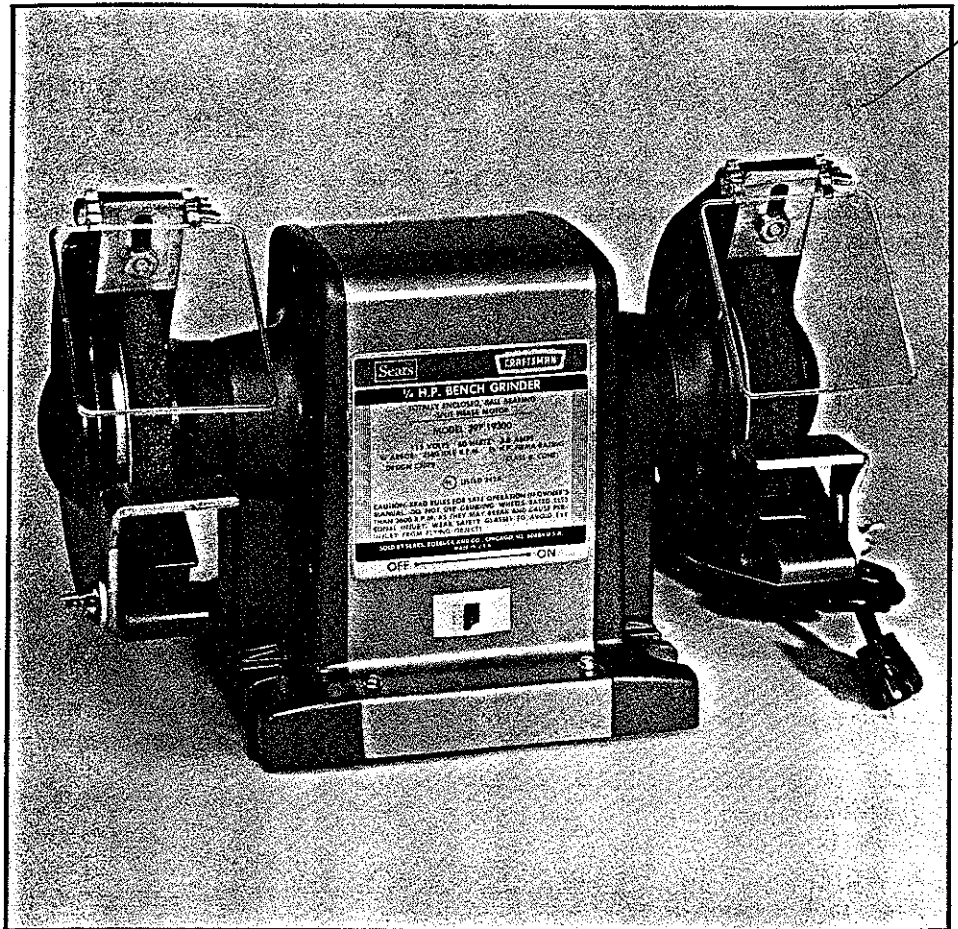


**Sears**

*Owner's  
Manual*



**MODEL NO.  
397.19300**

# **CRAFTSMAN**

## **1/4 H.P. GRINDER**

**CAUTION!**  
Read Rules for  
Safe Operation  
and Instructions  
carefully

- Assembly
- Installation
- Operation
- Repair Parts

Sold by SEARS, ROEBUCK AND CO., Chicago, IL 60684, U.S.A.

# RULES FOR SAFE OPERATION

Read instructions before using grinder

## — FOR BENCH GRINDERS —

1. **EXAMINE GRINDING WHEELS FOR CRACKS** or other damage before operating. Replace cracked wheel immediately.
2. **DO NOT OVER-TIGHTEN WHEEL NUTS.**
3. **USE ONLY WHEEL FLANGES FURNISHED WITH GRINDER.** Use of other flanges may cause damage or breakage of the grinding wheel and result in injury to the operator.
4. **MOUNT THE GRINDER SECURELY** to prevent damage. See "INSTALLATION" page.
5. **DO NOT FORCE WORK** against the grinding wheel! Excessive pressure may cause damage or breakage of the grinding wheel, resulting in injury to the operator or bystander.
6. **STOP GRINDER BEFORE MAKING ADJUSTMENTS.**

## — FOR ALL 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 it on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations. Keep work area well lit.
5. **KEEP CHILDREN AND VISITORS AWAY.** Remove starter keys and turn off master switches. Padlock equipment or work area when not in use.
6. **DONT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
7. **USE RIGHT TOOL.** Don't force tool or attachment to do a job it was not designed for.
8. **WEAR PROPER APPAREL.** No loose clothing or jewelry to get caught in moving parts. Rubber-soled footwear is recommended for best footing.
9. **USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty.
10. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
11. **DON'T OVERREACH.** Keep proper footing and balance at all times.
12. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
13. **DISCONNECT TOOLS** before servicing; when changing accessories such as blades, bits, cutters, etc.
14. **AVOID ACCIDENTAL STARTING.** Make sure switch is in "Off" position before plugging in.
15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause hazards.
16. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
17. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to assure that it will operate properly and perform its intended function — check for alignment of moving parts, binding of moving parts, breaking 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.
18. **GROUND THE OUTLET BOX** to prevent possible fatal shocks. See "OPERATION" page.



THIS SAFETY SEAL OF THE POWER TOOL INSTITUTE ASSURES YOU:

1. That the manufacturer's power tools, including the particular tool associated with the Seal, are produced in accordance with applicable Standards for Safety of Underwriter's Laboratories.
2. That compliance with applicable safety standards is assured by independent inspection and testing conducted by Underwriter's Laboratories (UL).
3. That every motorized tool is inspected under power.
4. That every tool has with it adequate instructions and a list of safety rules for the protection of the user.
5. That the tool manufacturer is a member of the Power Tool Institute and is a sponsor of the Institute's Consumer Safety Education Program.

COPYRIGHT, 1969, BY POWER TOOL INSTITUTE, INC. ALL RIGHTS RESERVED

**CRAFTSMAN FULL ONE YEAR WARRANTY  
ON BENCH GRINDERS**

If this Craftsman bench grinder fails to give complete satisfaction within one year from the date of purchase, return it to any Sears store throughout the United States and it will be replaced free of charge.

***CUSTOMER'S RESPONSIBILITIES***

**WARNING: MAKE SURE RECEPTACLE BOX IS PROPERLY GROUNDED. OPERATION WITHOUT GROUNDING CAN CAUSE SERIOUS ELECTRICAL SHOCKS WHICH MIGHT BE FATAL.**

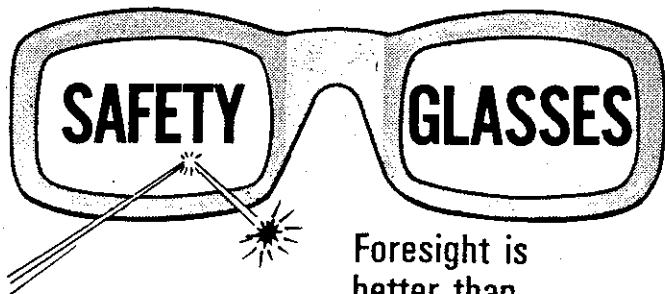
This grinder will start and operate on a 115 volt lighting circuit.

Replace a damaged or worn cord immediately.

If necessary to use an extension, use only 3-wire cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tool's plug. The following chart of lengths and wire sizes must be followed for safe operation.

Length of Extension	Wire Size Required (American Wire Gauge No.)
15 feet or less	No. 14
50 feet or less	No. 12
100 feet or less	No. 10

**WEAR YOUR**



**Foresight is better than NO sight!**

**THE OPERATION OF ANY POWER TOOL CAN RESULT IN FOREIGN OBJECTS BEING THROWN INTO THE EYES, WHICH CAN RESULT IN SEVERE EYE DAMAGE. ALWAYS WEAR SAFETY GLASSES OR EYE SHIELDS BEFORE COMMENCING POWER TOOL OPERATION.** We recommend Wide Vision Safety Mask for use over eye glasses or standard safety glasses . . . available at Sears retail or catalog stores.

# ASSEMBLY

INSPECT GRINDING WHEELS FOR DAMAGE BEFORE USING.

## STEP 1

Attach wheel covers to wheel guards using six screws (8-32 x 3/8 Hx. Hd.) furnished. See figure 1.

## STEP 2

Attach spark arrester to top front of wheel guard as shown. Note that head of screw (5/16-18 x 1/2 Pan Head) with lockwasher attached, slides into slot provided. Adjust spark arrester to 1/16 inch from wheel and tighten nut. See figure 1.

## STEP 3

Fasten eyeshield to top of wheel guards using bolts — (1/4-20 x 2 1/4) and wing nuts. See figure 1.

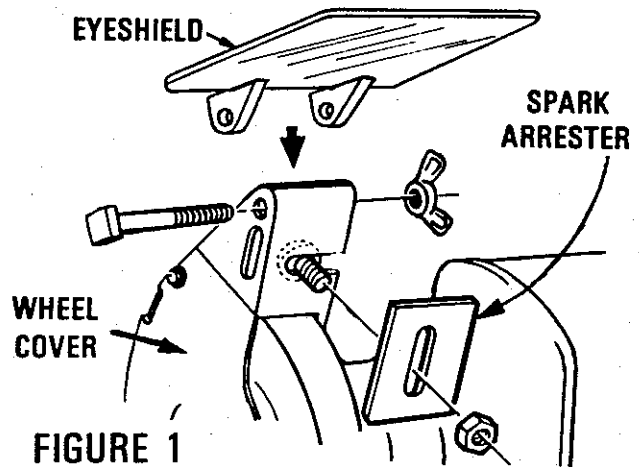


FIGURE 1

## STEP 4

Attach tool rests to bottom front of wheel guards inserting bolts — 5/16-18 x 3/4 from inner side of guards as shown. Add washers and wing nuts. See figure 2.

## STEP 5

Insert 4 base bushings in slots provided at each corner of base as shown in illustration. *Thick section of bushing extends below grinder base.* See figure 2.

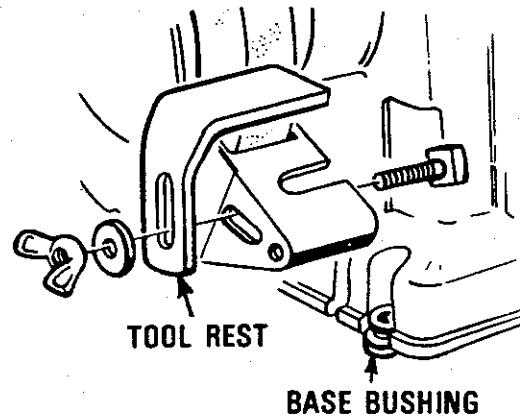


FIGURE 2

## STEP 6

The illustration shows how the washer spacer is assembled to your grinder when accessories are used. See figure 3. Spacer washers are not used or required with standard grinding wheels.

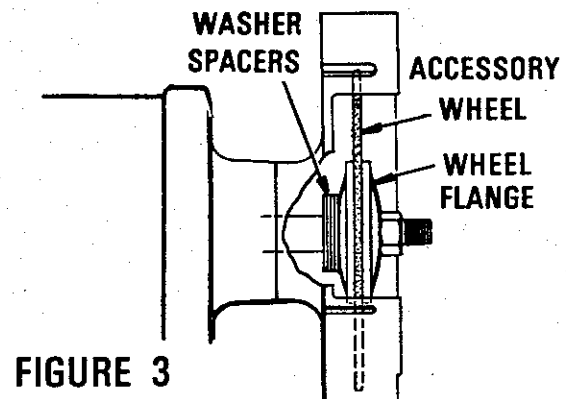


FIGURE 3

# INSTALLATION

Grinder must be mounted on horizontal surface.

The Craftsman grinder pedestal available at Sears retail or catalog store is designed especially for your grinder. Use of the pedestal will permit greater accessibility to your unit for grinding, buffing and many other uses.

To mount your grinder to the pedestal, align slots in base with corresponding holes in table of the pedestal. Use two 5/16 bolts 2 inches long with flat washers beneath the heads. Tighten nuts until space between grinder base and pedestal is 3/16 inch. See figure 4.

Using a second nut on each bolt, jam-tighten against the first to prevent loosening by vibration.

A Craftsman Workbench provides a good mounting for your grinder, when drawer space is desired as well as surface space.

To mount your grinder to the bench top use two 5/16 wood screws 2 inches long with flat washers beneath the heads. Tighten screws until clearance between base and surface of bench is 3/16 inch. See figure 5.

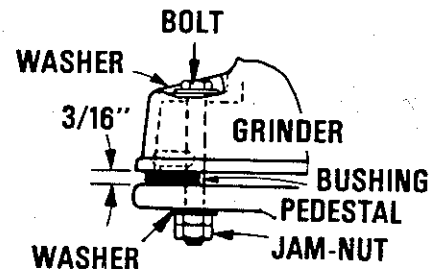


FIGURE 4

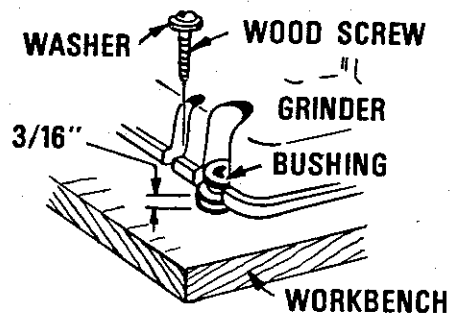


FIGURE 5

## OPERATION

- Replace cracked wheel immediately.
- Always use guards and eye shields.
- Do not overtighten wheel nut.
- Use only flanges furnished with this grinder.

This grinder is equipped with an approved three-conductor cord and a three-prong grounding type plug to fit the proper grounding type receptacle. The green (or green and yellow) conductor in the cord is the grounding wire. Never connect the green (or green and yellow) wire to a live terminal. An adapter, Figure 7 & 8 is available for connecting Figure 6 plugs to two-prong receptacles. The green-colored rigid ground lug extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

**MAKE SURE OUTLET BOX IS PROPERLY GROUNDED. OPERATION WITHOUT GROUNDING CAN CAUSE SERIOUS ELECTRICAL SHOCKS WHICH MIGHT BE FATAL.**

Use only three-wire extension cords that have three-prong grounding type plugs and three-pole receptacles that accept the tool plug. (Figure 6.)

SEE CUSTOMER'S RESPONSIBILITIES ON PAGE 3

Replace or repair damaged or worn cord immediately.

If this grinder is not required to start under load and is not overloaded after starting, the standard 15 ampere lighting circuit fuses should be satisfactory. Otherwise use a "delayed-action" type fuse designed to meet the demands of motor protection and minimize possible nuisance of "blown" fuses from momentary overloading.

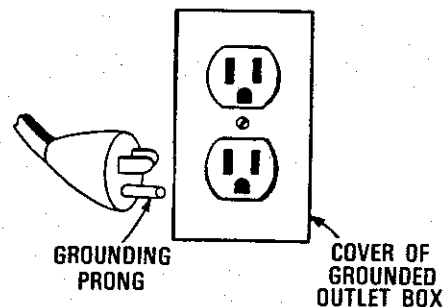


FIGURE 6

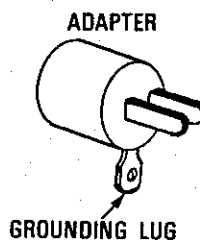


FIGURE 7

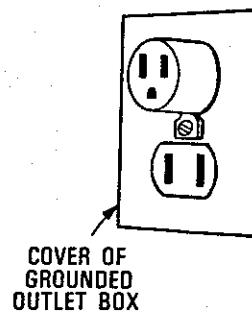


FIGURE 8

# OPERATION - CONT'D

## 1. WARNING:

BE SAFE! PROTECT YOUR EYES. WEAR APPROVED SAFETY GLASSES, AND ASSEMBLE EYE SHIELDS FURNISHED WITH YOUR GRINDER. STAND AWAY FROM FRONT OF GRINDER DURING FIRST MINUTE OF OPERATION.

THE OPERATION OF ANY POWER TOOL CAN RESULT IN FOREIGN OBJECTS BEING THROWN INTO THE EYES, WHICH CAN RESULT IN SEVERE EYE DAMAGE. ALWAYS WEAR SAFETY GLASSES OR EYE SHIELDS BEFORE COMMENCING POWER TOOL OPERATION. We recommend Wide Vision Safety Mask for use over eye glasses or standard safety glasses . . . available at Sears retail or catalog stores.

2. To start, move switch to "ON" position. If grinder does not start immediately, disconnect power and check for voltage at power source.
3. The tool rests should be positioned securely so that a clearance of approximately 1/16 inch can be maintained between wheel and tool rests. Adjust the tool rest so that the material to be ground will contact the wheel slightly above center-line of shaft at the desired angle, as shown in figure 9.

## WARNING:

ADJUSTMENTS SHOULD BE MADE ONLY WHEN GRINDER HAS STOPPED TO PROTECT AGAINST INJURY.

## 4. WARNING:

DO NOT GRIND ON SIDE OF WHEELS!  
DO NOT FORCE WORK AGAINST THE GRINDING WHEEL! EXCESSIVE PRESSURE MAY CAUSE DAMAGE OR BREAKAGE TO THE GRINDING WHEEL, RESULTING IN INJURY TO THE OPERATOR OR BYSTANDER.

SEE CUSTOMER'S RESPONSIBILITIES ON PAGE 3

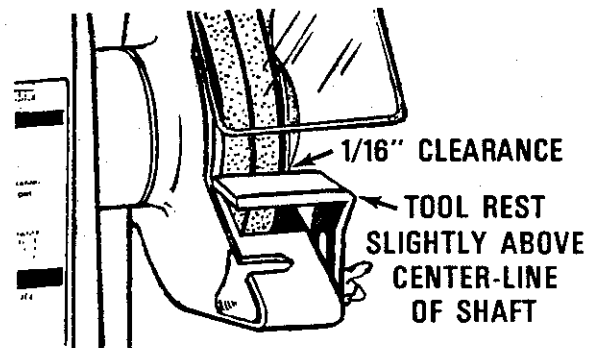


FIGURE 9

# MAINTENANCE

1. When vitrified wheels become irregular or glazed from use, they may be trued and cleaned, returning them to near-new condition with the cutting face fresh and square. Use a Sears wheel dresser to keep your wheels in good condition. Available at Sears retail stores or through catalog.

**WARNING: WHEEL GUARDS AND COVERS MUST BE ASSEMBLED WHEN WHEEL DRESSER IS USED TO PROTECT OPERATOR FROM INJURY.**

2. Clean out any accumulation of cuttings and abrasive each time outer cover is removed.

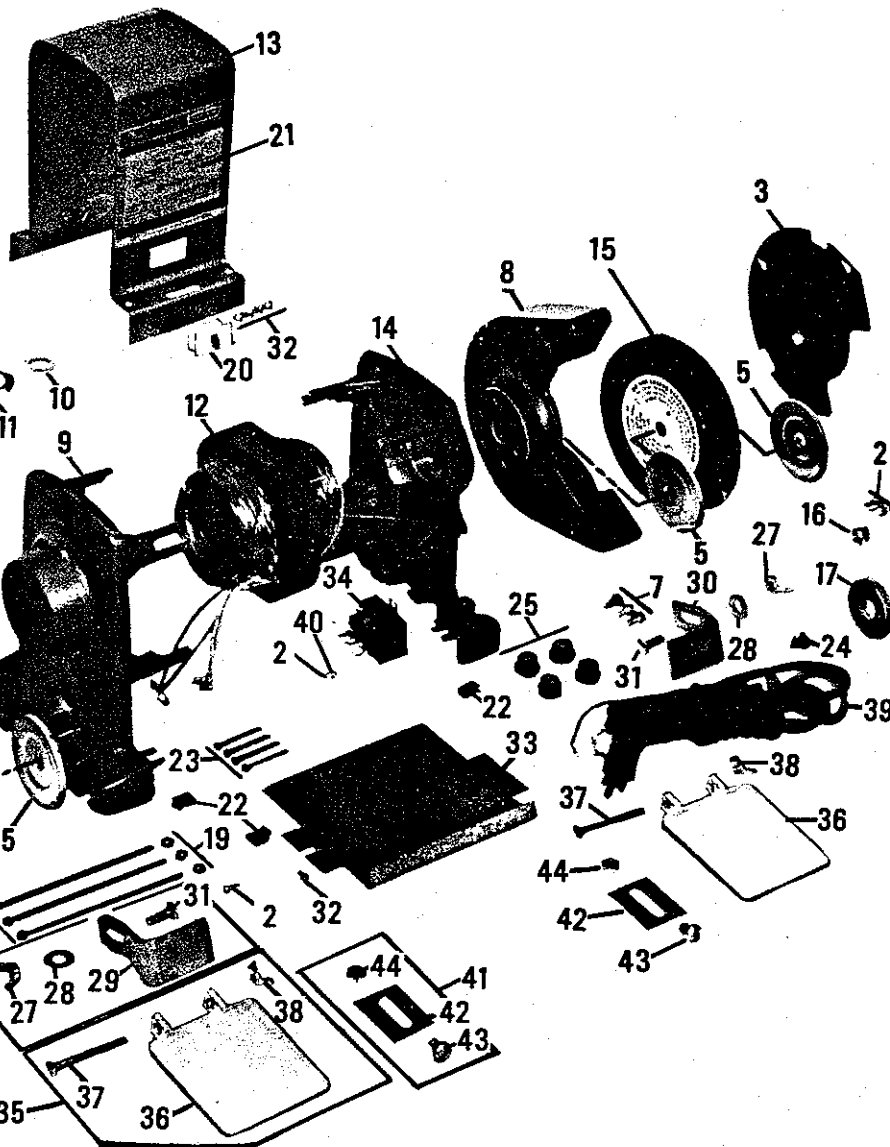
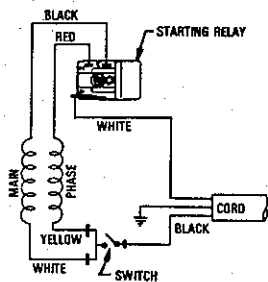
3. Examine replacement grinding wheel for cracks or other damage before assembling to spindle.

4. When replacing grinding wheels DO NOT OVER-TIGHTEN NUT. EXCESSIVE PRESSURE CAN DAMAGE WHEEL. Be sure flanges and wheel blotters are free of foreign particles and tighten only sufficiently to drive the wheel. Be sure the maximum speed rating of your replacement wheel corresponds to or exceeds the rating of your grinder nameplate.

5. Lubrication was provided at the factory for the life of the ball bearings.

**BE SAFE—OBSERVE ALL THE RULES FOR SAFE OPERATION !**

CRAFTSMAN 1/4 H.P. GRINDER – MODEL NUMBER 397.19300



REPAIR PARTS

Key	Part No.	PART NAME	Qty.	Key	Part No.	PART NAME	Qty.
1	4992102	Rotor & Bearing Assembly	1	24	3169206	Grommet	1
2	9421091	*Screw, 8-32 x 3/8 Hex Head Slotted	8	25	5537401	Base Bushing	4
3	3160353	Wheel Cover	2	26	4998257	Tool Rest Pack (Includes R.H. & L.H. Set)	1
4	9428172	Nut, 1/2-20 Hex (L.H. Thread)	1	27	142745	*Wing Nut, 5/16-18	2
5	4971420	Wheel Flange	4	28	120387	*Washer, 5/16 Flat	2
6	3161746	*Grinding Wheel (36 Grit – Coarse) (L.H.)	1	29	4998263	Tool Rest (L.H.)	1
7	5353426	*Screw, 1/4-20 x 1/2 Hex Head Self Tap	6	30	4998262	Tool Rest (R.H.)	1
8	3160352	Wheel Guard	2	31	149535	*Bolt, 5/16-18 x 3/4 Sq. Head	2
9	4988540	End Frame (L.H.)	1	32	9434158	*Screw, 8-15 x 1/2 Hex Hd Self Tap	5
10	3167424	Felt Washer	2	33	3168889	Cover	1
11	5211995	Ball Bearing Spring	2	34	4948850	Starting Relay	1
12	4990623	Stator and Coil Assembly	1	35	3161437	Eyeshield Pack (Includes 36, 37, 38 - 2 ea.)	1
13	4990628	Cover Band	1	36	3161434	Eyeshield	2
14	4988542	End Frame (R.H.) Cable End	1	37	5520393	*Screw, 1/4-20 x 2 1/2 Sq. Head	2
15	3161745	*Grinding Wheel (60 Grit – Fine) (R.H.)	1	38	3161433	*Wing Nut, 1/4-20	2
16	124934	*Nut, 1/2-20 Hex	1	39	5545336	Cable Assembly	1
17	5375637	*Spacer (Accessory) 1/2 I.D.	4	40	453299	*Lockwasher No. 8	1
18	4971779	Thru Bolt, 10-32 Hex Head	3	41	3176154	Spark Arrester Pack (Incl. 2 ea. 42, 43, 44)	1
19	3169218	*Nut, 10-32 Hex	3	42	3175504	Spark Arrester	2
20	4984992	Switch	1	43	442689	Screw and L.W., 5/16-18 x 1/2 Pan Head	2
21	4990702	Name Plate	1	44	134556	*Nut, 5/16-18 Hex	2
22	3161432	Spring Clip	5		4990632	Owner's Manual (Not Illustrated)	
23	4990630	*Screw 8-32 x 1 1/2 Fill Hd. Self Tap	4				

\*Standard Hardware Items – May be purchased locally.

**Sears**

**Owner's  
Manual**

**MODEL NO.  
397.19300**

**Sears  
SERVICE  
is at  
YOUR  
SERVICE  
wherever YOU  
live or move  
in the U.S.A.  
or Canada.**

## HOW TO ORDER REPAIR PARTS

The Model Number will be found on the name plate attached to the front of the Cover Band of your Grinder. Always mention the Model Number when requesting service or repair parts for your CRAFTSMAN GRINDER.

All parts listed herein may be ordered through SEARS. When ordering parts by mail, selling prices will be furnished on request or parts will be shipped at prevailing prices and you will be billed accordingly.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN THIS LIST.

1. The PART NUMBER
2. The PART DESCRIPTION
3. The MODEL NUMBER  
397.19300
4. The NAME OF ITEM—  
GRINDER

Your Sears merchandise takes on added value when you discover that Sears has over 2,000 Service Units throughout the country. Each is staffed by Sears-trained, professional technicians using Sears approved parts and methods.

Sold by SEARS, ROEBUCK AND CO., Chicago, IL 60684, U.S.A.