

Sears

***Owner's
Manual***

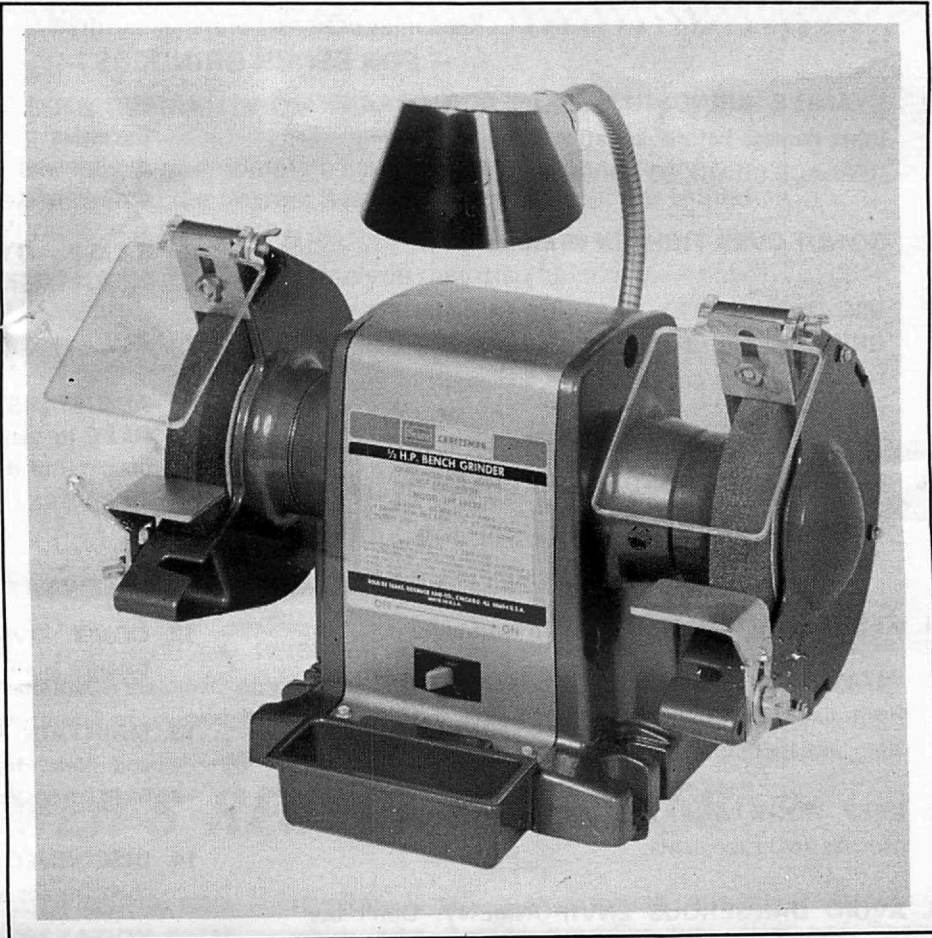
**MODEL NO.
397.19340**

SERIAL
NO. _____

MODEL AND SERIAL
NUMBER MAY BE FOUND
ON THE NAMEPLATE
LOCATED ON THE
FRONT OF THE TOOL.

YOU SHOULD RECORD
BOTH MODEL AND
SERIAL NUMBER AND
RETAIN IN A SAFE
PLACE FOR FUTURE
USE.

DANGER —
For Your Own
Safety, Read
and Understand
this Manual
Before
Operating
Grinder.



CRAFTSMAN

1/2 H.P. GRINDER

- Assembly
- Installation
- Operation
- Repair Parts

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

Printed in U.S.A. 5/77

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 to 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.**
7. **ALWAYS USE GUARDS AND EYESHIELDS.**
8. **ADJUST DISTANCE BETWEEN WHEEL AND WORK REST** to maintain 1/16 inch or less separation as the diameter of the wheel decreases with use.

— 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 or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from work area.
6. **MAKE WORKSHOP KID-PROOF** with padlocks, master switches or by removing starter keys.
7. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Don't force tool or attachment to do a job it was not designed for.
9. **WEAR PROPER APPAREL.** No loose clothing or jewelry to get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
10. **USE SAFETY GOGGLES** which comply with ANSI Z87.1-1968. Also use face or dust mask if cutting operation is dusty.
11. **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.
12. **DON'T OVERREACH.** Keep proper footing and balance at all times.
13. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
14. **DISCONNECT TOOLS** before servicing; when changing accessories such as blades, bits, cutters, etc.
15. **AVOID UNINTENTIONAL STARTING.** Make sure switch is in "Off" position before plugging in.
16. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause hazards.
17. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
18. **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.
19. **GROUND THE OUTLET BOX** to prevent possible fatal shocks. See "OPERATION" page.
20. **NEVER LEAVE TOOL RUNNING UNATTENDED.**



power tool institute, inc.

FULL ONE YEAR WARRANTY ON CRAFTSMAN GRINDER

If this Craftsman Grinder fails to give complete satisfaction within one year from the date of purchase, return it to the nearest Sears store throughout the United States and Sears will replace it free of charge.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

SEARS, ROEBUCK AND CO.
BSC 41-3
SEARS TOWER
CHICAGO, IL 60684

COMPARISON OF RATED HORSEPOWER AND DEVELOPED HORSEPOWER

A **RATED** horsepower motor normally has approximately **TWICE** the breakdown torque strength, **TWICE** the maximum momentary power output capability and **TWICE** the power output capability for prolonged operation without damage, when compared to a **DEVELOPED** horsepower motor of the same horsepower.

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. Use a 15 ampere "delayed action" fuse.

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



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 GOGGLES WHICH COMPLY WITH AMERICAN NATIONAL STANDARD (ANSI) Z87.1-1968 BEFORE COMMENCING POWER TOOL OPERATION.

Additional face protection is available by use of Wide-Vision Face Mask which may be obtained at your 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 Hd) 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 guard using bolts – (1/4-20 x 2 1/4) and wing nuts. See figure 1.

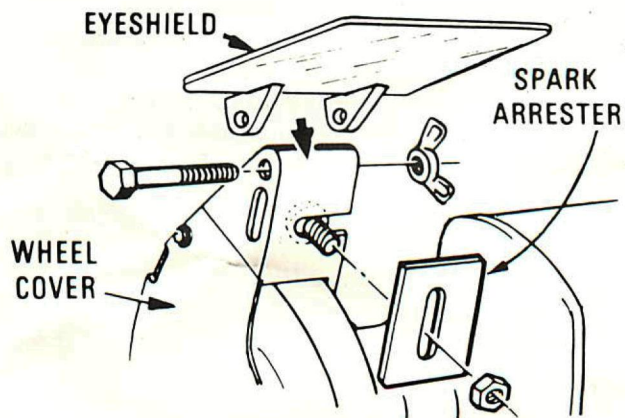


FIGURE 1

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.

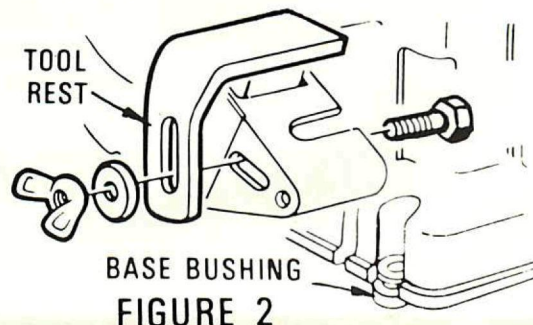


FIGURE 2

STEP 6

Assemble lamp shade cover to metal lamp shade with screw 8-32 x 1/4 Pan Hd. Clamp this assembly to lamp holder. Either 40 watt "regular" or 50 watt "rough service" bulbs are recommended in your grinder lamp. See figure 3.

STEP 7

Mount quench tray to front of cover band in knockout slot provided. Lip at side of tray hooks into slot. See figure 3.

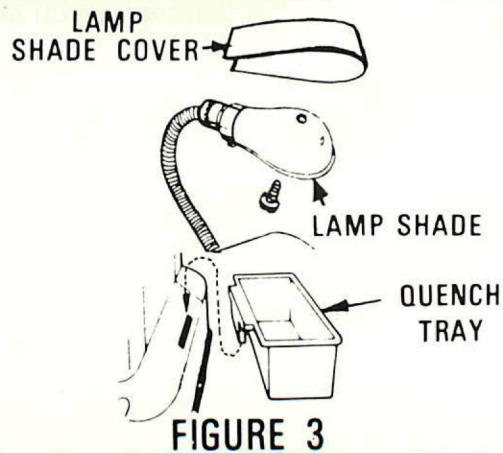


FIGURE 3

STEP 8

The illustration shows how the washer spacers are assembled to your grinder when buffing wheels and other accessories are used. See Figure 4. Spacer washers are not used or required with standard grinding wheels.

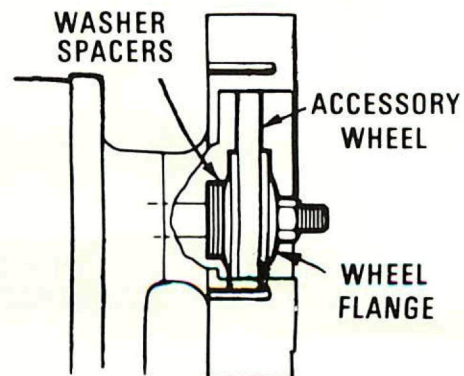


FIGURE 4

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 5.

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 6.

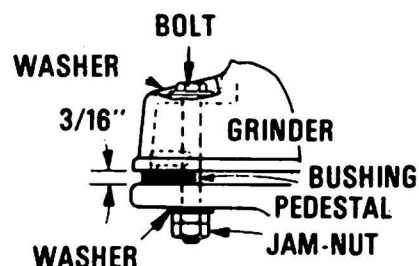


FIGURE 5

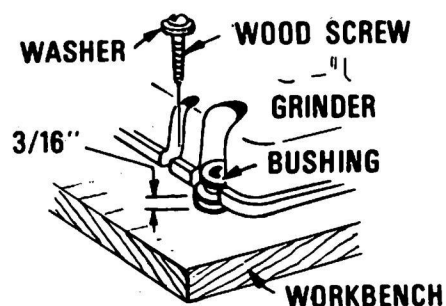


FIGURE 6

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 8 & 9 is available for connecting Figure 7 plugs to two-prong receptacles. The green-colored rigid grounding 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 7).

SEE CUSTOMER'S RESPONSIBILITIES ON PAGE 3

Replace or repair damaged or worn cord immediately.

This grinder will start and operate on a 115 volt lighting circuit. Use a 15 ampere "delayed action" fuse.

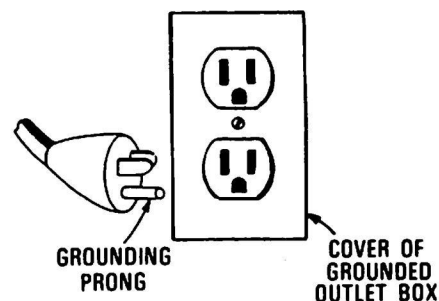


FIGURE 7

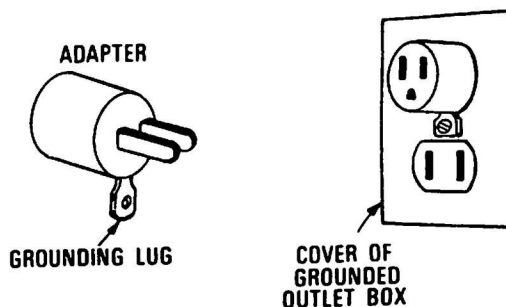


FIGURE 8

FIGURE 9

OPERATION - CONT'D

1. WARNING:

BE SAFE! PROTECT YOUR EYES. WEAR APPROVED SAFETY GOGGLES WHICH COMPLY WITH ANSI Z87.1-1968. 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 GOGGLES BEFORE COMMENCING POWER TOOL OPERATION.

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 10.

WARNING:

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

4. WARNING:

DO NOT GRIND ON SIDE OF WHEEL. 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

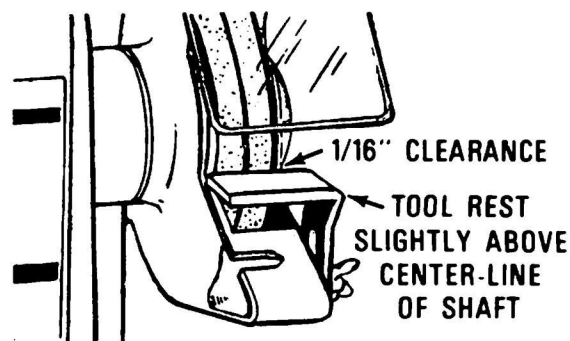


FIGURE 10

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 GUARD AND COVER MUST BE ASSEMBLED WHEN WHEEL DRESSER IS USED TO PROTECT OPERATOR FROM INJURY.

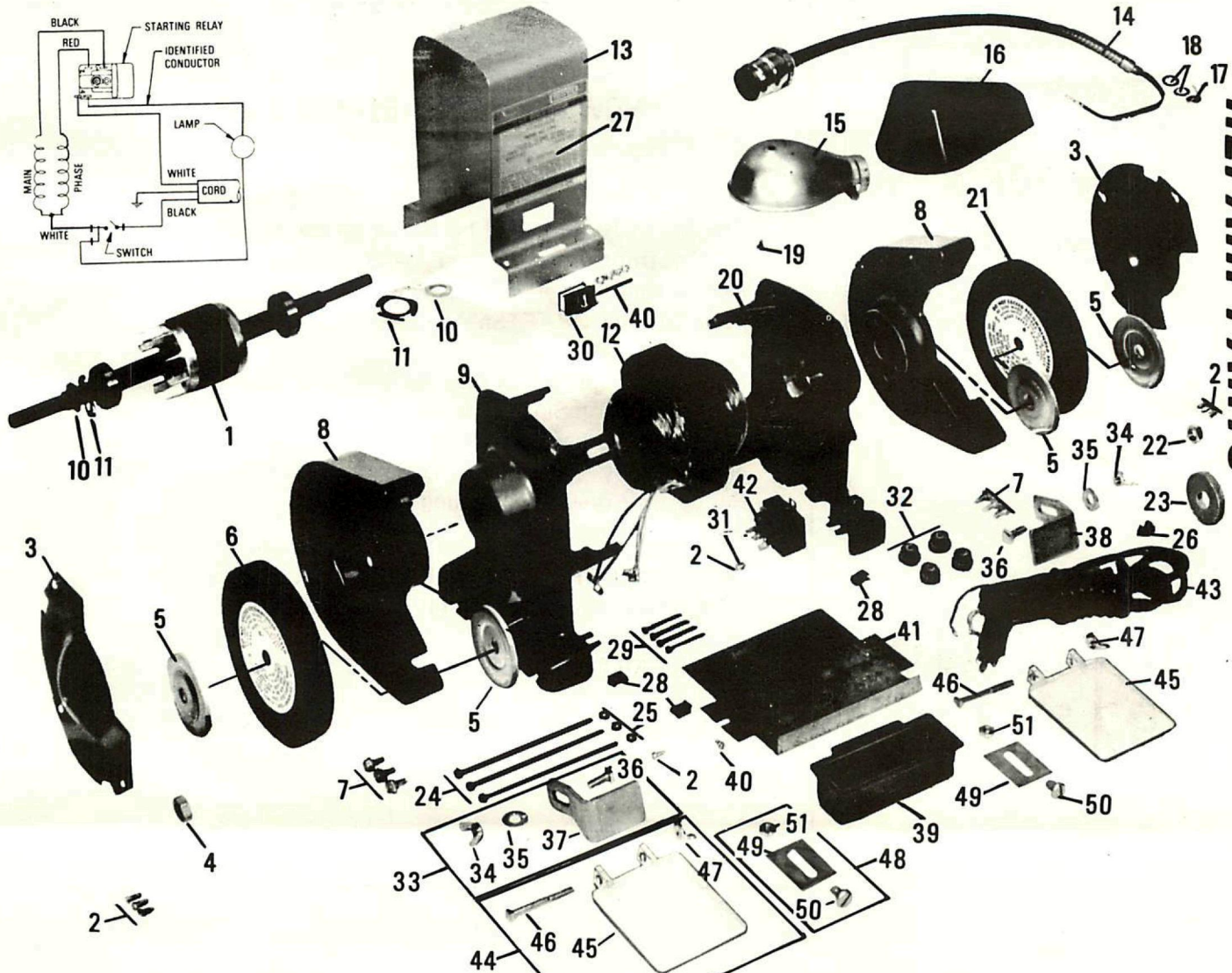
2. Replace grinding wheel when diameter has been reduced 1" through wear. Undersize wheels are a hazard to operator safety as proper spark arrestor and tool rest adjustments cannot be maintained with undersize wheels. Replacement wheels are available at Sears retail or catalog stores.

3. Examine replacement grinding wheel for cracks or other damage before assembling to spindle.
4. Clean out any accumulation of cuttings and abrasive each time outer wheel cover is removed.
5. When replacing grinding wheels DO NOT OVERTIGHTEN NUT. EXCESSIVE PRESSURE CAN DAMAGE WHEEL. We recommend that wheel nuts be tightened to 75 inch pounds. Be sure flanges and wheel blotters are free of foreign particles. Be sure the maximum speed rating of your replacement wheel corresponds to or exceeds the rating of your grinder nameplate.
6. Lubrication was provided at the factory for the life of the ball bearings.

BE SAFE—OBSERVE ALL THE RULES FOR SAFE OPERATION !

CRAFTSMAN 1/2 H.P. GRINDER – MODEL NUMBER 397.19340

REPAIR PARTS



Key	Part No.	PART NAME	Qty.	Key	Part No.	PART NAME	Qty.
1	22005336	Rotor and Bearing Assembly	1	28	3161432	Spring Clip	5
2	STD600803	*Screw, 8-32 x 3/8 Hex Hd Slotted Self Tap	8	29	9437389	Screw, 8-32 x 1-3/4 Hx Hd Self Tap	4
3	3160353	Wheel Cover	2	30	4984992	Switch	1
4	9428172	Nut, 1/2-20 Hex (L.H. Thread)	1	31	STD551108	*Lockwasher, No. 8	1
5	22001523	Wheel Flange	4	32	5537401	Base Bushing	4
6	5201093	*Grinding Wheel (Coarse-36 Grit) (L.H.)	1	33	4998257	Tool Rest Pack (Inc. R.H. & L.H. Set)	1
7	5353426	*Screw, 1/4-20 x 1/2 Hex Hd Self Tap	6	34	STD541631	*Wing Nut, 5/16-18	2
8	3160352	Wheel Guard	2	35	STD551031	*Washer, 5/16 Flat	2
9	4988540	End Frame (L.H.)	1	36	STD523107	*Bolt, 5/16-18 x 3/4 Hex Head	2
10	3167424	Felt Washer	2	37	4998263	Tool Rest (L.H.)	1
11	5211995	Ball Bearing Spring	2	38	4998262	Tool Rest (R.H.)	1
12	22005344	Stator and Coil Assembly	1	39	5336943	Quench Tray	1
13	4990629	Band	1	40	9434158	*Screw, 8-15 x 1/2 Hex Hd Self Tap	5
14	4978296	Gooseneck & Socket Assembly	1	41	3168889	Covers	1
15	4971959	Lamp Shade – Metal	1	42	22005349	Starting Relay	1
16	4971958	Cover – Lamp Shade	1	43	4978534	Cable Assembly	1
17	5219097	*Nut (1/8-27 Pipe Thread)	1	44	3161437	Eyeshield Pack (Inc. 2 ea. 45, 46, 47)	1
18	3187112	*Lockwasher	2	45	3161434	Eyeshield	2
19	STD600802	Screw, 8-32 x 1/4 Pan Head Self Tap	1	46	9437023	*Screw, 1/4-20 x 2 1/4 Hx Head	2
20	4988542	End Frame (R.H.) Cable End	1	47	STD541625	*Wing Nut, 1/2-20 Thread	2
21	5201092	*Grinding Wheel (Fine – 60 Grit) (R.H.)	1	48	3176154	Spark Arrester Pack (Inc. 2 ea. 49, 50, 51)	1
22	STD541350	*Nut, 1/2-20 Hex	1	49	3175504	Spark Arrester	2
23	5375637	*Spacer (Accessory) 1/2 I.D.	4	50	442689	Screw and L.W., 5/16-18 x 1/2 Pan Head	2
24	4971779	Thru Bolt, 10-32 Thread	3	51	STD541031	*Nut, 5/16-18 Hex	2
25	STD541110	*Nut, 10-32 Thread	3		22005364	Owner's Manual	
26	3169206	Grommet	1				
27	22014998	Name Plate	1				

*Standard Hardware Items – May be purchased locally.

Sears

**Owner's
Manual**

**MODEL NO.
397.19340**

**Sears
SERVICE
is at
YOUR
SERVICE**

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 from any Sears, Roebuck & Co. or Simpsons-Sears Ltd. retail or catalog store. If the parts you need are not stocked locally, your order will be electronically transmitted to Sears Repair Parts Distribution Center for expedited handling.

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

- | | |
|-------------------------|----------------------------------|
| 1. The PART NUMBER | 3. The MODEL NUMBER
397.19340 |
| 2. The PART DESCRIPTION | 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 methods.

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