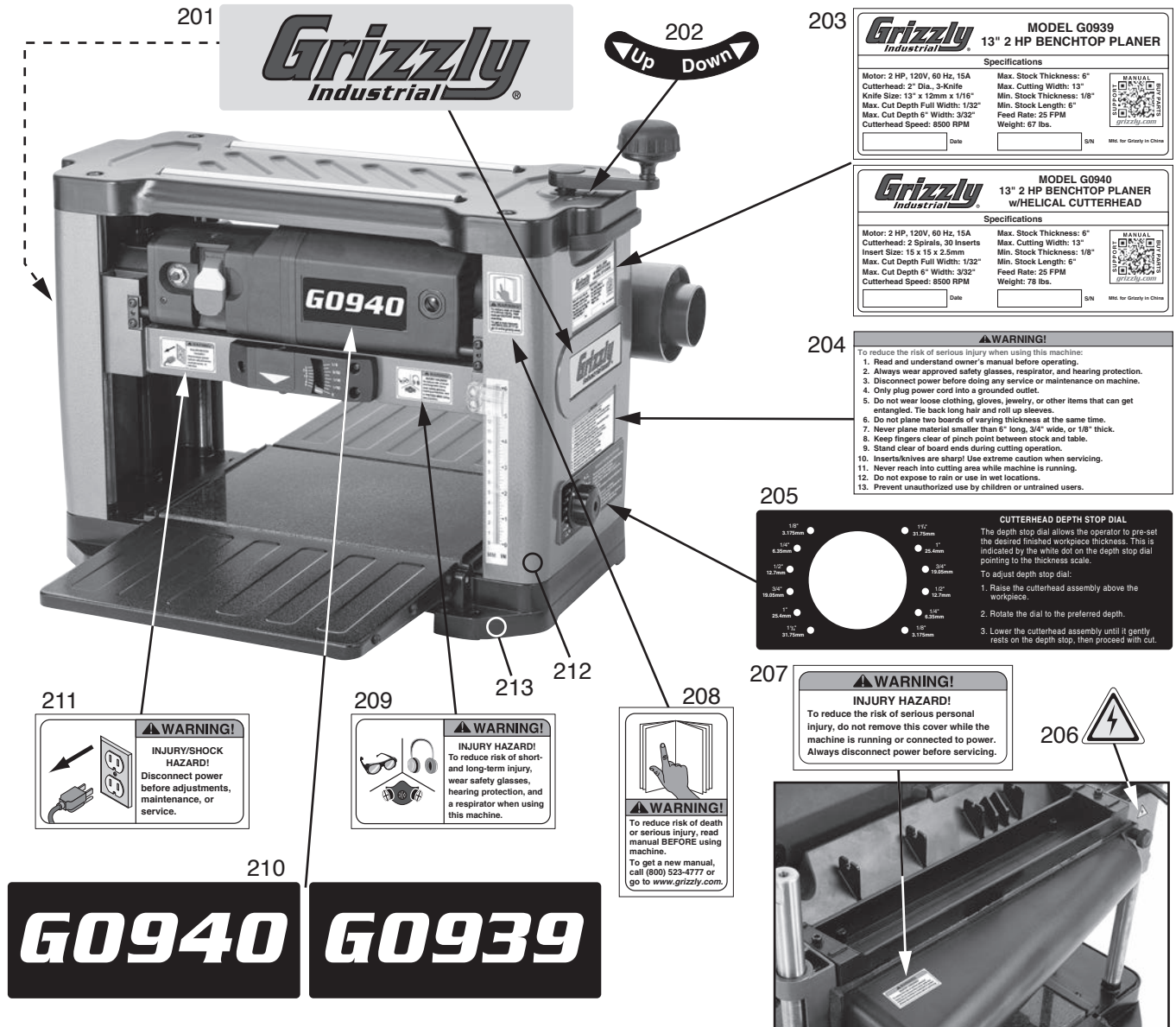
G0940 Parts List (Cont.)

REF	PART #	DESCRIPTION
102V2	P0940102V2	DEPTH STOP ROD 60MM V2.12.22
103	P0940103	CUTTERHEAD LOCK LATCH
104	P0940104	SPACER
105	P0940105	CAP SCREW M5-.8 X 12
106	P0940106	KEY 5 X 5 X 12 RE
107	P0940107	BALL BEARING 6203ZZ
108	P0940108	BEARING COVER
109	P0940109	CAP SCREW M5-.8 X 12
110	P0940110	CUTTERHEAD PULLEY
111	P0940111	POLY-V BELT 135J
112	P0940112	HEX NUT M16-1.5 LH
113	P0940113	MOTOR PULLEY
114	P0940114	MOTOR 2HP 120V 1-PH
115	P0940115	SPACER
116	P0940116	FLAT WASHER 8MM
117	P0940117	CAP SCREW M8-1.25 X 25
118	P0940118	CAP SCREW M5-.8 X 16
119	P0940119	CAP SCREW M5-.8 X 12
120	P0940120	FLAT WASHER 5MM
121	P0940121	GEAR SUPPORT
122	P0940122	FLAT WASHER 8MM
123	P0940123	GEAR
124	P0940124	DEPTH STOP BLOCK

REF	PART #	DESCRIPTION
125	P0940125	GEAR SHAFT
126	P0940126	SIDE COVER (RIGHT)
127	P0940127	DEPTH STOP ADJUSTING KNOB
128	P0940128	CAP SCREW M5-.8 X 12
129	P0940129	CUTTERHEAD 13" HELICAL
130	P0940130	CARBIDE INSERT 15 X 15 X 2.5MM (10-PK)
131	P0940131	FLAT HD TORX T-20 M5-.8 X 12
132	P0940132	PADDLE SWITCH KEDU HY18 12A 125/250V
133	P0940133	CIRCUIT BREAKER ZHONGZUI 15A 125/250V
134	P0940134	BRUSH HOUSING
135	P0940135	CARBON BRUSH (2-PK)
136	P0940136	BRUSH CAP
137	P0940137	POWER CORD 14G 3W 72" 5-15P
138	P0940138	T-HANDLE TORX WRENCH T-20
139	P0940139	CUTTERHEAD ELEVATION SCALE
140	P0940140	HEX NUT M20-1.5
141	P0940141	COLLAR NUT W/SET SCREWS (LEFT)
142	P0940142	SET SCREW M5-.8 X 6
143	P0940143	FLAT WASHER 6MM
144	P0940144	LOCK WASHER 6MM
145	P0940145	HEX NUT M6-1
146	P0940146	COLLAR NUT W/SET SCREWS (RIGHT)



Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P0939201	GRIZZLY LOGO LABEL
202	P0939202	ELEVATION LABEL
203	P0939203	MACHINE ID LABEL (G0939)
203	P0940203	MACHINE ID LABEL (G0940)
204	P0939204	MACHINE WARNINGS LABEL
205	P0940205	DEPTH STOP DIAL LABEL (G0940)
206	P0939206	ELECTRICITY LABEL
207	P0939207	INJURY HAZARD LABEL

REF	PART #	DESCRIPTION
208	P0939208	READ MANUAL LABEL
209	P0939209	EYE, EARS, LUNGS LABEL
210	P0939210	MODEL NUMBER LABEL (G0939)
210	P0940210	MODEL NUMBER LABEL (G0940)
211	P0939211	DISCONNECT POWER LABEL
212	P0939212	TOUCH-UP PAINT, GRIZZLY GREEN
213	P0939213	TOUCH-UP PAINT, GRIZZLY BLACK

⚠ WARNING

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



WARRANTY & 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.

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.

In the event you need to use 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.

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.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/forms/warranty>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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