

Grizzly[®] Industrial, Inc.

Model H7757

3" MINI WOOL BUFFER OWNER'S MANUAL



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#JK7772 PRINTED IN CHINA



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 chemical are:

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

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

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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 Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
20. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
21. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
22. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
23. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
24. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.

WARNING

Safety Instructions for the 3" Mini Wool Buffer

- 1. EYE PROTECTION.** Grinding causes small particles to become airborne at a high rate of speed. ALWAYS wear safety glasses when using this machine.
- 2. MOUNTING TO BENCH/STAND.** An unsecured grinder may become dangerously out of control during operation. Make sure grinder is FIRMLY secured to a bench/stand before use.
- 3. WHEEL SPEED RATING.** Grinding wheels operated at a faster speed than rated for may break or fly apart. Before mounting a new wheel, be sure the wheel RPM rating is equal or higher than the speed of the buffer.
- 4. WHEEL FLANGES.** Only use the flanges included with the buffer when mounting wheels. Other flanges may not properly secure the wheel and cause an accident.
- 6. STARTING BUFFER.** If a grinding wheel is damaged, it will usually fly apart shortly after start-up. To protect yourself, always stand to the side of the buffer when turning it **ON** and allow it to gain full speed before standing in front of it.
- 7. LUNG PROTECTION.** Grinding produces hazardous dust, which may cause long-term respiratory problems if breathed. Always wear a NIOSH approved dust mask or respirator when grinding.
- 8. SIDE GRINDING.** Grinding on the side of wheels can cause them to break and fly apart—unless the wheel is rated for side grinding.
- 9. TOP GRINDING.** Grinding on the top of wheels greatly increases the risk of workpiece kickback. Always grind on the downward part of the wheel.
- 10. HAND TO WHEEL CONTACT.** Grinding wheels can remove a lot of skin quickly. Keep a firm grip on the workpiece and position your hands a safe distance away when grinding. Avoid wearing gloves as they may get caught in the grinding wheel and cause serious entanglement injuries.
- 11. TOOL REST POSITION.** If the tool rest is too far away from the wheel, the workpiece may be pulled down, causing loss of control and pulling your hand into the grinding wheel. Keep the tool rest within $\frac{1}{8}$ " from the wheel when operating.
- 12. CRACKED WHEEL.** Cracked wheels may break and fly apart during operation. Replace cracked wheels immediately!

SECTION 2: INTRODUCTION

Foreword

We are proud to offer the Grizzly Model H7757 3" Mini Wool Buffer. This Model is part of a growing Grizzly family of fine power tools. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

It is our pleasure to provide this manual with the Model H7757. It was written to encourage safety considerations and guide you through general operating procedures and maintenance.

The specifications, details, and photographs in this manual represent the Model H7757 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.

Contact Information

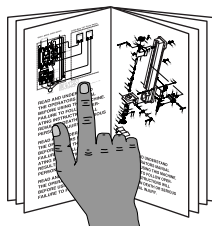
If you have any comments regarding this manual, please write to us at the following address:

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, we stand behind our tools. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycorning Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>

WARNING



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

SECTION 3: SET UP

Unpacking

Your mini wool buffer left our warehouse in a carefully packed box. If you discover the mini wool buffer is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of the shipment, you should inventory the equipment.

Inventory

After you have unpacked the carton you should find the following.

Model H7757 Inventory (Figure 1)

| | |
|-----------------------------|---|
| A. Buffer | 1 |
| B. Eye Shield Brackets..... | 2 |
| C. Tool Rests..... | 2 |
| D. Eye Shields..... | 2 |

Tools and Hardware

| | |
|---------------------------------------|---|
| Phillips Head Screws M5-.8 x 12 | 4 |
| Wing Bolts M4-.7 x 10 | 2 |
| Phillips Head Screws M4-.7 x 40 | 1 |
| Flat Washers 4mm | 2 |
| Flat Washers 5mm | 4 |
| Hex Nuts M5-.8 | 4 |
| Hex Nuts M4-.7 | 2 |
| Lock Washers 5mm..... | 4 |
| Lock Washers 4mm..... | 2 |
| Wrench 7mm x 10mm | 1 |
| Wrench 8mm x 10mm | 1 |

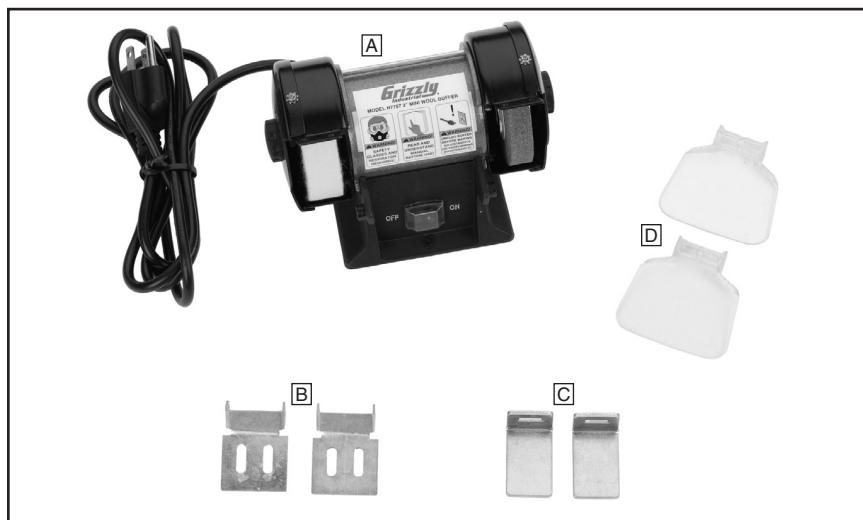


Figure 1. Model H7757 inventory

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

| Description | Qty |
|---------------------------------------|-----|
| Safety Glasses (for each person)..... | 1 |
| Phillips Head Screwdriver | 1 |

Optional Items for Mounting

| | |
|---------------------------------------|---|
| Drill with 4mm bit | 1 |
| Wrench 4mm | 1 |
| Hex Bolts M4x.7 (length varies) | 3 |
| Hex Nuts M4-.7 | 3 |
| Flat Washers 4mm | 3 |
| Lock Washers 4mm..... | 3 |

Tool Rests

The tool rests attach to the inward side of the guard and must be used to support the workpiece during operation. Failure to install and use the tool rests can lead to serious personal injury!

| Components/Hardware Required | Qty |
|------------------------------|-----|
| Tool Rests | 2 |
| Wing Bolts M3-.5 x 10 | 2 |
| Flat Washers 4mm | 2 |

To install the tool rests:

- Loosely attach the tool rests perpendicular to the surface of each wheel with the wing bolts and 4mm washers.

- Adjust both tool rests approximately $\frac{1}{16}$ " from the grinding and buffing wheels and tighten the wing bolts. **Figure 2** shows the correct adjustment for the tool rest at the grinding wheel.

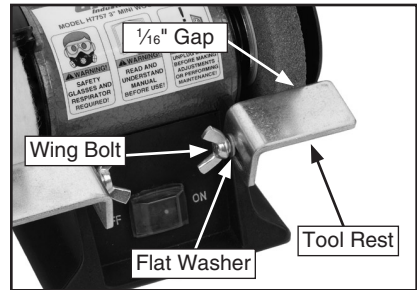


Figure 2. Tool Rest Installation.

Eye Shields

The eye shield must be positioned between the grinding or buffing wheel and the operator's face to protect the operator from flying debris. The eye shields are not a replacement for safety glasses!

| Components/Hardware Required | Qty |
|---------------------------------------|-----|
| Eye Shields | 2 |
| Eye Shield Brackets | 2 |
| Phillips Head Screws M4-.7 x 40 | 2 |
| Hex Nuts M4-.7 | 2 |
| Flat Washers 4mm | 2 |
| Phillips Head Screws M5-.8 x 12 | 4 |
| Flat Washers 5mm | 4 |
| Hex Nuts M5-.8 | 4 |
| Lock Washers 5mm..... | 4 |
| Lock Washers 4mm..... | 2 |

To install the eye shields:

- Attach the eye shield brackets to the buffer with the 5mm Phillips head screws, flat washers, lock washers and hex nuts, as shown in **Figure 3**.

Continued on next page →

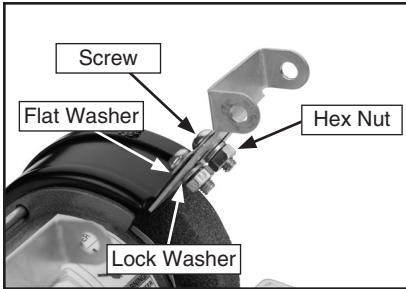


Figure 3. Eye Shield Bracket Installation.

2. Attach the eye shield to the bracket with the 4mm Phillips head screws, flat washers, lock washers and hex nuts as shown in **Figure 4**. The hex nut should be tightened to a point where the eye shields are stiff to move.

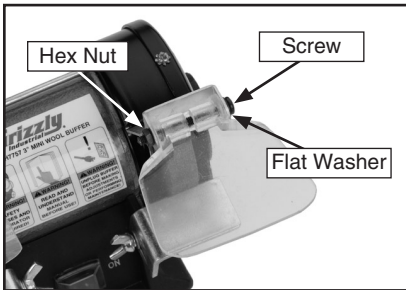


Figure 4. Eye Shield Installation.

Mounting

The buffer must be mounted to a benchtop or mounting board before it can be used. An unmounted buffer can become unbalanced when in use, potentially causing serious injury.

| Components/Hardware Required | Qty |
|--------------------------------------|------------|
| Hex Bolts M4-.7 (length varies)..... | 3 |
| Hex Nuts M4-.7 | 3 |
| Flat Washers 4mm | 3 |
| Lock Washers 4mm..... | 3 |

To secure the buffer to a benchtop or mounting board:

1. Place the buffer on a workbench or mounting board no smaller than 12"W x 10"D.
2. Using the 4mm holes in the buffer base as a template, drill holes through the mounting board or benchtop as appropriate.
3. Secure the buffer to the benchtop or mounting board with 4mm hex bolts, washers, lock washers, and hex nuts as shown in **Figures 5 & 6**.

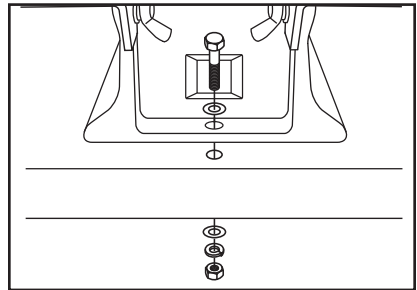


Figure 5. Mounting the buffer (front).

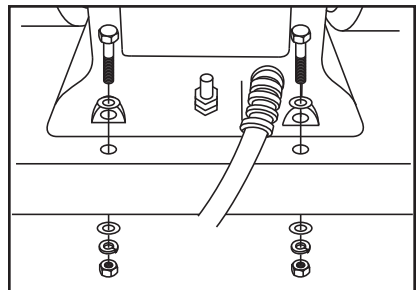
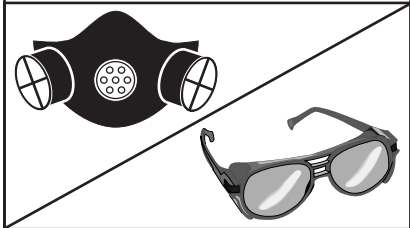


Figure 6. Mounting the buffer (back).

SECTION 4: OPERATIONS

⚠️WARNING

Using this machine produces dust which may cause eye injuries or respiratory problems. Protect yourself by wearing safety glasses and a respirator during the entire operation process.



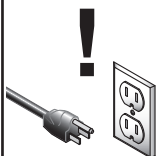
⚠️WARNING

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



⚠️WARNING

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



Test Run

To test run the buffer:

1. Plug the machine into the power source.
2. Stand to the side of the buffer and turn the machine **ON**.

The machine should run smoothly with little or no vibration or rubbing noises. Strange or unusual noises should be investigated and corrected before operating the machine further. If the machine seems okay, stay out of the line of rotation of either wheel and let it run for approximately one minute to make sure the wheels are structurally sound and safe to use.

If you cannot easily locate the source of an unusual noise or vibration, contact our Technical Support department for help.

⚠️WARNING

All grinding wheels, regardless of size, have the potential of breaking apart during operation, causing serious personal injury or death! Always stand to the side of the grinder when turning it **ON** and wear the proper safety equipment to protect yourself.

Grinding and Buffing

The processes for grinding and buffing with the H7757 are very similar.

To grind or buff:

1. Ensure all eye shields are in place and that you are wearing the appropriate safety gear.
2. With the machine plugged into power, stand to the side of the machine, and turn it **ON**.
3. Allow the machine to run for at least one full minute to ensure that the wheels are safe for use, then move to the front of the machine.
4. Grasp the workpiece tightly and properly support it on the appropriate tool rest.
5. Place the workpiece against the front surface of the wheel with moderate pressure, moving it back and forth in a steady, even motion.

Note: *Using too much pressure will slow the motor and may damage the wheel. Using too little pressure will make the workpiece bounce around and you will not make good contact with the wheel.*

6. After turning the buffer **OFF**, DO NOT continue grinding or buffing and DO NOT manually stop either wheel with your workpiece!

Wheel Care

Your safety largely depends on the condition of the wheels during grinding or buffing. A grinding wheel in poor condition presents the possibility of breaking apart during rotation and injuring the operator, while a buffing wheel in poor condition can tear apart and snag a workpiece, potentially causing serious entanglement injuries.

To properly care for your wheel, follow these tips:

- Always transport, store and handle wheels with care. Grinding wheels may be damaged if they are dropped or if heavy objects are stacked on them.
- Select the right wheel for the job. DO NOT grind or buff material that is not designed for the wheel.
- Select the right wheel for the machine. A machine that rotates at a higher RPM than the wheel rating may cause the wheel to break or tear apart.
- Mount the wheels properly. (See the **Replacing Wheels** instructions on **Page 13** for guidance.) Never use a wheel with the wrong arbor size for the buffer.
- DO NOT abuse a wheel by jamming the workpiece into the wheel with excessive force.
- Learn how to use the buffer and the grinding and buffing wheels properly. Ask a trusted person with experience or consult with your local library to learn more.

Grinding Wheel Dressing

Dressing restores the grinding wheel with a like-new abrasive quality. Whenever the front surface of the wheel loses its abrasive qualities or balance due to particle loading or polishing of the wheel surface, then the wheel should be dressed. Use a commercially-available dressing tool, such as those available on **Page 15**.

To dress the grinding wheel:

1. With the machine plugged into power, stand to the side of the grinding wheel turn the machine **ON**.
2. Allow the machine to run for at least one full minute to make sure that the grinding wheel is safe to use, then move to the front of the machine.
3. Hold the dressing tool firmly on the tool rest with both hands and press it lightly against the front surface of the grinding wheel.
4. Move the dressing tool in a side-to-side motion, while keeping it even with the surface of the grinding wheel.
5. Regularly pull the dressing tool away from the wheel for visual inspection and repeat **Steps 3 & 4** until the surface of the wheel appears to be restored to its normal color and balance.

Buffing Wheel Care

WARNING

The process of cleaning buffing wheels produces airborne dust and particles may cause eye injuries or respiratory problems. Protect yourself by wearing safety glasses and a respirator during the entire cleaning process.

Buffing wheels can sometimes become caked or clogged with buffing compound, reducing their effectiveness. In order to clean a buffing wheel, use a commercially-available buffing rake, such as those available on **Page 15**.

To clean the buffing wheel:

1. With the machine plugged into power, stand to the side of the grinding wheel and turn the machine **ON**.
2. Hold the buffing rake firmly on the tool rest with both hands and press it lightly against the front surface of the buffing wheel.
3. Move the buffing rake in a side-to-side motion, while keeping it even with the surface of the buffing wheel. As the buffing wheel is cleaned, old compound will be removed and fresh fibers exposed.
4. Regularly pull the buffing rake away from the wheel for visual inspection and repeat **Steps 3 & 4** until the surface of the wheel appears to be cleaned of compound and restored to its original condition and color.

Wheel Selection

The Model H7757 only accepts Type 1 3" x 1/2" wheels with a 1/4" bore.

Aluminum oxide and silicon carbide wheels are marked in a somewhat uniform manner by all major manufacturers. Understanding these markings will help you understand the capabilities of various wheels. Always refer to the manufacturer's grinding recommendations when selecting a wheel for your project.

The basic format for wheel numbering is:

| Prefix | Abrasive Type | Grit Size | Grade Type | Bond Type |
|--------|---------------|-----------|------------|-----------|
| Type 1 | A | 60 | L | V |

The *Prefix* is the manufacturer's designation for a particular standardized type of grinding wheel. Different Type prefixes indicate different wheel shapes and designs. For more information on wheel types, ask a person with grinding experience or consult your local library.

The most common *Abrasive Types* used are A for Aluminum Oxide and C for Silicon Carbide, and occasionally SG for Seeded Gel.

The *Grit Size* is a number that refers to the size of the abrasive grain in the wheel. The lower the number, the coarser the wheel. Grit sizes range from 10, which is a very coarse grit used for roughing, to 220, which is usually the upper range for fine finish work.

Grade Type is an indication of the hardness of the wheel—"A" being the softest and "Z" being the hardest.

Bond Type refers to the type of bonding material used to hold the abrasive material. Most general purpose wheels will have a "V" indicating Vitrified Clay is used. Vitrified Clay provides high strength and good porosity. The other common bond type is "B" for resin where synthetic resins are used. These are used to grind cemented carbide and ceramic materials.

There may be other numbers inserted that have meaning for a particular type of wheel. Refer to the wheel manufacturer's technical data for a complete explanation.

Wheel Inspection

WARNING

The hazards of using a damaged grinding wheel include flying chunks of sharp abrasive material that could cause serious injury or death. Inspect every grinding wheel before it is mounted and DO NOT use a damaged grinding wheel!

Before mounting a new grinding wheel, it must be inspected. DO NOT assume that a wheel is in sound condition just because it is new—often, damage can occur during shipping, with age, or with exposure to moisture.

First, the wheel should be given a **Visual Inspection**. Look for any cracks, chips, nicks, or dents in the surface of the wheel. If you see any of these, DO NOT use the wheel.

Second, the wheel should be given a **Ring Test**. This test will give you an indication of any internal damage that may not be obvious during a visual inspection.

To perform a Ring Test:

1. Make sure the wheel that you test is clean and dry; otherwise, you may get false results.
2. Hang the wheel in the air with a piece of cord or string looped through the hole in the center.
3. At the spots shown in **Figure 7**, gently tap the wheel with a light non-metallic device such as the handle of a screwdriver or a wooden mallet.

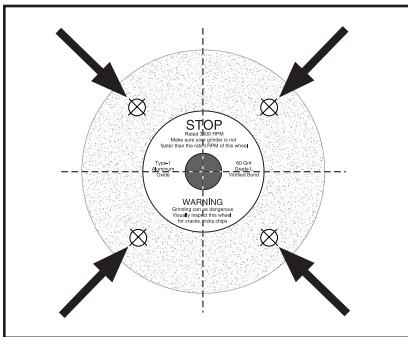


Figure 7. Ring test tapping locations.

4. An undamaged wheel will emit a clear metallic ring or “ping” sound in each of these spots. A damaged wheel will respond with a dull thud that has no clear tone.
5. If you determine from the ring test that the wheel is damaged, **DO NOT** use it!

Replacing Wheels

The wheel guard assembly must be removed in order to mount or dismount a buffing or grinding wheel.

To remove/mount a wheel:

1. **DISCONNECT THE MACHINE FROM THE POWER SUPPLY!**
2. Remove the three Phillips head screws and tooth washers that go through the outer guard, and take off the outer guard.
3. Use a wrench on the nut that holds the wheel on the arbor. Hold the wheel from turning with your other hand.

Note: *The left end of the arbor has a left-handed thread, so loosening the nut will require turning it clockwise.*

4. Remove the outer wheel flange and paper disc. Pull the wheel free from the arbor. There will also be a paper disc and a wheel flange on the back side of the wheel which should also be removed.
5. Mount the new wheel in the reverse order that you removed it or as shown in **Figure 8**. Always make certain there are paper or fiber discs between the wheel flanges and the wheel itself. Tighten the nut snugly but **DO NOT** over-tighten. Over-tightening can crack a grinding wheel.

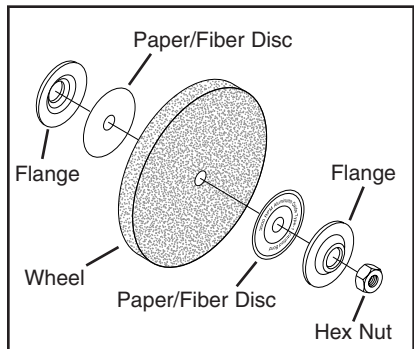


Figure 8. Wheel mounting order.

Continued on next page 

CAUTION

NEVER assemble a grinding wheel on the arbor without paper or fiber discs between the wheel and the flanges. Failure to include the paper or fiber discs can result in damage to the wheel and cause it to fail when at speed, causing serious injury!

6. Re-install the guards and shields.
7. Run a new wheel for at least one minute while standing clear of the line of rotation. If a wheel does have defects it will generally fail as soon as it gets up to full speed.

SECTION 5: ACCESSORIES

G7984—Face Shield

H1298—Dust Sealed Safety Glasses

H1300—Clear Safety Glasses

H2347—Uvex® Spitfire Safety Glasses

H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



Figure 9. Our most popular safety glasses.

H5944—#0 Wheel Dresser

H5945—#1 Wheel Dresser

H5946—#2 Wheel Dresser

These wheel dressers expose new grains for aggressive cutting on all types of grinding wheels. The star wheels and discs are hardened steel, and the cast iron handle provides stabilizing mass for better control. Available in three sizes: #0, #1 and #2.

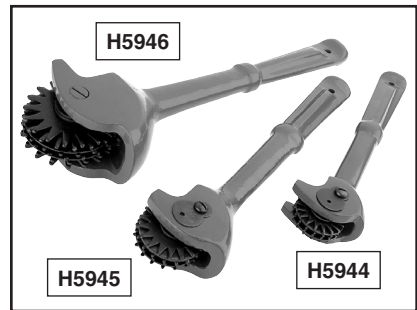


Figure 10. Our range of Wheel Dressers.

H4383—Buffing Rake

H4384—Replacement Rake

Great for removing dried compound from buffing wheels. Simply guide the rake across the buffing surface to clean the wheel and expose fresh fibers.

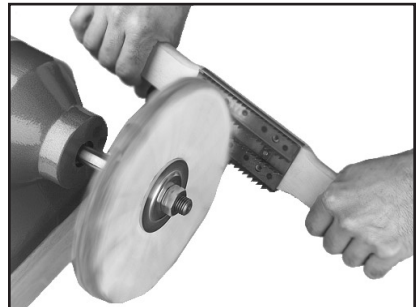


Figure 11. Our Buffing Rake in action.

Call 1-800-523-4777 To Order

SECTION 5: MAINTENANCE

General

Always be aware of the condition of your machine. Routinely check the condition of the following items and repair or replace as necessary:

- Damaged or loose grinding wheels.
- Loose mounting bolts or arbor nuts.
- Worn switch.
- Worn or damaged cord.
- Worn or damaged support bearings.
- Any other condition that could hamper the safe operation of this machine.

Lubrication

Sealed and pre-lubricated ball bearings require no additional attention for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our Parts Department or a bearing supply store.

Grinding Wheels

The grinding wheel should be visually inspected before every use. Take care when storing grinding wheels to keep them free from potential damage due to being dropped or having other items dropped on them. Store all grinding wheels in a dry location. Type 1 grinding wheels should be stored vertically with cushioning material between each wheel.

If a grinding wheel diameter has been reduced to 2½", the wheel must be replaced. Operating a wheel at anything less than this diameter can lead to wheel explosion and serious personal injury.

Grinding wheels will require periodic dressing. Refer to the **Wheel Dressing** instructions on **Page 13** for details on how this is done.

Buffing Wheels

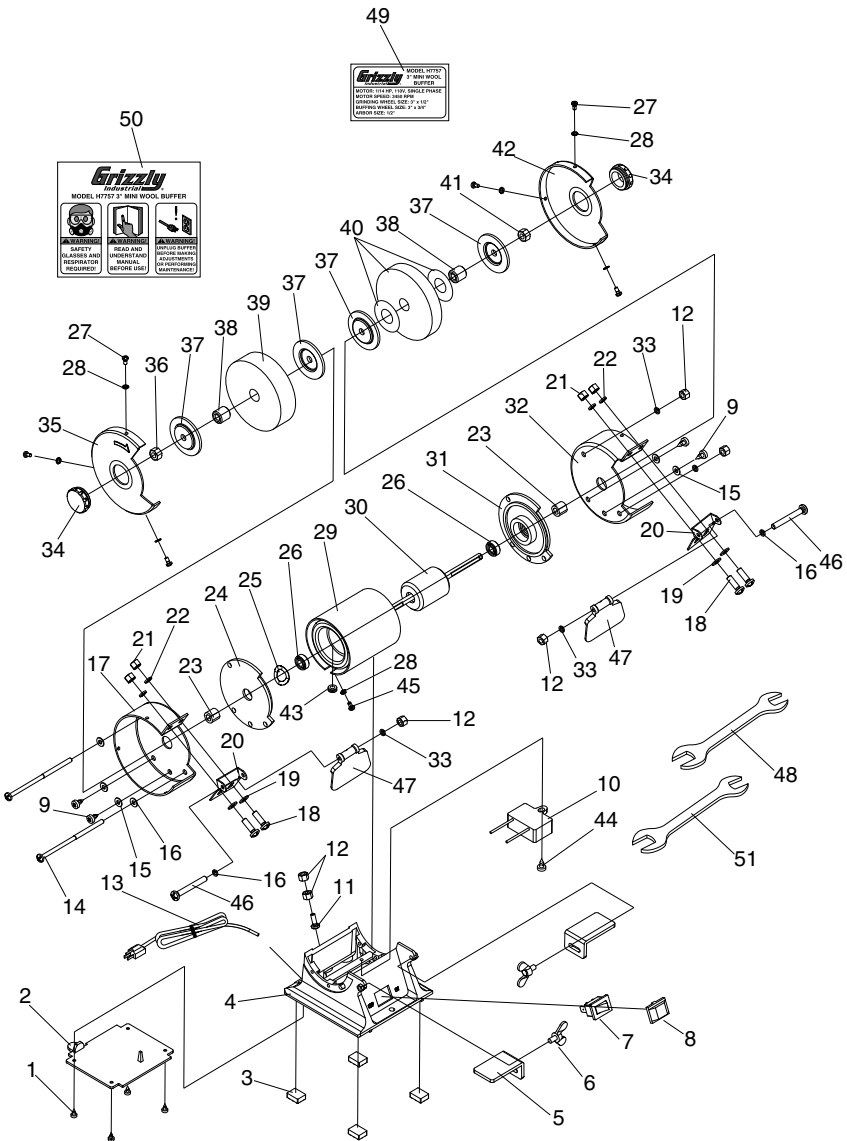
Buffing wheels should be regularly cleaned of compounds to maintain their effectiveness and surface texture. Wool buffing wheels will shed fibers and will need to be replaced eventually. If a buffing wheel is reduced to 2½", the wheel must be replaced. Operating a wheel at anything less than this diameter can tear or rip, posing an entanglement hazard for the workpiece and operator.

SECTION 6: SERVICE

Troubleshooting

| Symptom | Possible Cause | Possible Solution |
|---|--|---|
| Machine slows when operating. | 1. Workpiece pressure is too great. | 1. Reduce workpiece pressure on wheel. |
| Machine vibrates when operating. | 1. Grinding wheel is unbalanced. 2. Grinding wheel is damaged. 3. Arbor is bent. 4. Bearings are worn or damaged. | 1. Adjust or tighten wheel mounting nut as necessary. 2. Replace the wheel. 3. Inspect arbor and replace if necessary. 4. Inspect bearings and replace if necessary. |
| Wavy condition on surface of workpiece. | 1. Workpiece not being held firmly. 2. Wheel face uneven. 3. Wheel is too hard. | 1. Use a holding device to firmly retain the workpiece. 2. Dress the grinding wheel. 3. Use softer wheel. |
| Lines on surface of workpiece. | 1. Impurity on wheel surface. 2. Workpiece not being held tightly. | 1. Dress the grinding wheel. 2. Use a holding device to firmly retain the workpiece. |
| Burning spots or cracks in the workpiece. | 1. Workpiece pressure is too great. 2. Improper grinding wheel type. 3. Coolant required. | 1. Reduce workpiece pressure on wheel. 2. Try a wheel that is of a softer style or coarser grit. 3. Cool the workpiece frequently. |
| Wheel dulls quickly, grit falls off. | 1. Workpiece pressure is too great. 2. Wheel is too soft. 3. Wheel diameter too small. 4. Bad wheel dress. 5. Defective wheel bonding. | 1. Reduce workpiece pressure on wheel. 2. Select a wheel with a harder bond. 3. Replace the wheel. 4. Dress the wheel. 5. Consult manufacturer of grinding wheel. |
| Wheel clogs and workpiece shows burn marks. | 1. Wheel is too hard. 2. Feed rate too slow. 3. Bad wheel dress. 4. Coolant required. | 1. Select a softer wheel bond. 2. Increase rate of movement of workpiece onto wheel. 3. Dress the wheel. 4. Cool the workpiece frequently. |
| Poor buffing performance. | 1. Buffing wheel is loaded with compound residue. 2. Buffing wheel is worn down. | 1. Clean wheel with a buffing rake as on Page 11 . 2. Replace buffing wheel. |

Parts Breakdown



Parts List

| REF | PART # | DESCRIPTION |
|-----|-----------|--------------------------|
| 1 | PS49M | PHLP HD SCR M3-.5 X 5 |
| 2 | PH7757002 | BASE PLATE |
| 3 | PH7757003 | RUBBER FOOT |
| 4 | PH7757004 | BASE |
| 5 | PH7757005 | MOVEABLE TOOL REST |
| 6 | PH7757006 | WING BOLT M4-.7 X 10 |
| 7 | PH7757007 | ROCKER SWITCH |
| 8 | PH7757008 | SWITCH COVER |
| 9 | PS02M | PHLP HD SCR M4-.7 X 12 |
| 10 | PH7757010 | CAPACITOR 3MFD 250VAC |
| 11 | PS21M | PHLP HD SCR M4-.7 X 15 |
| 12 | PN04M | HEX NUT M4-.7 |
| 13 | PH7757013 | CORD & PLUG |
| 14 | PH7757014 | PHLP HD SCR M4-.7 X 86 |
| 15 | PW05M | FLAT WASHER 4MM |
| 16 | PW05M | FLAT WASHER 4MM |
| 17 | PH7757017 | LEFT SAFE GUARD PLATE |
| 18 | PS08M | PHLP HD SCR M5-.8 X 12 |
| 19 | PW02M | FLAT WASHER 5MM |
| 20 | PH7757020 | EYE SHIELD BRACKET |
| 21 | PN06M | HEX NUT M5-.8 |
| 22 | PLW01M | LOCK WASHER 5MM |
| 23 | PH7757023 | ARBOR BUSHING |
| 24 | PH7757024 | LEFT END CAP |
| 25 | PH7757025 | SPECIAL WAVE WASHER 19MM |
| 26 | PH7757026 | BEARING 626Z |
| 27 | PS49M | PHLP HD SCR M3-.5 X 5 |
| 28 | PTLW13M | EXT TOOTH WASHER 3MM |
| 29 | PH7757029 | STATOR |
| 30 | PH7757030 | ROTOR |
| 31 | PH7757031 | RIGHT END CAP |
| 32 | PH7757032 | RIGHT SAFE GUARD PLATE |
| 33 | PLW02M | LOCK WASHER 4MM |
| 34 | PH7757034 | SEAL RING |
| 35 | PH7757035 | LEFT SAFE GUARD COVER |
| 36 | PN37M | HEX NUT M5-.8 LH |
| 37 | PH7757037 | FLANGE |
| 38 | PH7757038 | SHAFT SLEEVE |
| 39 | H8871 | BUFFING WHEEL 3" X 3/4" |
| 40 | H8870 | GRINDING WHEEL 3" X 1/2" |
| 41 | PN06M | HEX NUT M5-.8 |
| 42 | PH7757042 | RIGHT SAFE GUARD COVER |
| 43 | PH7757043 | CORD BUSHING |
| 44 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 45 | PS49M | PHLP HD SCR M3-.5 X 5 |
| 46 | PS65M | PHLP HD SCR M4-.7 X 40 |
| 47 | PH7757047 | EYE SHIELD |
| 48 | PH7757048 | WRENCH 7 X 10 |
| 49 | PH7757049 | MACHINE ID LABEL |
| 50 | PH7757050 | MACHINE WARNING LABEL |
| 51 | PWR810 | WRENCH 8 X 10 |

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3. What is your annual household income?

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 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

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 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for our customers in your area?

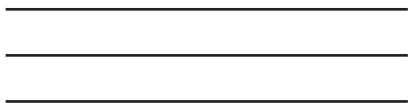
Note: *We never use names more than 3 times.* Yes No

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