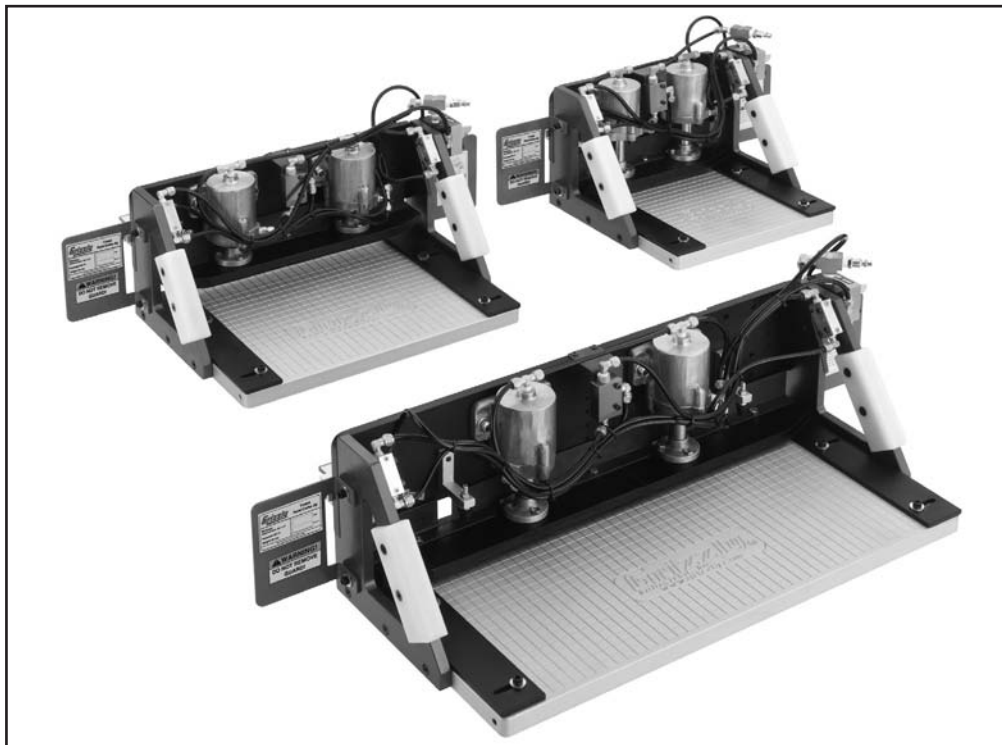


# *Grizzly* *Industrial, Inc.*®

## MODEL T10460, T10462 & T10464 PANEL SHAPING JIG OWNER'S MANUAL *(For models manufactured since 01/12)*



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**  
#KN14658 PRINTED IN TAIWAN



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.**

**Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.**

**The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.**

**The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.**



## **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.**

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# INTRODUCTION

## Manual Accuracy

We are proud to offer this manual with your new jig! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the jig we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your jig may not exactly match the manual**. If you find this to be the case, and the difference between the manual and jig leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your jig by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your jig.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:		<b>Manufacture Date of Your Machine</b> ing this machine: operation. s and respirator. sted/setup and suit before starting.	
Specification:			
Specification:			
Specification:			
Weight:			
<input type="text"/>	Date		
<input type="text"/>	Serial Number		
Manufactured for Grizzly in Taiwan			
4.	make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.		
5.	DO NOT expose to rain or dampness.		
6.	DO NOT modify this machine in any way.		
7.	DO NOT remove safety guards.		
8.	Never leave machine running unattended.		
9.	DO NOT operate under the influence of drugs or alcohol.		
10.	Maintain machine carefully to prevent accidents.		

For your convenience, we post all available manuals and manual updates for free on our website at [www.grizzly.com](http://www.grizzly.com). Any updates to your model of jig will be reflected in these documents as soon as they are complete.

## Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Email: [techsupport@grizzly.com](mailto:techsupport@grizzly.com)

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: [manuals@grizzly.com](mailto:manuals@grizzly.com)

## Machine Description

The T10460/T10462/T10464 Panel Shaping Jig is a great addition to any shop. The jig uses pneumatic power to reliably hold the workpiece and provide a cushion of air, making movement on the table easy. The jig increases accuracy and safety when using shapers. The template holder allows templates to be quickly swapped out for efficiency, and the dual guards and power air switches keep hands safely out of the way while providing maximum control.

The T10460 has an 11½" base, T10462 has a 16" base, and the T10464 has a 24" base.



# Identification

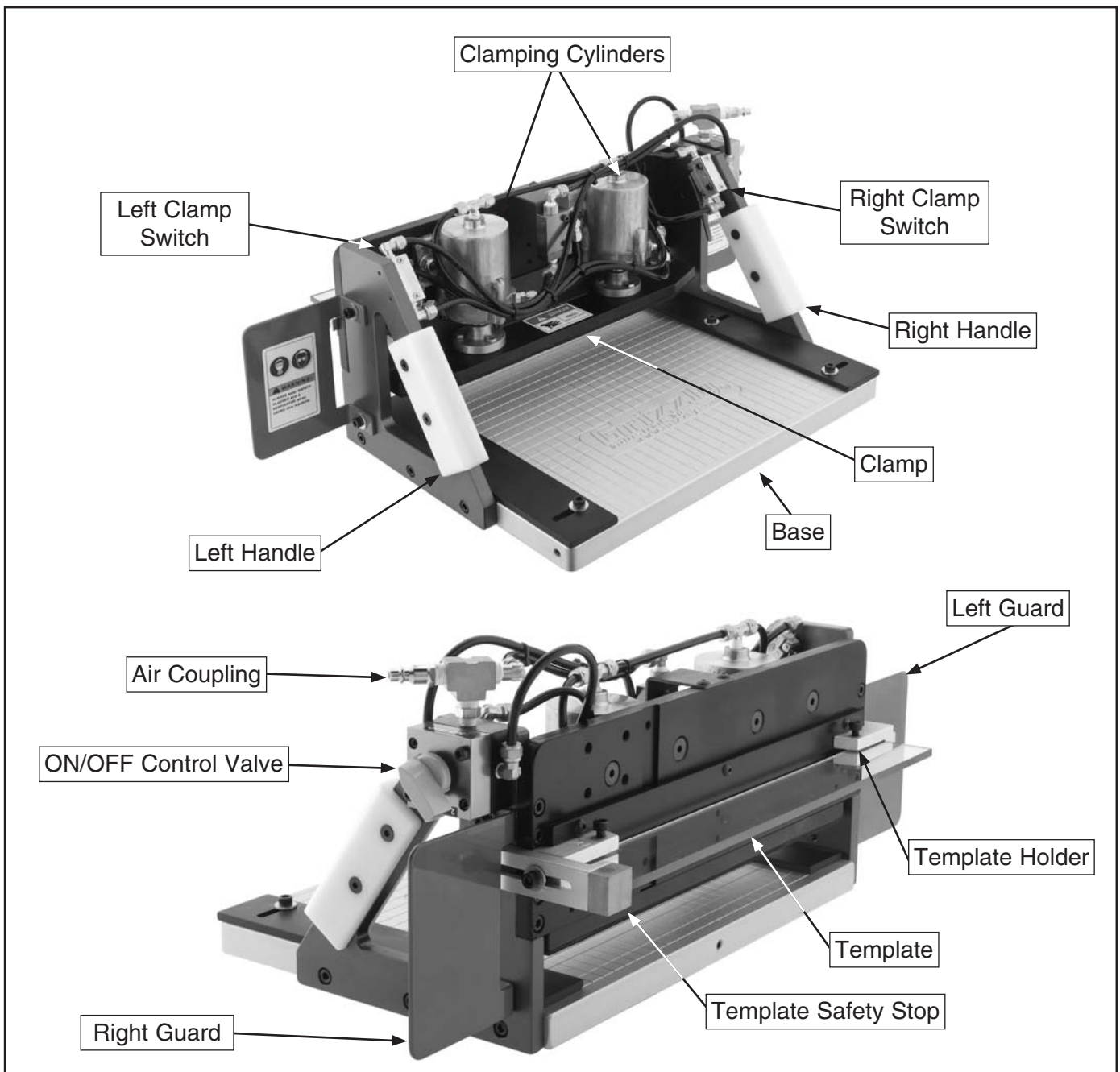
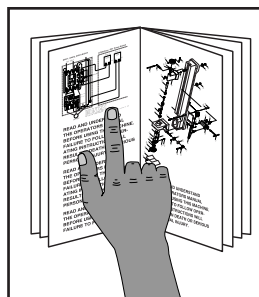


Figure 1. Identification (T10462 shown).

	<p><b>! WARNING</b></p> <p>To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.</p>
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# MACHINE DATA SHEET

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## MODEL T10460, T10462, T10464 PANEL SHAPING JIG

Model Number	T10460	T10462	T10464
<b>Product Dimensions</b>			
Weight	30 lbs.	37 lbs.	50 lbs.
Width (side-to-side) /Depth (front-to-back)/Height	21" x 11 <sup>3</sup> / <sub>4</sub> " x 11"	25" x 11 <sup>3</sup> / <sub>4</sub> " x 11"	32" x 11 <sup>3</sup> / <sub>4</sub> " x 11"
Foot Print (Width/Depth)	13" x 11 <sup>3</sup> / <sub>4</sub> "	17" x 11 <sup>3</sup> / <sub>4</sub> "	25" x 11 <sup>3</sup> / <sub>4</sub> "
<b>Shipping Dimensions</b>			
Type	Cardboard Box		
Weight	39 lbs.	43 lbs.	52 lbs.
Width (side-to-side)/Depth (front-to-back)/Height	19" x 14" x 13"	22" x 14" x 13"	29" x 14" x 13"
<b>Pneumatic</b>			
Required Air Pressure	71 PSI		
Connection Type	Male Coupling 1/4"		
<b>Construction</b>			
Paint	Urethane		
Material	Aircraft Aluminum		
Template Material	1/4" Plexiglass		



# SECTION 1: SAFETY

## **WARNING**

### **For Your Own Safety, Read Instruction Manual Before Operating this Machine**

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words 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.



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



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



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 machine.

## **WARNING**

### **Safety Instructions for Machinery**

**OWNER'S MANUAL.** Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

**HAZARDOUS DUST.** Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

**WEARING PROPER APPAREL.** Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

**HEARING PROTECTION.** Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

**MENTAL ALERTNESS.** Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



# WARNING

**DISCONNECTING POWER SUPPLY.** Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

**APPROVED OPERATION.** Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

**DANGEROUS ENVIRONMENTS.** Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in dark areas. Keep work area clean, dry, and well-lighted.

**ONLY USE AS INTENDED.** Only use machine for its intended purpose. Never modify machine for a purpose not intended by the manufacturer!

**USE RECOMMENDED ACCESSORIES.** Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

**CHILDREN & BYSTANDERS.** Keep children and bystanders a safe distance away from work area. Stop using machine if children or bystanders become a distraction.

**REMOVE ADJUSTING TOOLS.** Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

**SECURING WORKPIECE.** When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

**FEED DIRECTION.** Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

**FORCING MACHINERY.** Do not force machine. It will do the job safer and better at the rate for which it was designed.

**GUARDS & COVERS.** Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

**NEVER STAND ON MACHINE.** Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

**STABLE MACHINE.** Unexpected movement during operations greatly increases risk of injury or loss of control. Before starting, verify machines are stable and mobile base (if used) is locked.

**AWKWARD POSITIONS.** Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

**UNATTENDED OPERATION.** Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

**MAINTAIN WITH CARE.** Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine increases risk of injury.

**CHECK DAMAGED PARTS.** Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

**MAINTAIN POWER CORDS.** When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

**EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.





# WARNING

## Additional Safety Instructions for Jig

**OPERATING MACHINERY.** Like all machinery, there is danger associated with operating the jig. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this jig with caution and respect to reduce the possibility of operator injury. If safety precautions are ignored, serious injury could occur.

**SHOP SAFETY.** Every shop environment is different. Always consider safety first, as it applies to your working conditions. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

**KICKBACK.** Be familiar with kickback. Kickback happens when the workpiece or jig is thrown towards the operator at a high rate of speed. Do NOT use the jig with the shaper until you understand what kickback is and how to prevent it.

**HAND POSITIONING.** ALWAYS control the jig with both hands on the handles. This keeps both hands behind the guards and away from the cutter to provide maximum control and reduce the risk of injury.

**SAFETY GUARDS.** DO NOT remove the hand guards. Guards help protect your hands during operation—as long as you are holding the handles.

**TABLE SIZE.** DO NOT use the jig on shaper tables that are too small or cannot support the shaper. The jig is heavy and may cause crushing injuries if it falls off the table.

**STOCK LENGTH/SHAPE.** DO NOT cut stock that is too small to fit fully under the clamps or is shaped in a way that it cannot be firmly clamped. Stock that is not firmly clamped increases the risk of kickback, which can result in serious personal injury or property damage.

**STOCK CONDITION.** ALWAYS use good stock. The danger of kickback increases when the stock has knots, holes, or foreign objects in it. Warped stock clamps unevenly and should be jointed flat before shaping.

**FEEDING WORKPIECE.** Feeding with excessive force is likely to result in poor cutting results and increase the risk of dangerous kickback. Always feed the workpiece against the rotation of the cutter. Never force materials through the shaper. Let the cutters do the work.

**STARTING MACHINE.** NEVER start the machine with the material against the cutter, as this will greatly increase the risk of kickback. Let the machine reach full speed before feeding stock into the cutter.

**DEPTH OF CUT.** NEVER remove too much material in one pass. Heavy cuts increase the risk of kickback. Several light passes are safer and produce a cleaner finish.

**SHAPING CONTOURED WORK.** Always use a rub collar and a template when doing contour shaping. DO NOT start the cut at a corner—this can lead to tear out or poor finish results. Begin towards the middle of the cut and shape outwards.

**BLIND CUT WHEN POSSIBLE.** Blind cuts keep the cutters on the underside of the workpiece and provide an increased safety for the operator.

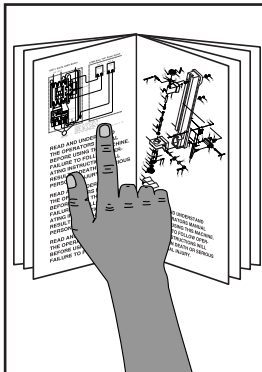
**STACKED CUTS.** NEVER stack cuts. The clamping pressure of the jig is not sufficient to prevent movement between the workpieces, which can lead to kickback. Material must be secured beneath the clamp during a cutting operation.

**DISCONNECT AIR.** ALWAYS disconnect air before adjusting or servicing the jig. Failure to do this can result in explosions or pinch hazards leading to serious personal injury and property damage.

**AIR PRESSURE.** Exceeding the appropriate air pressure can cause explosion, leading to impact injury or jig damage. On the other hand, insufficient air pressure will not provide the clamping pressure needed for safe operation. ALWAYS use the correct air pressure for the jig.



# SECTION 2: SETUP



**!WARNING**  
This jig presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before using the jig!



**!WARNING**  
Wear safety glasses during the entire setup process!



**!WARNING**  
This jig and its components are heavy. Get lifting help to move heavy items.

## Unpacking

Your jig was carefully packaged for safe transportation. Remove the packaging materials from around your jig and inspect it. If you discover any damage, *please call us immediately at (570)546-9663.*

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 your shipment, inventory the contents.



**!WARNING**  
**SUFFOCATION HAZARD!**  
Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

## Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses .....	1
• Teflon Tape .....	As Needed
• Disposable Shop Rags.....	As Needed

## Inventory

The following is an inventory of the jig and main components. Lay the components out to inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.



Box 1: (Figures 2)	Qty
A. Jig Body (Not Shown).....	1
B. Ball Bearing Rub Collar 6208RS.....	1
C. Rub Collar Bushing Set 1/4" .....	1
D. Male Coupling 1/4" .....	1
E. Right Guard.....	1
F. Left Guard .....	1
G. Square Template .....	1
H. Template Mounting Bracket.....	1
I. Template Bracket Holder.....	1
J. Hex Wrench Set 1.5, 2, 3, 4, 5, 6, 8, 10mm .....	1 Ea.
K. Combo Wrench 17/19mm .....	1
L. Combo Wrench 10/12mm.....	1
M. Miter Bar.....	1
N. Rear Fence.....	1
O. Hardware (Not Shown)	
—Flat Washers 6mm .....	4
—Cap Screws M6-1 X 16.....	4
—Button Head Cap Screws M5-.8 X 16 ....	3

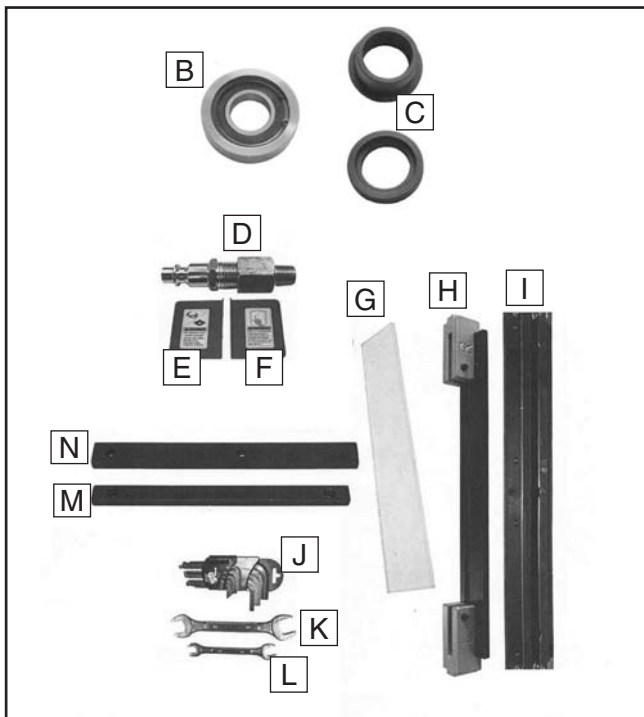


Figure 2. Jig component inventory.

## NOTICE

If you cannot find an item on this list, carefully check the jig and the packaging materials. Some of these items may be pre-installed for shipping or become misplaced during unpacking.

# Site Considerations

## Shaper Table Size

Some shapers may require a table extension to adequately support the jig. DO NOT attempt to use the jig on router tables, as the table size will not be adequate for the jig.

## Placement Location

Consider existing and anticipated needs, size of material to be processed using the jig, and space for auxiliary stands, work tables or other machinery. A mobile cart or dedicated work stand is a good idea for storing the jig away from the shaper table. See Figure 3 for the footprint sizes.

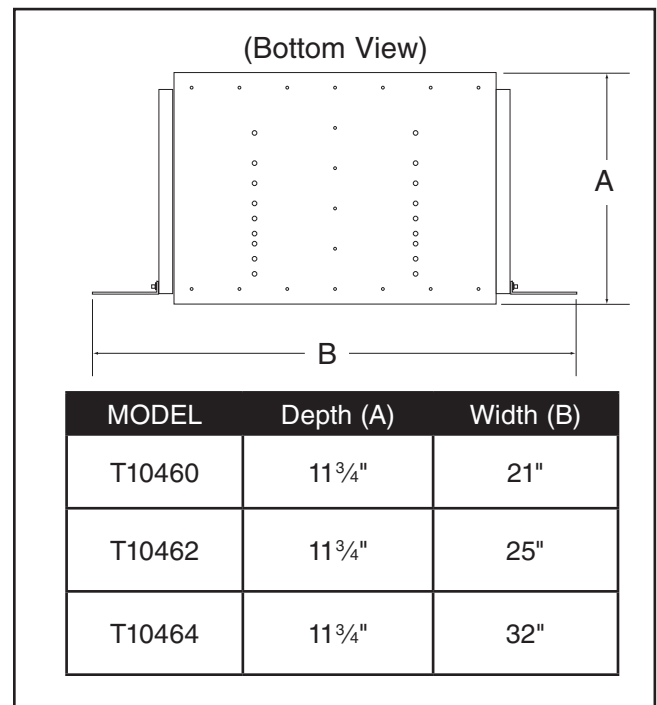
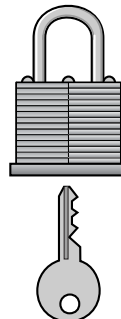


Figure 3. Footprint sizes.



## CAUTION

Children and visitors may be seriously injured if unsupervised around machinery. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.



# Attaching Guards

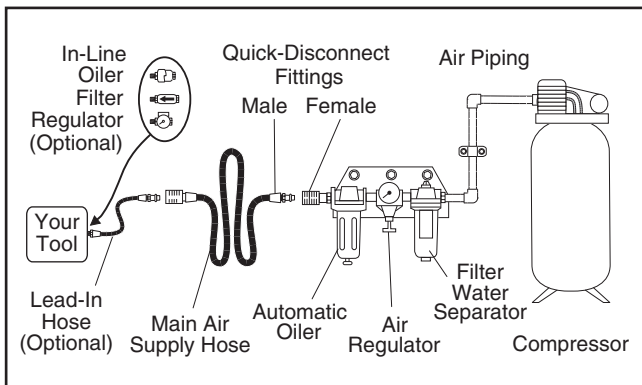
Assemble the jig by attaching the guards with (4) M6-1 x 16 cap screws and (4) 6mm flat washers, as shown in **Figure 4**.



**Figure 4.** Attaching guard to jig.

# Air Connection

We recommend using an air supply system similar to that illustrated in **Figure 5** for the best performance. Use an air compressor with a regulator and gauge rated for at least 90 PSI.



**Figure 5.** Recommended air supply system setup.

## To connect the jig to compressed air:

1. Check the air pressure reading on the air compressor gauge. The correct setting is 90 PSI.
2. Connect the air hose from the air supply unit to the jig with a standard 1/4" NPT female quick-release coupler.

# Test Run

Verify that the jig operates correctly on a shaper table or similar surface. Use a scrap piece of material for the test run.

If the jig does not operate correctly, refer to **Troubleshooting** on **Page 20**. If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

## To verify the jig runs correctly:

1. Make sure you have read the safety instructions in this manual, the guards are installed, and all tools and objects used during setup are cleared away from the jig.
2. Connect the jig to the air supply.
3. Turn the air control valve to **ON**.
4. Position a workpiece on the jig as if preparing it for shaping.
5. Press both switch valves. The material clamp should lower and clamp the workpiece firmly.
6. While pressing the switch valves, move the jig across the table. The jig should slide easily across the surface of the table.

—If there is too much friction, adjust the air-flow control valve to increase the airflow at the base.

—If there is too little friction, adjust the air control valve to decrease the airflow at the base.

7. Release the double switch valves. Air should stop flowing through the jig.

—If air stops flowing through the jig, proceed to **Step 9**.

—If air does not stop flowing through the jig, turn the air control valve **OFF** and call Tech Support.

8. Congratulations—the jig is ready to use.

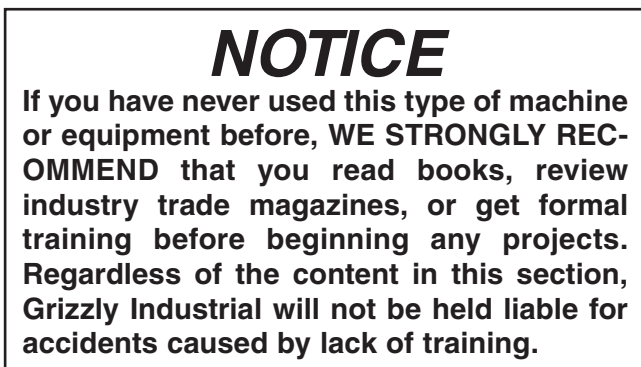
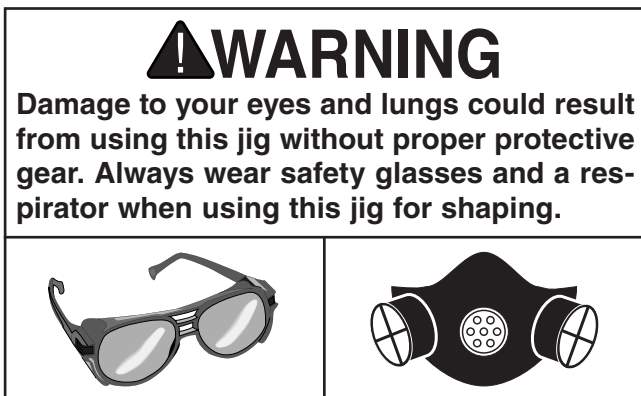


# SECTION 3: OPERATIONS

## Operation Overview

The purpose of this overview is to provide the novice operator with a basic understanding of how the jig is used during operation, so the jig controls and components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for shaping.
2. Adjusts the shaper for the intended operation.
3. Connects the jig to the air supply.
4. Clamps the workpiece in the jig.
5. With the shaper **OFF**, simulates shaping the workpiece with the jig. Makes any needed adjustments.
6. Puts on safety glasses and a respirator.
7. Starts the shaper.
8. Feeds the jig and workpiece all the way through the shaper, keeping both hands on the jig at all times until the operation is complete.
9. Stops the shaper.
10. Turns the jig **OFF** and removes the workpiece.



# Workpiece Inspection

Some workpieces are not safe to use in the jig or may require modification before they are safe to use. **Before shaping, inspect all workpieces for the following:**

- **Material Type:** Only use the jig to shape materials for which the shaper is intended. Failure to do so can cause personal injury and property damage.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While shaping, these objects can become dislodged and hit the operator, cause kickback, or damage the cutterhead, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT shape the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the shaping operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid shaping them.
- **Wet or "Green" Stock:** Shaping wood with a moisture content over 20% causes unnecessary wear on the cutterhead blades, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to shape because they are unstable, unpredictable when being shaped, and cannot be properly clamped in the jig. DO NOT use workpieces with these characteristics!

# Basic Controls

## ON/OFF Control Valve

The ON/OFF control valve (see **Figure 6**) controls airflow from the air supply to the jig. Turning the valve **ON** allows the air to pressurize the cylinder for clamping. Turning the valve **OFF** discharges the cylinders, allowing them to return to the open position.

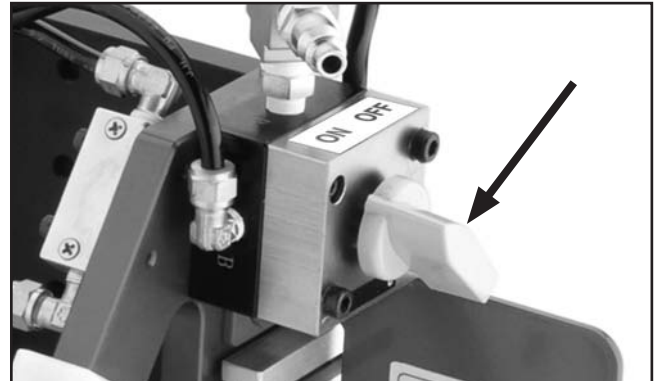


Figure 6. ON/OFF control valve.

## Clamping Switches

Depressing *both* switches does two things: 1) clamps the workpiece, and 2) allows airflow to the base to provide a low-friction surface for the jig.

The switches must remain pressed for the jig to maintain constant clamping pressure on the workpiece and have a low-friction surface.

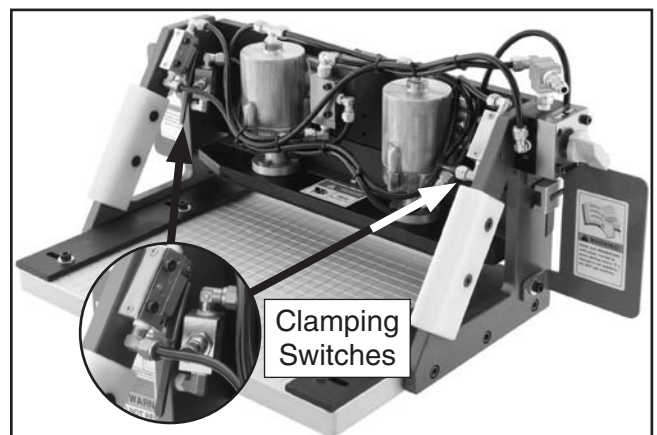


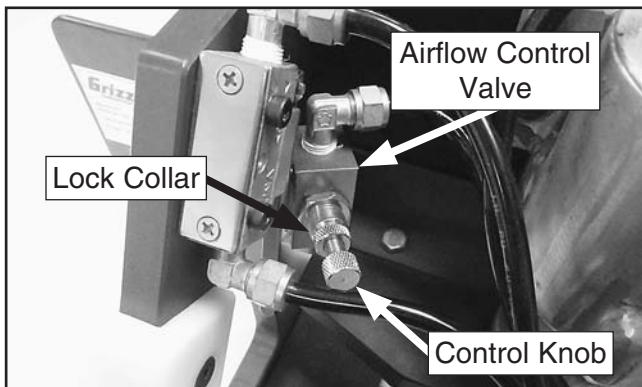
Figure 7. Clamping switch location.



## Adjusting Airflow

The airflow control valve (see **Figure 8**) adjusts the amount of air flowing through the base to provide the "cushion" of air between the jig and shaper table. The lock collar secures the setting on the valve.

Adjust the valve by threading the lock collar up the control knob stem. Turn the valve counter-clockwise to increase friction or turn it clockwise to decrease friction. Thread the lock collar against the airflow control valve to lock the control knob.



**Figure 8.** Airflow control valve.

# Adjustments

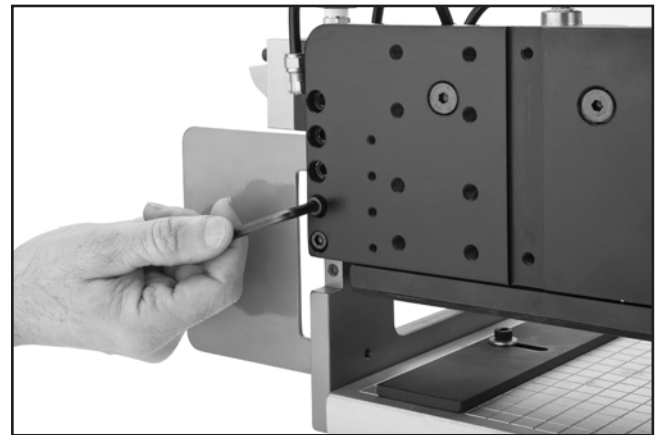
The jig may be configured for various types of operations. Not all of the following adjustments will apply to every scenario. However, you should familiarize yourself with the following adjustments. This will clarify the jig's versatility and usefulness.

## Adjusting Clamp Height

The height of the cylinder bracket may be adjusted to increase the clamping capacity of the jig.

**To adjust the cylinder bracket height:**

1. Remove the (6) M6-1 x 20 cap screws, as shown in **Figure 9**.



**Figure 9.** Adjusting the clamp height.

2. Adjust the height of the cylinder bracket to the new height.

**Important:** *The cylinder bracket must be fastened with the (6) M6-1 x 20 cap screws to operate safely.*

3. Re-secure the cylinder bracket at the new height by replacing the (6) M6-1 x 20 cap screws.



## Positioning Workpiece

The jig has two side coping fences and a rear fence for repeatable positioning of the workpiece in the jig. They cannot be installed simultaneously. Always place the workpiece against the coping fence that is opposite the cutterhead at the beginning of the operation (see **Figure 10**).



**Figure 10.** Workpiece positioned on jig.

### To install the rear fence:

1. Remove the (4) M6-1 x 16 cap screws securing the coping fences.
2. Position the rear fence for the necessary operation.
3. Secure the rear fence in place using (2) M6-1 x 16 cap screws, as shown in **Figure 11**.

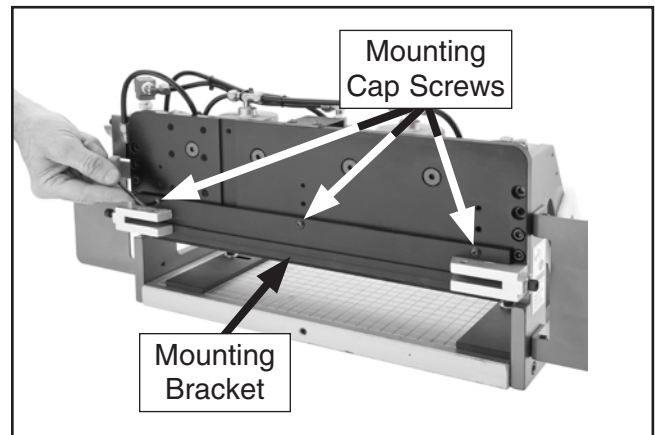


**Figure 11.** Securing the rear fence using M6-1 x 16 cap screw (1 of 2).

**Note:** To install the coping fences simply reverse the above steps.

## Template Mounting Bracket

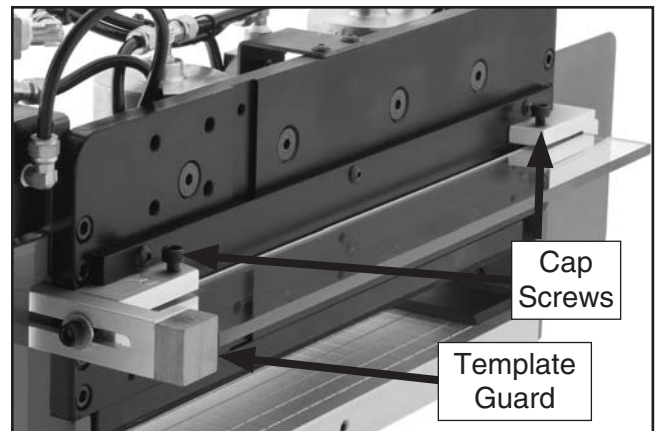
Secure the template mounting bracket to the cylinder plate with (3) M5-.8 x 16 button head cap screws, as shown in **Figure 12**.



**Figure 12.** Installing template mounting bracket.

## Installing Templates

The template mounting bracket lets you change templates for various shaping operations. To mount a template, insert it into the template mounting bracket, and secure it with the (2) M6-1 x 16 cap screws (see **Figure 13**). Position the template guard flush with the front edge of the template to protect the template from damage.

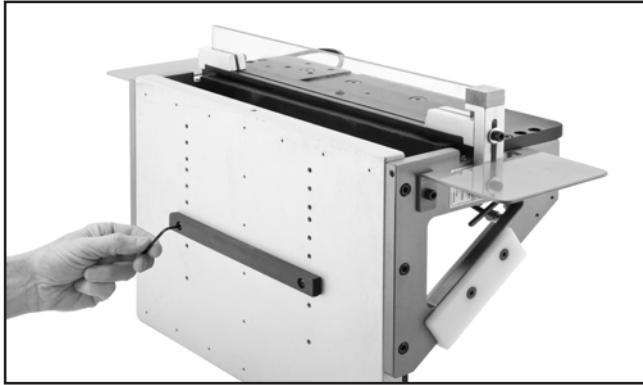


**Figure 13.** Installing the template.



## Miter Bar

The jig can use a  $\frac{3}{8}$  x  $\frac{3}{4}$ " miter bar for straight shaping and table saw operations. Nine positions allow you to adjust the jig-to-cutterhead distance. Attach the miter bar with (2) M5-.8 x 16 button head cap screws for Models T10460/T10462 and (3) M5-.8 x 16 button head cap screws for Model T10464, as shown in **Figure 14**.



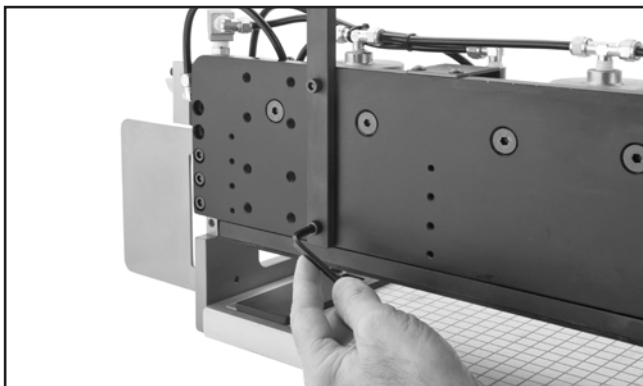
**Figure 14.** Attaching the miter bar to the jig.

## ⚠ CAUTION

Always ensure that the jig base will clear the cutterhead or kickback could occur, causing personal injury or property damage.

## Vertical Fence

The jig has a vertical fence for positioning the workpiece vertically for various shaping operations. To mount the vertical fence, secure it to the cylinder bracket with (2) M6-1 x 16 cap screws, as shown in **Figure 15**.



**Figure 15.** Installing the vertical fence.

## Rub Collar

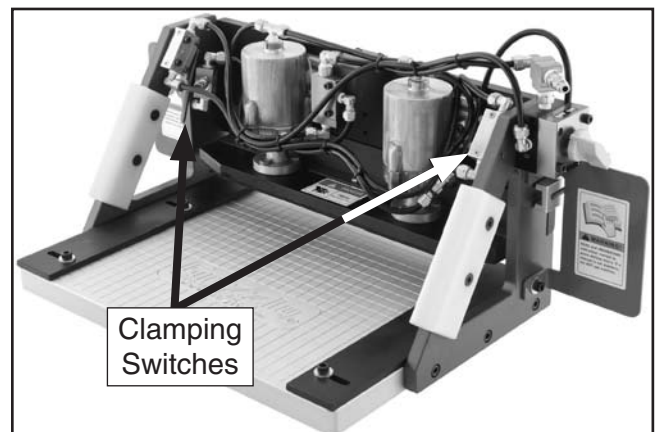
The jig comes with a 6208RS ball bearing rub collar and bushing kit (see **Figure 16**). This rub collar is designed for  $1\frac{1}{4}$ " shaper spindles. Since each shaper will have different rub collar mounting instructions, refer to the shaper owner's manual for rub collar installation instructions.



**Figure 16.** Ball bearing rub collar and bushings.

## Clamping Workpiece

With the workpiece properly positioned, turn the air control valve **ON**. Press and hold both clamping switches shown in **Figure 17**. Doing this clamps the workpiece and provides air to the base for frictionless movement.



**Figure 17.** Clamping the workpiece.



## Using Jig

Before using the jig, take time to review the owner's manual for your shaper to ensure the correct setup and operating procedures.

You are ready to begin shaping when the jig and shaper are properly adjusted, personal protective equipment is on, and safety material has been reviewed.

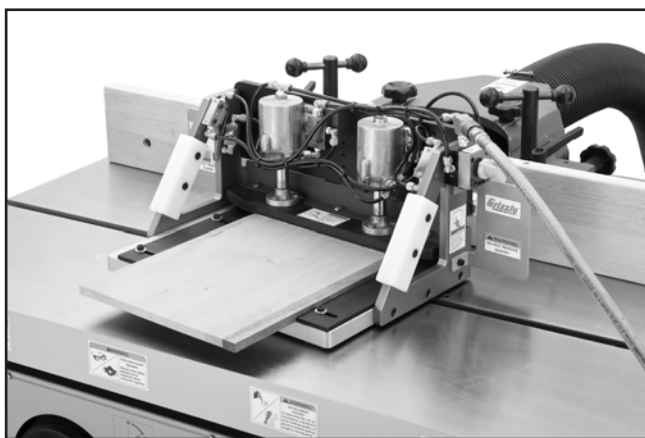
**Tip:** Use a practice piece similar to the workpiece in order to test the results before shaping the workpiece.

### **WARNING**

Disconnect the shaper from power before making any adjustments to the shaper cutterhead or jig. Failure to do so could result in serious personal injury or property damage.

#### To use the jig:

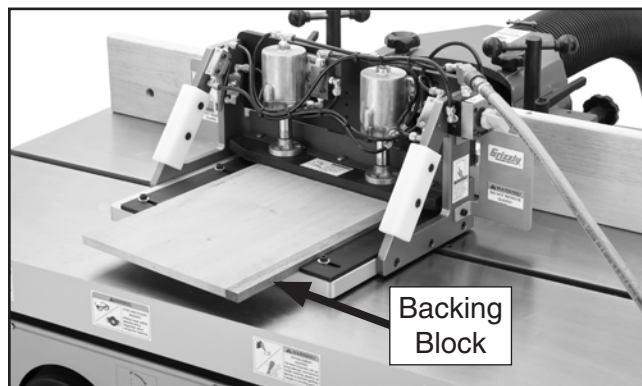
1. Place the jig on the shaper table and connect it to compressed air.
2. Turn the ON/OFF valve **ON**.
3. Position the workpiece and clamp it in the jig, as shown in **Figure 18**.



**Figure 18.** Shaping jig prepared for use with shaper **OFF**.

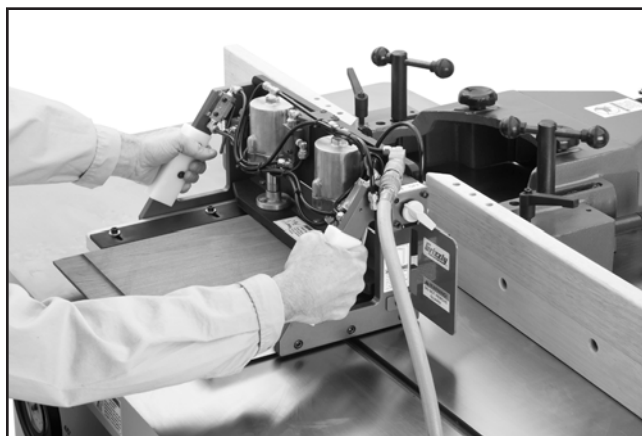
**Note:** When using templates, always center the workpiece with the template to ensure symmetrical results. Always adjust the coping fence or use a spacer block to provide a positive stop for the workpiece.

**Tip:** To prevent tear-out in the workpiece shape end grain first. Wood is less likely to tear while edge-shaping, so any tearout from end grain shaping can be removed. Use a sacrificial backing block between the workpiece and the coping fence as needed to further reduce tearout (see **Figure 19**).



**Figure 19.** Backing block in place.

4. Turn the shaper **ON**.
5. While pressing both clamping switches, as shown in **Figure 20**, move the workpiece slowly against the rotation of the cutterhead until the cut is complete.



**Figure 20.** Shaping jig in use.

6. Turn the shaper **OFF**.
7. Turn the jig ON/OFF valve **OFF**.



# SECTION 4: ACCESSORIES

## **⚠️ WARNING**

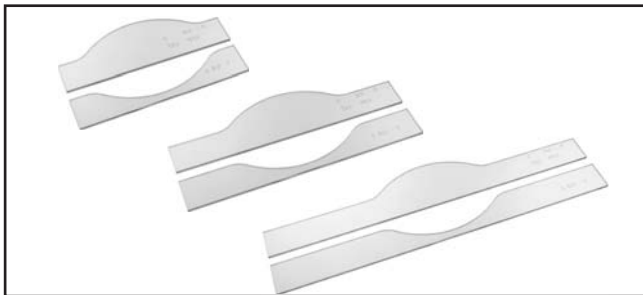
Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

## **NOTICE**

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

**Call 1-800-523-4777 To Order**

**T10461—T10460 Arched Door Templates**  
**T10463—T10462 Arched Door Templates**  
**T10465—T10464 Arched Door Templates**



**Figure 21.** Models T10461, T10463, T10465 arched door templates.

### **T24721—Face Clamps**

This quick action toggle clamp allow you to orient workpieces vertically on the panel shaping jig.



**Figure 22.** Model T24721 Panel Shaping Jig face clamps.

### **T23115—1/2" X 50' Hose Reel**

Heavy-duty rubber air hose inside a heavy gauge all steel reel assembly. 8 position ratchet gear locks reel at desired hose lengths. Also has a 5-position adjustable roller outlet arm.



**Figure 23.** Model T23115 Hose Reel.

### **H7274—Pressure Regulator**

Provides regulated output pressure of 0 to 125 PSI. Includes 0 to 160 PSI gauge, with 15 SCFM flow capacity at 90 PSI, 2 1/4" NPT (F) ports.



**Figure 24.** Model H7274 line regulator.

### **T20881—In-Line Lubricator**

Provides automatic lubrication, extending air tool life. It attaches directly to the tool. 1/4" Female NPT inlet by 1/4" NPT outlet. 0.15 oz. bowl capacity.

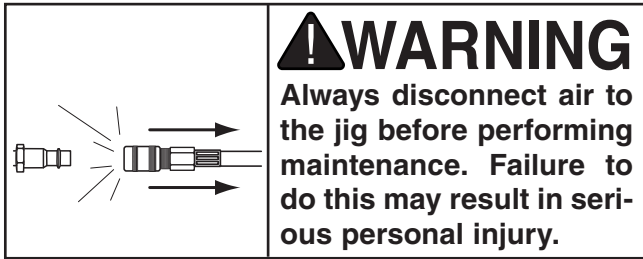


**Figure 25.** Model T20881 in-line lubricator.

**Call 1-800-523-4777 To Order**



# SECTION 5: MAINTENANCE



## Schedule

For optimum performance from the jig, follow this maintenance schedule and refer to any specific instructions given in this section.

### Daily Check

- Loose fasteners.
- Damaged or worn hoses/air lines.
- Air leaks.
- Drain water in air filter collection cups.
- Any other unsafe condition.

### Weekly Maintenance

- Check/adjust lubrication level in lubricator.
- Clean/vacuum dust buildup.

## Cleaning

Cleaning the Model T10460/T10462/T10464 Panel Shaping Jig is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. A light coat of machine oil will keep the aircraft aluminum body and base corrosion free.

## Lubrication

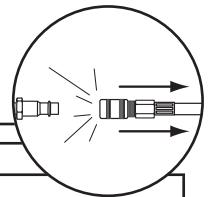
We recommend you use an in-line lubrication system for the jig. This sort of system removes moisture from the air supply before it reaches the jig and will provide lubrication to the air supply system of the jig.

# SECTION 6: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your jig. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

**Note:** Please gather the serial number and manufacture date of your jig before calling.

## Troubleshooting

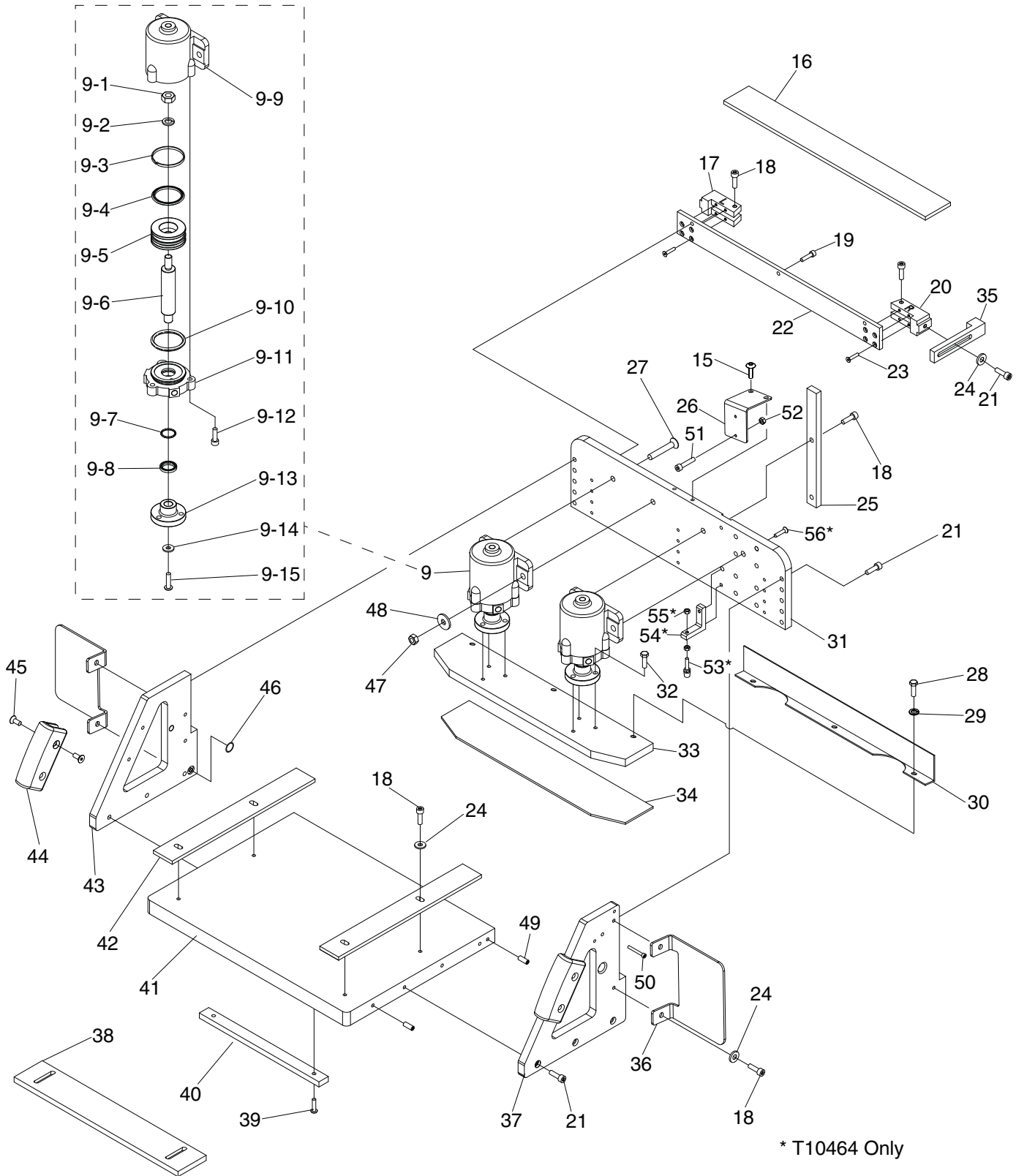


Symptom	Possible Cause	Possible Solution
Jig does not clamp workpiece.	<ol style="list-style-type: none"> <li>1. Insufficient air pressure.</li> <li>2. Air leak.</li> <li>3. Faulty ON/OFF valve.</li> <li>4. Faulty clamping switch.</li> <li>5. Workpiece is warped or misshapen.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust regulator air pressure.</li> <li>2. Find and repair leak.</li> <li>3. Replace ON/OFF valve.</li> <li>4. Replace clamping switch.</li> <li>5. Use a different workpiece.</li> </ol>
Excessive friction when using jig on shaper.	<ol style="list-style-type: none"> <li>1. Faulty airflow valve.</li> <li>2. Burrs or warped base is creating contact despite air cushion.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace airflow valve.</li> <li>2. Remove any burrs or replace warped base.</li> </ol>



# SECTION 7: PARTS

## T10460/T10462/T10464 Main Breakdown



\* T10464 Only



# T10460/T10462/T10464 Parts List

REF	PART #	DESCRIPTION
9	PT10460009	CYLINDER ASSEMBLY
9-1	PN02M	HEX NUT M10-1.5
9-2	PLW06M	LOCK WASHER 10MM
9-3	PT10460009-3	WEAR RING 50 X 46 X 6
9-4	PT10460009-4	PISTON BACKING 50 X 40 X 4
9-5	PT10460009-5	PISTON
9-6	PT10460009-6	PISTON ROD
9-7	PORP020	O-RING 19.8 X 2.4 P20
9-8	PT10460009-8	O-RING DH20
9-9	PT10460009-9	CYLINDER BODY
9-10	PORG045	O-RING 44.4 X 3.1 G45
9-11	PT10460009-11	CYLINDER END COVER
9-12	PCAP07M	CAP SCREW M6-1 X 30
9-13	PT10460009-13	CLAMPING DISC
9-14	PW03M	FLAT WASHER 6MM
9-15	PCAP115M	BUTTON HD CAP SCR M6-1 X 16
16	PT10460016	SQUARE TEMPLATE 11-1/2" (T10460)
16	PT10462016	SQUARE TEMPLATE 16" (T10462)
16	PT10464016	SQUARE TEMPLATE 24" (T10464)
17	PT10460017	LEFT TEMPLATE HOLDER
18	PCAP01M	CAP SCREW M6-1 X 16
19	PCAP24M	CAP SCREW M5-.8 X 16
20	PT10460020	RIGHT TEMPLATE HOLDER
21	PCAP02M	CAP SCREW M6-1 X 20
22	PT10460022	TEMPLATE RACK PLATE 12" (T10460)
22	PT10462022	TEMPLATE RACK PLATE 16" (T10462)
22	PT10464022	TEMPLATE RACK PLATE 24" (T10464)
23	PCAP23M	CAP SCREW M4-.7 X 12
24	PW03M	FLAT WASHER 6MM
25	PT10460025	VERTICAL FENCE
26	PT10460026	FIXED RACK
27	PFH36M	FLAT HD SCR M8-1.25 X 35
28	PB04M	HEX BOLT M6-1 X 10

REF	PART #	DESCRIPTION
29	PLW03M	LOCK WASHER 6MM
30	PT10460030	CLAMPING FENCE 12"
30	PT10462030	CLAMPING FENCE 16"
30	PT10464030	CLAMPING FENCE 24"
31	PT10460031	CYLINDER HOLDING PLATE (T10460)
31	PT10462031	CYLINDER HOLDING PLATE (T10462)
31	PT10464031	CYLINDER HOLDING PLATE (T10464)
32	PB08M	HEX BOLT M6-1 X 20
33	PT10460033	MATERIAL CLAMP
34	PT10460034	HOLDDOWN PAD
35	PT10460035	TEMPLATE GUARD
36	PT10460036	GUARD
37	PT10460037	RIGHT HANDLE
38	PT10460038	FENCE BACK (T10460)
38	PT10460038	FENCE BACK (T10462)
38	PT10460038	FENCE BACK (T10464)
39	PBHS16M	BUTTON HD CAP SCR M5-.8 X 16
40	PT10460040	SLIDING TABLE SUPPORT
41	PT10460041	BASE 11-1/2 X 12" (T10460)
41	PT10462041	BASE 11-1/2 X 16" (T10462)
41	PT10464041	BASE 11-1/2 X 24" (T10464)
42	PT10460042	COPE FENCE
43	PT10460043	LEFT HANDLE
44	PT10460044	GRIP
45	PFH02M	FLAT HD SCR M6-1 X 12
46	PORP009	O-RING 8.8 X 1.9 P9
47	PLN04M	LOCK NUT M8-1.25
48	PW01M	FLAT WASHER 8MM
49	PT10460049	DOWEL PIN
50	PCAP109M	CAP SCREW M5-.8 X 50
51	PCAP162M	CAP SCREW M4-.7 X 25
52	PN04M	HEX NUT M4-.7

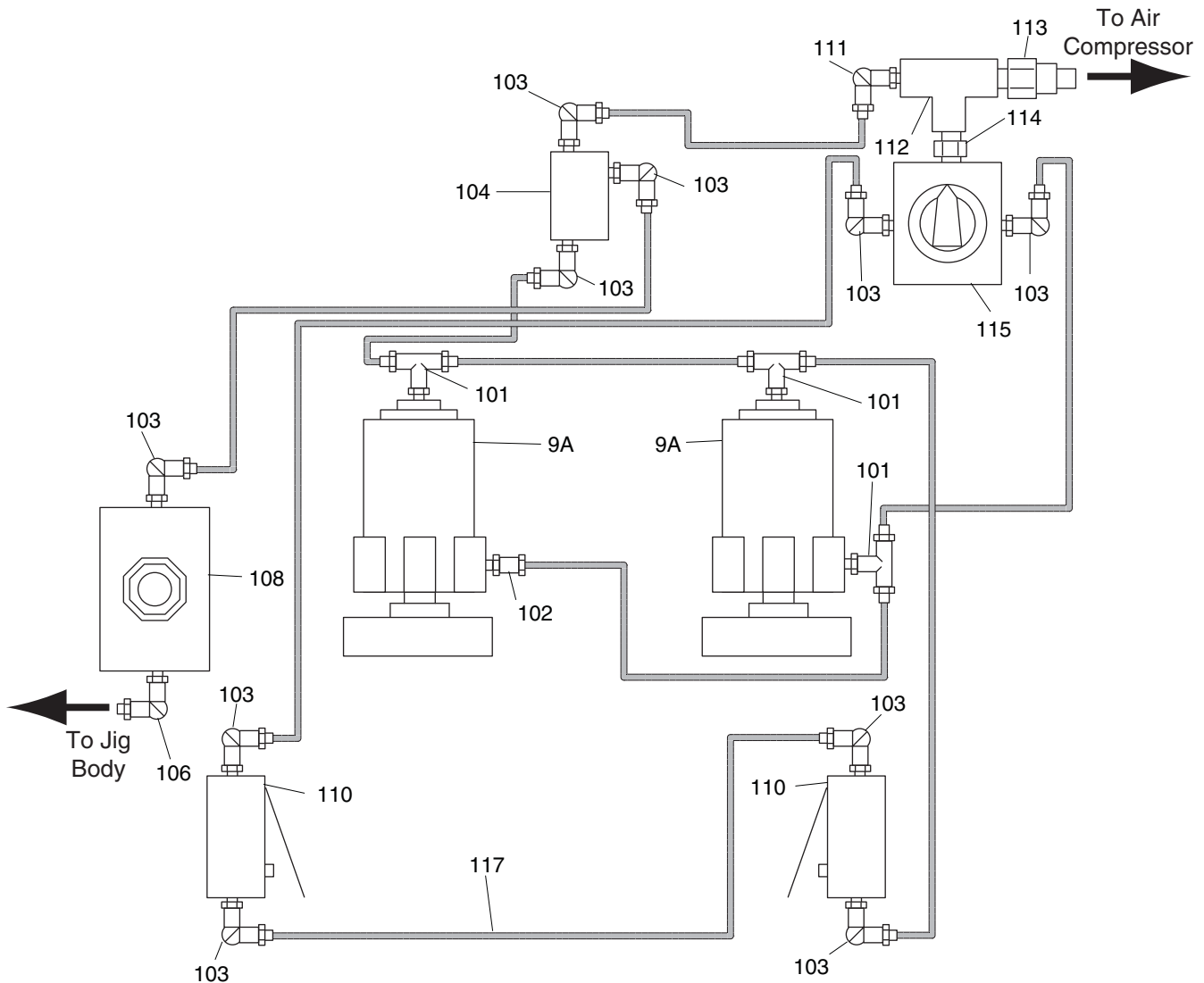
## T10464 Only

REF	PART #	DESCRIPTION
53	PT10464053	RUBBER HEAD SCREW M6-1
54	PT10464054	CLAMP LIMIT SET

REF	PART #	DESCRIPTION
55	PN01M	HEX NUT M6-1
56	PFH54M	FLAT HD SCR M5-.8 X 20

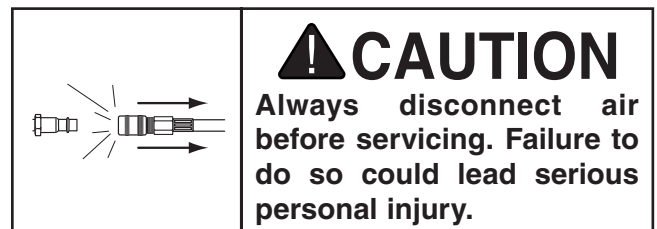


# T10460/T10462/T10464 Pneumatic

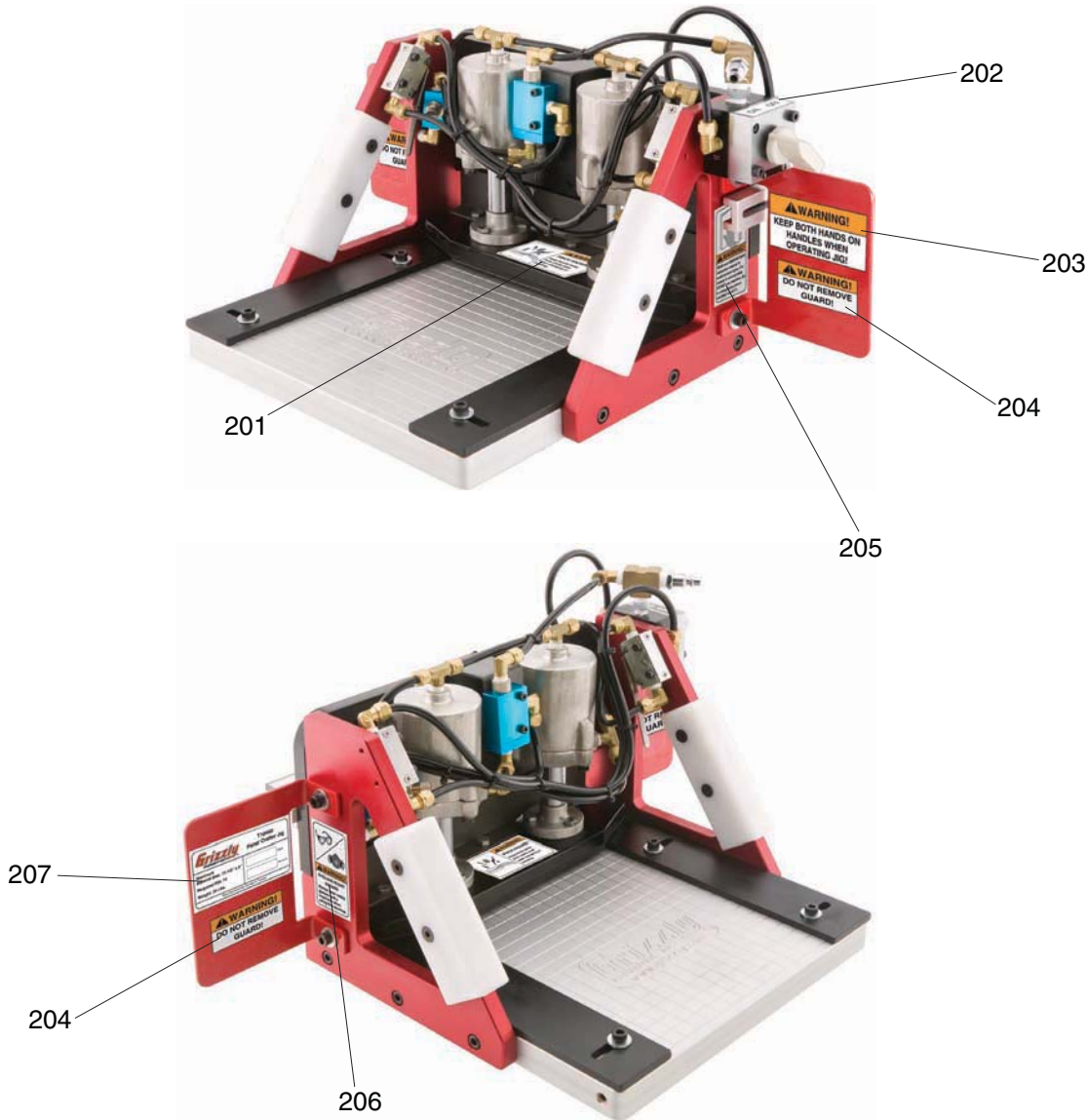


REF	PART #	DESCRIPTION
9	PT10460009	CYLINDER ASSEMBLY
101	PT10460101	T-CONNECTOR 1/8" NPT X 6 X 6MM
102	PT10460102	MALE CONNECTOR 1/8" NPT X 6MM
103	PT10460103	L-CONNECTOR 1/8" NPT X 6MM
104	PT10460104	PILOT CHECK
106	PT10460106	L-CONNECTOR 1/8" NPT X 1/8"
108	PT10460108	AIRFLOW CONTROL VALVE 1/8" NPT

REF	PART #	DESCRIPTION
110	PT10460110	DOUBLE SWITCH
111	PT10460111	L-CONNECTOR 1/4" X 6MM
112	PT10460112	BLOCK 1/4" NPT X 1/4" X 1/4"
113	PT10460113	MALE COUPLING 1/4" NPT
114	PT10460114	CONNECTION 1/4" NPT X 1/8"
115	PT10460115	CONTROL VALVE
117	PT10460117	AIR TUBING 6 X 4MM



# T10460/T10462/T10464 Labels



REF	PART #	DESCRIPTION
201	PT10460201	PINCH HAZARD LABEL
202	PT10460202	ON/OFF VALVE LABEL
203	PT10460203	USE BOTH HANDS LABEL
204	PT10460204	DO NOT REMOVE GUARD LABEL
205	PT10460205	READ MANUAL LABEL

REF	PART #	DESCRIPTION
206	PT10460206	GLASSES/REGULATOR LABEL
207	PT10460207	MACHINE ID LABEL (T10460)
207	PT10462207	MACHINE ID LABEL (T10462)
207	PT10464207	MACHINE ID LABEL (T10464)

## **⚠️ WARNING**

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or [www.grizzly.com](http://www.grizzly.com).







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