



MODEL H7653/H7654 6" & 8" INDEXABLE INSERT SPIRAL CUTTERHEADS INSTRUCTIONS

These indexable insert spiral cutterheads are designed to replace both straight knife and spiral 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 additional help.*

Inventory (Figure 1)

- A. Spiral Cutterhead 1
- B. Torx Drivers T20 1/4"..... 5
- C. T-Handle Socket Driver 1
- D. Hex Nuts 3/8"-24 2
- E. Flat Washers 10mm 2
- F. Lock Washers 10mm..... 2
- G. Bearing Block Studs 3/8"-24 x 4 2
- H. Flat Head Torx Screws T20 M6-1 x 15 10
- I. Spare Cutterhead Inserts 14 x 14 x 2..... 5

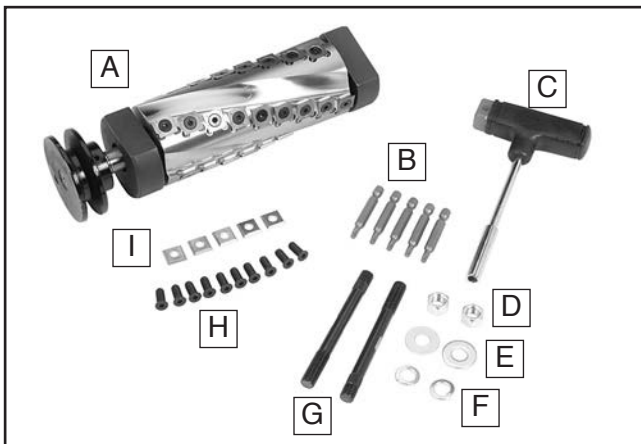


Figure 1. Model H7653/H7654 Inventory.

Recommended Tools

- Wrench 8 x 14mm 1
- Precision Straightedge 1
- Feeler Gauge Set..... 1
- Pair of Heavy Leather Gloves 1

Installation

1. DISCONNECT THE JOINTER FROM THE POWER SOURCE!
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 2**.

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

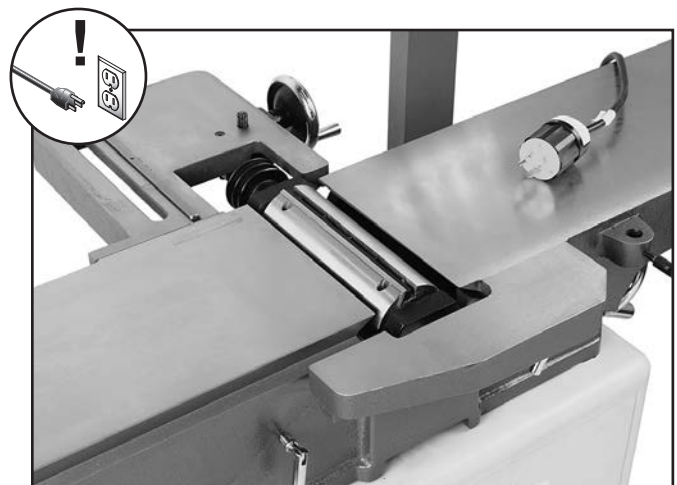


Figure 2. Joints disassembly Steps 1-4.

COPYRIGHT © FEBRUARY, 2006 BY GRIZZLY INDUSTRIAL, INC., REVISED MARCH, 2024 (BL)
WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.
 (FOR MODELS MFD. SINCE 11/06) #JK7972 PRINTED IN TAIWAN

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

- Remove the nut on the bearing block stud, as shown in **Figure 3**, and repeat on the other side.



Figure 3. Removing nut on bearing block stud.

- Wearing heavy leather gloves, carefully remove the cutterhead from the casting (see **Figure 4**).

Note: Your cutterhead may have paper shims stuck to the bearing block or the part of the casting where the bearing block rests. 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 shims.

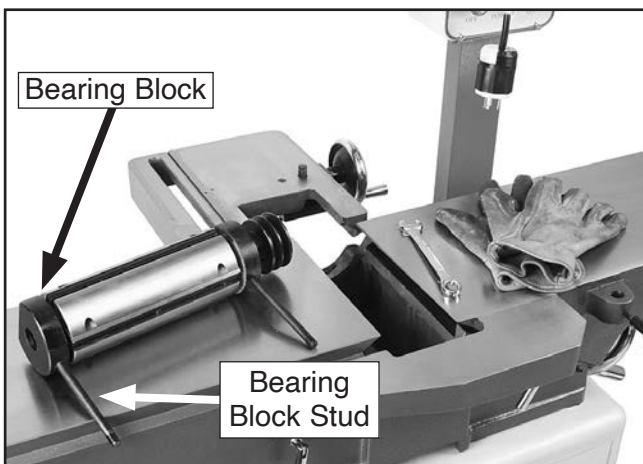


Figure 4. Cutterhead removed.

- Install the included bearing block studs into the spiral cutterhead bearing blocks, and install the cutterhead (**Figure 5**).



Figure 5. Spiral cutterhead installed.

- Tighten the spiral cutterhead in place, and ensure both pulley setscrews are tight.
- Using the straightedge and feeler gauge set, inspect the cutterhead parallelism with the outfeed table as shown in **Figure 6**. With the straightedge in position, raise or lower the outfeed table until the cutterhead body (not the carbide insert) just touches the straightedge.
- 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 13**.

—If the cutterhead is over 0.004" from one side to the other, go to **Step 11**.

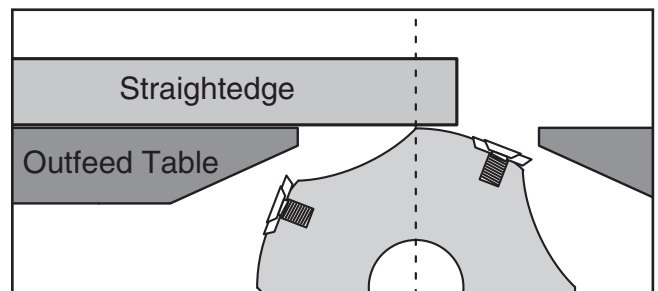


Figure 6. Checking cutterhead parallelism.



11. Lift the spiral cutterhead slightly and place a shim beneath the bearing block.

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).

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

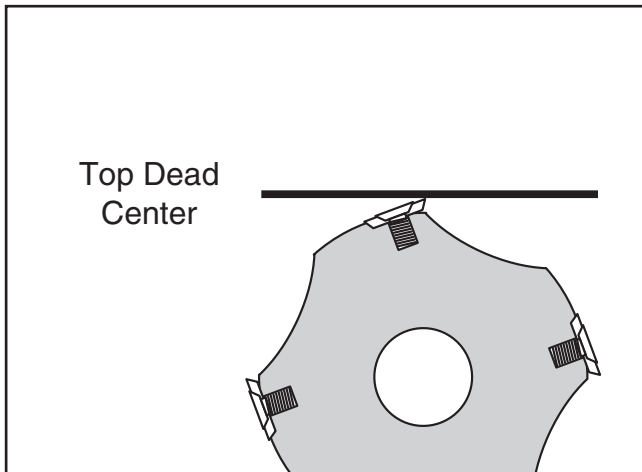


Figure 7. Cutterhead at TDC (Top Dead Center).

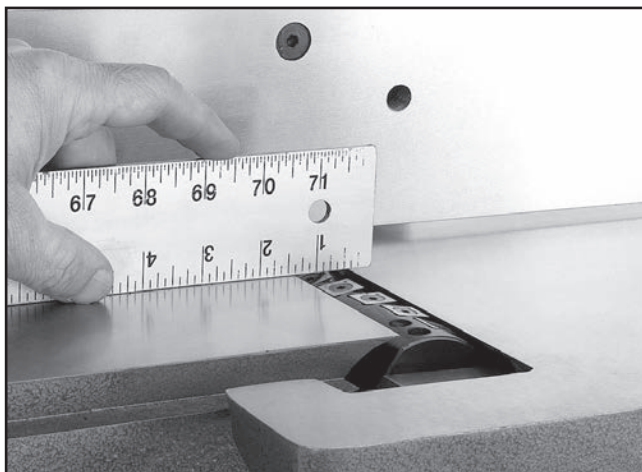


Figure 8. Setting outfeed table height.

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

Insert Service

The H7653 6" cutterhead is equipped with 34 indexable carbide inserts; the H7654 8" cutterhead has 40. 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 9**).

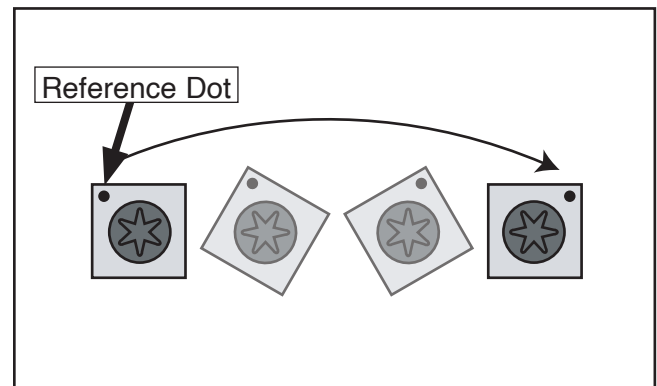


Figure 9. Rotating indexable carbide inserts.

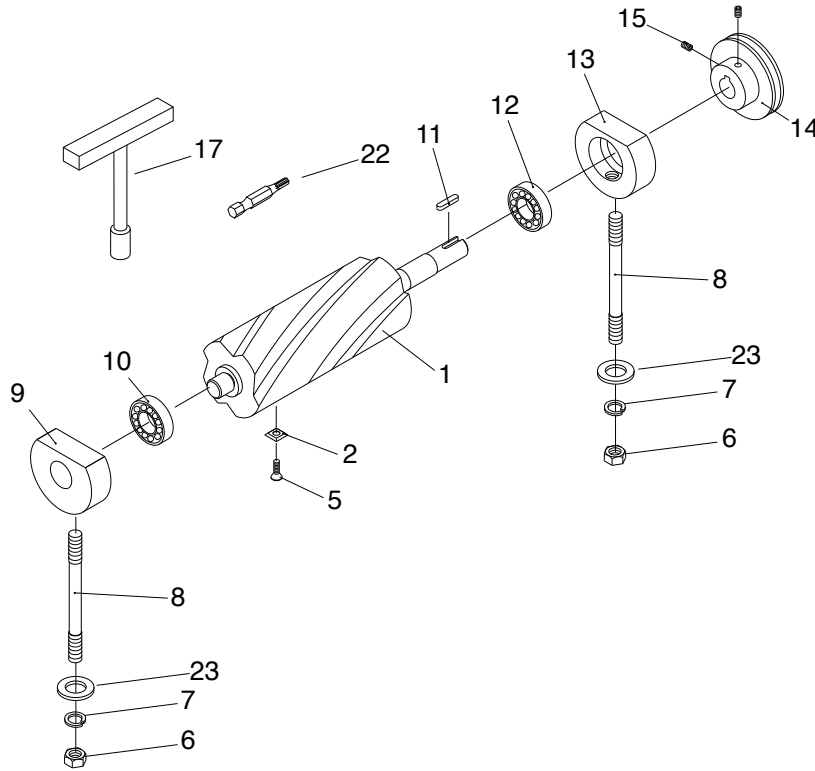
In addition, each insert has a reference dot on one corner. As the insert is rotated, the reference dot location can be used as an indicator of which edges are used and which are new. The insert must be replaced when all four edges are dull.

Installing or adjusting a carbide cutter:

1. **DISCONNECT THE JOINTER FROM THE POWER SOURCE!**
2. Remove any sawdust from the head of the carbide insert Torx screw.
3. Remove the Torx screw, rotate or replace the carbide insert, lubricate the Torx screw threads with a light machine oil, and torque the Torx screw to 48-50 inch/pounds.



H7653/H7654 Parts Breakdown & List



H7653 Parts

REF	PART #	DESCRIPTION
1	PH7653001	SPIRAL CUTTERHEAD 6"
2	PH7653002	INDEXABLE INSERT 14 X 14 X 2
2-1	PH7653002-1	SET OF 10 INDEXABLE INSERTS
5	PH7653005	FLAT HD TORX SCR T20 M6-1 X 15
6	PH7653006	HEX NUT 3/8-24
7	PH7653007	LOCK WASHER 10MM
8	PH7653008	BEARING BLOCK STUD
9	PH7653009	BALL BEARING BLOCK
10	PH7653010	BALL BEARING 6202

REF	PART #	DESCRIPTION
11	PH7653011	KEY 5 X 5 X 30
12	PH7653012	BALL BEARING 6203
13	PH7653013	BALL BEARING BLOCK
14	PH7653014	PULLEY
15	PH7653015	SETScrew 1/4-20 X 3/8
17	PH7653017	T-HANDLE DRIVER 1/4"
22	PH7653022	TORX BIT T20
23	PH7653023	FLAT WASHER 10MM

H7654 Parts

REF	PART #	DESCRIPTION
1	PH7654001	SPIRAL CUTTERHEAD 8"
2	PH7654002	INDEXABLE INSERT 14 X 14 X 2
2-1	PH7654002-1	SET OF 10 INDEXABLE INSERTS
5	PH7654005	FLAT HD TORX SCR T20 M6-1 X 15
6	PH7654006	HEX NUT 3/8-24
7	PH7654007	LOCK WASHER 10MM
8	PH7654008	BEARING BLOCK STUD
9	PH7654009	BALL BEARING BLOCK
10	PH7654010	BALL BEARING 6204

REF	PART #	DESCRIPTION
11	PH7654011	KEY 5 X 5 X 35
12	PH7654012	BALL BEARING 6205
13	PH7654013	BALL BEARING BLOCK
14	PH7654014	PULLEY
15	PH7654015	SET SCREW 5/16-18 X 3/8
17	PH7654017	T-HANDLE DRIVER 1/4"
22	PH7654022	TORX BIT T20
23	PH7654024	FLAT WASHER 10MM

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.

