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

DANGER —

Assembly
Operation
Installation
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.

— 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.

<table>
<thead>
<tr>
<th>Length of Extension</th>
<th>Wire Size Required</th>
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<tbody>
<tr>
<td>15 feet or less</td>
<td>No. 14</td>
</tr>
<tr>
<td>50 feet or less</td>
<td>No. 12</td>
</tr>
<tr>
<td>100 feet or less</td>
<td>No. 10</td>
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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.

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ASSEMBLY

INSPECT GRINDING WHEELS FOR DAMAGE BEFORE USING.

STEP 1
Attach wheel covers to wheel guards using six screws (8-32 x 3/8 H x 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”) and wing nuts. See figure 1.

STEP 4
Attach tool rest 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.

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.

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.
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.

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.
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.

4. 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 arrester 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 OVER-TIGHTEN 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 name-plate.

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

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

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<tbody>
<tr>
<td>1.</td>
<td>The PART NUMBER</td>
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<tr>
<td>2.</td>
<td>The PART DESCRIPTION</td>
</tr>
<tr>
<td>3.</td>
<td>The MODEL NUMBER 397.19340</td>
</tr>
<tr>
<td>4.</td>
<td>The NAME OF ITEM—GRINDER</td>
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</tbody>
</table>

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.