

# *Grizzly* **Industrial, Inc.**®

## **MODEL T10170/T10171 COLLET CLOSER OWNER'S MANUAL**



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(FOR MODELS MANUFACTURED SINCE 12/09) #CR12458 PRINTED IN TAIWAN.



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.**

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

**The owner of this machine/equipment 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, blade/cutter 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

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## Manual Accuracy

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We are proud to offer this document with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, errors occasionally happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual.** If you find this to be the case, and the difference between the manual and machine leaves you in doubt, immediately call our technical support for updates or clarification.

For your convenience, we post all available documentation on our website at **www.grizzly.com**. Any updates to this document will be reflected on our website as soon as complete.

## Contact Info

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We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Fax: (800) 438-5901  
E-Mail: techsupport@grizzly.com

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

Grizzly Industrial, Inc.  
c/o Technical Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: manuals@grizzly.com

## Specifications

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### T10170

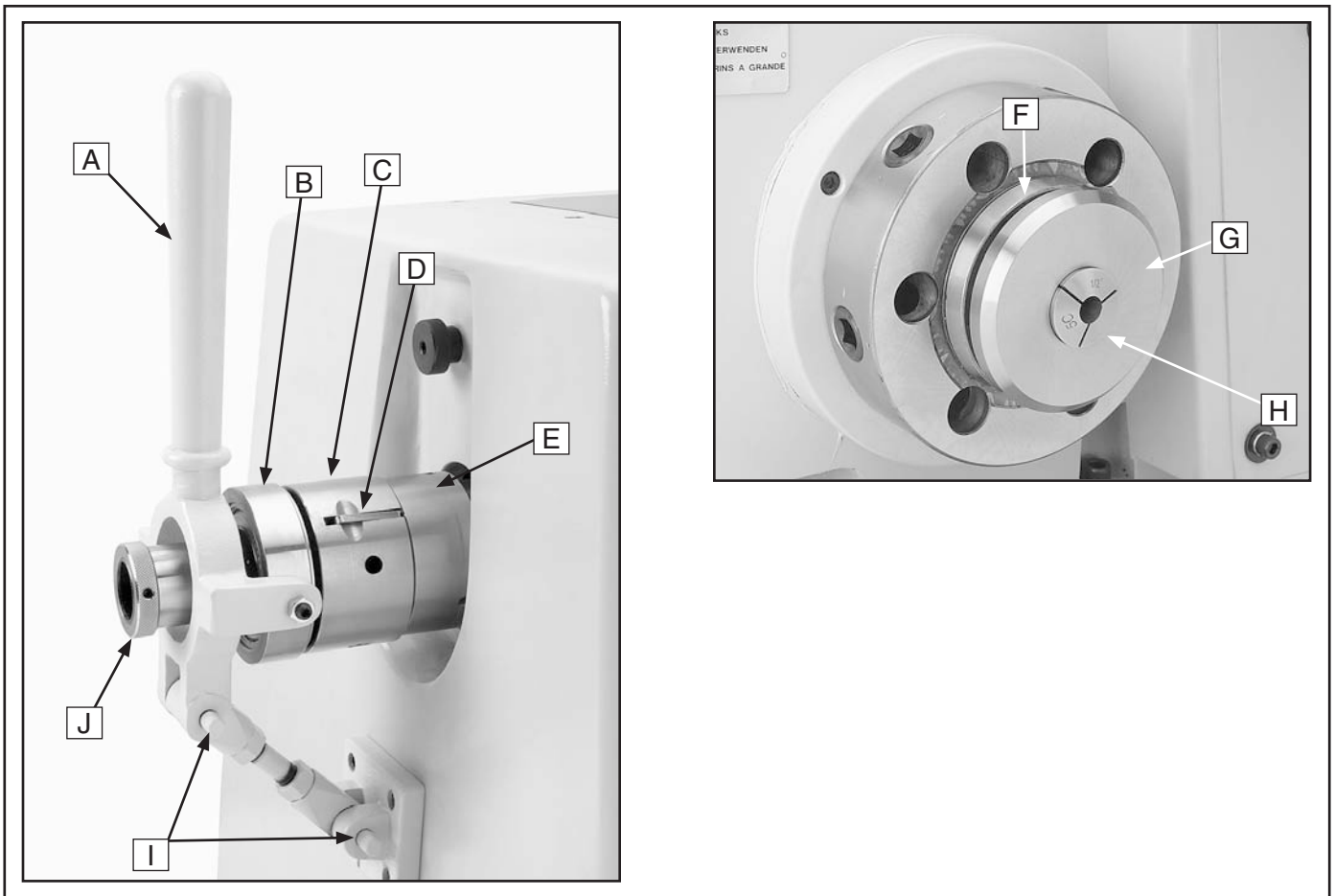
- Lathe Used On .....G9732
- Collet Size ..... 5-C Collets
- Quick Removal Design..... Yes
- All Metal Construction ..... Yes
- Installation Time .....45 Minutes
- Net Weight ..... 16 lbs.
- Origin..... Taiwan

### T10171

- Lathe Used On .....G9733
- Collet Size ..... 5-C Collets
- Quick Removal Design..... Yes
- All Metal Construction ..... Yes
- Installation Time .....45 Minutes
- Net Weight ..... 18 lbs.
- Origin..... Taiwan



# Identification



**Figure 1.** Controls and features.

- A. Collet Closer Lever:** Locks the collet and workpiece in place.
- B. Lock Ring:** Holds the collet closer main bearing, and allows fixed control over the movable draw tube.
- C. Adjusting Sleeve:** When rotated, the length of the draw tube is increased or decreased to adjust the clamping pressure of the collet.
- D. Thumb Lever:** When unlocked, this lever allows the adjustment sleeve to be rotated for draw tube length adjustments.
- E. Spindle Adapter:** Three set screws fasten this adapter to the outboard spindle and secure the collet closer to the spindle.
- F. Lathe Spindle:** Holds the collet closer adapter with a tapered fit.
- G. Collet Closer Adapter:** Seats into the lathe spindle, and has an internal alignment pin to prevent the collet from spinning in the adapter when the draw tube is threaded on or off of the collet.
- H. 5-C Collet (Not Included):** An array of 5-C collets can be used in this collet closer.
- I. Knurled Pins:** Allows for speedy installations and removal of the collet closer assembly.
- J. Knurled Bushing:** When the adjusting sleeve is unlocked and the knurled bushing is rotated, the draw tube will rotate so it can be threaded onto the collet.




# 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.

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

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

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

**NOTICE** This symbol is used to alert the user to useful information about proper operation of the machine.

## **WARNING**

### **Safety Instructions for Machinery**

- 1. READ ENTIRE MANUAL BEFORE STARTING.** Operating machine before reading the manual greatly increases the risk of injury.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



# WARNING

## Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN/VISITORS AWAY.** Keep all children and visitors away from machinery. When machine is not in use, disconnect it from power, lock it out, or disable the switch to make it difficult for unauthorized people to start the machine.
9. **UNATTENDED OPERATION.** Leaving machine unattended while its running greatly increases the risk of an accident or property damage. Turn machine **OFF** and allow all moving parts to come to a complete stop before walking away.
10. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
11. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
12. **USE A GROUNDED POWER SUPPLY RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Operating machine on an incorrect size of circuit increases risk of fire.
13. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
14. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
16. **REMOVE CHUCK KEYS OR ADJUSTING TOOLS.** Make a habit of never leaving chuck keys or other adjustment tools in/on the machine—especially near spindles!
17. **DAMAGED MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, other conditions that may impair machine operation. Always repair or replace damaged parts before operation.
18. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
19. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
20. **DO NOT OVERREACH.** Maintain stability and balance at all times when operating machine.
21. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
22. **STABLE MACHINE.** Machines that move during operations greatly increase the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.
23. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.
24. **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 Collet Closers and Lathes

- 1. TOOL SELECTION.** Cutting with an incorrect or dull tool increases the risk of accidental injury because extra force is required, which increases risk of breaking or dislodging components. Always select the right cutter for the job, and make sure it is sharp. A correct, sharp tool decreases strain on collets and provides a better finish.
- 2. SECURING THE WORKPIECE.** Before starting the lathe, make sure the collet and workpiece are properly secured with the draw tube, and that the collet closer lever is in the locked position. A thrown workpiece may cause severe injury or even death.
- 3. LONG STOCK SAFETY.** Long stock can whip violently if not properly supported, causing serious impact injury and damage to the lathe. Reduce this risk by supporting any stock that extends from the chuck/headstock more than three times its own diameter. Always turn long stock at slow speeds.
- 4. SPEED RATES.** Operating the lathe at the wrong speed can cause nearby parts to break or the workpiece to come loose, which could result in them becoming dangerous projectiles. Large workpieces must be turned at slow speeds. Always use the appropriate feed and speed rates.
- 5. STOPPING LATHE BY HAND.** Stopping the spindle by putting your hand on the workpiece creates an extreme risk of entanglement, impact, crushing, friction, or cutting hazards. Never attempt to slow or stop the lathe by using your hand. Allow the spindle to come to a stop on its own or use the brake (if equipped).
- 6. PROJECTILE HAZARD.** A camlock or chuck key left in the spindle or chuck can become a dangerous projectile if the lathe is started. Never walk away from the lathe leaving any of these tools in the spindle or chuck. Always remove all keys and tooling after use.
- 7. AVOIDING A CRUSHING HAZARD.** Chucks can be heavy and difficult to grasp, which can lead to crushed fingers or hands if mishandled. Get assistance when installing or removing chucks to reduce this risk. Protect your hands and the precision ground ways by using a chuck cradle or piece of plywood over the ways of the lathe when servicing chucks.
- 8. AVOIDING ENTANGLEMENT.** Disconnect the lathe from power before installing and removing the collet closer, collets, and work pieces. Accidental lathe startup can cause severe injury or death.

## **WARNING**

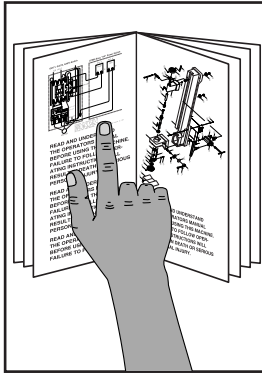
Like all machinery and tooling there is potential danger when operating this collet closer. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this collet closer with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## **CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other collet closer with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



# SECTION 2: SETUP



**! WARNING**  
 This collet closer presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting your lathe!



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

## Needed for Setup

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

Description	Qty
• Safety Glasses .....	1
• Cleaner/Degreaser ( <b>Page 8</b> ) .....	As Needed
• Disposable Shop Rags.....	As Needed
• Hex Wrench 4mm.....	1
• Hex Wrench 5mm.....	1
• Open-End Wrench 12mm.....	1
• Open-End Wrench 19mm.....	1
• Drill Bit 5mm or #9, (0.196") .....	1
• M6-1 Tap .....	1
• Electric Hand Drill.....	1

## Unpacking

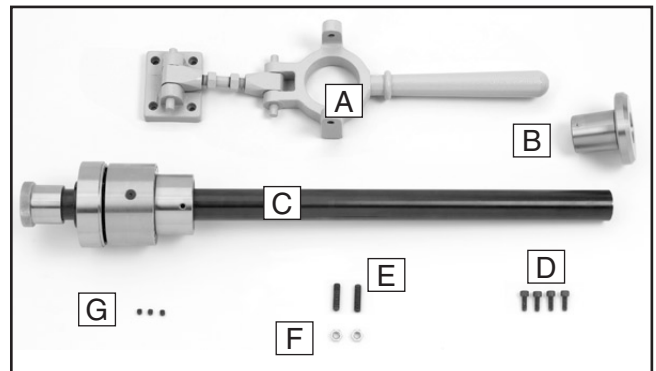
Your collet closer was carefully packaged for safe transportation. Remove the packaging materials from around the tool and inspect it. If you discover it is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

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

## Inventory

**Note:** *If you can't find an item on this list, check the mounting location on the collet closer or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Contents: (Figure 3)	Qty
A. Lever and Yoke Assembly .....	1
B. Collet Adapter.....	1
C. Collet Closer Assembly .....	1
D. Cap Screws M6-1 x 10 .....	4
E. Set Screws M8-1.25 x 30 .....	2
F. Hex Nuts M8-1.25.....	2
G. Set Screws M6-1 x 6 .....	3



**Figure 2.** Inventory.

If any nonproprietary 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.



# Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage.

This rust preventative has been your machine's close ally and guardian since it left the factory. If your machine arrived to you free of rust, then be thankful that the rust preventative protected it during its journey...and try to stay thankful as you clean it off, because it can be challenging to remove if you are unprepared and impatient.

Plan on spending some time cleaning your machine. The time you spend doing this will reward you with smooth sliding parts and a better appreciation for the proper care of your machine's unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, these instructions walk you through what works well for us.

## Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (see below)
- Safety glasses & disposable gloves

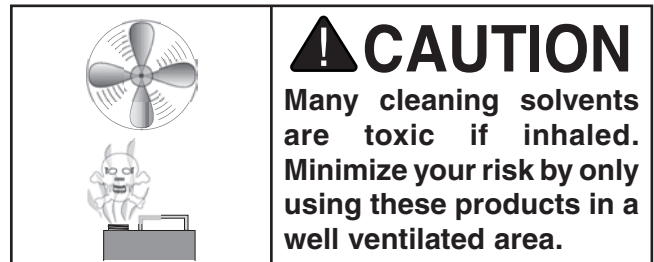
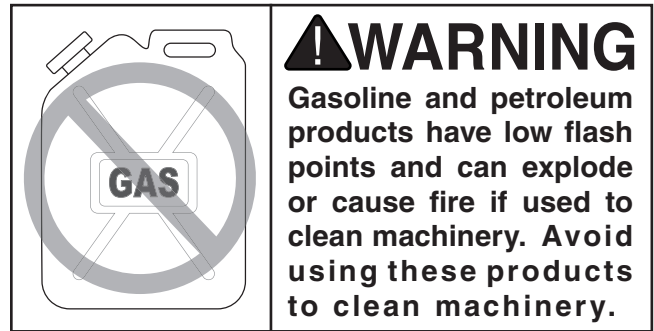
## H9692—Orange Power Cleaner & Degreaser

One of the best cleaners we've found for quickly and easily removing rust preventative.



**Figure 3.** Model H9692 Industrial Orange Power Cleaner/Degreaser (99.9% biodegradable).

**Note:** In a pinch, automotive degreasers, mineral spirits or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of your paint to make sure they will not damage it.



## Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.
2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner/degreaser and let them soak for few minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily.

**Note:** To clean off thick coats of rust preventative on flat surfaces, such as tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or you may scratch your machine.)

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



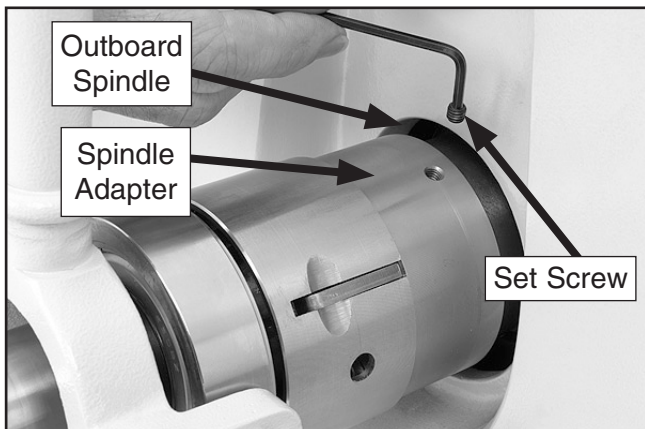
# Installation

## **⚠️ WARNING**

Do not install this collet closer on any lathe that has a plastic or fiberglass gear cover. This collet closer is designed to be used only with cast metal covers that offer high rigidity and support. Ignoring this warning can lead to severe injury or death.

### To install the collet closer:

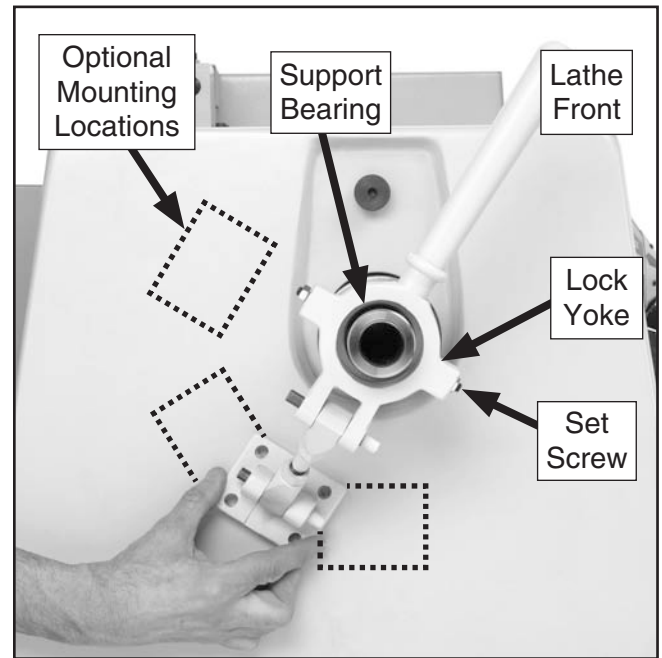
1. DISCONNECT LATHE FROM POWER!
2. Remove the lathe chuck.
3. Using a lightly oiled rag, wipe the inboard and outboard ends of the lathe spindle until they are clean.
4. Carefully insert the collet closer draw tube into the lathe spindle, and fully seat the spindle adapter onto the end of the outboard spindle shown in **Figure 4**.



**Figure 4.** Mounting set screw 1 of 3 every 120°.

5. Using a 3mm hex wrench, install and tighten the three spindle adapter set screws shown in **Figure 4**.

6. Using a 4mm hex wrench, install the lock yoke (**Figure 5**) onto the support bearing with two M8-1.25 x 30 set screws and hex nuts. These set screws will serve as the pivot pins for the lever. Make sure that the set screws bottom in their bores for full pivot support before the hex nuts are tightened.



**Figure 5.** Lever positioning range.

7. Position the lever where it will be most convenient for the lathe operator to use. The normal range of mounting locations is shown in **Figure 5**.
8. While keeping the lever parallel with the lathe gear cover, have an assistant hold the lever in the required position.
9. Using the mounting pad as a template, mark the mounting bolt holes on the gear cover.
10. Remove the collet closer and the lathe gear cover.
11. Using a 5mm or a #9 drill bit and an M6-1 tap, drill and thread the four mounting holes in the gear cover.



12. Reinstall the cover and collet closer but leave the spindle adapter set screws shown in **Figure 4** loose.

13. Fasten the mounting pad to the gear cover with the four M6-1 x 10 cap screws, as shown in **Figure 6**.

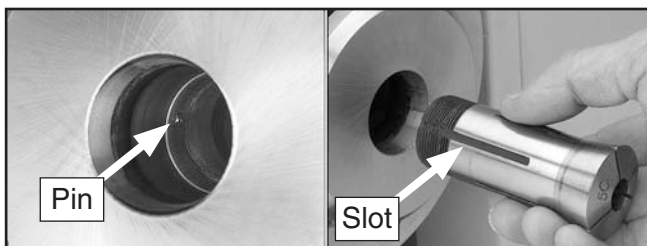
**Note:** *If you want to increase the cap screw anchoring ability in an aluminum cover, you may use thread locking compound.*



**Figure 6.** Mounting pad installed.

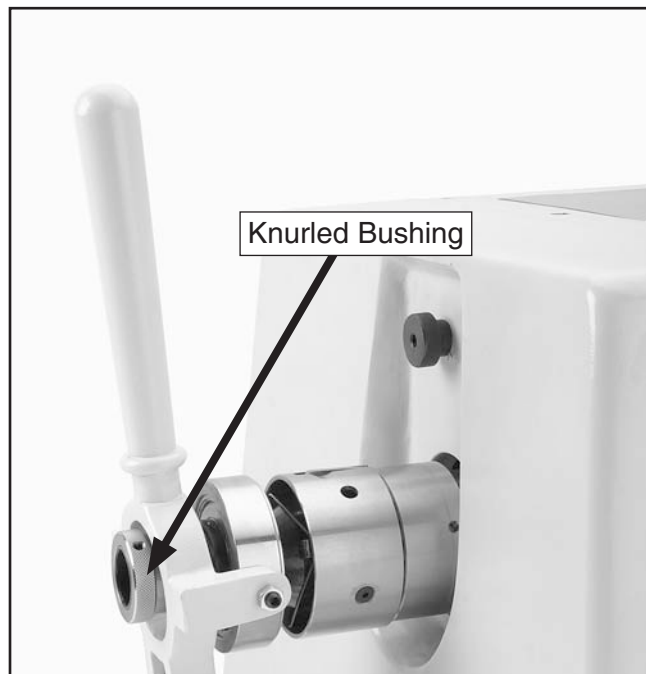
14. Wipe the spindle collet adapter clean and insert it into the lathe spindle.

15. Align the slot in the collet with the pin in the spindle collet adapter, and install the collet. See **Figure 7** for pin and slot locations if required.



**Figure 7.** Collet alignment.

16. While holding the collet against the spindle collet adapter, rotate the knurled bushing (**Figure 8**), and wiggle the collet closer assembly, so the leading thread of the draw tube and collet catch one another. Keep tightening the knob until the collet fully seats into the collet adapter, and the adjusting sleeve fully seats with the outboard spindle. When the knurled bushing is tight, the collet closer assembly will be aligned and concentric with the lathe spindle.



**Figure 8.** Installed collet closer.

17. Using a 3mm hex wrench, tighten the spindle adapter set screws (shown in **Figure 4**) to hold the collet closer on the lathe spindle and concentric with the spindle.

**Note:** *Depending on the age of the lathe, the outboard spindle may be slightly worn down and undersized which can cause the collet adapter to mount at a slight angle. If the entire collet closer is removed and reinstalled, and the draw tube and collet do not thread together, the alignment covered in **Step 16** may have to be repeated.*

*After long-term collet closer use, if the end of the draw tube begins to hang too low to thread onto the collet, and if the alignment step does not correct the situation, the collet closer bearing has reached the end of its usable life and must be replaced.*

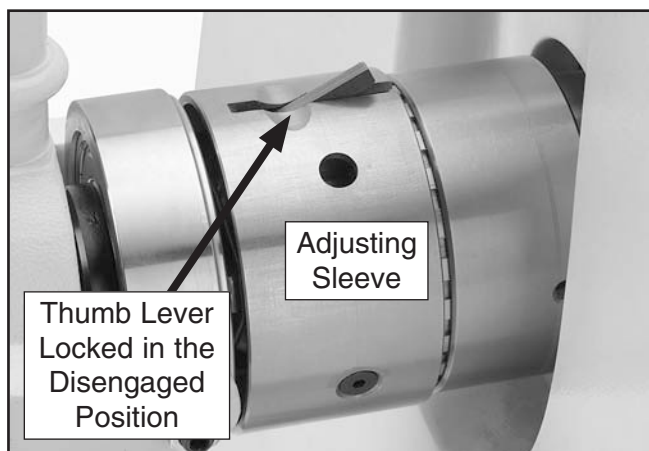


18. Insert the correct size of workpiece or dowel into the collet, as shown in **Figure 9**.



**Figure 9.** Installing a workpiece.

19. Press the adjusting sleeve thumb lever so the lever rocks outward and locks in the disengaged position, as shown in **Figure 10**.



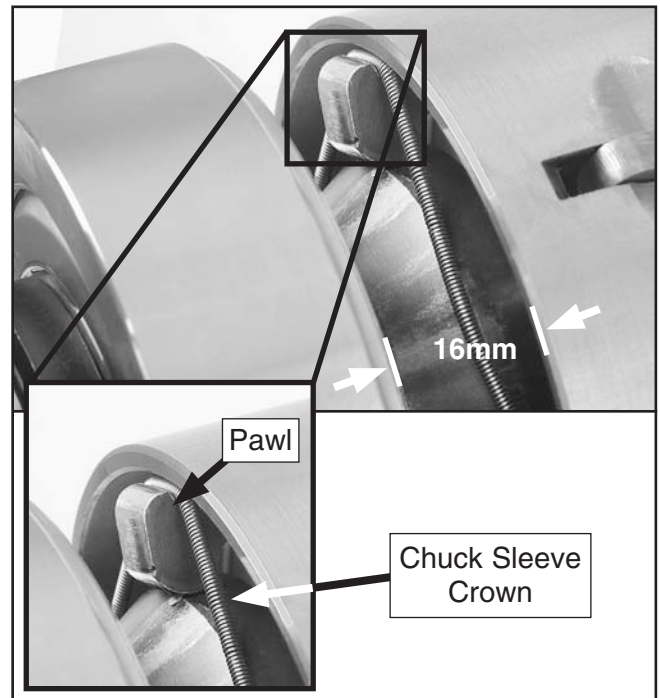
**Figure 10.** Adjusting sleeve and thumb lever.

20. Grasp the adjusting sleeve and rotate it counterclockwise  $\frac{3}{4}$  to 1 turn. Then pull the collet closer lever outward.

—If the lever locks loosely or the workpiece slips in the collet, release the lever and tighten the adjusting sleeve until the lever snaps to the locked position easily, and the workpiece is held tightly.

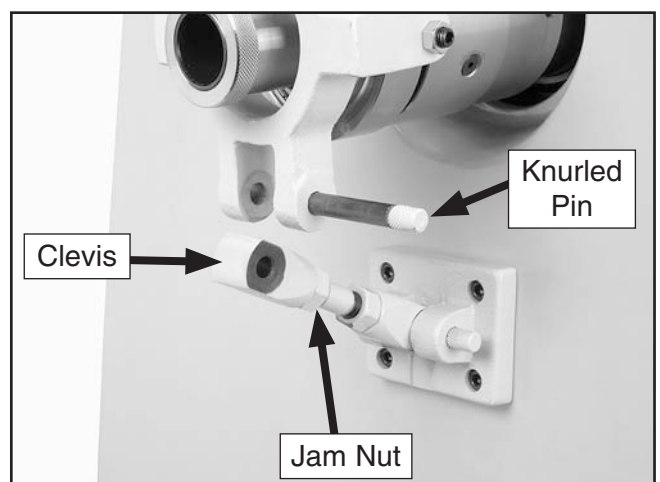
—If the lever does not move far enough to lock, loosen the adjusting sleeve until the lever snaps to the locked position easily and the workpiece is held tightly.

**Note:** When the lever is locked, the pawls will be positioned on the crown of the chuck sleeve, and there will be a gap of approximately 16mm exposing the pawls, as shown in **Figure 11**.



**Figure 11.** Pawls in the locked position.

21. Push the thumb lever back into its locked position (**Figure 11**), so it is flush with the adjusting sleeve surface. You may have to rotate the adjusting sleeve slightly to get the lever to drop back down into the slot.
22. Remove one of the knurled pins, and use a 19mm wrench to loosen the clevis jam nut shown in **Figure 12**.



**Figure 12.** Clevis adjustment.



23. Adjust the clevis so it is parallel with the lathe gear cover, as shown in **Figure 13**, when the collet closer lever is in the released position. When the lever is in the locked position it should be tilted outward away from the lathe by only a few degrees, as shown in **Figure 14**.



**Figure 13.** Unlocked collet-closer lever.



**Figure 14.** Locked collet-closer lever.

24. When the adjustment is complete, tighten the jam nut, and reinsert the knurled pin.
25. Rotate the lathe spindle by hand to verify that the collet closer does not bind.

## Test Run

Once the assembly is complete, test run your lathe with the collet closer installed to make sure the unit is ready for regular operation.

The test run consists of verifying the collet closer is concentric with the lathe spindle and that no vibration exists.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using lathe immediately, and correct the problem.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

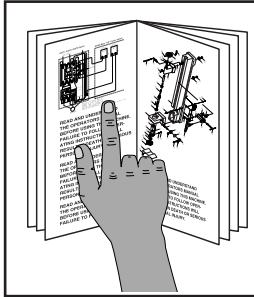
### To test run the collet closer:

1. Make sure you have read the safety instructions at the beginning of the manual and that the collet closer is set up properly.
2. Lock a small dowel or workpiece in the collet, and verify that the lathe spindle rotates freely by hand.
3. Make sure all tools and objects used during setup are cleared away from the collet closer.
4. Set the lathe to a low spindle speed, and disengage any feed levers.
5. Put on safety glasses, connect the lathe to power, and turn the lathe **ON**.
6. Run the lathe through its full range of speeds.
  - When operating correctly, the collet closer runs smoothly with little or no vibration or rubbing noises.
  - Investigate and correct strange or unusual noises or vibrations before operating the collet closer further. Always disconnect the collet closer from power when investigating or correcting potential problems.
7. Turn the lathe **OFF**.



# SECTION 3: OPERATIONS

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**! WARNING**  
To reduce the risk of serious injury when using this collet closer, read and understand this entire manual before beginning any operations.

## NOTICE

If you have never used this type of tooling on a lathe before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

## Operation Overview

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This overview gives you the basic process that happens during an operation with this collet closer. Familiarize yourself with this process to better understand the remaining parts of the **Operation** section.

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

1. Selects the correct-sized collet for the diameter of the workpiece.
2. Verifies that no burrs exist on the workpiece.
3. Aligns the slot in the collet with the pin in the collet adapter, and inserts the collet and workpiece into the adapter.
4. Threads the draw tube onto the collet by turning the knurled bushing until the collet is seated and the knurled bushing is snug.
5. Closes the collet with the lever and checks how well the workpiece is clamped.  
—If clamping is too loose or too tight, releases the lock lever and rotates the adjustment sleeve to attain correct lever clamping and correct workpiece holding.
6. Installs the required inboard and outboard workpiece support with stands, the steady rest, or the follow rest.
7. Installs the required tooling, puts on safety glasses, and begins lathe operations.

## Collet Closer Removal

---

To remove the collet closer assembly:

1. DISCONNECT MACHINE FROM POWER!
2. Place a wooden board on the lathe ways to protect the ways.
3. Support the collet with your right hand. With your left hand, unlock the collet closer lever and turn the knurled knob to un-thread the draw tube from the collet.
4. When the collet is free, remove the knurled pin, and slide the collet closer assembly out of the spindle.
5. With your right hand, keep the spindle collet adapter from falling out of the lathe spindle; and with your left hand, insert a wooden dowel into the spindle from the outboard side and tap the spindle collet adapter free from the lathe spindle.
6. Reinstall the chuck.



# SECTION 4: ACCESSORIES

## G9737—Taper Attachment for G9732 Lathe

## G9738—Taper Attachment for G9733 Lathe

Easily and economically cut tapers on shafts with the Grizzly taper attachment. No more offsetting and realigning the tailstock. Every lathe operator should have one of these. The Model G9737 taper attachment weighs 64 lbs, and the Model G9738 weighs 69 lbs. Installation is simple and quick.

## H6499—Brass 5-C Emergency Collet

## H6500—Nylon 5-C Emergency Collet

## H7500—Steel 5-C Emergency Collet

Emergency collets to the rescue! We offer three styles of collets to get you out of a bind and back to work! Available in steel, brass and nylon, our 5-C collets are easy to machine to the size you need for holding delicate parts, odd sized tooling or your greatest challenge. (The steel collets have annealed faces and bores.) Minimum diameters are less than 0.085". Every busy shop should have a few of these on hand.

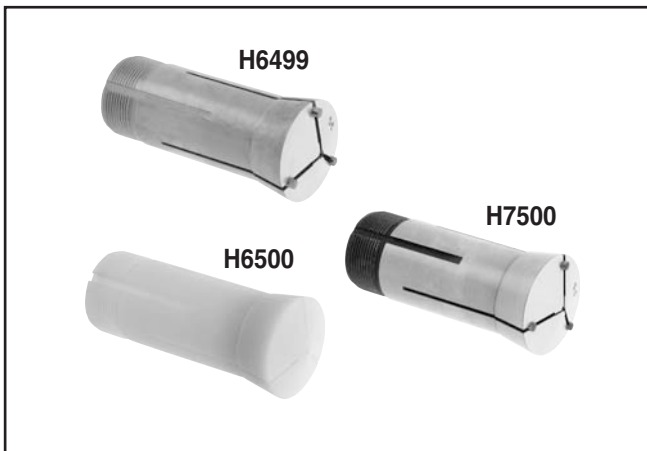


Figure 15. 5-C emergency collets

## H7504—6 Pc. Square 5-C Collet Set

## H7505—7 Pc. Hex 5-C Collet Set

When working with a collet closer, eventually you are going to need to hold hex or square stock. These two sets feature hardened and ground bodies and sizes that fit most needs. The H7504 square set has sizes: 1/8", 1/4", 3/8", 1/2", 5/8" and 3/4". The H7505 hex collet set has sizes: 1/8", 1/4", 3/8", 1/2", 5/8", 3/4" and 7/8".



Figure 16. 5-C hex and square collets.

## G1238—Precision 5-C Collet Set

This 15 piece 5-C collet set is made from high grade collet steel and precision ground to exacting tolerances.



Figure 17. 15 Piece 5-C collet set.

Call 1-800-523-4777 To Order



## High Speed Steel Ground Center Drills

MODEL	SIZE	BODY DIA.	DRILL DIA.	OVERALL LENGTH
H4456	1	1/8"	3/64"	1 1/4"
H4457	2	3/16"	5/64"	1 7/8"
H4458	3	1/4"	7/64"	2"
H4459	4	5/16"	1/8"	2 1/8"
H4460	5	7/16"	3/16"	2 3/4"
H4461	6	1/2"	7/32"	3"
H4462	7	5/8"	1/4"	3 1/4"
H4463	8	3/4"	5/16"	3 1/2"

These high speed steel center drills are precision ground for unsurpassed accuracy.

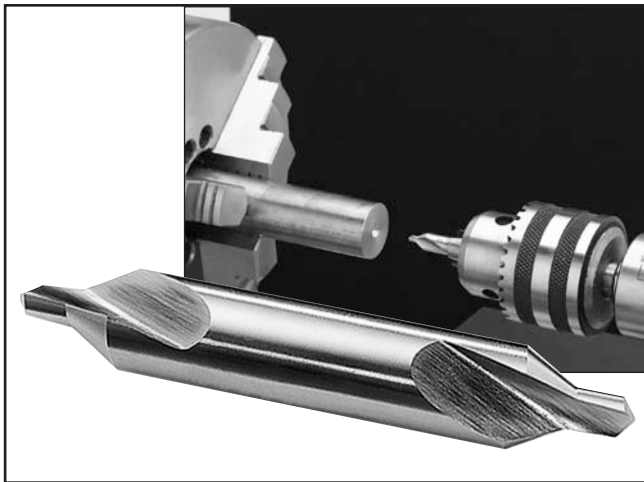


Figure 18. H4456-63 HSS ground center drills.

### H5930—HSS Center Drill Set 60°

### H5931—HSS Center Drill Set 82°

Double ended HSS center drills, are precision ground for unsurpassed accuracy. Each set includes sizes 1-4.

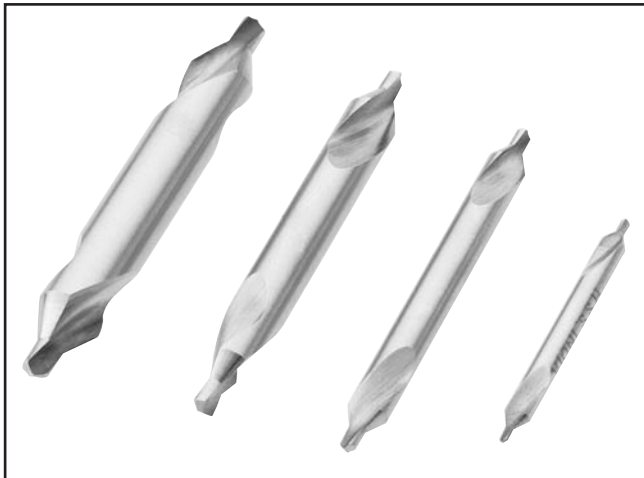


Figure 19. HSS center drills.

## H8257—Primrose Armor Plate with Moly-D Machine and Way Oil 1 Quart

This superior machine and way lubricant prevents stick slip and chatter due to anti-friction capabilities resulting in greater precision machining capabilities. Provides the thinnest oil film possible while effectively providing needed lubrication and rust/corrosion protection. Adhesive/cohesive components are added for vertical surfaces. Resists squeeze out, running, dripping and non-gumming.

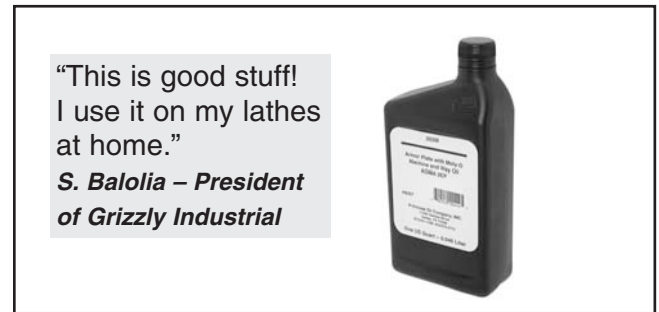


Figure 20. Primrose armor plate lubricant.

## G1070—MT3 Live Center Set for G9732 Lathe

## G9245—MT4 Live Center Set for G9733 Lathe

A super blend of quality and convenience, this live center set offers seven interchangeable tips. High-quality needle bearings prolong tool life and special tool steel body and tips are precision ground. Supplied in wooden box.



Figure 21. G9245 live center set.

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



# SECTION 5: MAINTENANCE

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## Cleaning

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Cleaning the your collet closer is relatively easy. Vacuum excess metal chips away, and wipe off the remaining metal parts with a rag that is moistened with the same machine oil that is used to lubricate your lathe.

## Schedule

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For optimum performance from your collet closer, follow this maintenance schedule and refer to any specific instructions given in this section.

### Daily Check:

- Clean and inspect all tapered mating surfaces.
- Inspect for loose mounting cap screws.
- Inspect collet adapter for missing pin.
- Inspect for missing or cracked pins or loose set screws.
- Check for any other unsafe condition.

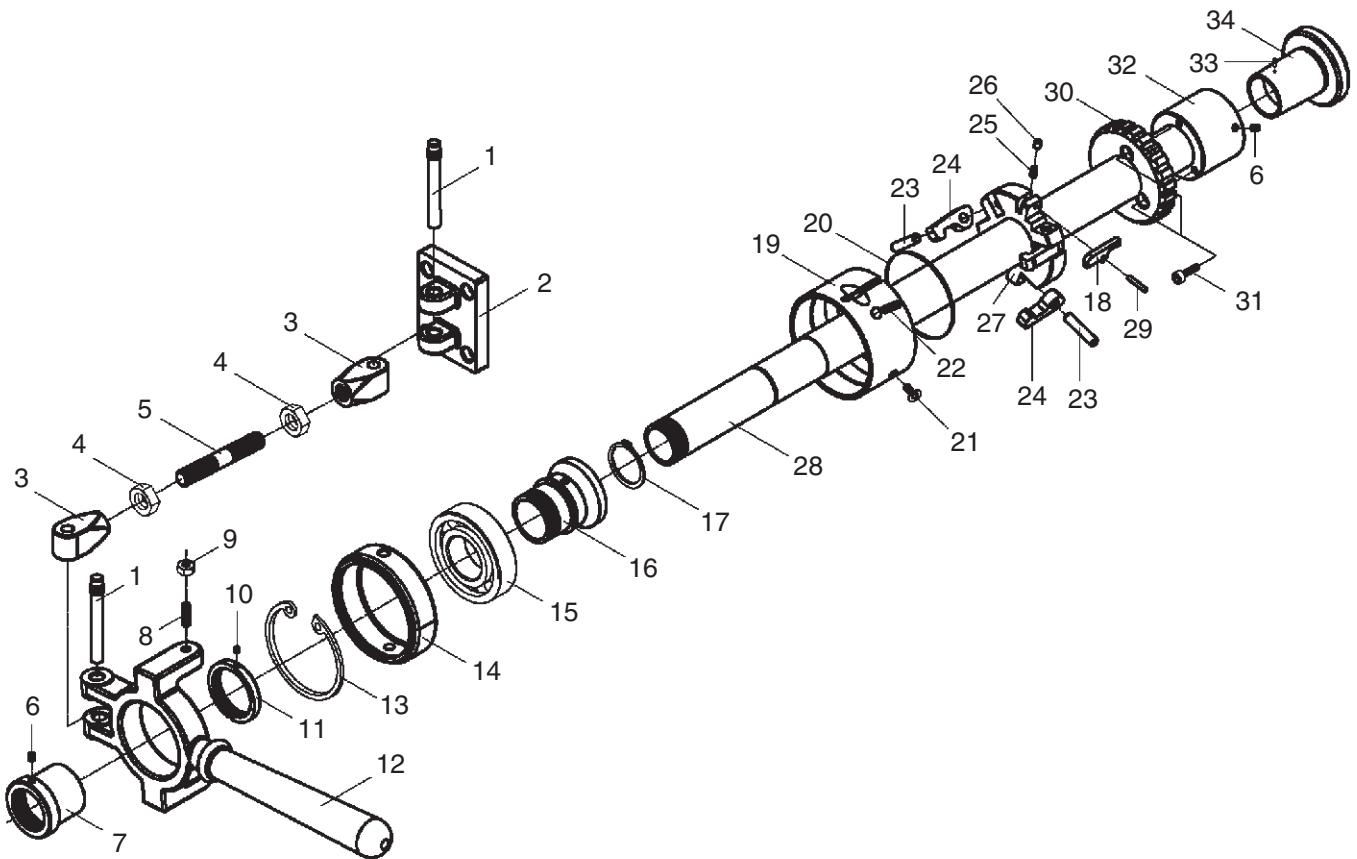
### Monthly Check:

- Clean and de-burr draw tube threads.
- Apply oil to all metal surfaces to prevent rust and maintain smooth operation.



# SECTION 6: PARTS

## Model T10170/T10171 Parts Breakdown



# Parts List

REF	PART #	DESCRIPTION
1	PT10170001	KNURLED DOWEL PIN
2	PT10170002	MOUNTING BRACKET
3	PT10170003	CLEVIS
4	PN01	HEX NUT 1/2-20
5	PT10170005	STUD 1/2"-20 X 3-1/4"
6	PSS02M	SET SCREW M6-1 X 6
7	PT10170007	KNURLED BUSHING
8	PSS19M	SET SCREW M8-1.25 X 30
9	PN03M	HEX NUT M8-1.25
10	PSS07M	SET SCREW M5-.8 X 5
11	PT10170011	SPANNER NUT
12	PT10170012	LEVER AND YOKE CASTING
13	PR50M	INT RETAINING RING 80MM
14	PT10170014	LOCK RING
15	P6208ZZ	BALL BEARING 6208ZZ
16	PT10170016	SLEEVE
17	PR37M	EXT RETAINING RING 32MM
18	PT10170018	LOCK LEVER
19	PT10170019	COLLET SLEEVE

REF	PART #	DESCRIPTION
20	PT10170020	CABLE SPRING
21	PFH05M	FLAT HD SCR M5-.8 X 12
22	PSS12M	SET SCREW M6-1 X 25
23	PT10170023	DOWEL PIN
24	PT10170024	LOCK PAWL SET (3-PCS)
25	PT10170025	COMPRESSION SPRING
26	PT10170026	DETENT PIN
27	PT10170027	CHUCK HOUSING
28	PT10170028	DRAW TUBE (T10170)
	PT10171028	DRAW TUBE (T10171)
29	PT10170029	PIVOT PIN
30	PT10170030	CHUCK ANCHOR
31	PCAP02M	CAP SCREW M6-1 X 20
32	PT10170032	ADAPTER (T10170)
	PT10171032	ADAPTER (T10171)
33	PRP14M	ROLL PIN 3 X 6
34	PT10170034	COLLET SPINDLE ADAPTER (T10170)
	PT10171034	COLLET SPINDLE ADAPTER (T10171)





# WARRANTY CARD

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Phone # \_\_\_\_\_ Email \_\_\_\_\_ Invoice # \_\_\_\_\_  
 Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

- How did you learn about us?
 

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
- Which of the following magazines do you subscribe to?
 

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	
- What is your annual household income?
 

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
- What is your age group?
 

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- How long have you been a woodworker/metalworker?
 

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
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- How many of your machines or tools are Grizzly?
 

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
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- Do you think your machine represents a good value?  Yes  No
- Would you recommend Grizzly Industrial to a friend?  Yes  No
- Would you allow us to use your name as a reference for Grizzly customers in your area?  
**Note: We never use names more than 3 times.**  Yes  No

10. Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

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TAPE ALONG EDGES--PLEASE DO NOT STAPLE

# WARRANTY AND RETURNS

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Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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