



6" & 8" SPIRAL CUTTERHEADS

MODEL H7590/H7591

INSTRUCTION SHEET

These spiral cutterheads are designed to replace the straight knife cutterheads from most Grizzly 6" and 8" jointers.

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 knife edges at TDC (top dead center). *Call Technical Support at (570) 546-9663 if you need help.*

Recommended Tools:

- Wrench 8 x 14mm 1
- Precision Straightedge (**Figure 1**) 1
- Feeler Gauge Set
- 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:

Cutterhead.....	1
Bearing Block Studs.....	2
Alignment Tools.....	2
T-Handle Hex Wrench 4mm.....	1
Flat Washers 3/8".....	2
Hex Nuts 3/8"-24.....	2



Figure 2. Spiral cutterhead inventory.

Installation:

1. **Disconnect/unplug jointer from power!**
2. Remove the jointer fence and cutterhead guard.
3. Remove the V-belts 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.*

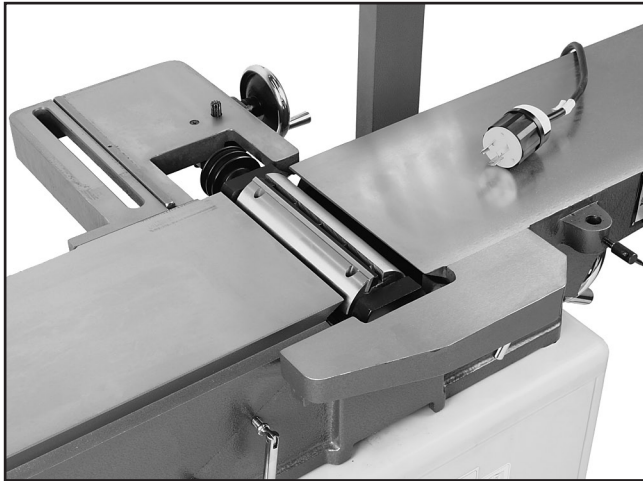


Figure 3. Jointer disassembly Steps 1–4.

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



Figure 4. Removing nut 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.

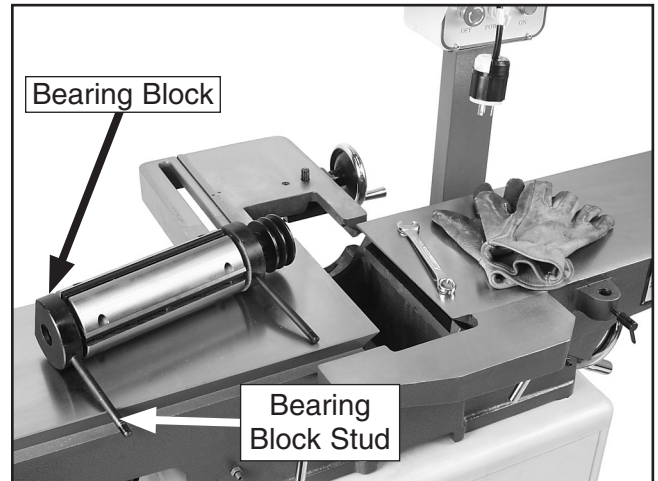


Figure 5. Cutterhead removed.

7. Install the included bearing block studs into the spiral cutterhead bearing blocks, and install the cutterhead (**Figure 6**).
8. Tighten the cutterhead in place.



Figure 6. Spiral cutterhead installed.

9. 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 knife) just touches the straightedge. Move the straightedge to the other side to determine if one end of the cutterhead is higher/lower than the other. (Place the feeler gauge between the knife edge and the straightedge to determine the height difference.)

—If the cutterhead is even or within 0.010" with the outfeed table from one side to the other, skip to **Step 12**.

—If the cutterhead is over 0.010" from one side to the other, go to **Step 10**.

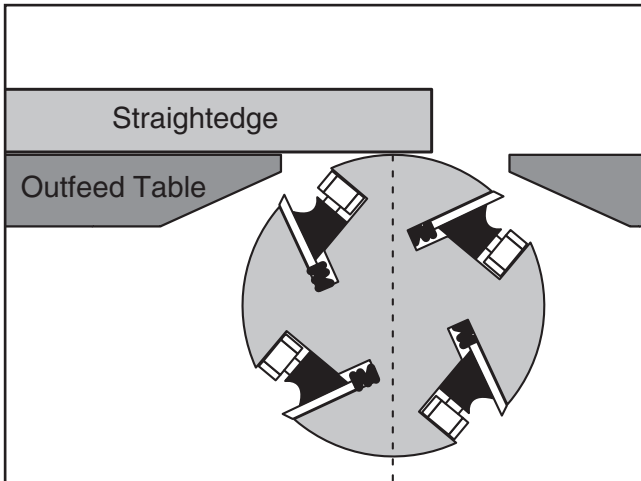


Figure 7. Checking cutterhead parallelism with a straightedge (repeat at both ends of cutterhead).

10. Remove the spiral cutterhead and place a shim where the bearing block rests.

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).

11. Repeat **Steps 7 & 10** and adjust if necessary.
12. Use the straightedge to adjust the outfeed table even with the edge of the cutterhead knives at TDC (**Figures 8 & 9**). This is a routine procedure that should be covered in more detail in the owner's manual that came with your jointer.
13. Reinstall the fence.

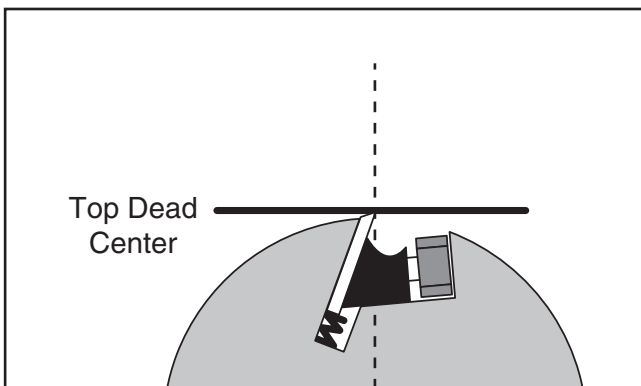


Figure 8. Cutterhead at TDC (Top Dead Center).

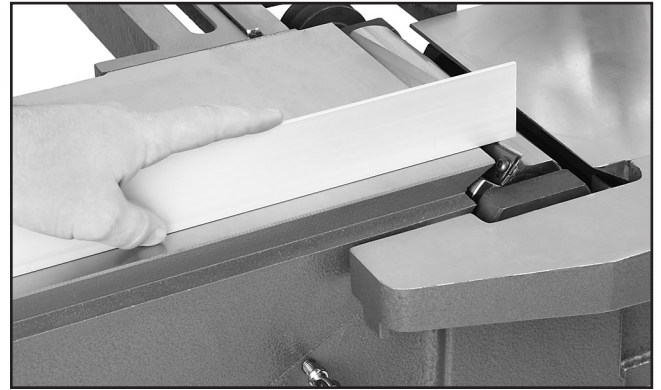


Figure 9. Setting outfeed table height with a straightedge.

14. 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.
15. Re-adjust the infeed table.

Knife Change & Setup:

1. **Always disconnect power to the jointer for knife changes or setup!**
2. Use the included T-handle wrench to remove knives for replacement.
3. When installing new knives, use the alignment tools to align the holes in the cutterhead, knife insert, and gibs while tightening the gibs in place (**Figure 10**). This will set the knife protrusion even among all the knives.
4. Snug the gibs in place with the T-wrench, and repeat with the remaining knives.
5. Fully tighten all the knife gibs in place.

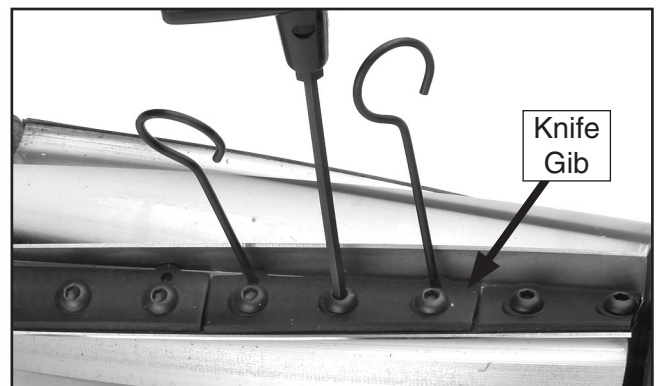
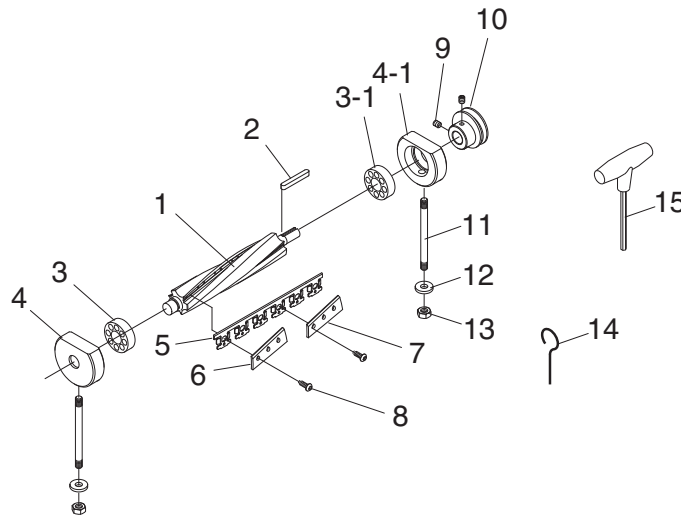


Figure 10. Installing gibs.

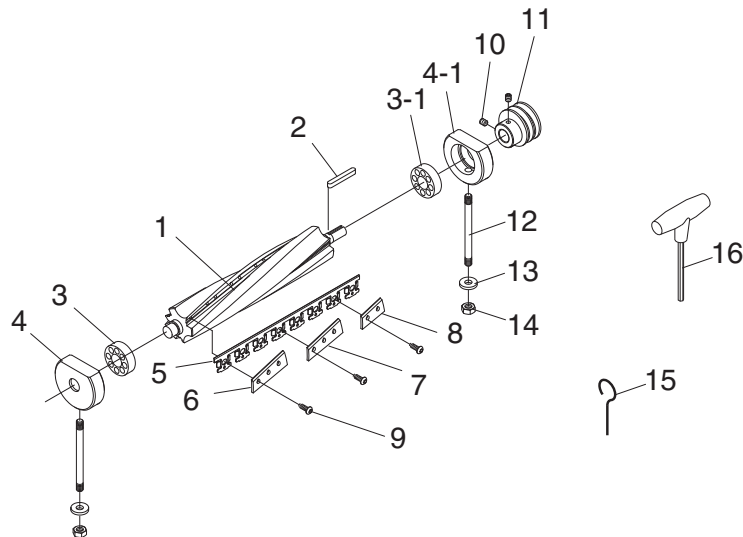
H7590 Parts Breakdown and List



REF	PART #	DESCRIPTION
1	PH7590001	6" SPIRAL CUTTERHEAD
2	PK19M	KEY 5 X 5 X 14
3	P6202	BALL BEARING 6202
3-1	P6203	BALL BEARING 6203
4	PH7590004	FRONT BEARING BLOCK
4-1	PH7590004-1	REAR BEARING BLOCK
5	PH7590005	FLEXIBLE KNIFE INSERT 6"
6	PH7590006	FRONT KNIFE GIB
7	PH7590007	REAR KNIFE GIB

REF	PART #	DESCRIPTION
8	PSBS12M	BUTTON HD CAP SCR M6-1 X 14
9	PSS11	SET SCREW 1/4"-20 X 1/4"
10	PH7590010	SINGLE SHEAVE PULLEY
11	PH7590011	STUD 3/8-24 X 4
12	PW02	FLAT WASHER 3/8
13	PN11	HEX NUT 3/8-24
14	PH7590014	ALIGNMENT TOOL
15	PH7590015	T-HANDLE HEX WRENCH 4MM

H7591 Parts Breakdown and List



REF	PART #	DESCRIPTION
1	PH7591001	8" SPIRAL CUTTERHEAD
2	PK23M	KEY 5 X 5 X 25
3	P6204	BALL BEARING 6204
3-1	P6205	BALL BEARING 6205
4	PH7591004	FRONT BEARING BLOCK
4-1	PH7591004-1	REAR BEARING BLOCK
5	PH7591005	FLEXIBLE KNIFE INSERT 8"
6	PH7591006	FRONT KNIFE GIB
7	PH7591007	CENTER KNIFE GIB
8	PH7591008	REAR KNIFE GIB

REF	PART #	DESCRIPTION
9	PSBS12M	BUTTON HD CAP SCR M6-1 X 14
10	PSS02	SET SCREW 5/16-18 X 3/8
11	PH7591011	TWO SHEAVE PULLEY
12	PH7591012	STUD 3/8-24 X 4-3/4
13	PW02	FLAT WASHER 3/8
14	PN11	HEX NUT 3/8-24
15	PH7590014	ALIGNMENT TOOL
16	PH7590015	T-HANDLE HEX WRENCH 4MM