3 H.P. HEAVY-DUTY SHAPER

MODEL G1026

INSTRUCTION MANUAL

REVISED AUGUST, 2001. PRINTED IN TAIWAN

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.

Table Of Contents

PAGE

1. **SAFETY**
   - SAFETY RULES FOR ALL TOOLS 2-3
   - ADDITIONAL SAFETY INSTRUCTIONS FOR SHAPERS 4
2. **CIRCUIT REQUIREMENTS**
   - 220V OPERATION 5
   - GROUNDING 5
3. **INTRODUCTION**
   - COMMENTARY 6
   - UNPACKING 7
   - PIECE INVENTORY 7
   - CLEAN UP 8
   - SITE CONSIDERATIONS 8
4. **ASSEMBLY**
   - BEGINNING ASSEMBLY 9
   - HANDWHEEL 9
   - SPINDLE INSTALLATION 10-11
   - EXTENSION WING 11-12
   - FENCE ASSEMBLY 12
   - SAFETY GUARD 13
   - HOLD DOWN 13
5. **ADJUSTMENTS**
   - PULLEYS & V-BELTS 14
   - V-BELT TENSION 15
   - SPEED CHANGES 15
   - FENCE ADJUSTMENT 15
   - TRUING THE FENCE 16
   - TABLE INSERTS 16
   - GIB ADJUSTMENTS 17
6. **OPERATIONS**
   - TEST RUN 18
   - CUTTER INSTALLATION 18-19
   - ROTATION 19
   - SPINDLE HEIGHT 19
   - STRAIGHT SHAPING 20-21
   - SHAPING SMALL STOCK 22
   - RUB COLLARS 23
   - IRREGULAR SHAPING 24-25
   - PATTERN WORK 26
7. **MAINTENANCE**
   - GENERAL 27
   - LUBRICATION 27
   - TABLE 27
   - V-BELT 27
   - SPINDLE BEARINGS 28
   - MAINTENANCE NOTES 29
8. **CLOSURE** 30

MACHINE DATA 31
PARTS BREAKDOWN AND PARTS LISTS 32-40
WIRING DIAGRAM 41
WARRANTY AND RETURNS 42

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

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

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

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

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

NOTICE — **This symbol is used to alert the user to useful information about proper operation of the equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT**. Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY**. All children and visitors should be kept a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.

⚠WARNING

Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	**25ft**	**50ft**	**100ft**
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, etc...

14. **DO NOT OVERREACH.** Keep proper footing and balance at all times.

15. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.

17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

20. **DO NOT USE POWER TOOLS WHEN** under the influence of alcohol or drugs, or when tired.

21. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

⚠WARNING

Additional Safety Instructions For The Shaper

1. **NEVER PLACE YOUR HANDS WITHIN 12 INCHES** of the cutters. Never pass your hands directly over, or in front of the cutter. As one hand approaches the 12-inch radius point, move it in an arc motion away from the cutter to the outfeed side and reposition that hand more than 12 inches beyond the cutter.

2. **DO NOT SHAPE STOCK SHORTER THAN 12 INCHES** without special fixtures or jigs. Where practical, shape longer stock and cut to size.

3. **BLIND CUT WHENEVER POSSIBLE.** This keeps the knives on the underside of the workpiece and provides a distance guard for the operator.

4. **ALWAYS ROTATE THE SPINDLE BY HAND**, with the machine unplugged, to test any new setup to ensure proper cutter clearance before starting the machine.

5. **WHEN SHAPING CONTOURED WORK** and using a rub collar, NEVER start out at a corner. See the rub collar section further on in the manual. The danger of kick-back is increased when the stock has knots, holes, or foreign objects in it. Warped stock should be run through a jointer before you run it through a shaper.

6. **KEEP ANY UNUSED PORTION OF THE CUTTER BELOW THE TABLE SURFACE.**

7. **NEVER ATTEMPT TO REMOVE TOO MUCH MATERIAL IN ONE PASS.** Several light passes are safer and give a cleaner finish.

8. **THE USE OF PUSH STICKS AS SAFETY DEVICES** in some applications is smart; in others it can be quite dangerous. If the push stick comes in contact with the cutter on the end grain, it can fly out of your hand like a bullet—potentially causing serious injury. We recommend using some type of fixture, jig, or hold-down device as a safer alternative. Use a guard or other type of protective device at all times.

9. **ALWAYS FEED AGAINST THE ROTATION OF THE CUTTER.**

10. **USE THE OVERHEAD GUARD WHEN FENCE IS NOT IN PLACE.**

11. **NEVER OPERATE THE SHAPER WITHOUT THE SECOND LOCKING NUT IN PLACE** over the spindle nut.

12. **IF AT ANYTIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE MACHINE!** Then contact our service department or ask a qualified expert how the operation should be performed.

13. **BE AWARE THAT CERTAIN WOODS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to, the possibility of a allergic reaction and always wear an approved respirator.

14. **NEVER REACH BEHIND THE SPINNING CUTTER.**

⚠WARNING

Like all power tools, there is danger associated with the Model G1026 Shaper. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment or poor work results.

SECTION 2: CIRCUIT REQUIREMENTS

220V Operation

The G1026 Shaper is furnished with a 3450 R.P.M. 3 H.P., 220V motor, push-button ON-OFF magnetic starter switch, forward-reverse switch and a cord set. Under normal use, the motor draws approximately 18 amps at 220V. We recommend a 20 amp circuit breaker or a 20 amp slow-blow fuse. If frequent circuit failures occur when using the shaper, contact our service department.

The shaper motor must be connected to its own dedicated 20 amp circuit. It should not share a circuit with any other machine. A standard 2-pole breaker should be satisfactory for use with the shaper.

We recommend using a NEMA-style L6-20 plug and outlet shown **Figure 1.** You may also "hard-wire" the shaper directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.

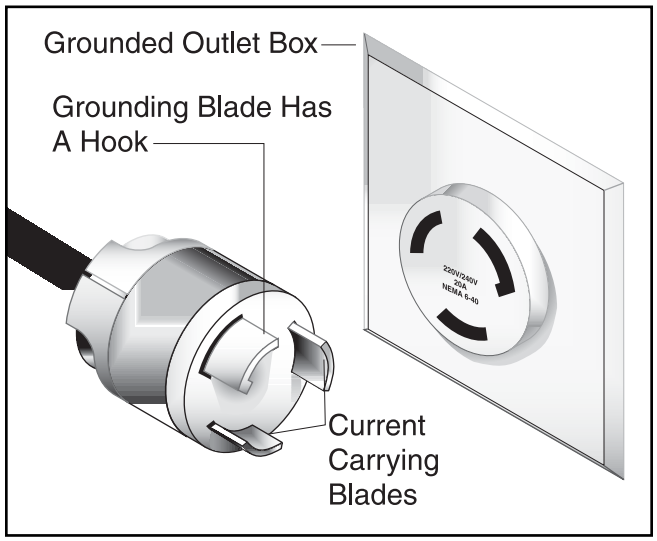
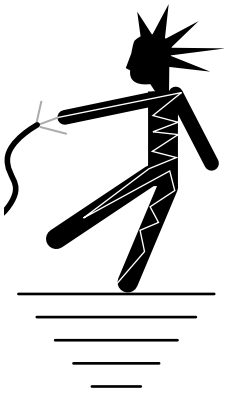


Figure 1. Recommended plug configuration.

Grounding

In the event of a malfunction or breakdown, grounding provides electric current a path of least resistance to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor which must be properly connected to a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.



WARNING

This equipment must be grounded. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. Under no circumstances should the grounding pin from any three-pronged plug be removed. Serious injury may occur.

SECTION 3: INTRODUCTION

Commentary

Grizzly Industrial, Inc. is proud to offer the Model G1026 Shaper. The Model G1026 is part of Grizzly's growing family of fine woodworking and metalworking machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation.

The Model G1026 is intended for heavy-duty professional use. This shaper features a 3 H.P., 220V single-phase motor, magnetic power switching and full reversing capabilities. The Model G1026 also features a precision-ground cast iron table, hold-down springs, three spindles and an extended table wing. This shaper is capable of operating at two spindle speeds: 7,000 and 10,000 R.P.M., giving you a versatile shaper at a reasonable price.

A number of optional accessories for the Model G1026 are available. Please refer to the current Grizzly catalog for more information.

We are also pleased to provide this manual with the Model G1026. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any criticisms that you feel we should address in our next printing, please write to us at the address below:

Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

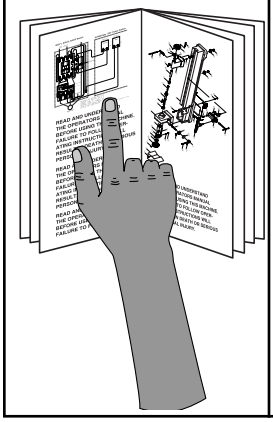
Most important, we stand behind our machines. We have an excellent service department at your disposal should the need arise. If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc.
2406 Reach Road
Williamsport, PA 17701
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

Address after fall, 2001:

Grizzly Industrial, Inc.
1203 Lycoming Circle
Pennsdale, PA 17756

The specifications, drawings, and photographs illustrated in this manual represent the Model G1026 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.

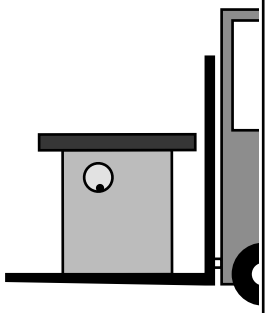


⚠WARNING

Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.

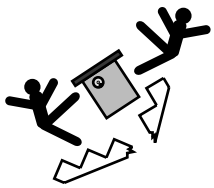
Unpacking

The Model G1026 Shaper is shipped from the manufacturer in a carefully packed carton. If you discover the machine is damaged after you've signed for delivery, and the truck and driver are gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for possible inspection by the carrier or its agent. Without the packing materials, filing a freight claim can be difficult. *If you need assistance determining whether you need to file a freight claim, or with the procedure to file one, please contact our Customer Service.*



⚠WARNING

The G1026 is a heavy machine, 353 lbs. shipping weight. DO NOT over-exert yourself while unpacking or moving your machine – consider using power equipment to move the machine. Serious personal injury may occur if safe moving methods are not followed.



⚠WARNING

If your shaper must be moved up or down a flight of stairs, be sure the stairs are capable of supporting the combined weight of people and machine. Serious personal injury may occur if this warning is ignored.

NOTICE

A full parts list and breakdown can be found toward the end of this manual. For easier assembly, or to identify missing parts, please refer to the detailed illustrations at the end of the manual.

Piece Inventory

After all the parts have been removed from the carton, you should have:

- Shaper Unit
- Miter Gauge
- Extension Wing
- 2 Wood Fences
- Hardware Box

The G1026 Hardware Box contains:

Hardware	Qty
½" Spindle	1
¾" Spindle	1
1" Spindle	1
½" Spindle Nut	2
¾" Spindle Nut	2
1" Spindle Nut	2
Spacer Set*	18
Draw Bar	1
Draw Nut	1
Spindle Wrench Set	2
Safety Guard	1
Safety Guard Shaft	1
Starting Pins	3
Hold Downs	4
Hold Down Bars	2
Hold Down Brackets	4
5/16"-18 x 1½" Flat Head Screws	4
5/16"-18 x ¾" Flat Head Screws	2
5/16" Flat Washers	4
5/16" Hex Nuts	6
Handle For Handwheel	1
½" Flat Washers	2
¾" Flat Washers	2
1" Flat Washers	2
Extension Bracket	1
Lock Handle	1
Lock Knob	1
Guard Extension	1
Setscrew 5/16"-18 x 3/8"	4

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or replacements can be obtained at your local hardware store.

*Refer to page 37 for a detailed listing of spacers supplied.

Clean Up

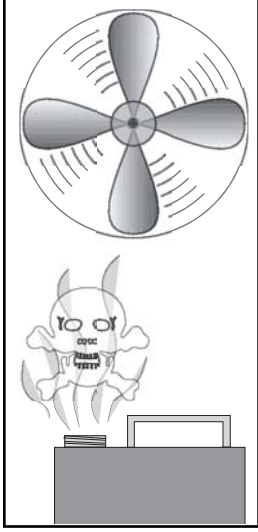
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the usage instructions on any cleaning product.

⚠WARNING

Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which makes them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.

⚠WARNING

Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.



⚠CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

Site Considerations

FLOOR LOAD

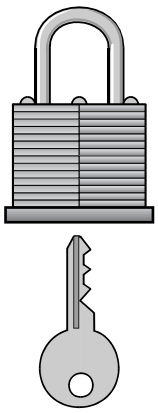
Your Model G1026 Shaper represents a moderately large weight load in a small footprint. Most commercial or home shop floors will be adequate for the 345 lb. weight of the Model G1026. Some floors may require additional support. Contact an architect or structural engineer if you have any question about the ability of your floor to handle the weight.

WORKING CLEARANCES

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

LIGHTING AND OUTLETS

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets, or circuits.



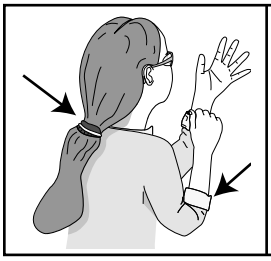
⚠CAUTION

Make your shop "child safe." Ensure that your workplace is inaccessible to youngsters by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting or operating equipment.

SECTION 4: ASSEMBLY

Beginning Assembly

Most of your Model G1026 Shaper has been assembled at the factory, but some parts must be assembled or installed after delivery. We have organized the assembly process into steps. Please follow along in the order presented here.



⚠WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.

⚠WARNING

Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during the entire assembly process. Failure to comply may result in serious personal injury.

⚠CAUTION

Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

Handwheel

The handwheel, pre-installed at the factory, is made of high impact plastic. It is used to raise and lower the spindle to accommodate the height required by your cutter.

1. Thread the crank handle onto the handwheel.

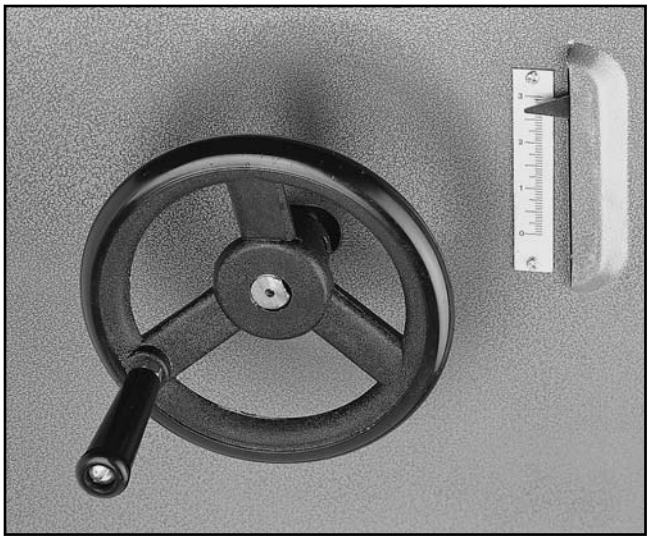


Figure 2. Handwheel mounted to shaper.

2. While holding handle screw with a flat head screwdriver, tighten the lock nut against the handwheel.

Spindle Installation

The Model G1026 comes with ½", ¾", & 1" interchangeable spindles. Each spindle is sized to work efficiently with different sized cutters and spacers. The spindles must be inserted correctly and remain securely locked in the machine in order to produce quality work. When installing and changing spindles, make sure the spindle seats snugly and that there is enough drawbar threaded into the bottom of the spindle to safely secure it in place.

To install a spindle:

1. **Disconnect the power first.**

2. Thread the drawbar approximately 10-15 turns into the bottom of the spindle. The drawbar has two threaded ends. One of them remains exposed. **See Figure 3.**

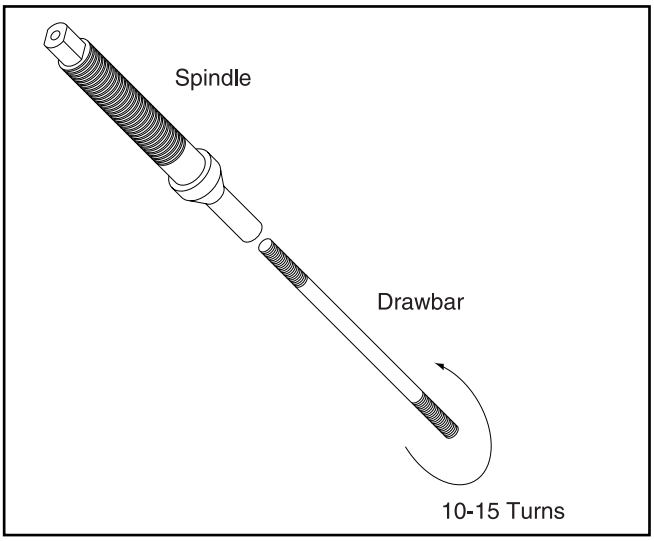


Figure 3. Spindle and drawbar.

NOTICE

On initial assembly, make sure all rust inhibitor has been removed from spindle and spindle cartridge taper.

3. Place the spindle/drawbar into the spindle cartridge at the top of the table. Line up the keyway on the spindle with the locating pin at the top of the spindle cartridge. You will feel the spindle seat itself. **See Figure 4.**

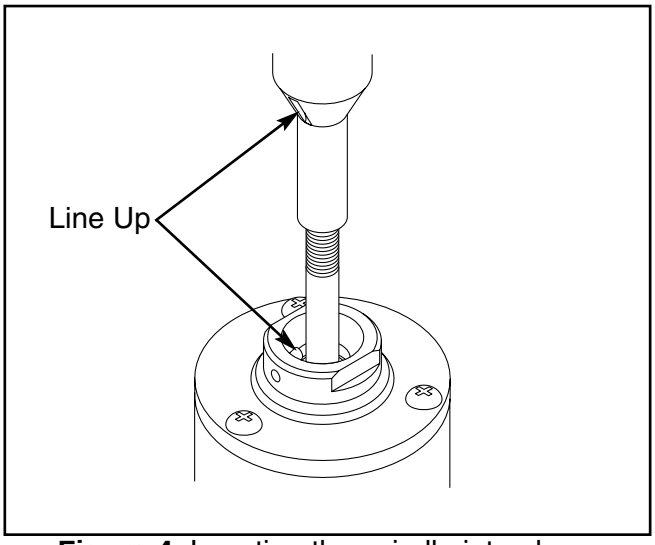


Figure 4. Inserting the spindle into place.

⚠CAUTION

Make certain the spindle keyway and pin are aligned and properly seated before tightening the drawbar nut. Improper assembly can create an unsafe condition and possible injury to the operator.

4. Thread the drawbar nut, tapered side up, onto the bottom of the drawbar. **See Figure 5.**

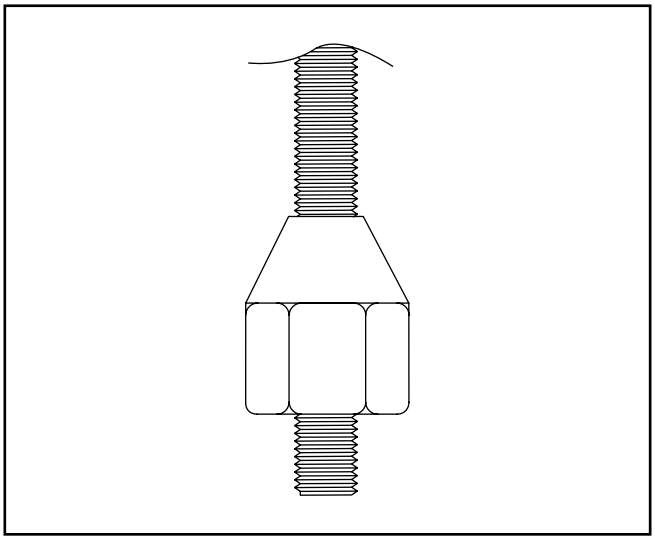


Figure 5. Nut threaded onto drawbar.

5. Place the spindle wrench on top of the spindle, so it fits over the head of the spindle. Place a 15mm wrench on the drawbar nut. **See Figure 6.**

Figure 6. Tightening the drawbar nut.

6. Hold the spindle in place and tighten the drawbar nut. **DO NOT** use excessive force.

⚠WARNING

Make certain the spindle is properly assembled before operating the shaper. Incorrect assembly can allow the spindle and cutter to fly off the machine causing injury to the operator. If you are uncertain of any aspect of this assembly, please review these instructions again or contact Grizzly's Customer Service.

Extension Wing

The cast iron wing extends your work surface area to provide support for larger workpieces. Follow the instructions below to ensure your extension wing is flush with the shaper table.

1. Make sure the contact surfaces are free of dirt or grit.

2. Put the three bolts with lock washers through the wing and thread them into the tapped holes at the front of the shaper. Leave them loose, for now.

3. Raise the wing up on one side and make sure it's flush to the table edge. Tighten the first bolt. **See Figure 7.**

4. By raising or lowering the far end of the wing, you can locate the center of the wing flush with the shaper table. Secure the center bolt.

Figure 7. Installing extension wing.

5. The end of the wing at the last bolt may not be flush with the surface of the table. Don't be alarmed. Make sure the wing edge is flush at the first two bolts and that the bolts are tight.

6. Now adjust the wing, either up or down, at the last bolt. If necessary, use a clamp and a couple of blocks to make the two surfaces flush. Tighten the final bolt when the two surfaces are flush. **See Figure 8.**

Figure 8. Adjusting to ensure flatness.

7. Once you've secured the wing to the table, inspect your results. Use a good-quality straightedge. If the wing is slightly tilted either up or down, you can place some masking tape along the whole length, between the table and the wing. Place the tape above the bolts to lower the wing and below the bolts to raise it. Remember to tighten the bolts in the same sequence, after making adjustments.

Fence Assembly

To install the wood facing:

1. Secure the wooden fence pieces with the 5/16"-18 x 1" Phillips® head screws, washers and hex nuts provided. **See Figure 9.**

2. If using your own wood pieces, make sure the countersunk holes in your fence material are deep enough to keep the entire screw head below the fence surface.

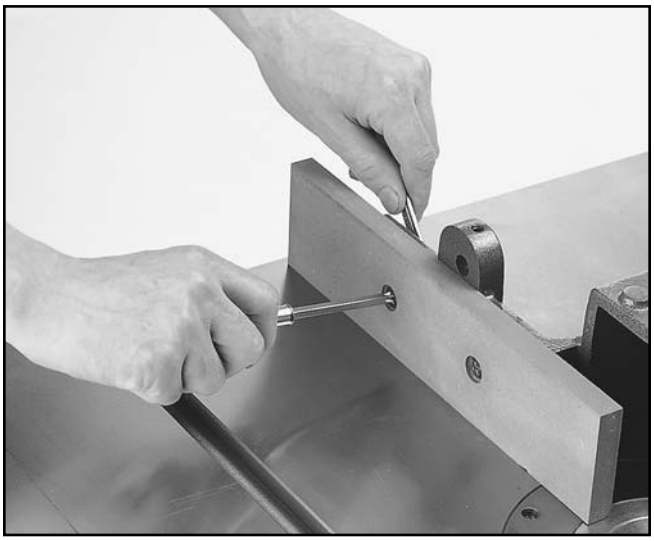


Figure 9. Attaching wooden fence assembly.

Safety Guard

To assemble the safety guard:

1. Place the safety guard support rod into the hole at the back of the table with the V-groove facing away from the machine.

2. Using the two 5⁄16" - 18 x 3⁄4" Phillips® head screws, tightly secure the extension bar to the main guard. **See Figure 10.**

3. Attach the guard assembly to the support rod and tighten the lock handle.

Under most conditions, this guard is used when doing freehand work. This should be used in addition to the starting pin—never as an alternative.

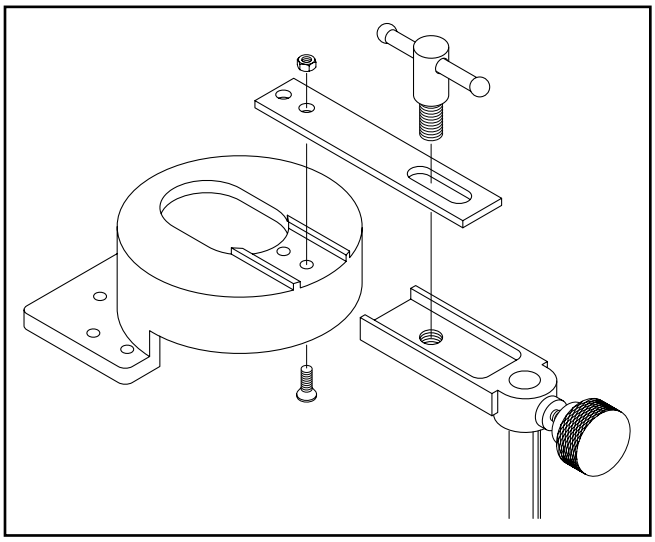


Figure 10. Safety guard assembly.

Hold-Downs

Hold-downs are used to hold the workpiece flat on the table and snug against the fence. **See Figure 11.** To assemble the spring hold-downs:

1. Slide two aluminum hold-down brackets onto each of the hold-down bars.

2. Slide the hold-down bars through the holes in the cast iron fence brackets.

3. Partially screw the 1⁄4" - 20 x 3⁄8" setscrews into the hold-down brackets.

4. Slide each hold-down between a bracket and hold-down bar.

5. Position the hold-downs according to the size of your workpiece.

6. Tighten the setscrews in the fence brackets and the hold-down brackets to fix the position of the hold-downs.

Remove the hold-down assembly when not in use.

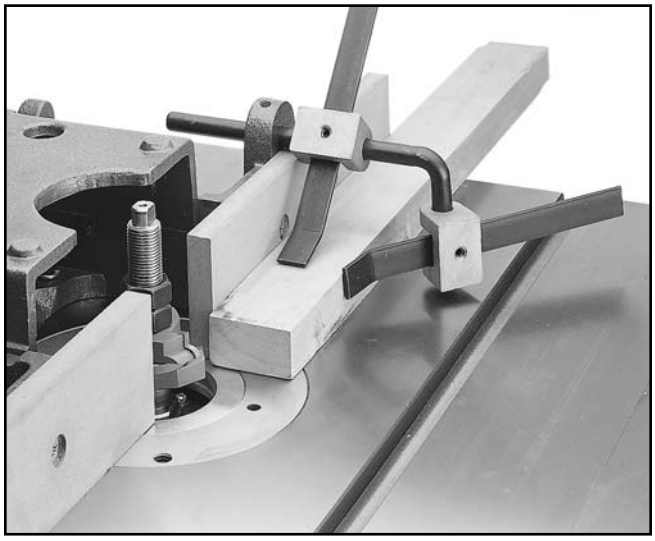
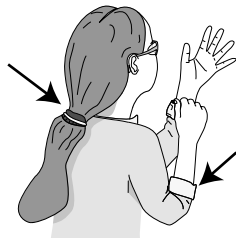


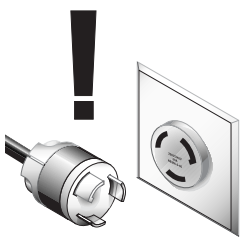
Figure 11. Hold-downs in place (guard removed for clarity).

SECTION 5: ADJUSTMENTS



⚠WARNING

Keep clothing rolled up and out of the way of machinery and keep hair pulled back.



⚠WARNING

Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during the entire adjustment process. Failure to comply may result in serious personal injury.

Pulleys & V-Belts

Improper pulley alignment sharply reduces the effectiveness of power transmission and belt life expectancy. To align the pulleys:

1. Open the motor cover on the side of the shaper cabinet.

2. Check the alignment with a straightedge. If the pulleys are in alignment, the straightedge should touch two sides of each pulley evenly. **See Figure 12.**

3. If pulleys are parallel with each other, but not in line, remove the belt from the spindle assembly and slide the spindle cartridge assembly either up or down.

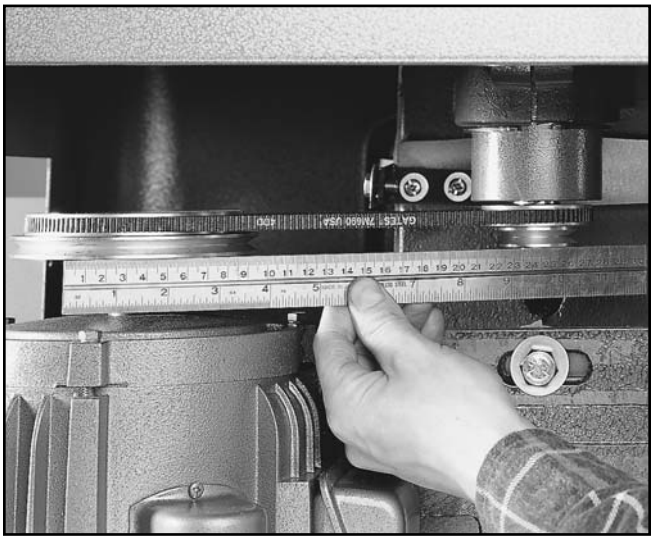


Figure 12. Inspecting pulley alignment.

4. The side cover can be removed from the shaper to improve access to the motor. Inspect for tilt on the motor pulley. If the pulley is tilted, loosen the four bolts holding the motor onto the motor plate. Wiggle the motor into position. (Do not loosen the bolts that hold the motor onto the motor mount; this plate is preset with blocks that hold it in position and it cannot be adjusted.)

5. Inspect your results. If they are satisfactory, tighten all fasteners. Remember to tighten the bolt in the split housing that holds the spindle cartridge in position.

6. You can also align the motor pulley by raising or lowering it along the motor shaft. Loosen the two setscrews and tap into the desired position with a dead blow hammer.

NOTICE

DO NOT over-tighten. Cast iron threads are more easily stripped than steel.

⚠WARNING
Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.

V-Belt Tension

You should be able to deflect the belt ¼" with moderate finger pressure. This may seem tight compared to most other V-belts, but since the belt is small and runs fast, this much tension is necessary. The V-belt will slip if too loose and squeal or cause vibration if too tight. To adjust V-belt tension:

1. Make sure the pulleys are properly aligned.
2. Loosen the two motor mount plate bolts and slide the motor left or right to modify the belt tension.
3. Tighten the motor mount plate bolts, test the tension, and check pulleys.
4. Repeat **steps 2-3** until tension is correct and pulleys are aligned.

Speed Changes

The Model G1026 Shaper is equipped with a special high speed V-belt. It was designed to withstand vibration and sudden shock loads associated with the operation of a shaper. To change spindle speeds:

1. Loosen the two motor plate bolts and slide the motor toward the spindle assembly. DO NOT take the bolts out.
2. Select the desired speed. **See Figure 13.**
3. Slide the motor back into position and tighten the belt. When the belt is properly tensioned, there should be approximately ¼" of deflection in the center of the belt when you press it with your thumb.
4. Tighten all the adjusting bolts.
5. Spin the pulley to ensure proper setup.

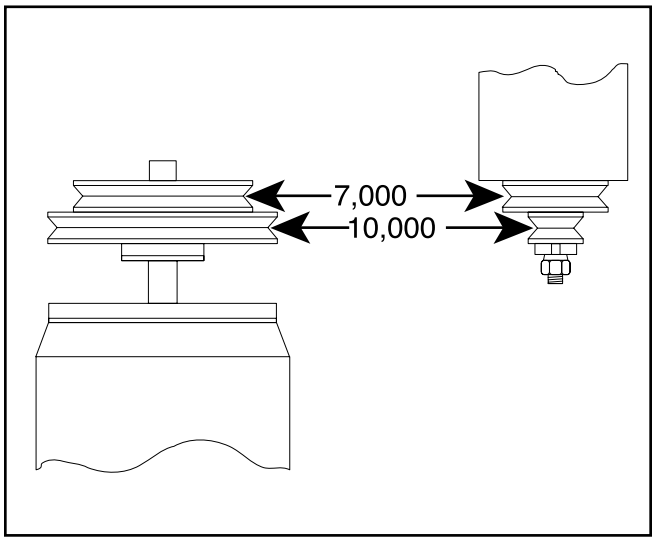


Figure 13. Spindle speed adjustment.

Fence Adjustment

The fence is a two-piece adjusting system. Each fence is independently adjustable to compensate for different cutting thicknesses and special shaping applications. One turn of the knob moves the split fence approximately 5⁄64" (.078"). To adjust the fence:

1. Loosen the fence lock handle.
2. Turn the fence adjustment knob until fence is set to the desired position.
3. Tighten the fence lock handle.

More detailed information concerning fence adjustments are covered in the “Straight Shaping” instructions in **Section 6**.

Truing The Fence

The following procedure will ensure that the fence is parallel with itself and square with the table.

1. Ensure that the bolts through the wood facing on each side are tight and adequately countersunk.

2. To align the wood facing, adjust one or both fence halves so they are in close alignment. Micro-adjust and check the alignment with a straightedge.

3. If the wood fences are not coplanar with each other, use electrical washers between the fence and the fence bracket to shim the fence into the correct position.

Table Inserts

The Model G1026 is supplied with three table inserts which give you four possible opening diameters in the shaper table surface. Use the smallest opening that a particular cutter will allow. This offers more support for the workpiece and reduces the amount of chips that can fall into the machine. The correct spindle opening will also allow any unused portion of the cutter to remain below the table surface—increasing operator protection. There are two aluminum table inserts and one cast iron table insert.

The cast iron table insert must be flush with the top of the table. To adjust the insert:

1. Remove the three Phillips® head screws that hold the cast iron insert in place.

2. By using a straightedge and a screwdriver, turn the barrel screws clockwise or counterclockwise to level the cast iron insert with the table. **See Figure 14.**

Figure 14. Leveling table insert.

3. Inspect with straightedge, replace the Phillips® head screws and secure.

Gib Adjustments

1. Elevate the spindle to its maximum 3" height. Test the spindle for movement from left to right after tightening the spindle assembly lock knob. If there is movement, adjust the gib against the elevation housing, using the adjustment screws at the top and bottom of the elevation housing. **Figure 15** shows the two upper gib adjustment screws and locknuts. One of the two lower adjustment screws is also visible in the photo.

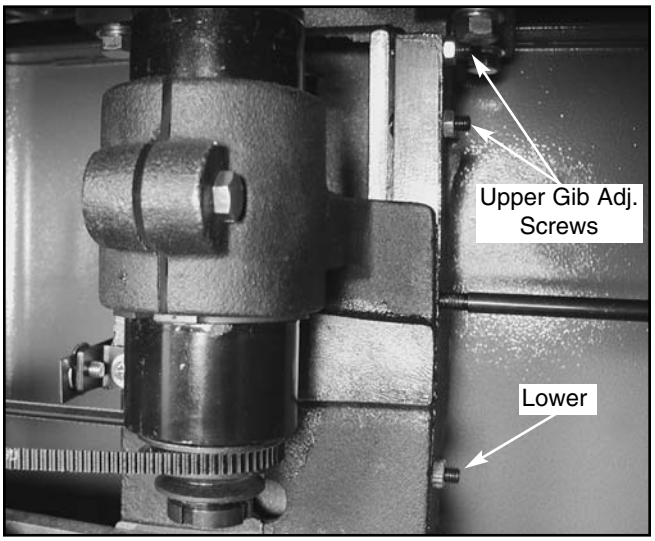


Figure 15. Gib adjustment screws.

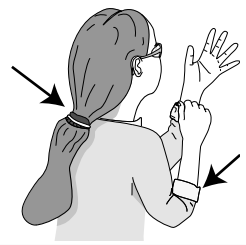
2. Loosen the four 12mm locknuts and remove the slack between the elevation housing and spindle cartridge slide by tightening the four 5/16" setscrews with a 4mm Allen® wrench. Alternate between the upper and lower adjustments to ensure consistent tightness. Failure to do so may cause disappointing results. DO NOT over-tighten the gib. Over-tightening will restrict spindle movement. Loosen the spindle assembly lock knob and raise or lower the spindle to check for free movement.

3. Since there is an unbalanced weight distribution on the cartridge slide, you may have to perform a number of adjustments before you find the ideal location. Don't get discouraged; it may take a few tries to get it right.

NOTICE

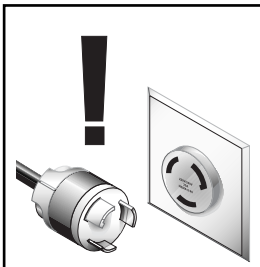
The lock knob keeps the spindle in a fixed position during shaper operation. Do not over-tighten the lock knob. A snug fit is all that's needed to keep the spindle from moving during shaper use.

SECTION 6: OPERATIONS



⚠WARNING

Keep clothing rolled up and out of the way of machinery and keep hair pulled back.

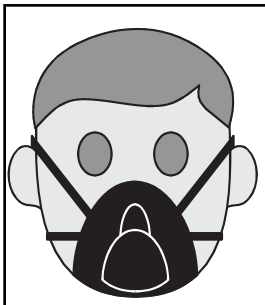


⚠WARNING

Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during the entire operation process. Failure to comply may result in serious personal injury.



⚠CAUTION

Always wear a dust mask when operating the shaper. Using this machine produces sawdust which may cause allergic reactions or respiratory problems.

NOTICE

The following section was designed to give instructions on the basic operations of this shaper. However, it is in no way comprehensive of every shaper application. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your shaper. There are many different jigs not mentioned in this manual that can be built to increase safety and accuracy for specialized cuts.

Test Run

Once assembly is complete and adjustments are done to your satisfaction, you are ready to test the machine.

Turn on the power supply at the main panel. Press the START button. Make sure that your finger is poised on the STOP button, just in case there's a problem. The shaper should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further.

If the shaper seems to be running correctly, check the directional switch. The spindle should be rotating in a counterclockwise direction when the switch is in the FORWARD position. Run the Model G1026 for a short time to ensure that the moving parts are working properly with no excessive vibration. If any problem develops, correct them before attempting to use the machine.

If you cannot locate the source of unusual noises, contact our service department for help.

Cutter Installation

Your shaper operates at speeds of 7,000 and 10,000 R.P.M. Cutters 3½" or larger must be operated at the slower speed. Always use the largest spindle size possible, and never use a cutter more than one size smaller than the spindle size.

To install a cutter:

1. Place an appropriate spacer or collar at the base of the spindle to support the shaper cutter.

2. Place the cutter on the spindle. Make sure the rotation is correct for your application.

3. Use spacers or collars to suit your particular application.

4. Place the spindle washer under the nut. Screw on the nut and locknut.

5. Tighten the nuts while holding the spindle as shown in **Figure 16**. Tighten the lower nut against the cutter, then tighten the upper lock nut against the lower nut.

Figure 16. Tightening spindle nuts.

Rotation

Your shaper is equipped with a FORWARD/REVERSE switch. **See Figure 17.** In many instances, it will be necessary to flip the cutter over and reverse cutter rotation. Whenever possible, mount the cutter so the board is milled on the bottom side. This does a better job and is safer for the operator.

⚠CAUTION

Always check the direction of cutter rotation before any shaping operation. Cutters rotating backwards will cause unsafe conditions.

Figure 17. Forward/reverse switch.

Spindle Height

To adjust the cutter height:

1. Loosen the spindle lock. **See Figure 18.**

2. Move the spindle up or down until the desired position is obtained.

3. Lock the spindle into position.

Figure 18. Location of spindle lock.

Straight Shaping

The fence assembly is a two-piece, independently adjustable system. When removing material from the whole face of your workpiece, the outfeed fence can be adjusted to provide support for the workpiece as it passes over the cutter, or it can be set up for partial face removal.

⚠WARNING

This section requires you to run the shaper to make several test pieces. Read through the entire manual before attempting to make cuts using your shaper. Always turn off the shaper and disconnect the power before making adjustments. Use a hold-down or other safety device whenever you run the shaper or serious personal injury will occur.

If removing material from the whole face, observe the following steps:

1. Loosen the locking handles that hold the fences in place. **See Figure 19.**

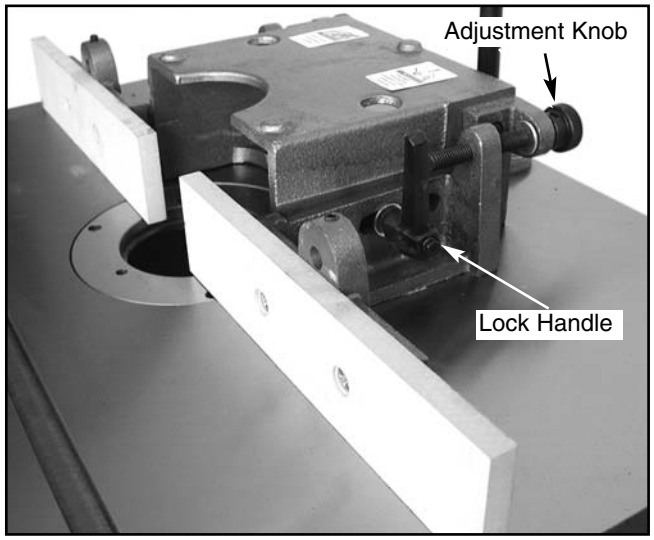


Figure 19. Location of fence locking handles. (Safety Guard removed for clarity.)

2. Adjust the infeed fence by turning the knurled adjustment knobs until the workpiece contacts the cutter in the desired location.

3. Use a test piece at least 24" long to determine the best setting.

4. Lock the infeed fence in position with the locking handle.

5. Advance a test sample of the desired cut about 8", then stop.

6. When the shaper is turned off and the cutter has come to a complete stop, adjust the outfeed fence to support the new profiled edge. **See Figure 20.**

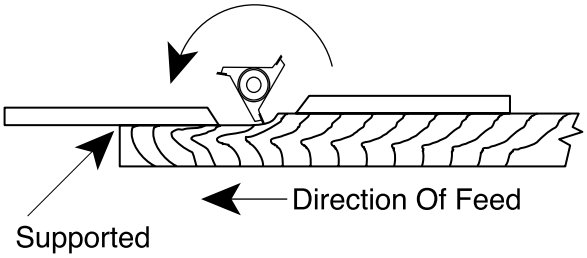


Figure 20. Fence adjusted to support workpiece.

⚠CAUTION

The miter gauge should not be used to feed material along the fence face when straight shaping. Use a push stick and hold downs to keep the workpiece in position. The fence may not always be perfectly parallel to the miter slot; therefore, using the miter gauge can cause binding and possible kickback of the workpiece towards the operator. If this happens, serious personal injury may occur.

If the face of the workpiece will only be partially removed, observe the following steps:

1. Adjust the infeed fence approximately to the the desired depth of cut. Lock the infeed fence in place.

2. Use a straightedge to adjust the outfeed fence to the same plane as the infeed fence. Lock the outfeed fence in place.

3. Set the right and left wood faces so they barely clear the cutter. This allows the maximum support possible for the workpiece when passing the cutter. Remember to tighten the wood facing before starting the shaper.

4. Run a test piece through the shaper. **See Figure 21.**

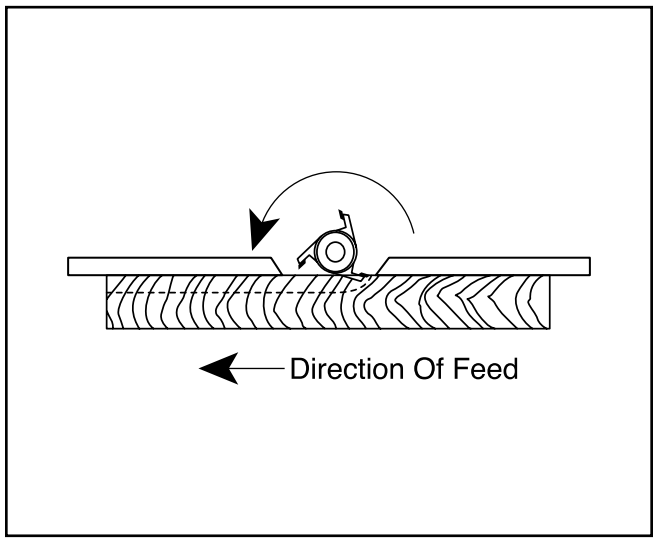


Figure 21. Fence adjustment for blind cuts.

5. Always cut the end grain first when putting an edge around the perimeter of your workpiece. **See Figure 22.**

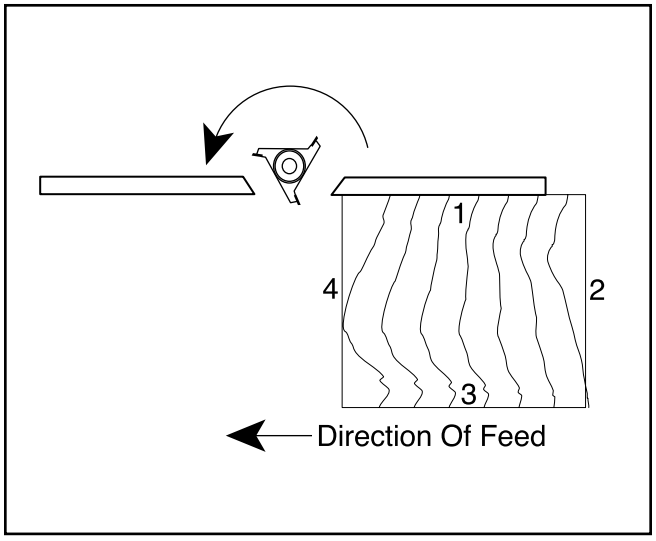


Figure 22. Fence adjustment for multiple cuts.

⚠WARNING

The sound of this machine when it is running may be less than that of other devices such as a dust collector which may be running at the same time. Because of this, it may be difficult to determine if the machine is ON merely by listening. It is necessary to make certain that this machine is OFF and unplugged before attempting any setup or adjustments. If this warning is ignored, serious personal injury will occur.

Shaping Small Stock

Shaping small stock is inherently dangerous on a shaper. Consider making a zero-clearance fence to increase your safety. A zero-clearance fence will provide more support that the standard fence and reduce tearout on narrow or fragile stock.

To make a zero-clearance fence:

1. Fasten a ⅝" piece of plywood to both ends of the split fence. This can be done using screws or less permanently with clamps (as long as they are positioned out of the way and are secure).

2. Turn on the shaper and carefully move the the plywood into the cutterhead by moving both sides of the fence. Only remove enough of the plywood to expose the cutterhead to where it will be needed for the cut.

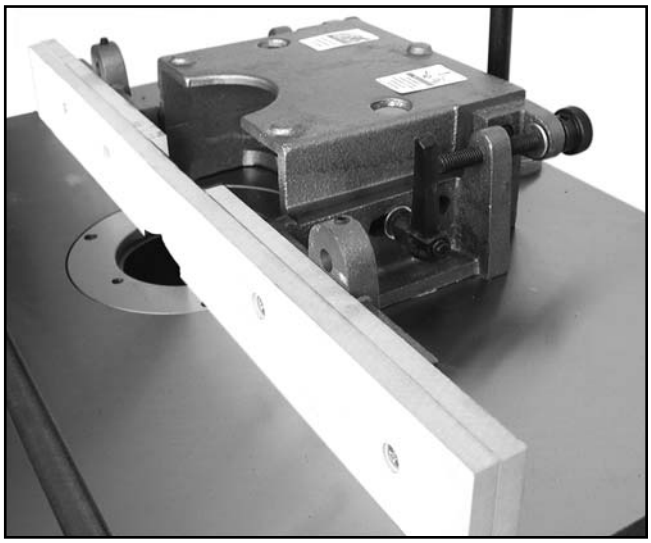


Figure 23. Example of a zero clearance fence.

⚠CAUTION

Always use a jig when when shaping small or narrow stock. Jigs will keep your hands away from the spinning cutterhead and support the stock sufficiently to allow a safe and effective cut. Failure to follow this warning may lead to injury.

Rub Collars

Rub collars are used when shaping curved or irregular workpieces, such as arched doors or round table tops, and to limit the depth of your cut.

There are two types of rub collars: solid and ball-bearing. We recommend against the use of solid rub collars. Grizzly carries an extensive line of ball bearing rub collars designed for use with Grizzly shapers. See the current catalog for listings.

Rub collars may be used in any of the following positions:

1. **Rub collar above the cutter (preferred):** When the rub collar is used above the cutter, the cut cannot be seen. **See Figure 24.** This offers some advantage: the stock is not affected by slight variations in thickness and accidental lifting will not damage the workpiece. If lifting occurs, simply correct the mistake by repeating the operation.

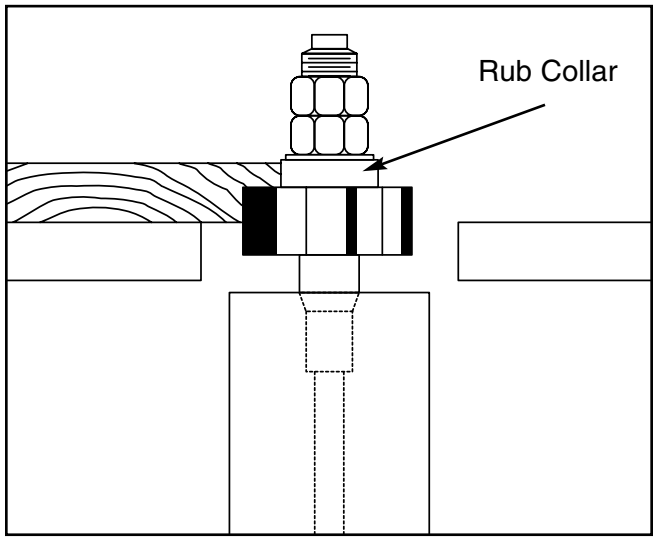


Figure 24. Rub collar installed above cutter.

2. **Rub collar below the cutter:** When the rub collar is used below the cutter (**See Figure 25**), the progress of the cut can be observed. However, any unintentional movement may lift the workpiece into the cutter, damaging your work and creating a dangerous situation. **We DO NOT recommend this setup.**

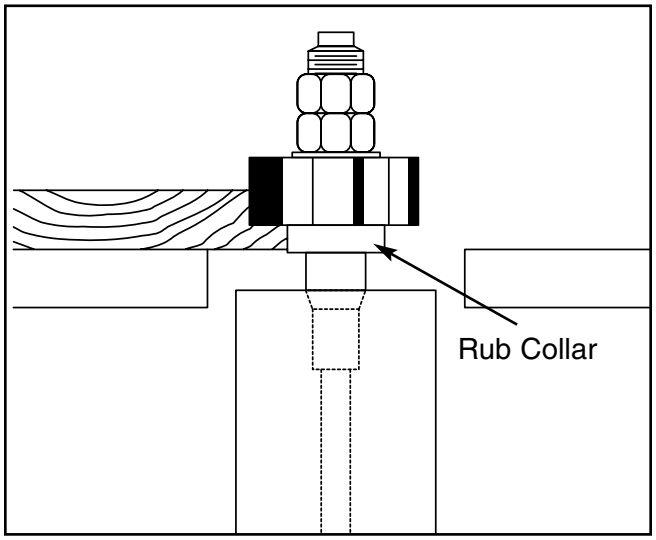


Figure 25. Rub collar installed below cutter.

3. **Rub collar between two cutters:** Using a rub collar between two cutters has the distinct advantage of performing two cuts at once or eliminating the need to change cutters for two different operations. **See Figure 26.** Notice that part of the edge is left uncut. The uncut portion rides on the rub collar.

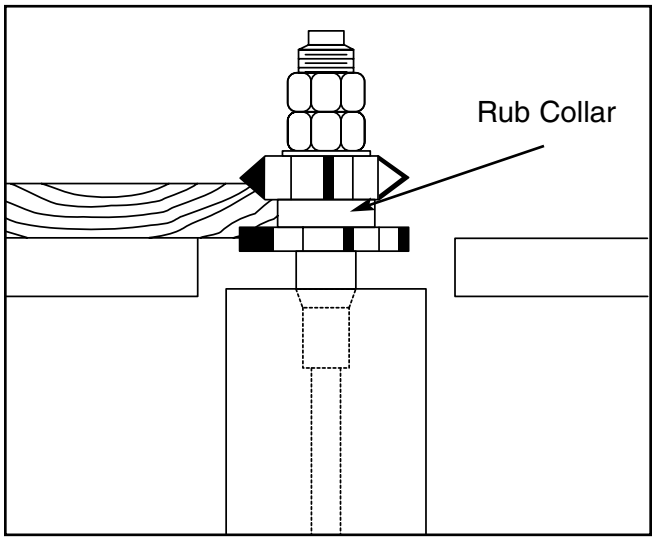


Figure 26. Rub collar between two cutters.

⚠CAUTION

Freehand shaping is one of the most dangerous operations on the shaper. Guards should be in place. Hands can be exposed to cutters if care is not used. Serious injury to hands and other body parts is possible.

Irregular Shaping

Irregular or freehand shaping takes a high degree of skill and dexterity. The fence assembly is not used in irregular shaping, so rub collars must be used. See the rub collar section for details.

When doing freehand work, a starting pin must be used. The purpose of the starting pin is to support the workpiece during the beginning of the cut. Your shaper is supplied with a starting pin which is placed in one of the holes located in the shaper table.

The work should be placed in the starting position using the starting pin for support as shown in **Figure 27.** Next, swing the work into the cutter while holding the workpiece firmly against the starting pin.

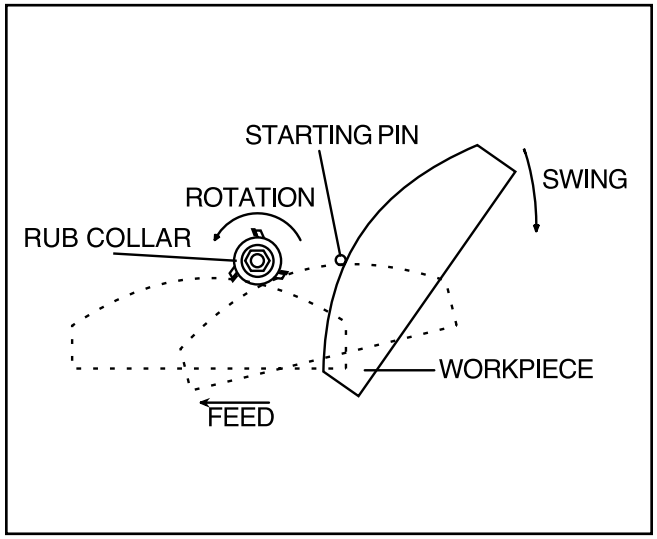


Figure 27. Suggested freehand operation (the guard has been removed in this picture for visual clarity – always use the guard during operation).

After the cut has been started, the work is swung away from the starting pin and is supported just by the rub collar as you hold it. This is shown by the broken line positions in **Figure 27.**

ALWAYS FEED AGAINST THE ROTATION OF THE CUTTER.

For irregular shaping:

1. Unplug shaper and remove the fence assembly.

2. Choose the appropriate cutter for your application and lock it in place with a rub collar.

3. Check cutter rotation.

4. Adjust the spindle height to align your workpiece to the cutter. Check that the rub collar will contact the workpiece edge or pattern edge (if used).

5. Insert a starting pin into the cast iron table insert, using one of the pin locations that best supports your work.

6. Use some type of hold-down fixture and guard when doing irregular work. **Figure 28** shows the Grizzly Model G3642 Shop Fox® Right Angle Jig. This is just one example. A good shaper book will provide many different ideas for making jigs for almost all shaping operations.

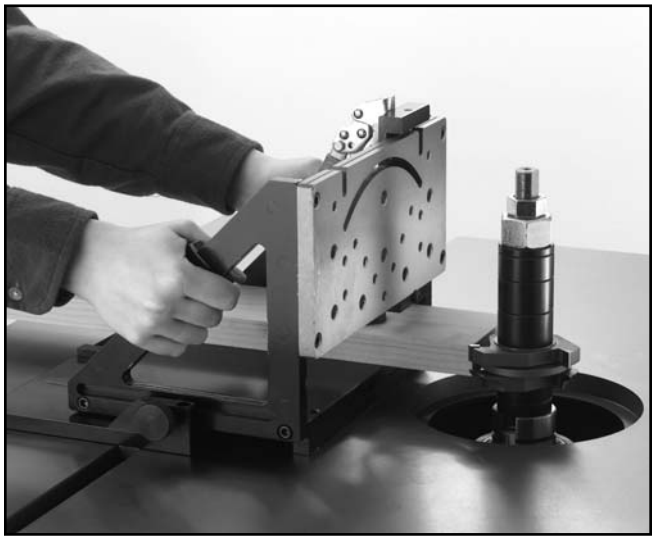


Figure 28. Using safety fixtures while shaping (guard removed for clarity).

7. Make a sample cut on a piece of scrap wood.

8. If everything is correct, feed your workpiece along the cutter, using firm pressure to keep your work against the rub collar. Feed against the cutter rotation only.

Sometimes the starting pin will not be in the most advantageous position. Firmly clamp a board in the desired position to act as a starting pin. See **Figure 29**. Some type of pivot point **must be** used. Notice in **Figure 28 & 29** the operator is not exposed to the cutting edge of the cutter.

The jig in **Figure 29** is designed to keep hands away from the blade by securing the workpiece to the bottom, while providing the operator a firm grip. This is just one example. For more complete information on the many jigs and fences that can be made to enhance the shaper, seek out training, books, or magazines that specialize in shapers. We cannot stress this enough—your safety is important!

Figure 29. Using board as starting pin.

⚠CAUTION

Incorrectly feeding stock (feeding with the rotation of the cutter) creates a potentially uncontrollable feed situation that can pull your hands into the spinning cutter or yank stock from your hands. Follow the above instruction at all times or serious personal injury can occur.

Pattern Work

When using a pattern, the rub collar can be positioned either above or in-between cutters. We do not recommend using the rub collar below the cutters. This exposes the cutterhead to the same surface level where your hands will pass, potentially causing a serious injury.

The pattern is usually used when the entire edge is to be shaped or when many duplicate pieces are needed. Pattern work is particularly useful when rough cutting irregular shapes oversize and then shaping the edge in a simple two-step operation. A pattern can be incorporated into a fixture by way of adding toggle clamps, hand holds, or other safety devices.

You have greater flexibility when choosing the correct diameter rub collar for pattern work than for non-pattern work. If you look at **Figure 30,** you'll notice that the position of the pattern determines the depth of cut. In other words, your pattern size is dependent upon the inter-relationship of cutting circle, the desired amount of material removed and the rub collar size. The cutting circle is the given in the equation, while the pattern and the rub collar size are the variables. Changing one or both of these will change the amount of material removed. You can decide which rub collars are best suited for your application by planning ahead.

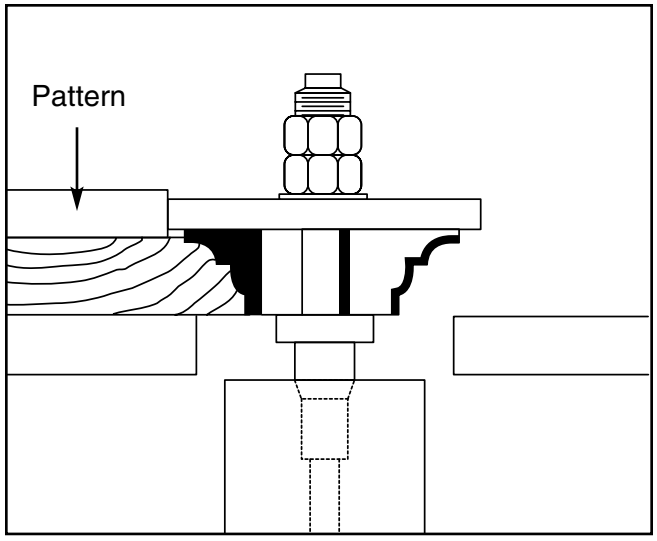


Figure 30. Rub collar determines depth of cut.

When making a pattern, jig, or fixture, here are a few things to consider:

1. Use a material that will smoothly follow the rub collar or fence.
2. Make the fixture stable. Use proven methods and materials.
3. Fasten hand holds for operator comfort and safety.
4. Secure your workpiece on three sides with toggle clamps or fasten the workpiece to the fixture with wood screws. Make sure they do not protrude through the workpiece.
5. Ensure that clamps and hidden screws do not come into contact with the cutter.
6. Design your fixture so that all cutting occurs underneath the workpiece.
7. Always consider cutting circle and rub collar diameter for correct depth of cut when designing your pattern.
8. Make sure the workpiece rests flat on the table, not on the fixture.
9. Remember, there is tremendous cutting force on the workpiece. Fixtures must be solid, stable and the workpiece must be firmly secured.

⚠CAUTION

Use care in designing and making fixtures. Clamps and screws must not touch the cutter and the fixtures must be stable in use, with the workpiece resting on the shaper table, not on the fixture. The workpiece must be fixed securely to the fixture.

SECTION 7: MAINTENANCE

⚠WARNING
Wear safety glasses during the entire maintenance process. Failure to comply may result in serious personal injury.

General

Regular periodic maintenance on your Model G1026 Shaper will ensure its optimum performance. Make a habit of inspecting your shaper each time you use it. Check for the following conditions and repair or replace when necessary.

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Damaged V-belt.
5. Any other condition that could hamper the safe operation of this machine.

Lubrication

The only parts on this machine that require periodic lubrication are the ways where the cartridge slide rides on the elevation housing and where the worm gear and bushing are located. Use a light grease or anti-seizing compound on the ways and worm gear and give the shaft mount a shot of light oil. The frequency of lubrication depends on the amount you use the shaper. As a habit, inspect the machine at least once a month.

Table

The table and other non-painted surfaces on the Model G1026 should be protected against rust and pitting. Wiping the table clean after every use ensures that wood dust isn't allowed to trap moisture against bare metal surfaces.

Tables can be kept rust-free with regular applications of products like Boeshield® T-9. For long term storage you may want to consider products like Kleen Bore's Rust Guardit™.

V-Belt

Avoid getting grease or oil on the V-belt or pulleys.

Check the V-belt, as part of your monthly inspection, for proper tension and belt condition. Cracking and glazing could result in belt failure. Replace the belt if such conditions appear.

Spindle Bearings

The spindle bearing housing equipped with the Model G1026 features factory-sealed bearings. A sealed bearing requires no lubrication during its lifetime.

Should a bearing fail, your shaper will probably develop a noticeable rumble that will increase when the machine is put under load. If allowed to get worse, overheating of the journal containing the bad bearing could occur. If the bad bearing is not replaced, it will eventually seize—doing damage to other parts of the machine. Bearings are standard sizes and can be replaced through Grizzly.

You must remove the complete bearing housing assembly to replace the bearings. To remove the bearing housing assembly:

1. Remove the V-belt.

2. Loosen the locking bolt on the spindle slide shown in **Figure 31.**

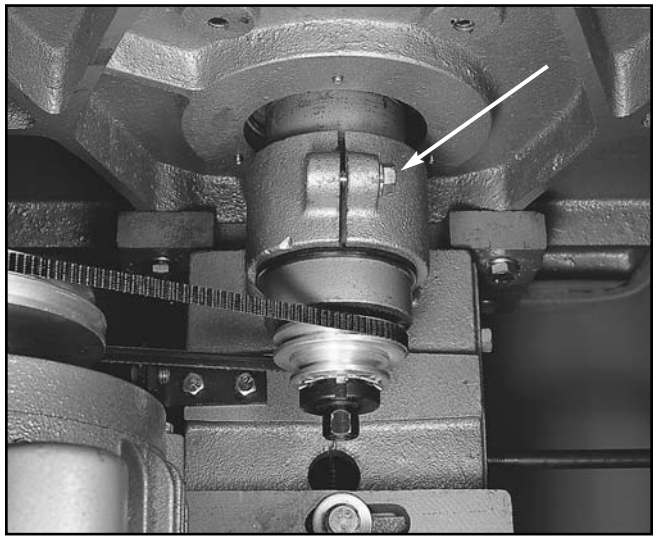


Figure 31. Locking bolt on spindle slide.

3. The bearing housing will drop down. If you need to spread the casting more, use a screwdriver.

⚠CAUTION

Use care when spreading the casting—it will break if too much pressure is applied. When the casting is spread, the housing can fall down. Watch your fingers to avoid being pinched. Place a pad underneath to protect the housing from being damaged if it falls.

4. Remove the spindle and replace the bearings inside the bearing housing. If you need pointers regarding bearing replacement, call our service department.

5. To slide the housing back in, reverse the procedure. Make sure the locking bolt is tightened securely.

Maintenance Notes

Date	Approximate Hours Of Use	Maintenance Performed

SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your Model G1026 3 H.P. Wood Shaper.

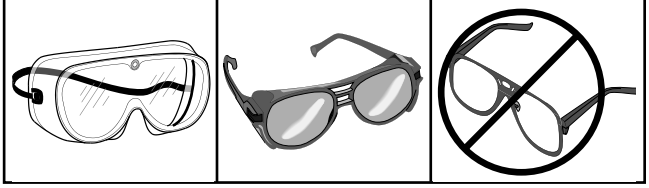
If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in **Section 3: Introduction**. The specifications, drawings, and photographs illustrated in this manual represent the Model G1026 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered as they apply to your specific situation.

⚠WARNING

Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).



We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department listed in **Section 3: Introduction**.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.

⚠WARNING

The Model G1026 was specifically designed for wood shaping operations only. DO NOT MODIFY AND/OR USE THIS MACHINE FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, DO NOT use it until all your questions have been answered. If you DO, serious personal injury may occur.

⚠WARNING

Like all power tools, there is danger associated with the Model G1026 Wood Shaper. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility 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

GRIZZLY MODEL G1026 3 H.P. SHAPER

Design Type ..... Floor Model

Overall Dimensions:

Table ..... 21¾" x 28¼"
Table with Extension Wing ..... 30½" x 28¼"
Height (Includes Fence) ..... 39½"
Height From Table To Floor ..... 34"
Length ..... 30½"
Width ..... 28¼"
Weight (Shipping) ..... 353 lbs.
Weight (in place) ..... 345 lbs.
Box Size ..... 32" L x 25" W x 43" H
Footprint ..... 21" x 20"

Capacities:

Spindle Sizes ..... ½", ¾", 1"
Spindle Lengths ..... ½" - 2¾"; ¾" - 3½"; 1"- 3"
Spindle Capacity Under Nut ..... ½" - 2", ¾" - 2½", 1" - 2¼"
Spindle Travel ..... 3"
Spindle Openings ..... 1⅜", 2¾", 4" and 5½"
Table Counter-bore ..... 7" Diameter x ⅝" Deep
Max. Cutter Diameter ..... 5½"
Spindle Speeds ..... 7,000 & 10,000 R.P.M.
Spindle Bearings ..... Shielded & Lubricated Ball Bearings

Construction:

Table ..... Surface Ground Cast Iron
Fence Assembly ..... Surface Ground Cast Iron
Body Assembly ..... Cast Iron
Base ..... Pre-formed Steel
Wing ..... Surface Ground Cast Iron

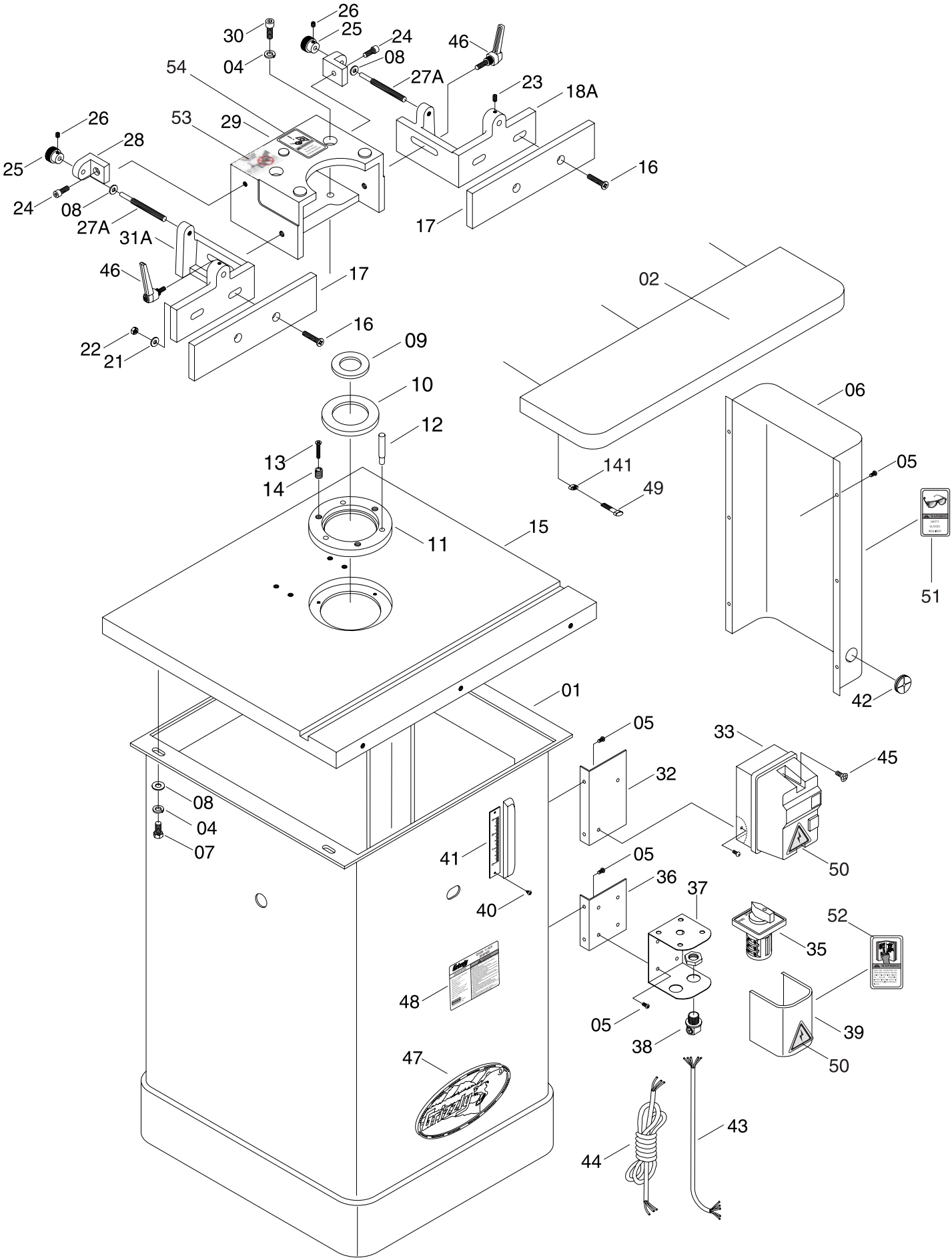
Motor:

Type ..... TEFC Capacitor-Start Induction
Horsepower ..... 3 H.P.
Phase / Voltage ..... Single Phase / 220V
Amps 18
Cycle / R.P.M. ..... 60 Hertz / 3450 R.P.M.
Bearings ..... Shielded & Lubricated Ball Bearings
Switch ..... Magnetic w/ Thermal Overload Protector

Features:

..... Independently Adjustable Split Fence
..... Magnetic w/ Thermal Overload Protector
..... Starting Pins
..... Hold Downs
..... Guard
..... Vertical Spindle Lock
..... Standard Miter Gauge

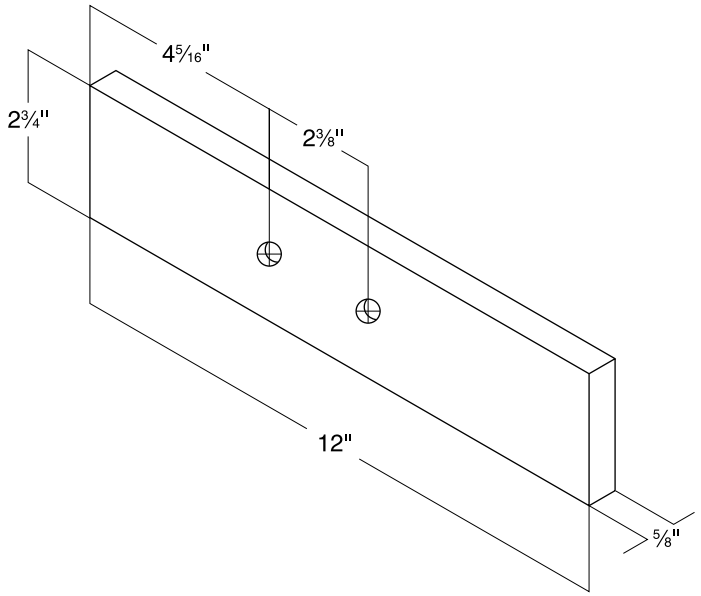
Specifications, while deemed accurate, are not guaranteed.

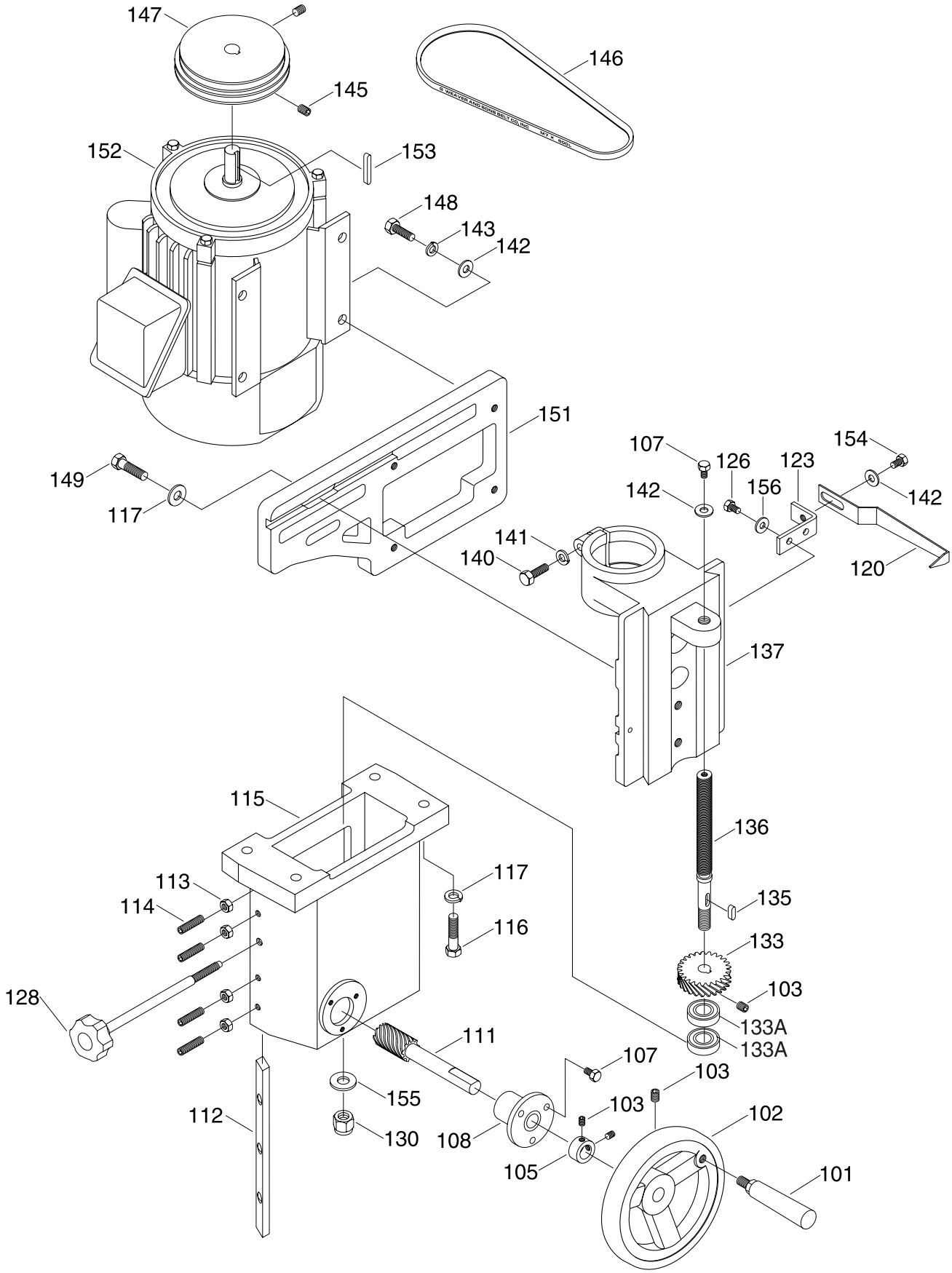

26
30
25
24
46
54
04
08
27A
23
18A
53
29
26
28
25
16
24
08
27A
31A
17
46
17
16
22
21
09
10
12
13
14
15
11
02
06
141
49
05
51
42
01
05
33
45
32
08
04
07
41
40
05
36
37
52
35
48
05
38
39
50
47
43
44
50

REF	PART #	DESCRIPTION
001	P1026001	STAND BODY
002	P1026002	EXTENSION WING
003	PB18	HEX BOLT 3/8"-16 x 1 1/4"
004	PLW04	LOCK WASHER 3/8"
005	PS07	PHLP HD SCR 1/4"-20 x 3/8"
006	P1026006	COVER
007	PB21	HEX BOLT 3/8"-16 x 3/4"
008	PW02	FLAT WASHER 3/8"
009	P1026009	TABLE INSERT
010	P1026010	TABLE INSERT
011	P1026011	TABLE INSERT
012	P1035012	STARTING PIN
013	PFH02	FLAT HD SCREW 10-24 x 1"
014	1035010	BARREL SCREW
015	P1026015	TABLE
016	PFH07	FLAT HD SCREW 5/16"-18 x 1 1/2"
018A	P1026018A	FENCE MOUNT RIGHT
021	PW07	FLAT WASHER 5/16"
022	PN02	HEX NUT 5/16"-18
023	PSS07	SETSCREW 1/4"-20 x 1/2"
024	PSB16	CAP SCREW 3/8"-16 x 3/4"
025	P1026025	HAND KNOB 3/8"
026	PSS17	SETSCREW 5/16"-18 x 5/16"
027A	P1026027A	FENCE ADJ SCREW
028	P1026028	ADJ SCREW BRACKET

REF	PART #	DESCRIPTION
029	P1026029	MAIN FENCE HOUSING
030	PSB14	CAP SCREW 3/8"-16 x 1"
031A	P1026031A	FENCE MOUNT LEFT
032	P1026032	SWITCH MOUNT BRACKET
033	PSW01	3 H.P. MAGNETIC SWITCH
035	PSW03	FWD/REV SWITCH
036	P1035034	BRACKET
037	P1035031	SWITCH BOX
038	P1071075	STRAIN RELIEF
039	P1035033	SWITCH BOX COVER
040	PHTEK1	SELF-TAPPING SCREW
041	P1026041	SCALE
042	P1026042	GROMMET
043	P1026043	MOTOR CORD
044	P1026044	POWER CORD
045	PSW01-1	REPLACEMENT SCREW
046	P1026046	LOCK HANDLE
047	G8588	GRIZZLY NAMEPLATE
048	P1026048	ID/WARNING LABEL
049	PB16	HEX BOLT 3/8"-16 X 1 1/4"
050	P1026050	ELECTRICITY LABEL
051	P1026051	SAFETY GLASSES LABEL
052	P1026052	READ MANUAL LABEL
053	P1026053	HAND/CUTTER LABEL
054	P1026054	UNPLUG MACHINE LABEL

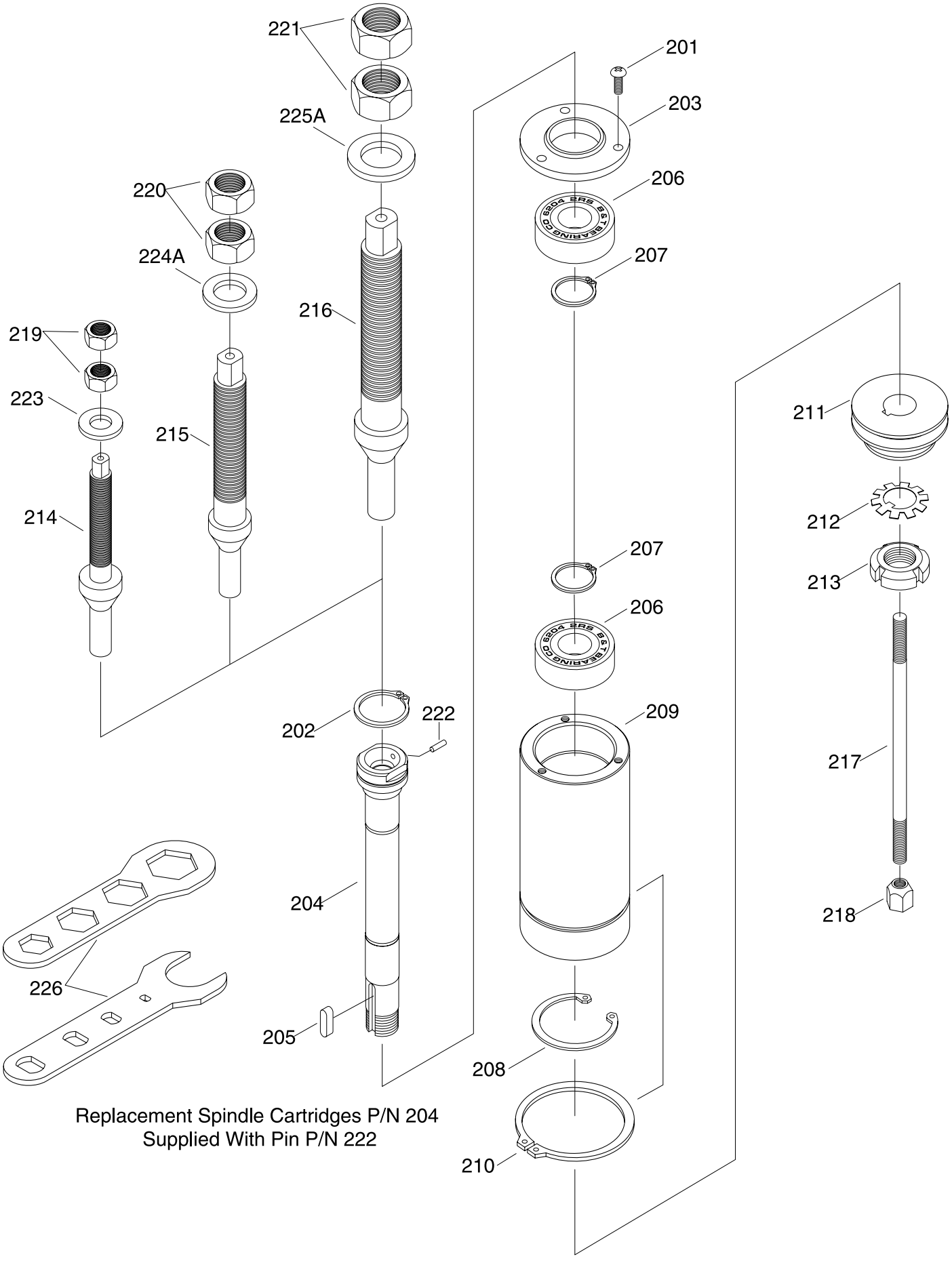
We regret to inform you that the wood facing for the G1026 Shaper fences are no longer available as a replacement part. For your convenience we have included a measured drawing so you may construct you own. We apologize for any inconvenience this may cause you.




147
145
146
152
153
148
143
142
151
149
117
107
126
123
154
142
156
142
141
140
120
137
115
136
113
114
117
135
116
133
128
103
133A
133A
111
107
103
155
103
112
130
108
102
105
101

REF	PART #	DESCRIPTION
101	P1026101	HANDLE
102	P1026102	HANDWHEEL
103	PSS17	SETSCREW 5/16"-18 x 5/16"
105	P1026105	SLEEVE
107	PB07	HEX BOLT 5/16"-18 x 3/4"
108	P1026108	SHAFT MOUNT
111	P1026111	WORM SHAFT
112	P1026112	GIB
113	PN02	HEX NUT 5/16"-18
114	PSS14	SETSCREW 5/16"-18 x 1 3/8"
115	P1026115	ELEVATION HOUSING
116	PB56	HEX BOLT 1/2"-13 x 1 3/4"
117	PW01	FLAT WASHER 1/2"
120	P1026120	POINTER
123	P1026123	POINTER MOUNT
126	PB19	HEX BOLT 1/4"-20 x 1/2"
128	P1026128	LOCK KNOB
130	PLN07	LOCK NUT 5/8"-11
133	P1026133	GEAR

REF	PART #	DESCRIPTION
133A	P1026133A	THRUST BEARING 51103
135	PK14M	KEY 5 x 5 x 18
136	P1026136	ELEVATION LEAD SCREW
139	PRP24M	ROLL PIN 5 x 16
140	PB16	HEX BOLT 1/2"-13 x 1 3/8"
141	PLW04	LOCK WASHER 3/8"
142	PW07	FLAT WASHER 5/16"
143	PLW01	LOCK WASHER 5/16"
145	PSS23	SETSCREW 5/16"-24 x 5/8"
146	P1026146	V-BELT M7 x 690
147	P1026147	MOTOR PULLEY
148	PB03	HEX BOLT 5/16"-18 x 1"
149	PB56	HEX BOLT 1/2"-13 x 1 3/4"
151	P1026151	MOTOR MOUNT PLATE
152	P1026152	3H.P. MOTOR
153	PK15M	KEY 5 x 5 x 35
154	PB09	HEX BOLT 5/16"-18 x 1/2"
155	PW14	FLAT WASHER 5/8"
156	PW06	FLAT WASHER 1/4"



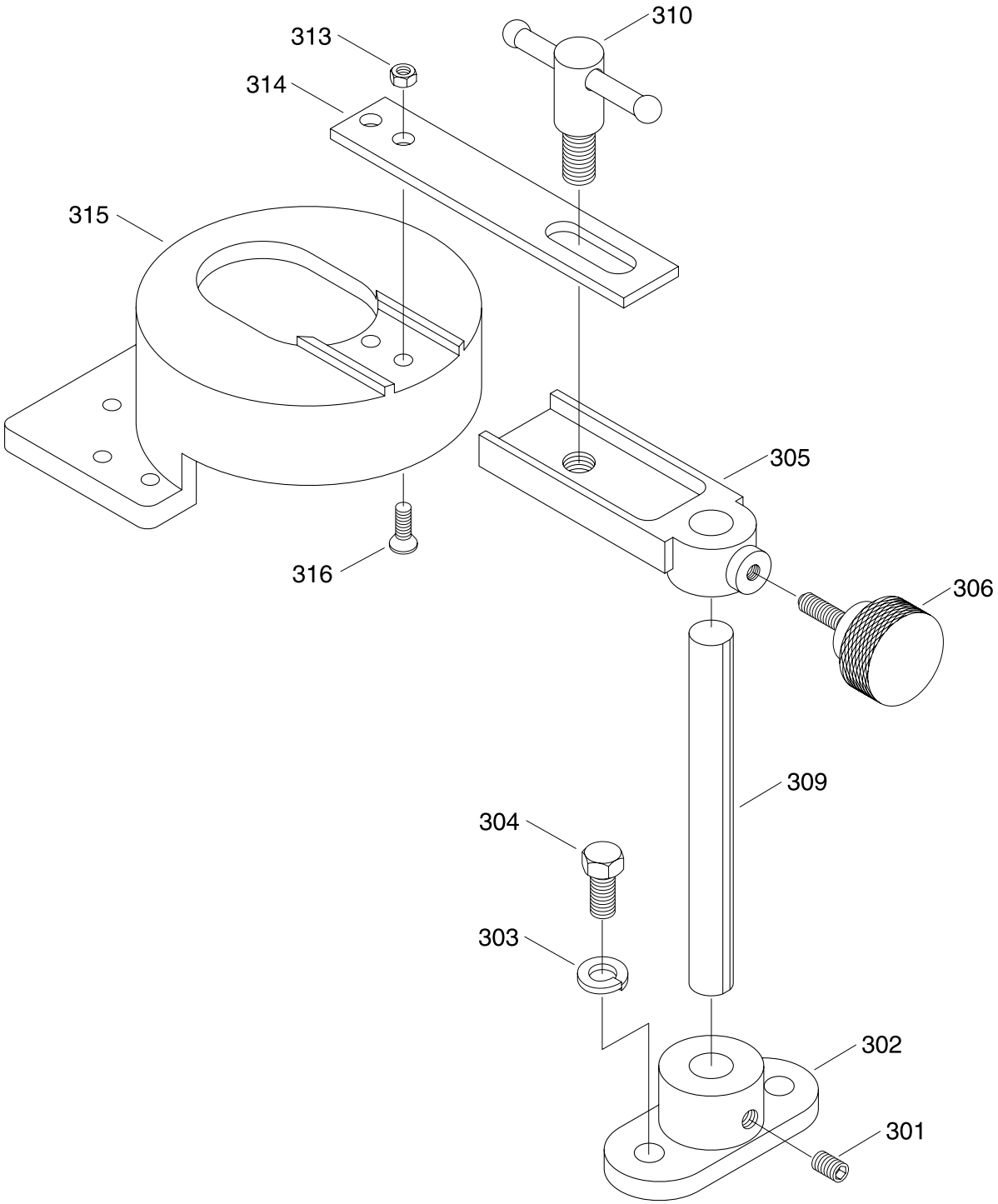
Replacement Spindle Cartridges P/N 204
Supplied With Pin P/N 222

REF	PART #	DESCRIPTION
201	PS01	PHILLIPS® HD SCR 10-24 x ½"
202	PR12M	SNAP RING 35MM
203	P1026203	FLANGE
204	P1026204	SPINDLE CARTRIDGE
205	PK20M	KEY 5 x 5 x 15
206	P6205	BEARING
207	PR11M	SNAP RING 25MM
209	P1026209	HOUSING
210	PR14M	SNAP RING 70MM
211	P1026211	PULLEY
212	P1035218	TOOTHED WASHER
213	P1025219	SPANNER NUT
214	P1026214	½" SPINDLE

REF	PART #	DESCRIPTION
215	P1026215	¾" SPINDLE
216	P1026216	1" SPINDLE
217	P1026217	DRAW BAR
218	P1026218	DRAW NUT
219	P1035201C	½" SPINDLE NUT
220	P1026220D	¾" SPINDLE NUT
221	P1026221	1" SPINDLE NUT
222	P1026222	PIN
223	P1026223	½" SPINDLE WASHER
224A	P1026224A	¾" SPINDLE WASHER
225A	P1026225A	1" SPINDLE WASHER
226	P1026219	SPINDLE WRENCH SET

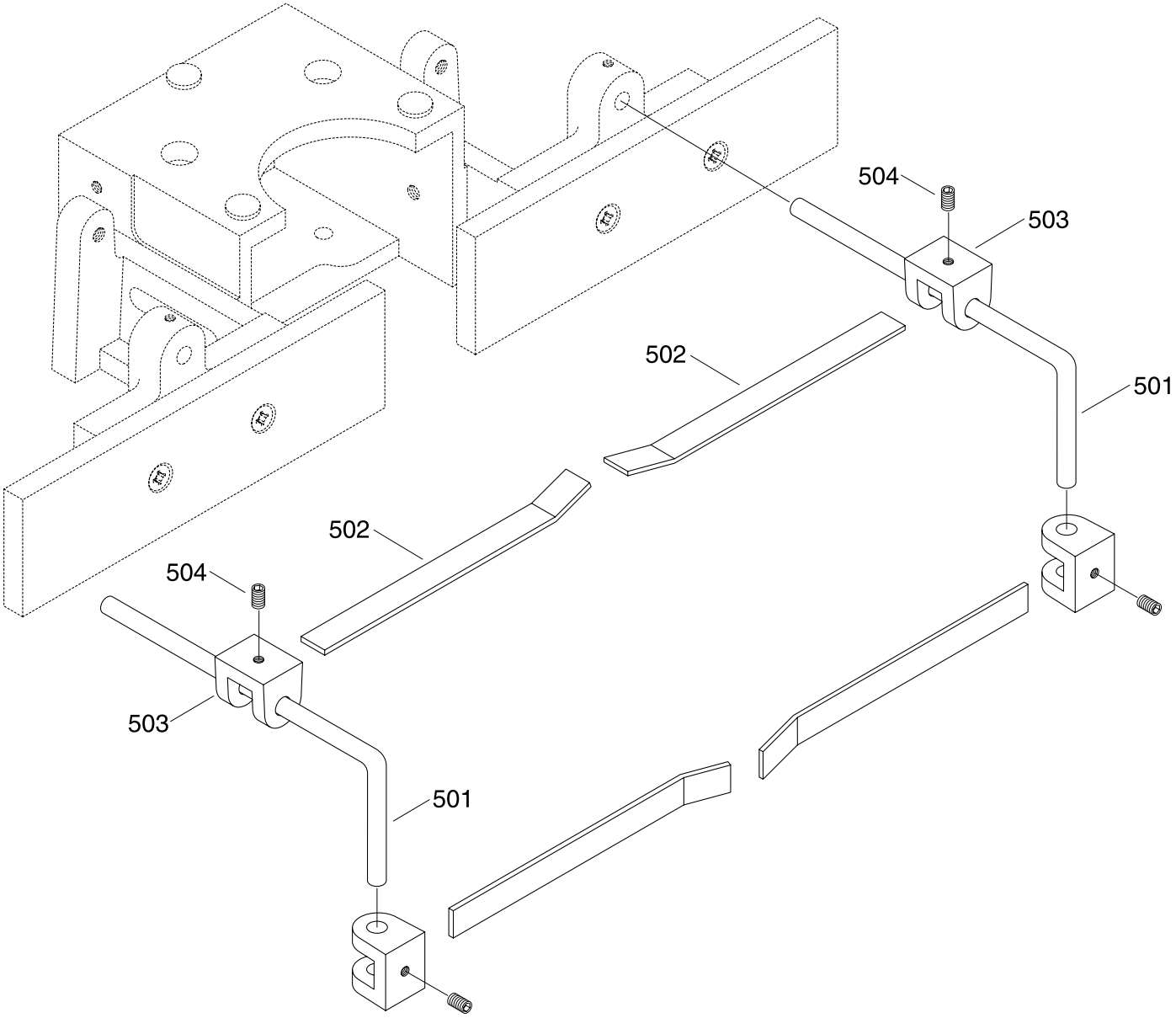
SPACERS

Bore	Diameter	Height	Replacement Part #
½"	1"	¼"	G2454
½"	1"	⅜"	G2455
½"	1"	½"	G2456
½"	1"	¾"	G2457
¾"	1¼"	¼"	G2460
¾"	1¼"	⅜"	G2461
¾"	1¼"	½"	G2462
¾"	1¼"	¾"	G2463
1"	1½"	¼"	G2466
1"	1½"	⅜"	G2467
1"	1½"	½"	G2468
1"	1½"	¾"	G2469
1"	1½"	1"	G2470
1¼"	1¾"	¼"	G2472
1¼"	1¾"	⅜"	G2473
1¼"	1¾"	½"	G2474
1¼"	1¾"	¾"	G2475
1¼"	1¾"	1"	G2476

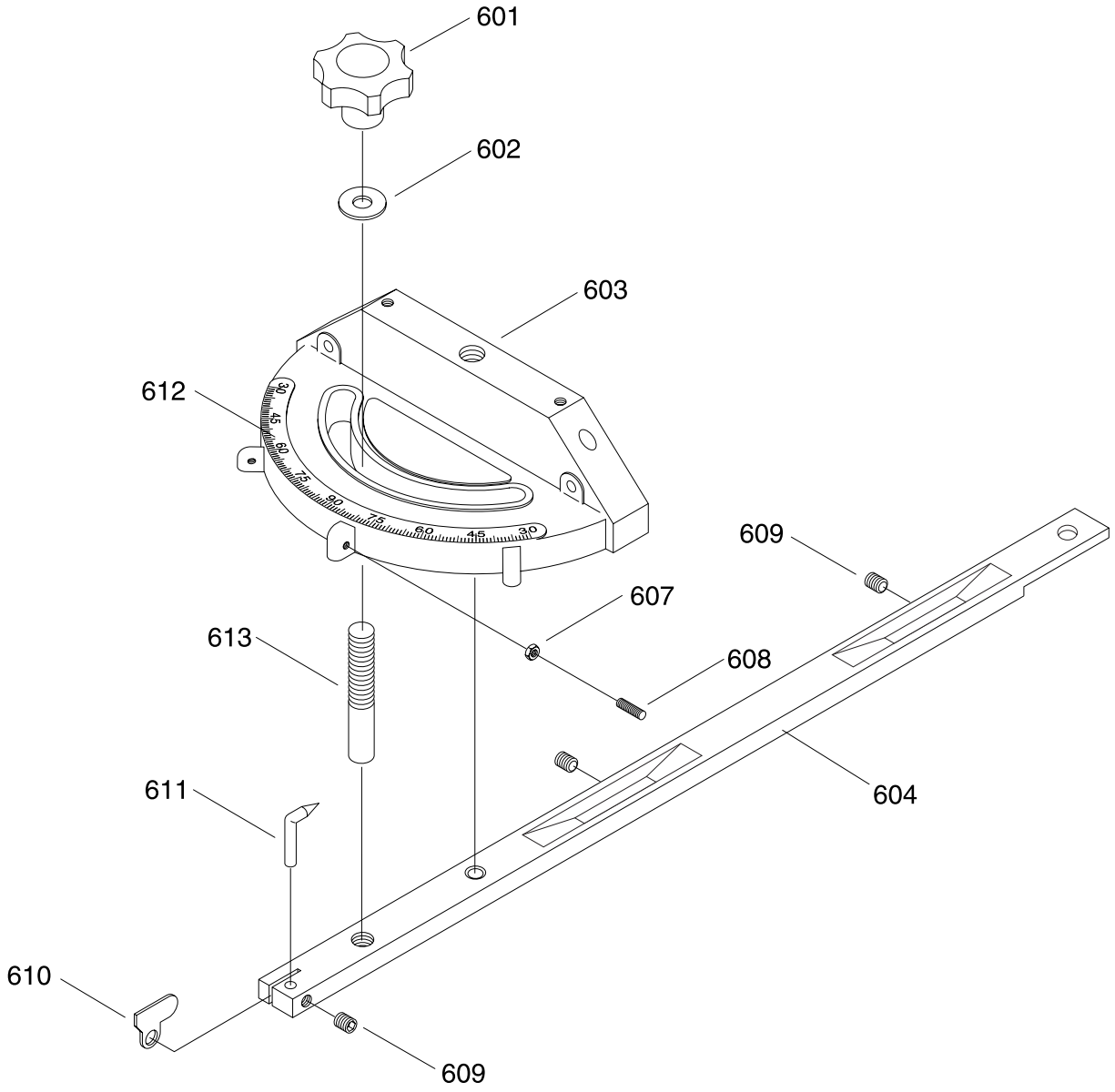


REF	PART #	DESCRIPTION
301	PSS02	SETSCREW 5/16"-18 x 3/8"
302	P1026302	SHAFT MOUNT
303	PW02	FLAT WASHER 3/8"
304	PB21	HEX BOLT 3/8"-16 x 3/4"
305	P1026305	EXTENSION BRACKET
306	P1026306	LOCK KNOB

REF	PART #	DESCRIPTION
309	P1026309	SHAFT
310	P1026310	LOCK HANDLE
313	PN02	HEX NUT 5/16"-18
314	P1026314	GUARD EXTENSION
315	P1026315	GUARD
316	PFH14	FLT HD SCREW 5/16"-18 x 3/4"



REF	PART #	DESCRIPTION
501	P1026501	HOLD-DOWN BAR
502	P1026502	HOLD-DOWN
503	P1026503	BRACKET HOLD-DOWN
504	PSS02	SETSCREW 5/16"-18 x 3/8"

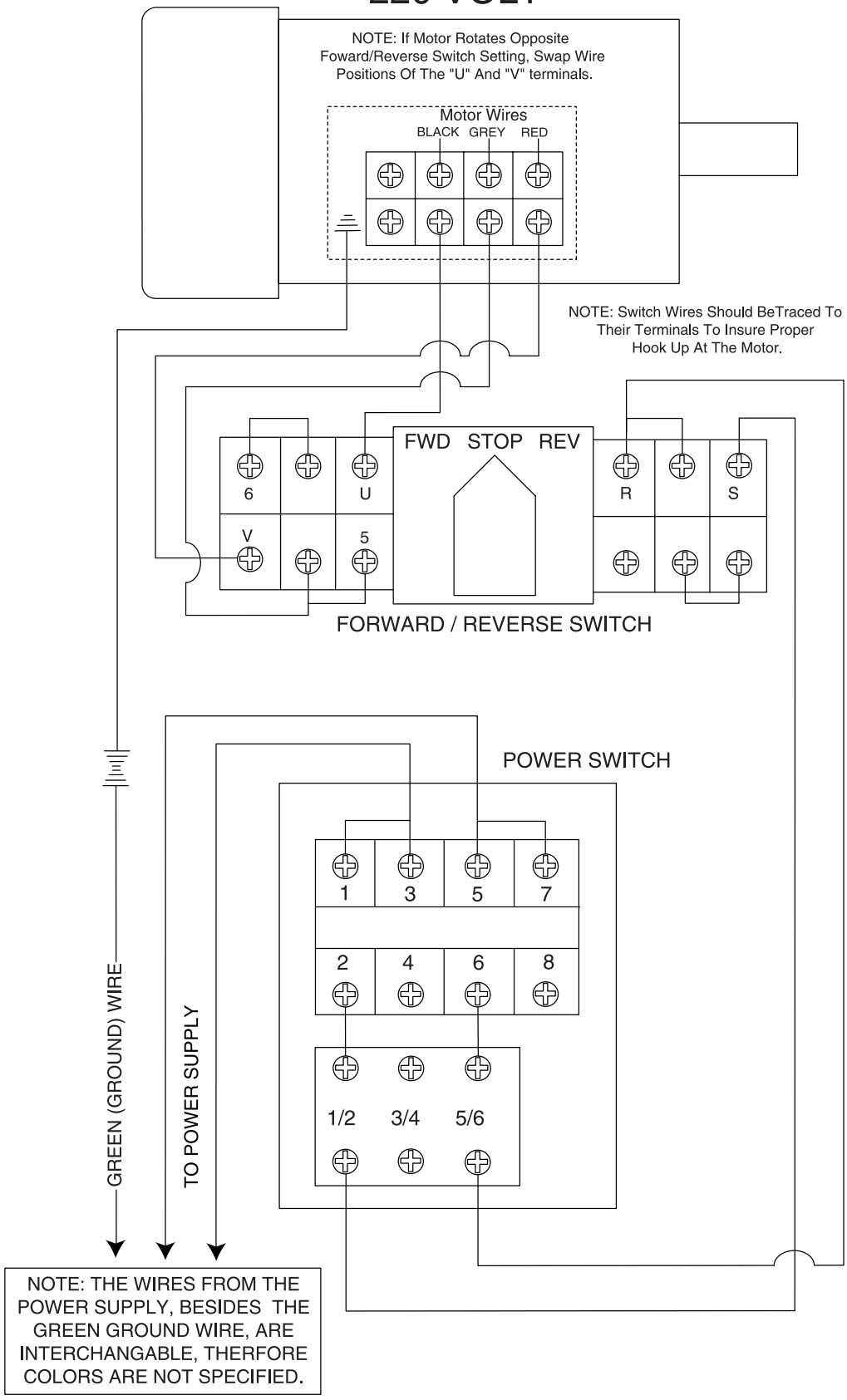


REF#	PART#	DESCRIPTION
601	P1023401	KNOB
602	P1023402	FLAT WASHER 5/16"
603	P1023403	MITER GAUGE BODY
604	P1023406	MITER BAR
607	P1023407	HEX NUT
608	P1023408	SETSCREW

REF#	PART#	DESCRIPTION
609	P1023409	SETSCREW
610	P1023410	STOP
611	P1023411	POINTER
612	P1023212	SCALE
613	P1023413	STUD

G1026 WIRING DIAGRAM

220 VOLT



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 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.

WARRANTY CARD

Name _____

Street _____

City _____State_____Zip_____

Phone Number_____E-Mail_____FAX_____

MODEL # G1026 3 H.P. Shaper Order #_____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?

___Advertisement
___Catalog
___World Wide Web
___Friend
___Card Deck

___Other_____

2. Which of the following magazines do you subscribe to.

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

___Other_____

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

___Other_____

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Band Saw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___Table Saw
___Vacuum Veneer Press
___Wide Belt Sander

___Other_____

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

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" Table Saw
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander

___Other_____

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

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

___Other_____

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

___12" Table Saw
___12" Jointer
___Combination Planer/Jointer
___Paint & Finishing Supplies
___Contractor's Supplies
___Radial Arm Saw
___Panel Saw
___Brass Hardware
___Lumber

___Other_____

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

___Builders Hardware
___Fasteners
___Hand Tools
___Wood Components

___Other_____

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

_____

_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

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

___Yes ___No

19. Comments:_____

_____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place Stamp Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE