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MODEL G4017–G4020 ARBOR PRESS INSTRUCTIONS

Introduction

This arbor press is designed to perform small press jobs, such as staking, riveting, and installing/removing bearings.

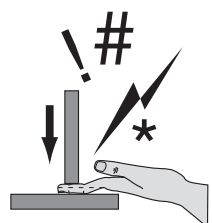


Figure 1. Model G4019 arbor press.



! WARNING

Material under pressure could fly apart and cause impact injuries. Always wear safety glasses when using this press.



Keep hands and fingers away from ram when applying downward pressure to avoid pinching injuries.

NOTICE

This arbor press is designed to only be used for small parts. Do not use this arbor press for operations beyond its capacity or modify it for increased leverage.

Specifications

G4017

Press Capacity ½ Ton
Throat Depth..... 3¼"
Maximum Workpiece Height 3⅛"
Ram Size ¾" x ¾"
Base Size 4" W x 9½" D
Overall Size 7" W x 10" D x 10" H
Weight 20 lbs.

G4018

Press Capacity 1 Ton
Throat Depth..... 3⅞"
Maximum Workpiece Height 4¾"
Ram Size 1" x 1"
Base Size 5" W x 10½" D
Overall Size 7¼" W x 11" D x 12¾" H
Weight 29 lbs.

G4019

Press Capacity 2 Tons
Throat Depth..... 5½"
Maximum Workpiece Height 7½"
Ram Size 1¼" x 1¼"
Base Size 7" W x 17" D
Overall Size 10½" W x 17" D x 17½" H
Weight 83 lbs.

G4020

Press Capacity 3 Tons
Throat Depth..... 6⅜"
Maximum Workpiece Height 11¾"
Ram Size 1½" x 1½"
Base Size 8" W x 18" D
Overall Size 11½" W x 18" D x 23½" H
Weight 135 lbs.

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V1.06.15

Small Item Inventory

Description	Qty
A. Lock Collar	1
B. Pinion Hub.....	1
C. Lock Handle Assembly.....	1
D. Sliding Handle	1
E. Handle Cap	1

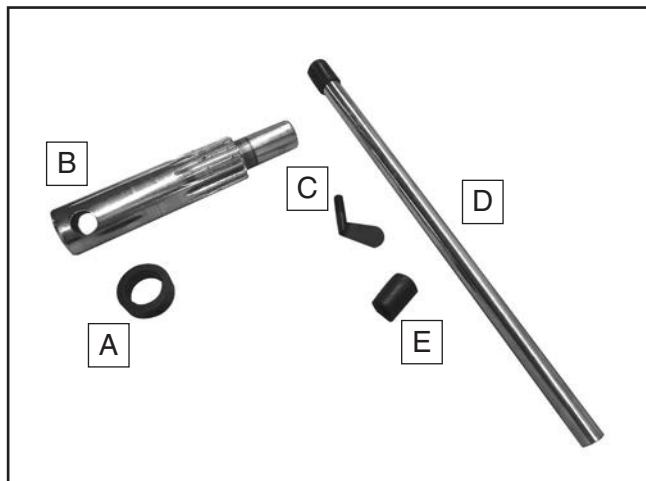
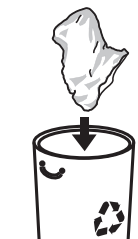


Figure 2. Small item inventory.



! WARNING
HEAVY LIFT!
 Straining or crushing injury may occur from improperly lifting the arbor press. To reduce this risk, get help from other people or lifting equipment rated for weight of the arbor press.



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

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 works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat rust preventative with a liberal amount of cleaner/degreaser (see **Page 8** for offerings from Grizzly), then let it soak for 5–10 minutes.
3. Wipe off surfaces. If your cleaner/degreaser is effective, rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with a rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.



Mounting

Because of the dynamic forces involved in operating the arbor press, we strongly recommend mounting it to a benchtop or other stable working surface to prevent it from moving during operation and causing accidental injury or damage.

The base of the arbor press has two, $\frac{3}{4}$ " mounting holes on each side of the upright (see **Figure 3**).

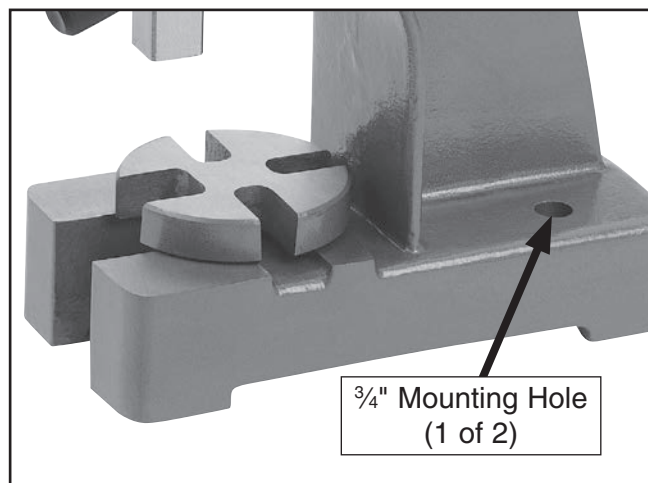


Figure 3. Mounting hole (1 of 2).

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

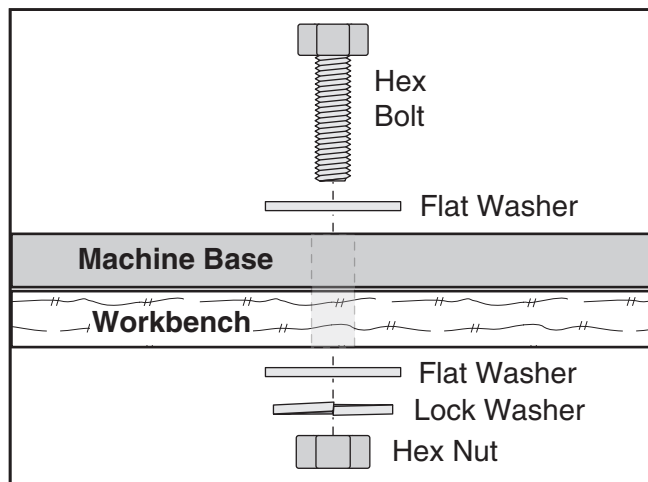


Figure 4. Example of a "Through Mount" setup.

Another option is a "Direct Mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

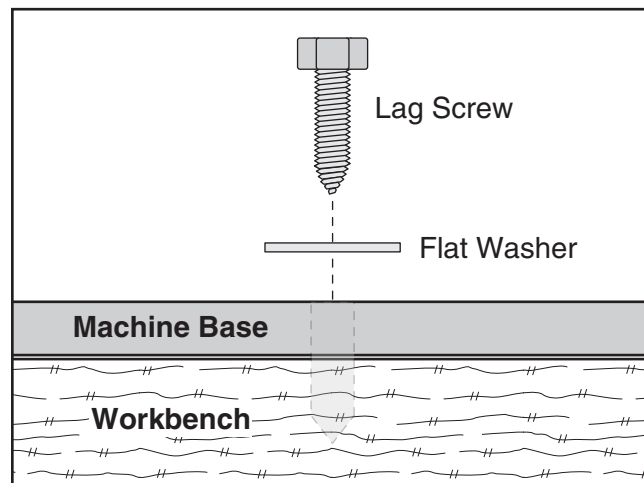


Figure 5. Example of a "Direct Mount" setup.

Assembly

Tools Needed

	Qty
Hex Wrench 3mm (G4017, G4018).....	1
Hex Wrench 4mm (G4019, G4020)	1

This arbor press arrives with the base plate pre-installed at the factory. Follow these instructions for final assembly of pinion hub and handle assembly.

1. Insert pinion hub into main body of arbor press (see **Figure 6**).

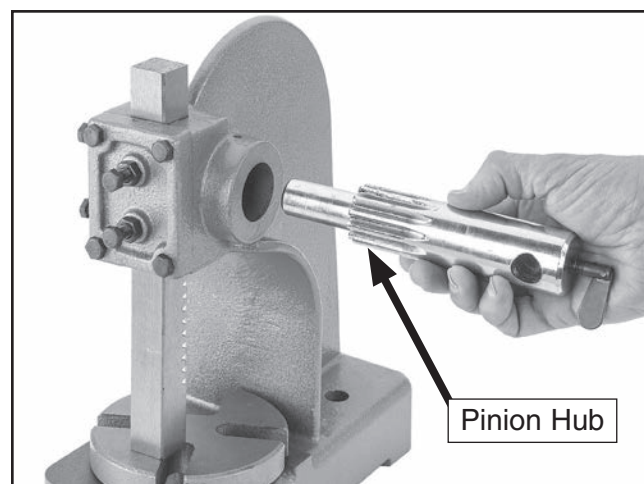


Figure 6. Inserting pinion hub into arbor press.



2. Install lock collar on pinion hub (see **Figure 7**) and tighten set screw.

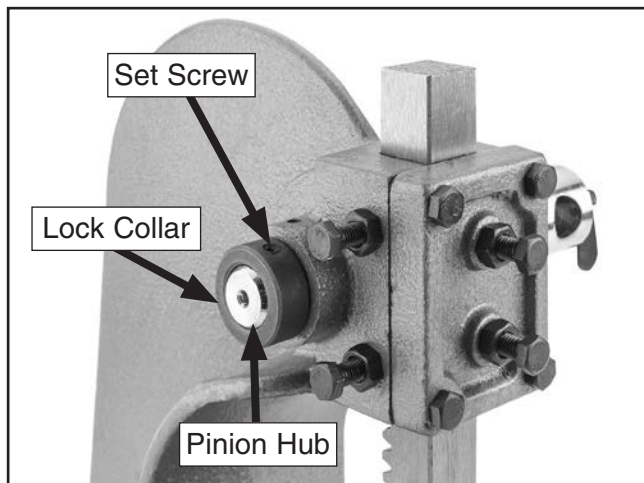


Figure 7. Pinion hub and lock collar assembly.

3. Insert handle through pinion hub and install handle cap, shown in **Figure 8**.
4. Thread handle lock bolt into hub, as shown in **Figure 8**. When tightened, lock bolt secures handle in position relative to hub.

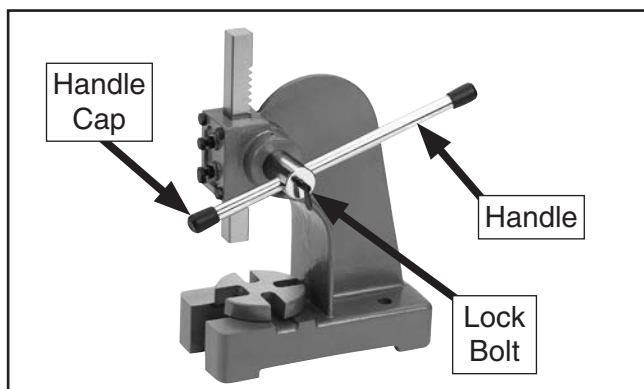


Figure 8. Handle with lock bolt installed.

Adjusting Ram Play

Hex bolts on the front and left side of the ram housing (see **Figure 9**) adjust the amount of ram free-play. The ideal adjustment allows the ram to move with very little play but not be overly stiff.

Tools Needed

Qty

Wrench or Socket 12mm (G4017, G4018) 1

Wrench or Socket 14mm (G4019, G4020) 1

To adjust ram play:

1. Loosen hex nuts shown in **Figure 9**.

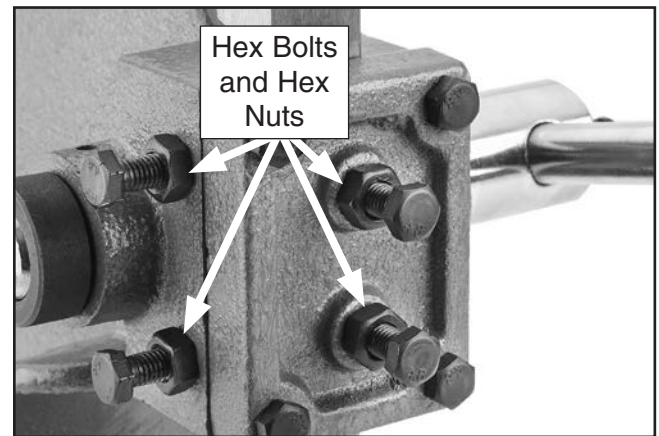


Figure 9. Hex bolts used to adjust ram free-play.

2. Equally adjust each pair of hex bolts a small amount in same direction (clockwise to decrease free-play, counterclockwise and increase free-play).
3. Use sliding handle to move ram up and down a few times to check adjustment. If necessary, further adjust hex bolts as you did in **Step 2**.
4. When you are satisfied with the amount of ram free-play, retighten hex nuts without moving hex bolts.



Cleaning & Protecting

Wipe the arbor press down with a clean shop rag and mineral spirits. When dry, protect the unpainted surfaces by applying a thin film of ISO 32 oil.

Oiling Pinion Hub Shaft

Oil TypeT26685 or ISO 32 Equivalent
Oil Amount..... 1–2 Pumps
Lubrication Frequency8 Hrs. of Operation

Proper lubrication of the pinion hub shaft is done with a pump-type oil can with a cone tip through the oil access holes (see **Figure 10**).

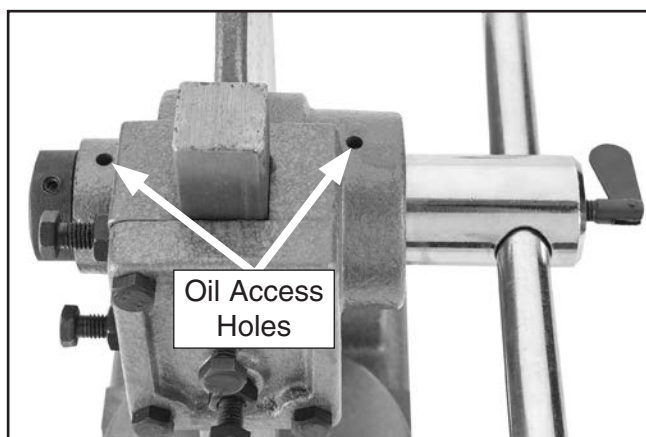


Figure 10. Locations of oil access holes to lubricate pinion hub shaft.

Push the tip of the oil can nozzle against the oil access hole and pump oil can once or twice. If you see sludge and contaminants coming out of the lubrication area, continue pumping the oil can until the oil runs clear. Move the components through the entire path of travel a few times to distribute the oil. When finished, wipe away the excess oil.

Greasing Rack and Pinion

Grease.....T23964 or NLGI#2 Equivalent
Grease Amount As Needed
Lubrication Frequency40 Hrs. of Operation

Tools Needed

Qty

Wrench or Socket 12mm (G4017, G4018) 1
Wrench or Socket 14mm (G4019, G4020) 1

To grease rack and pinion:

1. Remove front plate, then remove ram to expose pinion and rack (see **Figure 11**).

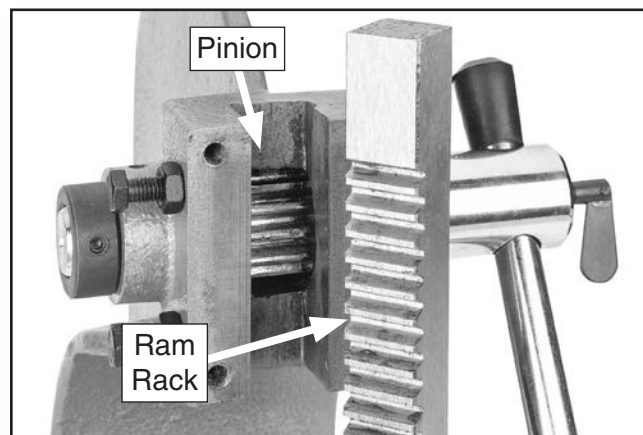
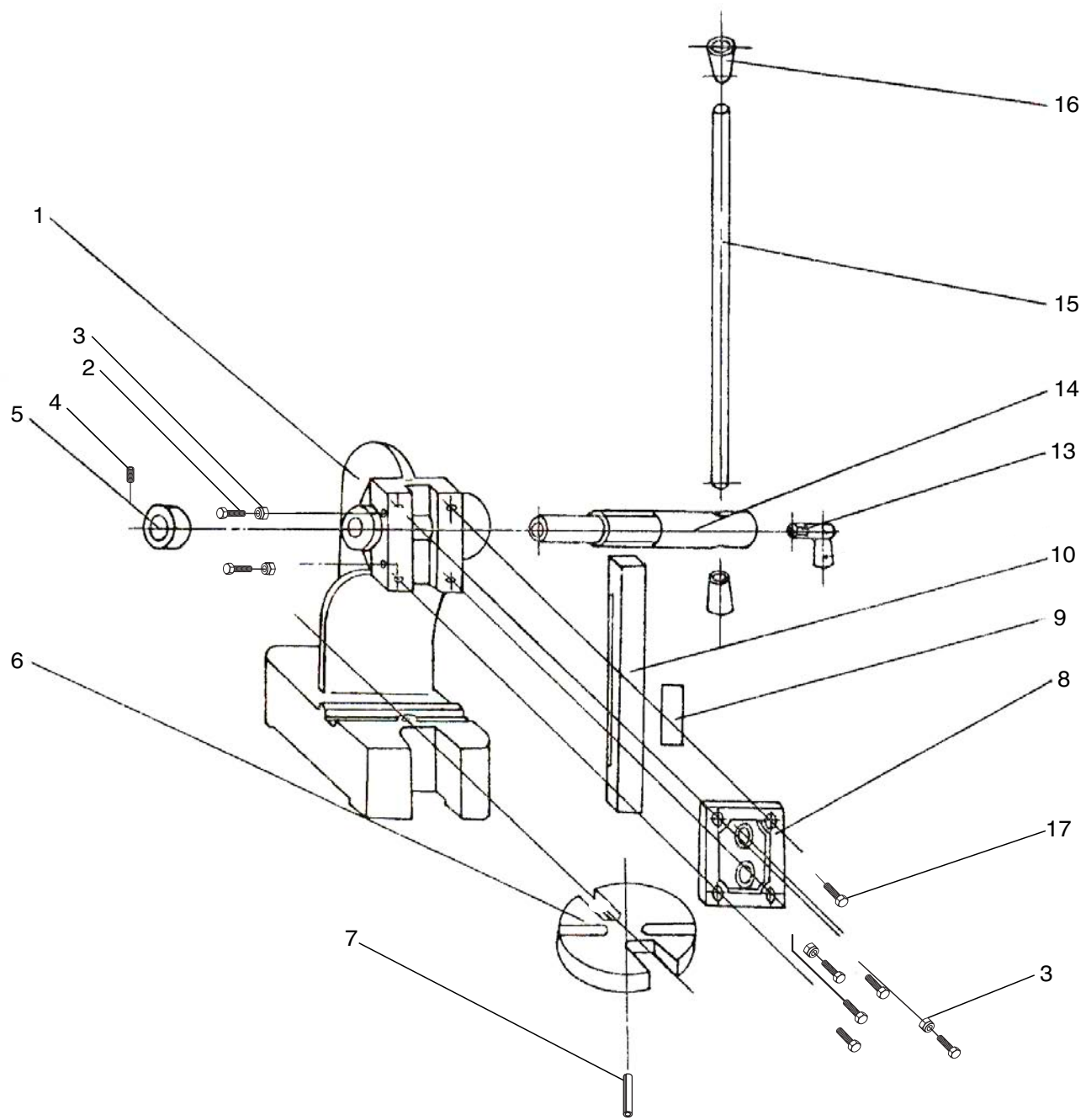


Figure 11. Ram rack and pinion exposed after removing front plate.

2. Use shop rags, a stiff brush, and mineral spirits to clean teeth of rack and pinion.
3. When dry, apply a light coat of grease to rack and pinion teeth.
4. Re-install ram and front plate.
5. Use sliding handle to move ram up and down several times to distribute grease.



G4017-20 Parts Breakdown



G4017 Parts List

REF	PART #	DESCRIPTION
1	P4017001	BODY
2	P4017002	HEX BOLT M8-1.25 X 30
3	P4017003	HEX NUT M8-1.25
4	P4017004	SET SCREW M8-1.25 X 8
5	P4017005	COLLAR
6	P4017006	BASEPLATE
7	P4017007	ROLL PIN 6 X 20
8	P4017008	COVER

REF	PART #	DESCRIPTION
9	P4017009	TENSIONING PLATE
10	P4017010	RAM
13	P4017013	LOCK HANDLE ASSEMBLY M8-1.25
14	P4017014	PINION HUB
15	P4017015	SLIDING HANDLE
16	P4017016	HANDLE CAP
17	P4017017	HEX BOLT M8-1.25 X 25

G4018 Parts List

REF	PART #	DESCRIPTION
1	P4018001	BODY
2	P4018002	HEX BOLT M8-1.25 X 35
3	P4018003	HEX NUT M8-1.25
4	P4018004	SET SCREW M8-1.25 X 8
5	P4018005	COLLAR
6	P4018006	BASEPLATE
7	P4018007	ROLL PIN 6 X 20
8	P4018008	COVER

REF	PART #	DESCRIPTION
9	P4018009	TENSIONING PLATE
10	P4018010	RAM
13	P4018013	LOCK HANDLE ASSEMBLY M8-1.25
14	P4018014	PINION HUB
15	P4018015	SLIDING HANDLE
16	P4018016	HANDLE CAP
17	P4018017	HEX BOLT M8-1.25 X 30

G4019 Parts List

REF	PART #	DESCRIPTION
1	P4019001	BODY
2	P4019002	HEX BOLT M10-1.5 X 40
3	P4019003	HEX NUT M10-1.5
4	P4019004	SET SCREW M8-1.25 X 10
5	P4019005	COLLAR
6	P4019006	BASEPLATE
7	P4019007	ROLL PIN 6 X 20
8	P4019008	COVER

REF	PART #	DESCRIPTION
9	P4019009	TENSIONING PLATE
10	P4019010	RAM
13	P4019013	LOCK HANDLE ASSEMBLY M10-1.5
14	P4019014	PINION HUB
15	P4019015	SLIDING HANDLE
16	P4019016	HANDLE CAP
17	P4019017	HEX BOLT M10-1.5 X 30

G4020 Parts List

REF	PART #	DESCRIPTION
1	P4020001	BODY
2	P4020002	HEX BOLT M10-1.5 X 45
3	P4020003	HEX NUT M10-1.5
4	P4020004	SET SCREW M8-1.25 X 10
5	P4020005	COLLAR
6	P4020006	BASEPLATE
7	P4020007	ROLL PIN 6 X 20
8	P4020008	COVER

REF	PART #	DESCRIPTION
9	P4020009	TENSIONING PLATE
10	P4020010	RAM
13	P4020013	LOCK HANDLE ASSEMBLY M10-1.5
14	P4020014	PINION HUB
15	P4020015	SLIDING HANDLE
16	P4020016	HANDLE CAP
17	P4020017	HEX BOLT M10-1.5 X 40

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.



Accessories

! WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

T23964—Armor Plate with Moly-D Multi-Purpose Grease, 14.5 oz. (NLGI#2 Equivalent)

Armor Plate with Moly-D is a rich green moly grease that provides excellent stability and unsurpassed performance under a wide range of temperatures and operating conditions. Armor Plate grease is entirely unique due to the fact that the moly in it is solubilized, which provides superior performance to other greases containing the black solid form of molybdenum disulfide.



Figure 12. T23964 Armor Plate with Moly-D Multi-Purpose Grease.

G2544—Solvent Cleaner & Degreaser

T23692—Orange Power Degreaser

Great products for removing shipping grease.



Figure 13. Cleaner/degreasers.

H7615—High-Pressure Oil Can

Whether you are lubricating cutting tools or maintaining machinery in top operating condition, you will appreciate this High-Pressure Oil Can. Can holds 5 ounces of oil and has a trigger-activated, high-pressure pump.



Figure 14. H7615 High-Pressure Oil Can.

T26685—Moly-D Multi-Function Machine Oil - ISO 32, 1 Gallon



Figure 15. Moly-D Multi-Function Machine Oil - ISO 32, 1 Gallon.

order online at www.grizzly.com or call 1-800-523-4777

