MODEL T10125
6" SPIRAL CUTTERHEAD
INSTRUCTIONS

The Model T10125 spiral cutterhead is designed to replace the straight knife cutterhead on the Model G0452 6" jointer.

The total procedure of changing the cutterheads and setting up the jointer takes approximately one hour. The job consists of removing the old cutterhead, installing and shimming the new spiral cutterhead, and readjusting the outfeed table even with the carbide inserts at TDC (top dead center). *Call Technical Support at (570) 546-9663 if you need help.*

⚠WARNING

The T10125 spiral cutterhead is only designed to be used with the Grizzly Model G0452 6" Jointer. Do NOT install this cutterhead in any other jointer model or make. Doing so could result in property damage or serious personal injury.

Recommended Tools

Wrench 17mm..... 1
Precision Straightedge (**Figure 1**)..... 1
Feeler Gauge Set..... 1
Pair of Heavy Leather Gloves 1

G9644—12" Precision Straightedge
H2675—16" Precision Straightedge
Is your straightedge really straight? These grade 00 heavy-duty stainless steel straightedges are manufactured to DIN874 standards for professional results in set-up and inspection work.

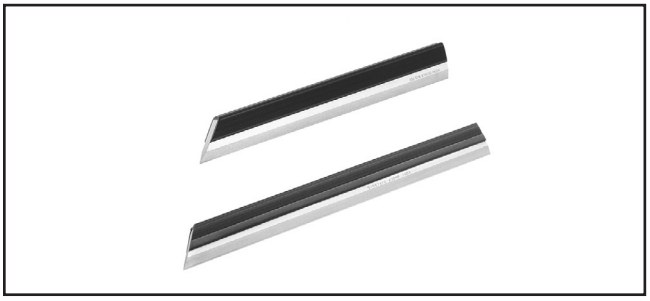

Figure 1. Precision straightedges.

Inventory (**Figure 2**)

A. Spiral Cutterhead 1
B. Torx Drivers T20 2
C. Flat Head Torx Screws T20 M6-1 x 15 3
D. Indexable Carbide Inserts 14 x 14 x 2 5
E. Torx L-Wrenches T20 (not shown) 2

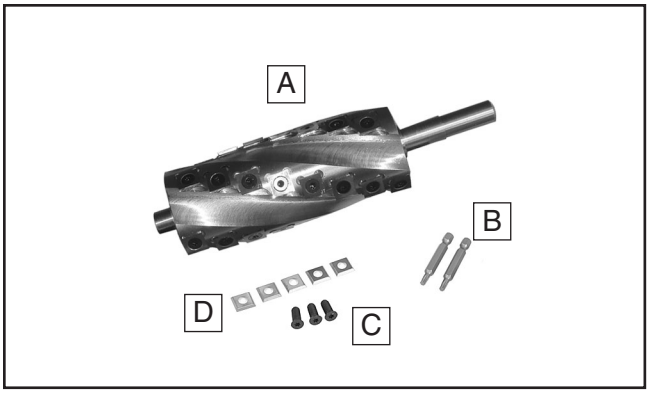

Figure 2. Spiral cutterhead inventory.

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Installation

1. DISCONNECT JOINTER FROM POWER!

2. Remove the jointer fence and cutterhead guard.

3. Remove the V-belt from the pulleys.

4. Lower both beds to make enough room for the cutterhead to come out, as shown in **Figure 3**.

   Note: *When lowering, make sure that the fence support does not come in contact with the cutterhead pulley.*

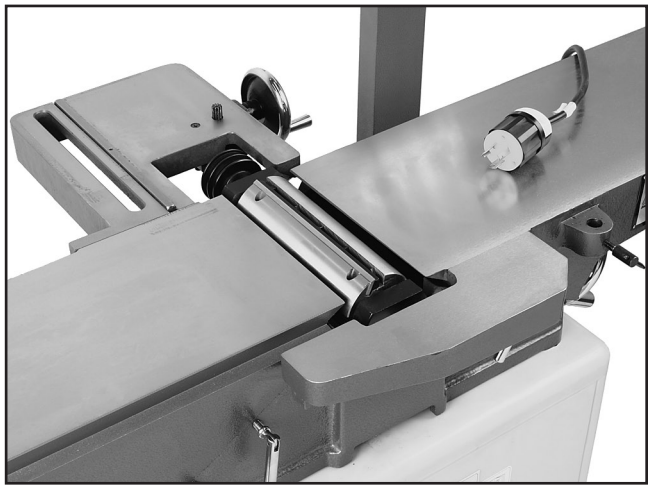


Figure 3. Example of jointer disassembly **Steps 1–4**.

5. Remove the nut and lock washer on the bearing block stud, as shown in **Figure 4**, and repeat on the other side.

Figure 4. Example of removing nut and lock washer on bearing block stud.

6. Wearing heavy leather gloves, carefully remove the cutterhead from the casting (see **Figure 5**).

   Note: *Your cutterhead may have paper shims stuck to the bearing block or the part of the casting where the bearing block rests. These were included at the factory when they calibrated your cutterhead even with the outfeed table. If you see these, carefully pull them off and set them aside for later use, or keep them with your cutterhead in the event that you reinstall it later. Also, mark the side of the cutterhead where they were used, so the future install will go smoothly. Your new cutterhead may or may not need these.*

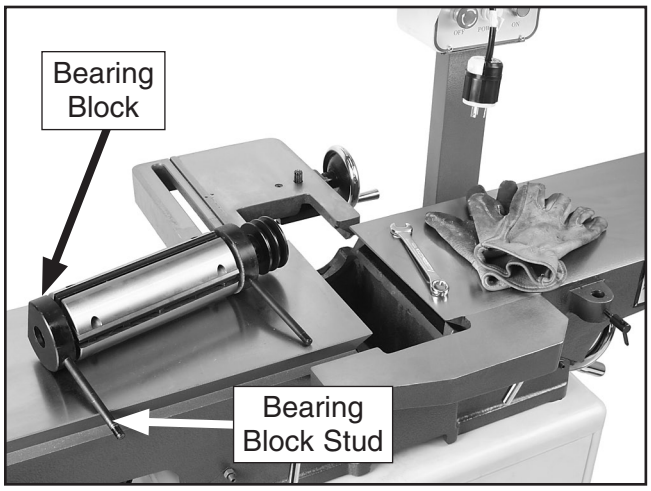


Figure 5. Example of cutterhead removed.

7. Remove the bearing block studs from the bearing blocks.

8. Use a pulley puller to remove the pulley, remove the key from the cutterhead, then use an arbor press to remove the bearings and bearing blocks from the cutterhead.

9. Reinstall the bearings removed in **Step 8** onto the bearing blocks, and install the bearing blocks onto the cutterhead with an arbor press or by gently tapping with a block of wood and a rubber dead blow hammer.

10. Reinstall the key onto the keyway, then press the pulley onto the new cutterhead shaft.

11. Reinstall the bearing block studs onto the bearing blocks.

12. Install the cutterhead (**Figure 6**) with the lock washers and hex nuts removed in **Step 5**.

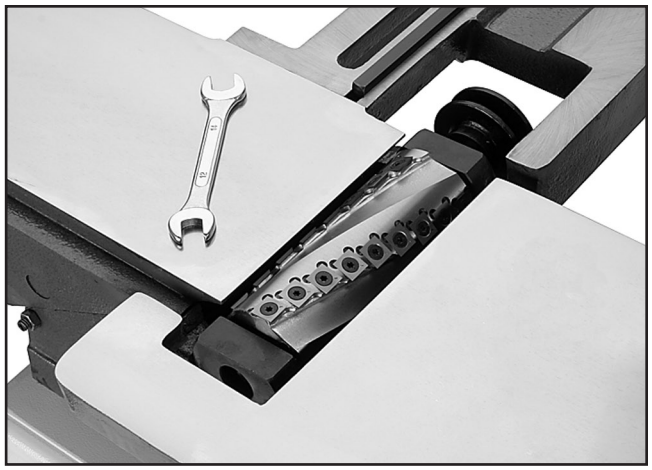


Figure 6. Example of spiral cutterhead installed.

13. Tighten the spiral cutterhead in place, and ensure both pulley setscrews are tight.

14. Using the straightedge and feeler gauge set, inspect the cutterhead parallelism with the outfeed table as shown in **Figure 7**. With the straightedge in position, raise or lower the outfeed table until the cutterhead body (not the carbide insert) just touches the straightedge.

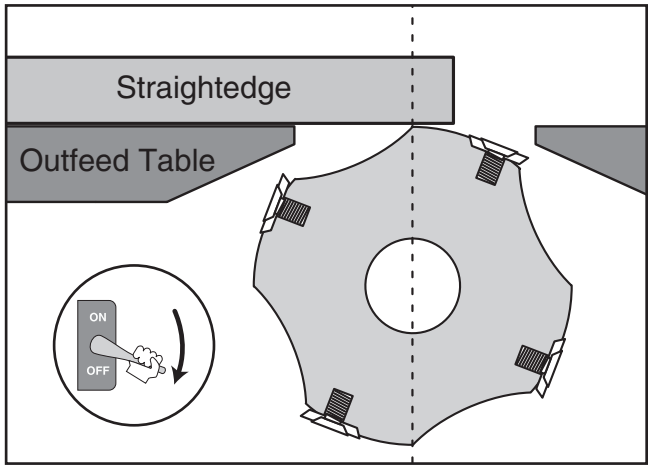


Figure 7. Checking cutterhead parallelism.

15. Move the straightedge to the other side to determine if one end of the cutterhead body is higher/lower than the other. (Place the feeler gauge between the cutterhead body and the straightedge to determine the height difference.)

—If the cutterhead is even or within 0.004" with the outfeed table from one side to the other, skip to **Step 18**.

—If the cutterhead is over 0.004" from one side to the other, go to **Step 16**.

16. Loosen the hex nuts securing both bearing block studs, lift the spiral cutterhead slightly, then place a shim beneath the bearing block that needs to be adjusted.

Note: *Use the shims from your old cutterhead if available. If not available, newspaper is approximately 0.003" thick and will work for shimming (we don't recommend shimming more than 0.004" on either side, as this may affect how the bearing block seats in the casting).*

17. Repeat **Steps 14–16** and adjust if necessary, then tighten the hex nuts on the bearing block studs.

18. Place a straightedge on the outfeed table so it extends over the cutterhead, and rotate the cutterhead pulley until one of the carbide inserts is at top-dead-center (TDC), as shown in **Figures 8 & 9**.

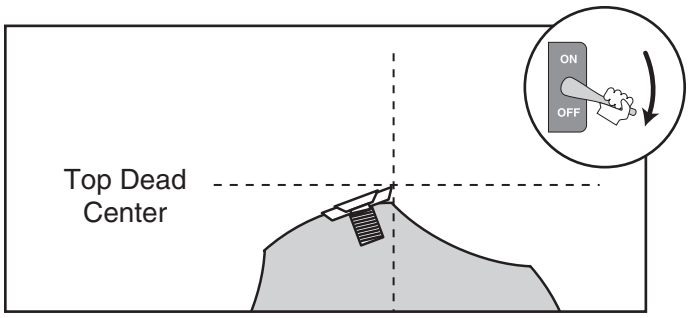


Figure 8. Cutterhead insert at top-dead-center.

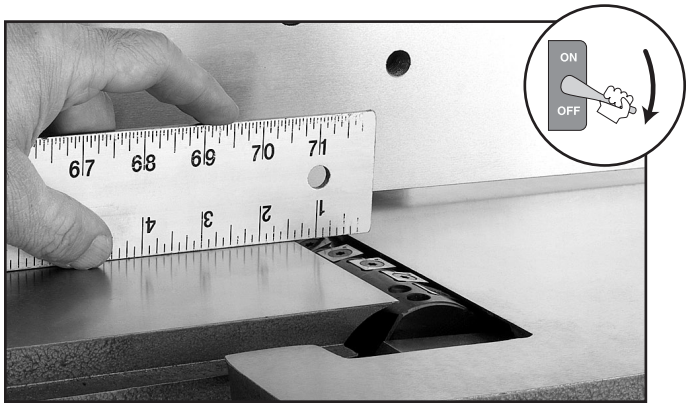


Figure 9. Setting outfeed table height.

When correctly set, the carbide insert will just touch the straightedge when the insert is at its highest point of rotation (**Figure 10**).

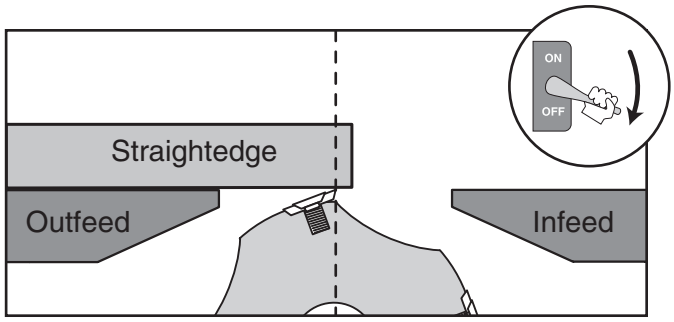


Figure 10. Using a straightedge to align outfeed table height with insert at TDC.

—If your outfeed table is correctly set, no adjustments are necessary.

—If the insert lifts the straightedge off the table or the table is below the straightedge, adjust the outfeed table height with the handwheel until the straightedge just touches an insert at its highest point of rotation.

19. Lock the outfeed table, then reinstall the fence.

20. Install the cutterhead guard back over the cutterhead, making sure that the spring tension in the guard is properly set so the guard springs back over the cutterhead when it is pulled back and released.

21. Re-adjust the infeed table.

Insert Service

The Model T10125 6" cutterhead is equipped with 32 indexable carbide inserts. Each insert can be rotated to reveal any one of its four cutting edges. Therefore, if one cutting edge becomes dull or damaged, simply rotate it clockwise 90˚ to reveal a fresh cutting edge (**Figure 11**).

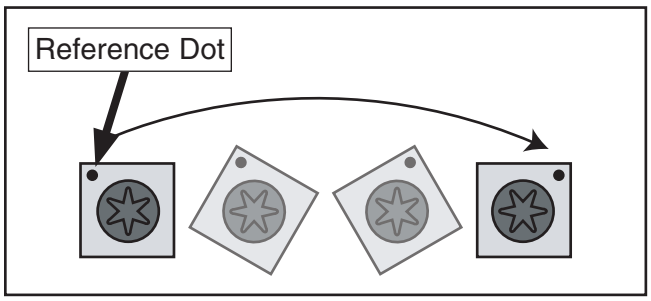


Figure 11. Rotating indexable carbide inserts.

In addition, each insert has a reference dot on one corner. As the insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. The insert must be replaced when all four edges are dull.

Installing or adjusting a carbide cutter:

1. DISCONNECT JOINTER FROM POWER!

2. Remove any sawdust from the head of the carbide insert Torx screw.

3. Remove the Torx screw and carbide insert.

4. Clean all dust and dirt off the insert and the cutterhead pocket from which the insert was removed, and replace the insert so a fresh, sharp edge is facing outward.

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

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

Note: *Excess oil may squeeze between the insert and cutterhead or in the screw hole, thereby lifting the insert or screw slightly and affecting workpiece finishes.*

Accessories

H7319—10 Pack of Indexable Carbide Inserts
Replacement carbide inserts for T10125 cutterhead.

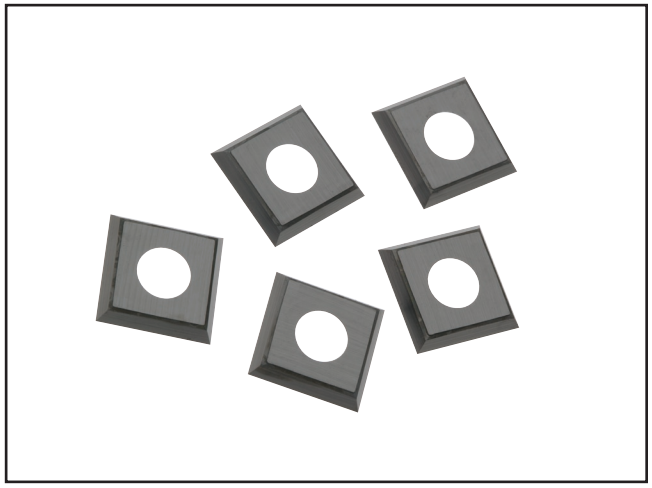


Figure 12. H7319 Indexable Carbide Inserts.

G8995—4" Heavy Duty Pulley Puller
Indispensable for pulling gears or pulleys off of press-fit shafts. Can be used in either a 2 or 3 jaw configuration. The 4" jaw fingers are also reversible so they can grab an outside or inside diameter. The forcing screw has a live center and is made of tough hardened steel. Keep one of these handy in your tool box.

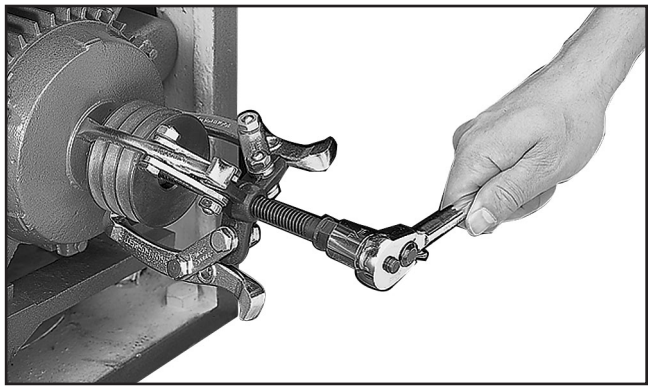


Figure 13. G8995 4" Heavy Duty Pulley Puller.

H7830—2 Ton Arbor Press

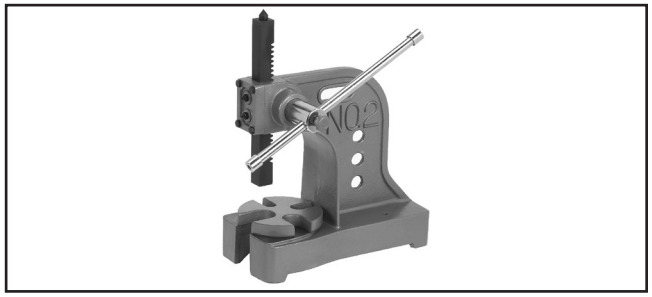


Figure 14. H7830 Arbor Press.

T20501—Face Shield, 4" Crown, Clear
T20502—Face Shield, 7" Crown, Clear
T20448—Economy Clear Safety Glasses
T20452—"Kirova" Anti-Reflective Glasses
T20456—"Dakura" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
These glasses meet ANSI Z87.1-2003 specifications. Buy extras for visitors or employees. You can't be too careful with shop safety!

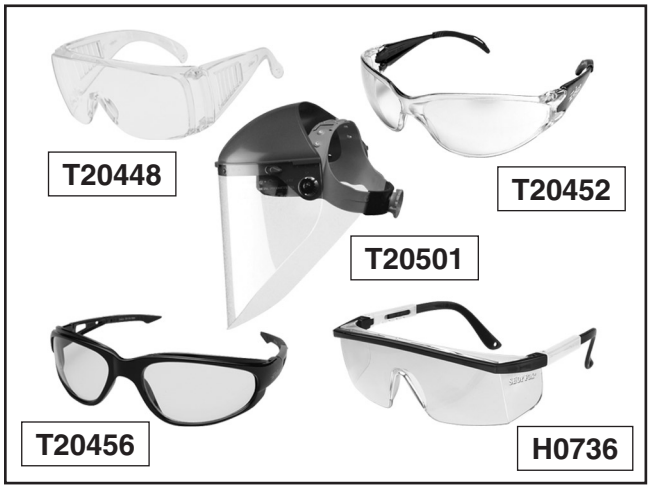


Figure 15. Our most popular eye protection.

H3153—Pigskin Palm Gloves
H3154—Lined Pigskin Palm Gloves
Durable pigskin leather is combined with cloth backs for true comfort. One size fits many.

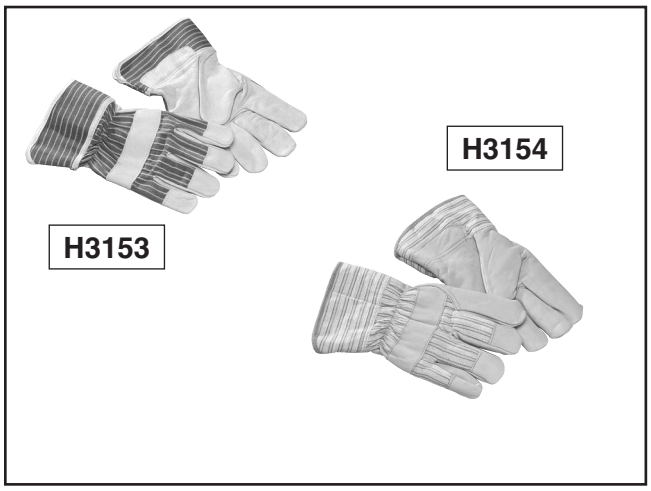
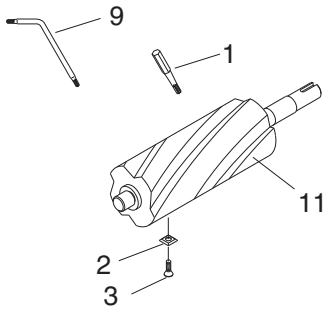


Figure 16. Work gloves.

T10125 Parts Breakdown and List



REF	PART #	DESCRIPTION
1	P0452Z001	DRIVER BIT TORX T20
2	P0452Z002	INDEXABLE INSERT 14 x 14 x 2
3	PFH35M	FLAT HD TORX SCR T20 M6-1 X 15
9	P0452Z009	L-WRENCH TORX T20
11	P0452Z011	SPIRAL CUTTERHEAD 6"

WARRANTY AND RETURNS

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

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

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

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

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

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