



MODEL T31563 BUILD-YOUR-OWN MOBILE BASE KIT INSTRUCTIONS

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

Introduction

The Model T31563 Bear Crawl Build-Your-Own Mobile Base Kit allows you to build a custom size base to fit a wide variety of machines.

Specifications

- Minimum Inside Dimensions 12" x 12"
- Minimum Base Thickness 1/2"
- Maximum Weight Capacity (1/2")..... 400 lbs.
- Maximum Weight Capacity (3/4"+) 600 lbs.

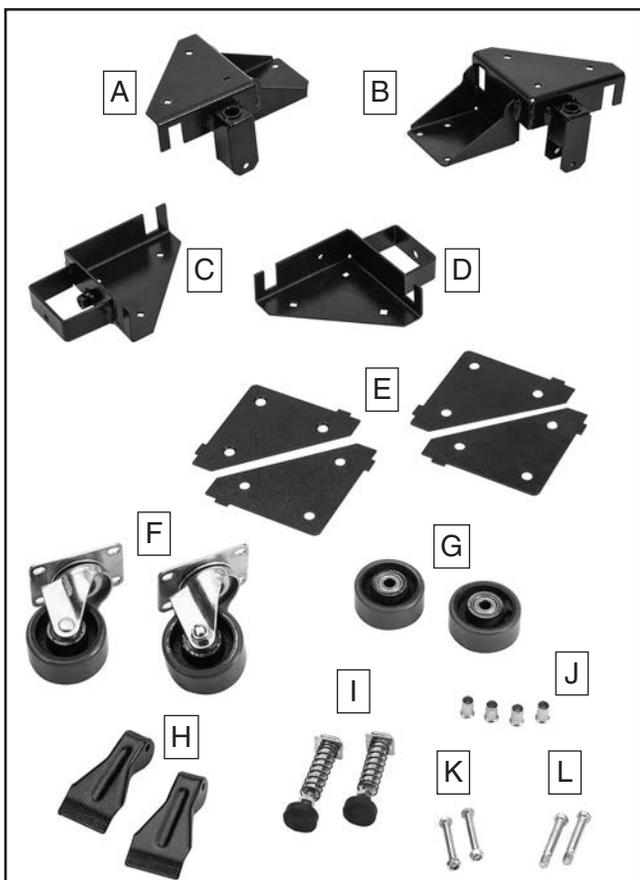


Figure 1. Inventory.

Inventory

Description	Qty
A. Right Front Corner Bracket	1
B. Left Front Corner Bracket.....	1
C. Right Rear Corner Bracket.....	1
D. Left Rear Corner Bracket	1
E. Top Plates.....	4
F. 3" Swivel Casters (Front).....	2
G. 3" Wheel (Rear).....	2
H. Foot Pedals	2
I. Feet	2
—Foot Pedal Plunger.....	1 Ea
—Compression Spring.....	1 Ea
—Rubber Foot.....	1 Ea
—Hex Nut M10-1.5	1 Ea
J. Bearing Sleeves	4
K. Shoulder Bolts M8-1.25 x 50 (Pedals).....	2
L. Shoulder Bolts M10-1.5 x 55 (Casters).....	2
M. Hardware (Not Shown)	
—Flat Hd Screws M8-1.25 x 30 (1/2" Base)	
.....	12
—Flat Hd Screws M8-1.25 x 40 (3/4" Base)	
.....	12
—Hex Bolts M8-1.25 x 16 (Casters).....	8
—Flange Nuts M8-1.25 (Base).....	12
—Lock Nuts M8-1.25 (Casters, Pedals) ...	10

Materials Needed for Assembly

- Plywood (See Page 2)
- Table Saw or Circular Saw
- Measuring Tape.....
- Pencil.....
- Drill Press or Handheld Drill
- Drill Bit 3/8"
- Phillips Screwdriver #2
- Wrench or Socket 12, 13, and 14 mm.....
- Open-End Wrench 17mm.....
- Machine-Specific Hardware
- (See Page 5)

Base Plate Material

The best material for the base plate is a natural wood plywood (hardwood plywood is best). Avoid using OSB, MDF, or particle board, as these materials are generally not strong enough to hold heavy machinery for a long period of time.

$\frac{3}{4}$ " plywood is recommended to make the base plate, with the included 40mm flat head screws. However, 30mm flat head screws are also included for use with $\frac{1}{2}$ " plywood. For base plates over $\frac{3}{4}$ ", longer flat head screws must be acquired separately. Use good judgement to determine the material that best fits your needs.

Preparing Base Plate for Assembly

The size requirements of the base plate vary depending on the size and weight of the machine you plan to put on the mobile base. The purpose of this section is to help you decide the size of base plate that works best for your machine.

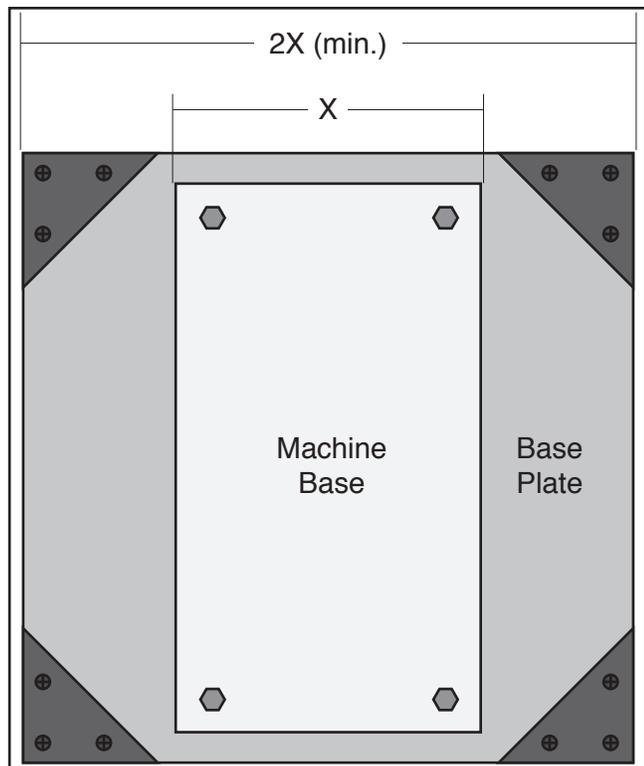


Figure 2. Example of wider base plate.

WARNING

Operating machinery on an unsecured mobile base may allow the machine to shift unexpectedly, which could result in accidental contact with the cutting device or other moving parts.

If the machine is top-heavy or has a narrow base, there is an increased risk of tipping when moving it around on a mobile base. To reduce this risk, make your base plate wider than the machine base (see **Figure 2**). Always secure the machine to the base plate for added stability—this will reduce the risk of tipping the machine over when moving it around the shop. See instructions for mounting the machine on **Page 5**.

To prepare base plate:

1. Measure footprint of machine base.
2. Cut base plate to chosen measurements.
 - If you plan on making the base plate the same dimensions as the machine base, add 1" to the width and the depth. This extra space will make mounting easier and will hardly be noticeable once the machine is mounted.
 - If you plan on making the base plate larger than the machine base to increase stability, don't make the base plate so large it becomes a tripping hazard.
3. Use a corner bracket as a template and mark mounting hole locations on each corner of the base plate.
4. Drill $\frac{3}{8}$ " mounting holes at marked locations.

Note: Think about the final appearance of your mobile base. If you are concerned about how the exposed portions of the base plate will look in your shop, paint or finish the base plate before completing the assembly.



Assembling Mobile Base

1. Attach swivel caster to each front corner bracket with (4) M8-1.25 x 16 hex bolts and (4) M8-1.25 lock nuts (see **Figure 3**).

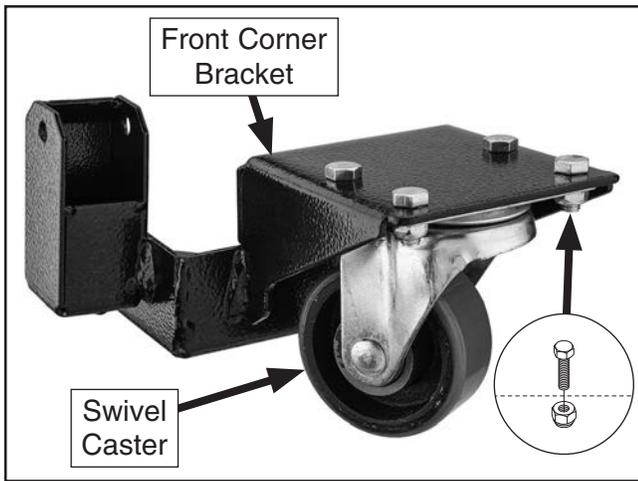


Figure 3. Swivel caster attached to front corner bracket.

2. Install foot pedal plunger and spring into each front corner bracket and attach adjustable foot with M10-1.5 hex nut to the bottom of each foot pedal plunger (see **Figure 4**).

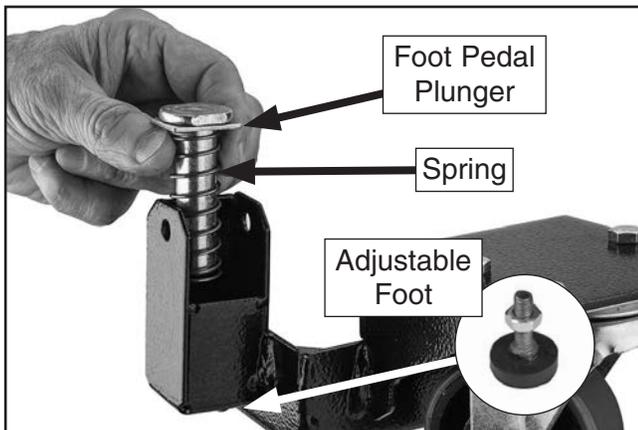


Figure 4. Installing foot pedal plunger and spring.

3. Attach foot pedal to each front corner bracket with M8-1.25 x 50 shoulder bolt and M8-1.25 lock nut (see **Figure 5**).

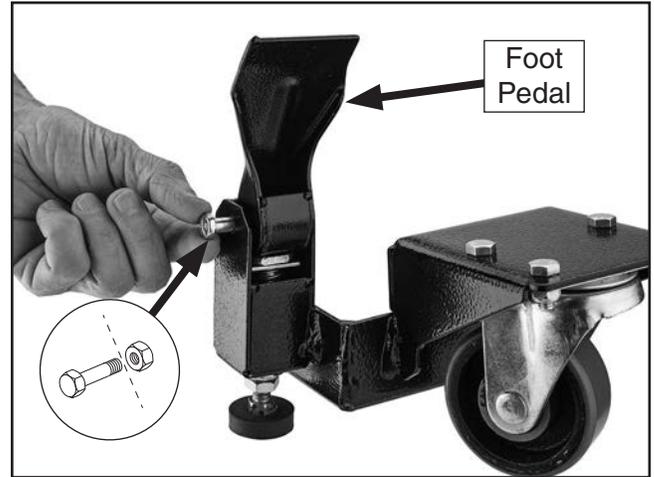


Figure 5. Attaching foot pedals.

4. Attach wheel to each rear corner bracket with M10-1.5 x 55 shoulder bolt and (2) bearing sleeves (see **Figure 6**).

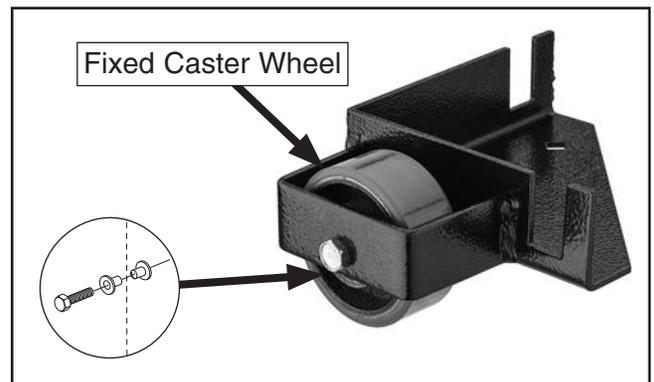


Figure 6. Wheel attached to rear corner bracket.



- Slide top plate tabs into left front corner bracket (see **Figure 7**). Attach bracket and top plate to base plate with (3) M8-1.25 flat head screws and (3) M8-1.25 flange nuts.

Note: 40mm flat head screws are used with $\frac{3}{4}$ " base plate and 30mm flat head screws are used with $\frac{1}{2}$ " base plate.

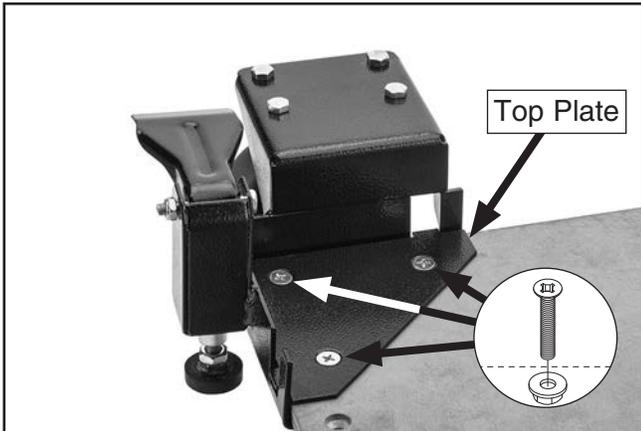


Figure 7. Corner bracket and top plate installed.

- Repeat **Step 5** for each corner bracket.

Note: Ensure fixed casters are oriented in direction machine will typically be moved (see **Figure 8**). Mounting fixed casters in wrong direction will make it difficult to move mobile base around in small spaces.

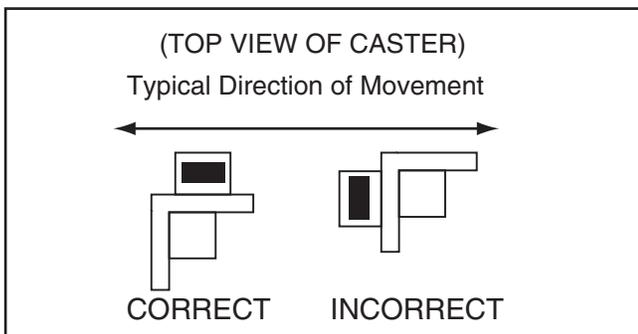


Figure 8. Correct orientation of fixed casters.

Adjusting Rubber Feet

The height of the rubber feet can be adjusted to stabilize the machine. To ensure the machine does not move during operations, always make sure the adjustable rubber feet (see **Figure 9**) are firmly touching the ground before operating the machine.

Tools Needed

Qty

Open-End Wrench 17mm..... 1

To adjust rubber foot height:

- Loosen hex nut on each foot to allow foot (see **Figure 9**) to move up or down as needed.

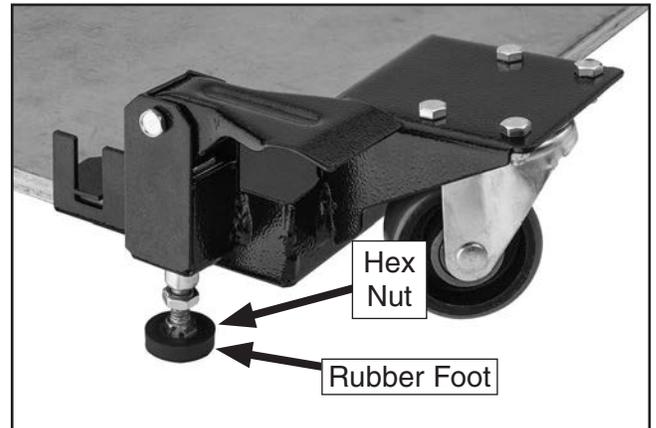


Figure 9. Rubber foot and hex nut adjustment.

- With all casters on the ground, lower each foot to firmly touch the ground without lifting caster.
- Tighten hex nut on each foot.



4. Raise foot pedals up to lift rubber feet and move machine (see **Figure 10**).

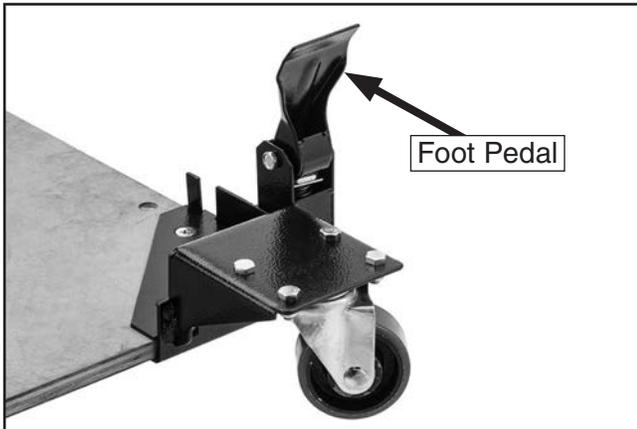


Figure 10. Foot pedal raised.

IMPORTANT: When moving the mobile base, the rubber feet should not touch the floor. Likewise, when operating the machine, ensure that the rubber feet are fixed firmly against the floor to provide stability, without lifting casters.

Mounting Machine to Mobile Base

1. Lower rubber feet to ensure mobile base is secure (see **Adjusting Rubber Feet** on **Page 4**).
2. With the help of an assistant, place machine on base plate.
3. Position machine near front or center of base plate, so mobile base will not be a tripping hazard.
4. Drill mounting holes of appropriate size using machine stand as template.
5. Secure machine with through bolts, flat washers, lock washers, and hex nuts (see **Figure 11**).

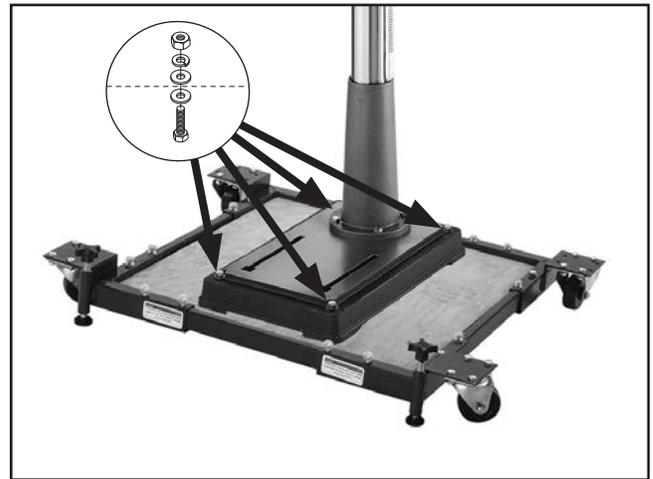


Figure 11. Example of drill press mounted to base plate.

	<p>!WARNING Lifting heavy machinery or parts without proper assistance or equipment may result in strains, back injuries, crushing injuries, or property damage.</p>
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<p>!WARNING To avoid serious personal injury, keep hands and fingers clear of machine base and mobile base pinch points when placing machine.</p>
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Using Mobile Base

1. DISCONNECT MACHINE FROM POWER!
2. With machine mounted on mobile base, adjust each rubber foot so it clears floor by at least 1/8". Refer to **Adjusting Rubber Feet** on **Page 4** for details.
 - If floor is uneven, retract feet completely to eliminate the chance of the pads dragging.
3. Check to make sure machine pathway is clear of all obstructions.
4. Push machine from lowest possible point to avoid tipping it over, and move it to its new location. The best control is usually achieved by pushing from swivel caster side of base.
 - If the machine is large, get an assistant to help stabilize the machine while it is being moved.
5. Adjust each foot until it touches floor, then lower each foot at least an additional half-turn. This ensures major load of machine is on feet rather than on casters.
6. Check machine to make sure it is stable in its new location, and make sure machine is clear of any obstructions before reconnecting power and turning machine **ON**.

WARNING

To reduce risk of serious injury when using this mobile base:

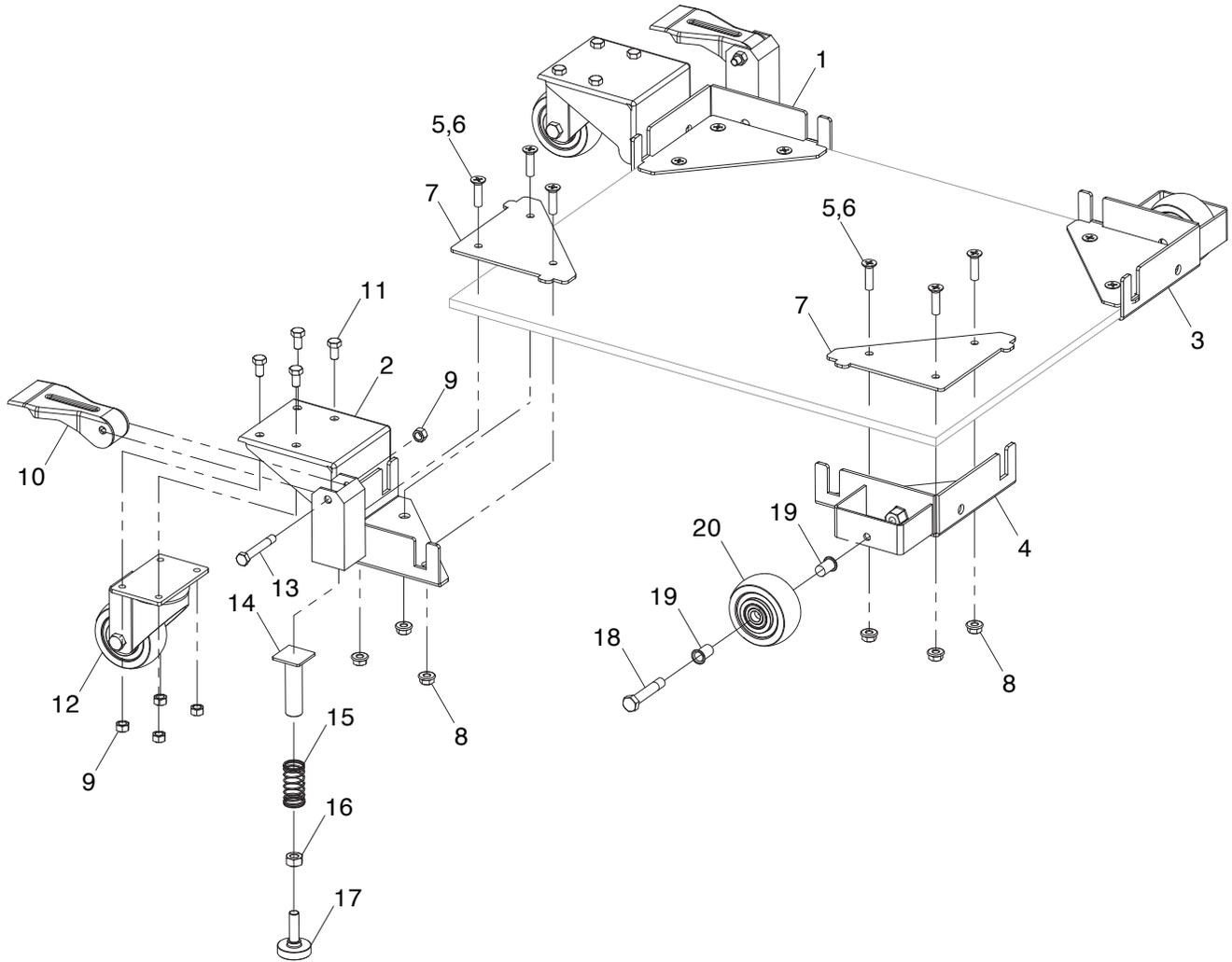
1. **LOCKING FEET.** Do not operate machine on mobile base unless both mobile base feet firmly contact floor and raise base enough to disable casters. Using the machine on base when it is not secured could result in a loss of workpiece control.
2. **MACHINE STABILITY.** Test for stability after placing the machine in its new location. Adjust feet so they each touch the ground, then push on machine at several locations, making sure it is not off balance. The hex nuts can be adjusted up to top of foot assembly to lock foot height setting.

CAUTION

Before moving machine and mobile base, check to make sure pathway is clear of any hoses, wires, tools or shop debris. An abrupt impact with an object along path of travel can lock a wheel and cause machine to fall over, resulting in serious personal injury. Disconnect machine from power supply or dust collection before moving.



T31563 Parts Breakdown & List



REF	PART #	DESCRIPTION
1	PT31563001	LEFT FRONT CORNER BRACKET
2	PT31563002	RIGHT FRONT CORNER BRACKET
3	PT31563003	LEFT REAR CORNER BRACKET
4	PT31563004	RIGHT REAR CORNER BRACKET
5	PT31563005	FLAT HD SCR M8-1.25 X 30
6	PT31563006	FLAT HD SCR M8-1.25 X 40
7	PT31563007	TOP PLATE
8	PT31563008	FLANGE NUT M8-1.25
9	PT31563009	LOCK NUT M8-1.25
10	PT31563010	FOOT PEDAL

REF	PART #	DESCRIPTION
11	PT31563011	HEX BOLT M8-1.25 X 16
12	PT31563012	CASTER, 3" SWIVEL
13	PT31563013	SHOULDER BOLT M8-1.25 X 8, 8 X 50
14	PT31563014	FOOT PEDAL PLUNGER 17MM
15	PT31563015	COMPRESSION SPRING 22 X 1.5 X 61
16	PT31563016	HEX NUT M10-1.5
17	PT31563017	ADJUSTABLE RUBBER FOOT M10-1.5 X 30
18	PT31563018	SHOULDER BOLT M10-1.5 X 14, 10 X 55
19	PT31563019	WHEEL BEARING SLEEVE
20	PT31563020	WHEEL, 3"

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.



WARRANTY & RETURNS

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.

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.

In the event you need to use 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.

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.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/secureforms/warranty-card>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.

