



# MODEL T32003

## 1/4 HP VARIABLE-SPEED MINI BENCHTOP POLISHER

### OWNER'S MANUAL

*(For models manufactured since 02/20)*



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# WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

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

The owner of this machine/tool 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, cutting/sanding/grinding tool 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.

# Table of Contents

<b>INTRODUCTION .....</b>	<b>2</b>
Contact Info .....	2
Manual Accuracy .....	2
Identification .....	3
Controls & Components .....	4
Machine Data Sheet.....	5
<b>SECTION 1: SAFETY .....</b>	<b>7</b>
Safety Instructions for Machinery .....	7
Additional Safety for Buffers.....	9
<b>SECTION 2: POWER SUPPLY .....</b>	<b>10</b>
<b>SECTION 3: SETUP .....</b>	<b>12</b>
Needed for Setup .....	12
Unpacking .....	12
Inventory.....	12
Site Considerations .....	13
Bench Mounting .....	13
Assembly.....	14
Test Run.....	15
<b>SECTION 4: OPERATIONS .....</b>	<b>16</b>
Buffing .....	17
Selecting Buffing Wheels .....	18
Installing/Removing Buffing Wheel .....	18
Selecting Buffing Compounds.....	19
Loading Compound.....	19
<b>SECTION 5: ACCESSORIES .....</b>	<b>20</b>
<b>SECTION 6: MAINTENANCE.....</b>	<b>22</b>
Schedule .....	22
Cleaning .....	22
Lubrication.....	22
<b>SECTION 7: SERVICE .....</b>	<b>23</b>
Troubleshooting.....	23
Replacing Motor Brushes.....	24
<b>SECTION 8: WIRING.....</b>	<b>25</b>
Wiring Safety Instructions .....	25
Wiring Diagram .....	26
<b>SECTION 9: PARTS .....</b>	<b>27</b>
Main.....	27
Labels & Cosmetics .....	28
<b>WARRANTY &amp; RETURNS .....</b>	<b>29</b>

# INTRODUCTION

## Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support  
1815 W. Battlefield  
Springfield, MO 65807  
Phone: (570) 546-9663  
Email: [techsupport@grizzly.com](mailto:techsupport@grizzly.com)

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: [manuals@grizzly.com](mailto:manuals@grizzly.com)

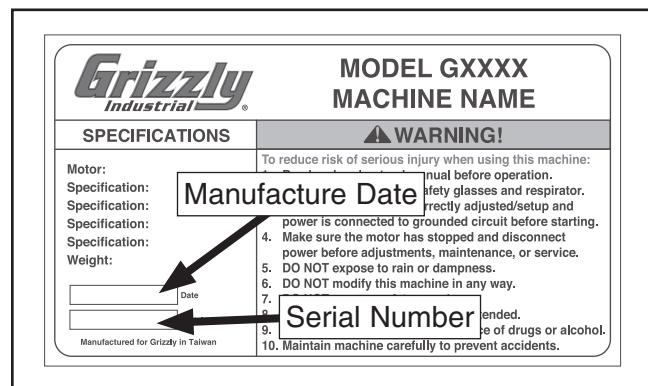
## Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual**.

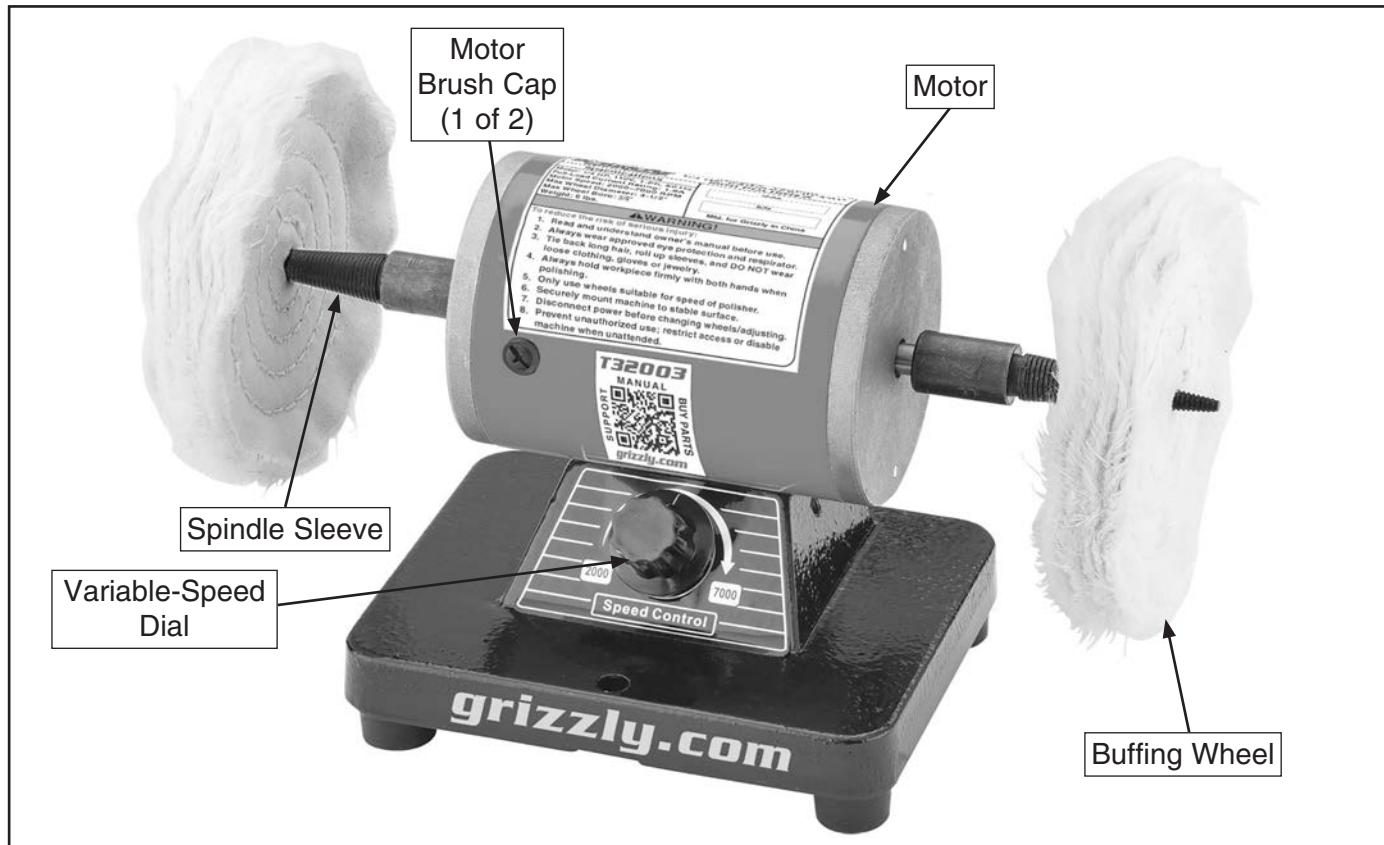
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at [www.grizzly.com](http://www.grizzly.com).

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

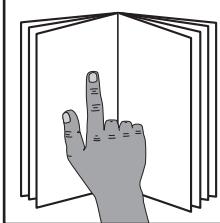


# Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



# Controls & Components



## WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

## Buffing Wheel Components

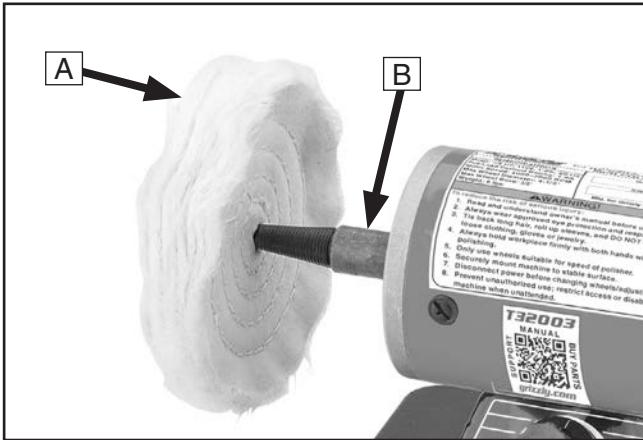


Figure 1. Buffing wheel components.

- A. **Buffing Wheel:** Spins to buff workpiece. Can be replaced with different buffing/polishing wheels for different operations and compounds.
- B. **Spindle Sleeve:** Secures and spins buffing wheels. Accepts wheels up to 4½" diameter of up to a ¾" wheel bore.

## Electrical Components



Figure 2. Electrical components.

- C. **Brush Cap:** Holds motor brush and provides easy access for replacement.
- D. **Variable-Speed ON/OFF Switch:** Rotates clockwise to turn machine **ON** and increase buffing wheels up to 7000 RPM, and rotates counterclockwise to decrease buffing wheels down to 2000 RPM. Rotating completely counterclockwise turns machine **OFF**.





# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

## MODEL T32003 1/4 HP VARIABLE-SPEED MINI BENCHTOP POLISHER

### Product Dimensions:

Weight.....	6 lbs.
Width (side-to-side) x Depth (front-to-back) x Height.....	11 x 4-1/2 x 5-1/2 in.
Footprint (Length x Width).....	6 x 4-1/2 in.

### Shipping Dimensions:

Type.....	Cardboard
Content.....	Machine
Weight.....	8 lbs.
Length x Width x Height.....	24 x 14 x 15 in.

### Electrical:

Power Requirement.....	110V, Single-Phase, 60 Hz
Full-Load Current Rating.....	1.8A
Minimum Circuit Size.....	15A
Connection Type.....	Cord & Plug
Power Cord Included.....	Yes
Power Cord Length.....	6 ft.
Power Cord Gauge.....	18 AWG
Plug Included.....	Yes
Included Plug Type.....	NEMA 5-15
Switch Type.....	Variable-Speed Dial

### Motors:

#### Main

Horsepower.....	1/4 HP
Phase.....	Single-Phase
Amps.....	1.8A
Speed.....	2000 - 7000 RPM
Type.....	Universal (DC)
Power Transfer.....	Direct
Bearings.....	Shielded & Permanently Lubricated

### Main Specifications:

#### Operation Info

Maximum Wheel Diameter.....	4-1/2 in.
Maximum Wheel Thickness.....	2 in.
Maximum Wheel Bore.....	3/8 in.



**Spindle**

Spindle Speed.....	2000 - 7000 RPM
Spindle Diameter.....	8mm (5/16 in.)
Spindle Thread Pitch.....	20 TPI
Spindle Length (Usable).....	1 in.
Tapered Spindle Sleeve Length (Threaded).....	2 in.
Tapered Spindle Sleeve Length (Overall).....	3 in.
Tapered Spindle Sleeve Diameter.....	1/16 - 1/2 in.
Tapered Spindle Sleeve Thread Pitch.....	20 TPI
Right Spindle Thread Direction.....	Right-Handed
Left Spindle Thread Direction.....	Left-Handed

**Construction**

Base.....	Cast Iron
Paint/Finish.....	Enamel

**Other Specifications:**

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	5 Minutes
Serial Number Location .....	Machine ID Label
ISO 9001 Factory .....	Yes

**Features:**

- Cast Iron Base
- Dual Cotton Buffing Wheels
- Two Tapered Spindle Sleeves
- Variable-Speed Dial

**Accessories Included:**

- Hex Wrench 2mm



# SECTION 1: SAFETY

## 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. Always use common sense and good judgment.



**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** Alerts the user to useful information about proper operation of the machine to avoid machine damage.

## Safety Instructions for Machinery



**OWNER'S MANUAL.** Read and understand this owner's manual BEFORE using machine.

**TRAINED OPERATORS ONLY.** Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

**DANGEROUS ENVIRONMENTS.** Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

**MENTAL ALERTNESS REQUIRED.** Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

**ELECTRICAL EQUIPMENT INJURY RISKS.** You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

**DISCONNECT POWER FIRST.** Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.



# **WARNING**

**WEARING PROPER APPAREL.** Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

**HAZARDOUS DUST.** Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

**HEARING PROTECTION.** Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

**REMOVE ADJUSTING TOOLS.** Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

**USE CORRECT TOOL FOR THE JOB.** Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

**AWKWARD POSITIONS.** Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

**CHILDREN & BYSTANDERS.** Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

**GUARDS & COVERS.** Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

**FORCING MACHINERY.** Do not force machine. It will do the job safer and better at the rate for which it was designed.

**NEVER STAND ON MACHINE.** Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

**STABLE MACHINE.** Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

**USE RECOMMENDED ACCESSORIES.** Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

**UNATTENDED OPERATION.** To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

**MAINTAIN WITH CARE.** Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

**DAMAGED PARTS.** Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

**MAINTAIN POWER CORDS.** When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

**EXPERIENCING DIFFICULTIES.** If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



# Additional Safety for Buffers

## **WARNING**

**Entanglement/amputation injuries can occur from being caught in moving parts or in-running pinch points. Buffing wheel can easily remove skin. To minimize risk of getting hurt or killed, anyone operating machine MUST completely heed hazards and warnings below.**

**WORKPIECE SELECTION.** Always inspect the condition of your workpiece. DO NOT buff pieces with loose knots, large splinters, sharp edges, and DO NOT buff knives, cable, chain or other potentially dangerous objects that may be grabbed by the buffing wheel and thrown at the operator.

**EYE/FACE/LUNG PROTECTION.** Always wear eye protection or a face shield and a heavy leather apron when operating the buffer. Wear a dust mask to protect your lungs from microscopic particulates. Particulates may cause allergies or long-term respiratory health problems.

**MOUNTING TO BENCH/STAND.** An unsecured buffer may become dangerously out of control during operation. Make sure buffer is **FIRMLY** secured to a bench/stand before use.

**WORKPIECE CONTROL.** If you cannot hold small workpieces securely, do not buff them with this machine. Secure them with clamps or similar jigs or use a different buffer.

**AVOIDING ENTANGLEMENT.** Becoming entangled in moving parts can cause severe injury or death. Keep all guards and covers in place; DO NOT wear loose clothing, gloves, or jewelry; and tie back long hair.

**OPERATOR POSITION.** Do not stand directly in front of the buffer wheel when turning the machine **ON**, or when buffing. Do not buff material at the rear of the machine.

**HAND/WHEEL CONTACT.** Do not allow your hands to come into contact with the buffing wheel. Abrasive accessories can remove skin fast. Keep a firm grip on the workpiece and position your hands at a safe distance away when buffing. Avoid wearing gloves as they may get caught in the buffing wheel and cause entanglement injuries.

**CORRECT ACCESSORIES AND USE.** The buffer is only designed for buffing and polishing. Never exceed the maximum speed listed on each buffering/polishing wheel.

**WORKPIECE FEED.** Allow the wheel to reach full speed, then slowly ease the workpiece into the buffing wheel, holding it in front of and slightly below the wheel center. Do not place the workpiece on the top or sides of the buffing wheel and do not place an edge or corner of the workpiece against the buffing wheel, or jam it against the wheel. The workpiece may eject toward the operator or be torn from the operator's hands, causing serious personal injury.

## **WARNING**

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine 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**

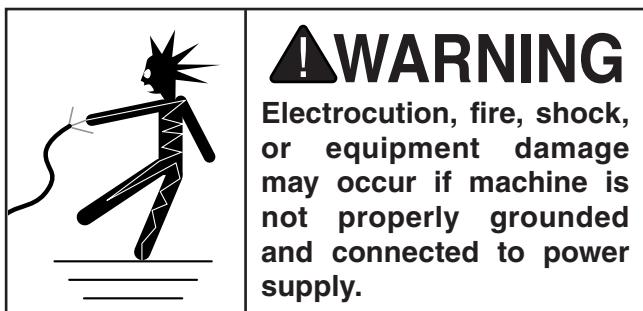
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



# SECTION 2: POWER SUPPLY

## Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



### WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

## Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

### Full-Load Current Rating at 110V..... 1.8 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

### WARNING

Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

## 110V Circuit Requirements

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage ..... 110V, 115V, 120V  
Cycle ..... 60 Hz  
Phase ..... Single-Phase  
Power Supply Circuit ..... 15 Amps

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

### CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

**Note:** Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.



## Grounding & Plug Requirements

This machine MUST be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

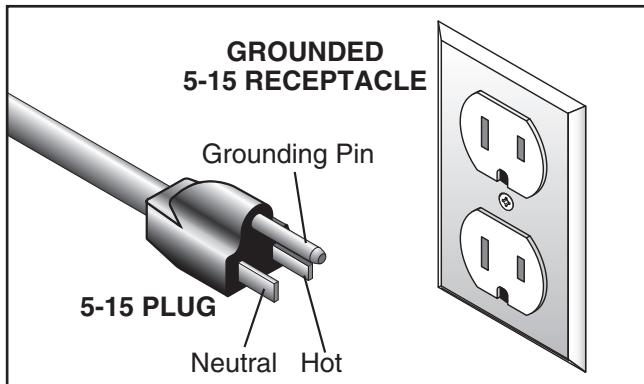
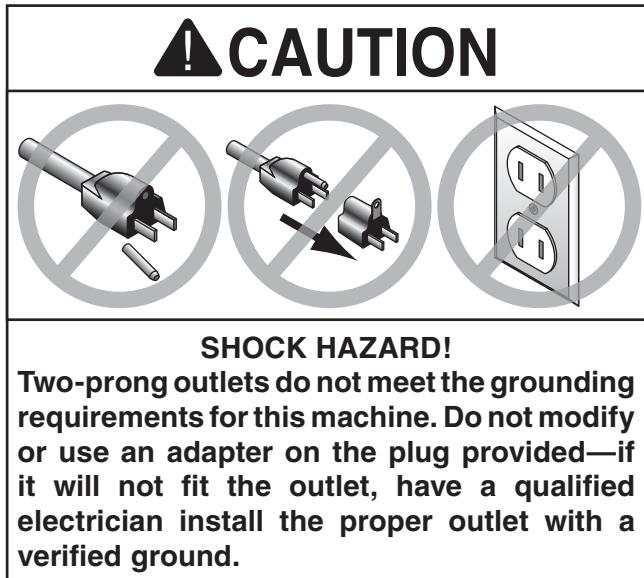


Figure 3. Typical 5-15 plug and receptacle.



Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

## Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

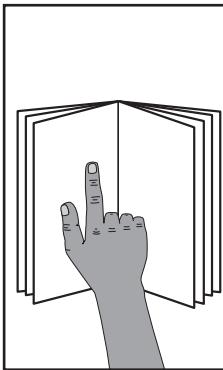
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

**Minimum Gauge Size .....** 16 AWG  
**Maximum Length (Shorter is Better).....** 50 ft.



# SECTION 3: SETUP



## WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



## WARNING

Wear safety glasses during the entire setup process!

## Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Safety Glasses .....	1

## Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. **If items are damaged, please call us immediately at (570) 546-9663.**

**IMPORTANT:** Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. You **MUST** have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.

## Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary 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.

## NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

### Box 1 (Figure 4) Qty

- |                                  |   |
|----------------------------------|---|
| A. Polisher.....                 | 1 |
| B. Tapered Spindle Sleeves ..... | 2 |
| C. Hex Wrench 2mm.....           | 1 |
| D. Buffing Wheels .....          | 2 |

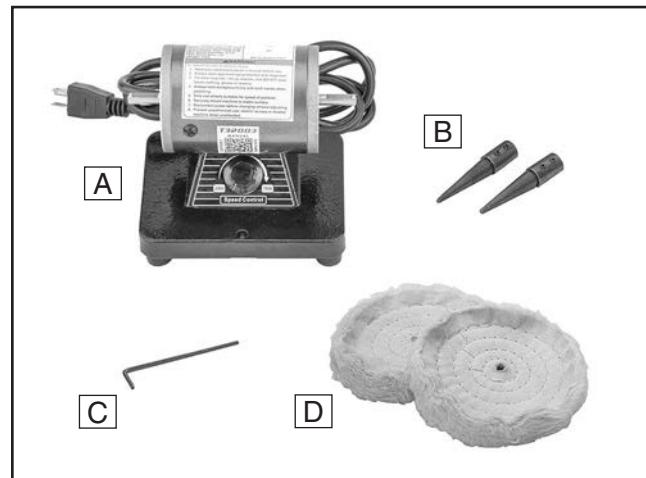


Figure 4. Loose inventory.



# Site Considerations

## Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

## Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

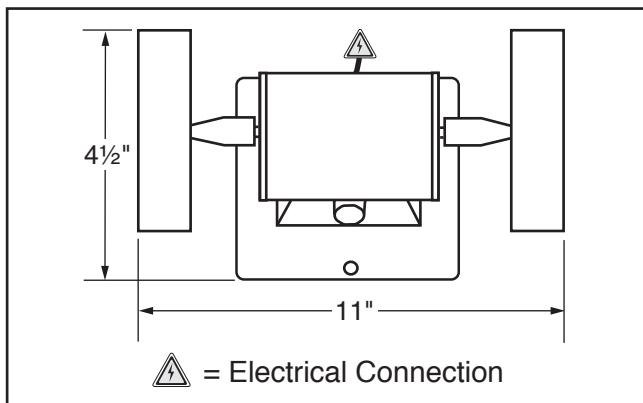
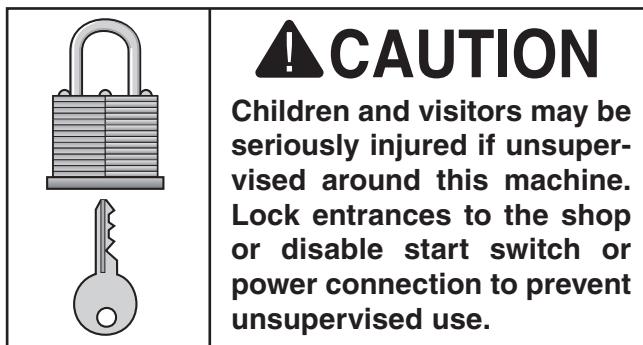


Figure 5. Minimum working clearances.



## Bench Mounting

Number of Mounting Holes ..... 1  
Dia. of Mounting Hardware Needed .....  $\frac{5}{16}$ "

The base of this machine has a mounting hole that allows it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

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.

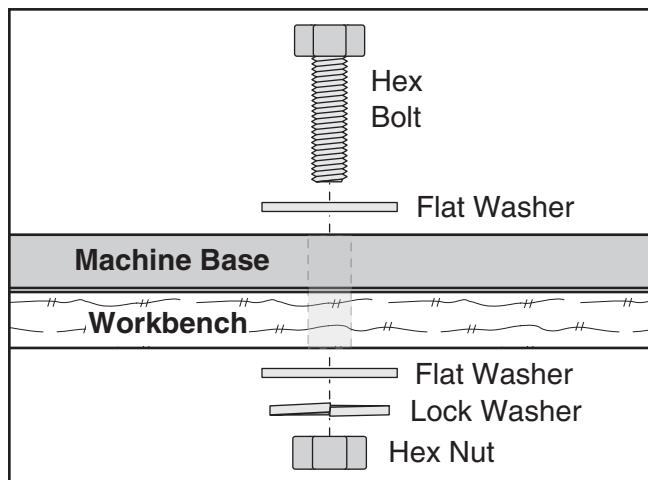


Figure 6. "Through Mount" setup.

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

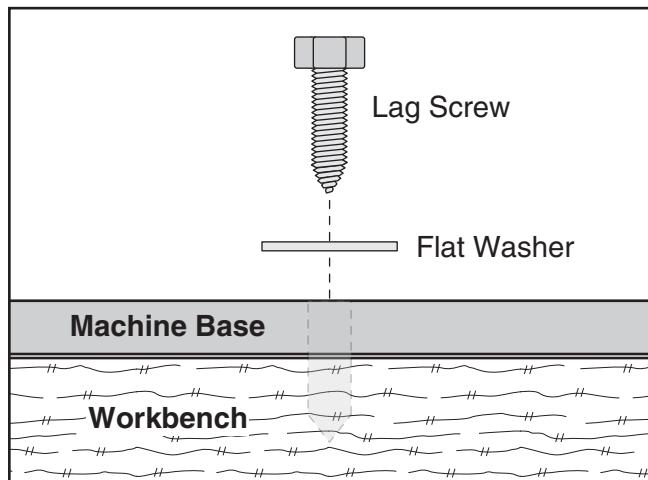


Figure 7. "Direct Mount" setup.



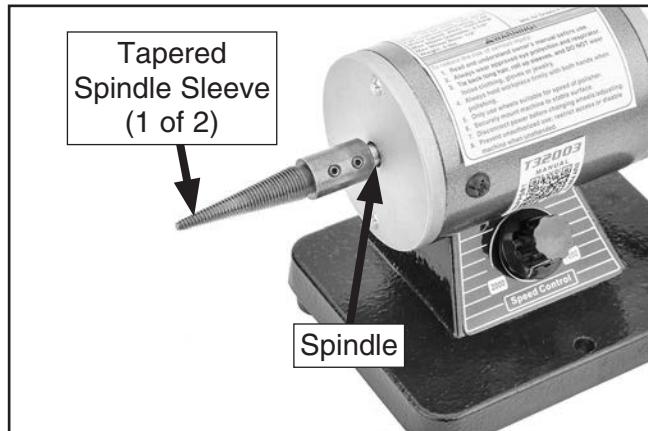
# Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

There is a range of options when it comes to buffing and polishing wheels, but two 4½", 50-ply cotton wheels are included with the Model T32003.

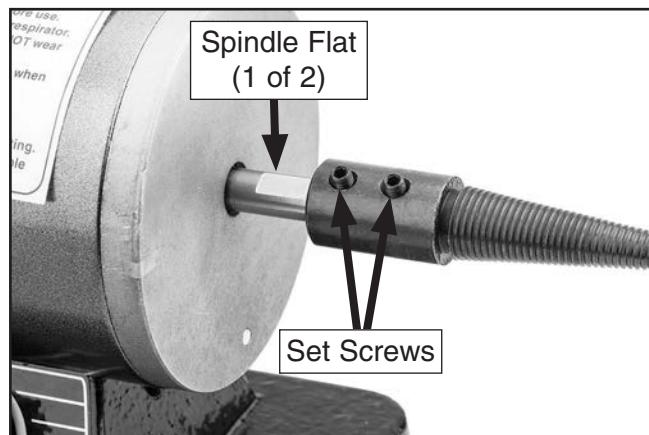
## To assemble machine:

1. Place (1) tapered spindle sleeve on each spindle shaft on each side of buffer (see **Figure 8**).



**Figure 8.** Tapered spindle sleeves on spindle.

**Note:** Pre-installed set screws in spindle sleeves should line up with flats on spindle (see **Figure 9**).



**Figure 9.** Set screws aligned with spindle flat.

2. Tighten (2) pre-installed set screws on each sleeve to secure sleeves on spindle shaft.

**Note:** Sleeve is not correctly installed if spindle flat is visible. Sleeve should cover entire spindle flat on each side.

3. Thread a buffering wheel onto either tapered spindle sleeve (see **Figure 10**).



**Figure 10.** Buffering wheels threaded onto tapered spindle sleeves.

**Note:** Left spindle sleeve has left-hand threads so buffering wheel threads counter-clockwise onto sleeve.



# Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly.

## !WARNING

**Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.**

## !WARNING

**DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.**

### To test run machine:

1. Clear all setup tools away from machine.
2. Turn variable-speed dial all the way counter-clockwise (see **Figure 11**) to ensure machine does not unexpectedly start in highest speed.



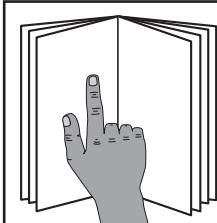
**Figure 11.** Variable-speed dial location.

3. Connect machine to power supply.
4. Turn variable-speed dial clockwise to turn machine **ON**.
5. Verify motor operation by slowly turning variable-speed dial back and forth to test variable-speed function. Motor should run smoothly and without unusual problems or noises.
  - If motor *does not* run smoothly, immediately turn machine **OFF** and disconnect power. Refer to **Troubleshooting** on **Page 23** to before operating.
6. Turn variable-speed dial all the way counter-clockwise to turn machine **OFF** to ensure machine does not unexpectedly start in highest speed.

Congratulations! Test run is complete.



# SECTION 4: OPERATIONS

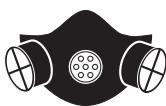
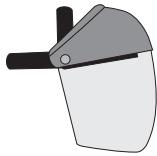


## WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

## WARNING

Eye and face injuries and respiratory problems can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



## NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/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.

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

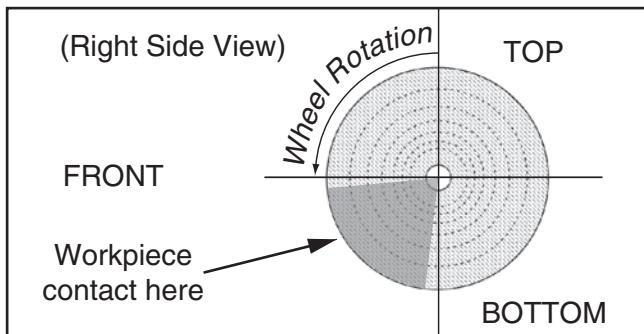
1. Cleans and examines workpiece to make sure it is suitable for buffing.
2. Selects appropriate polishing compound.
3. Ensures that variable-speed dial is turned all the way counterclockwise in OFF position, and connects buffer to power.
4. Puts on personal protective equipment.
5. Stands aside, starts machine, adjusts speed, then applies polishing compound and gradually feeds workpiece into wheel.
6. Stops machine once buffing operation is complete.



# Buffing

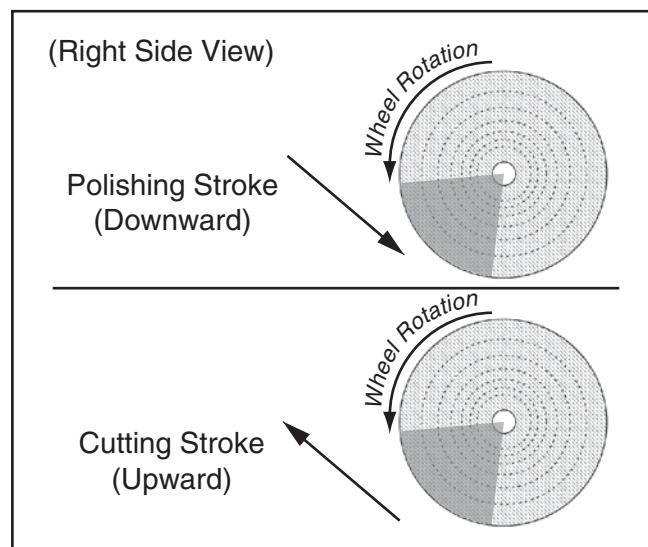
Below are some quick tips for getting the most out of your buffing wheels. Remember, there is no substitute for experience. Learning how to hold the workpiece, how much pressure to apply, how to move the workpiece against the wheel, and how much compound to use requires a certain amount of trial-and-error.

- Thoroughly clean all parts you plan to buff. Dirt, oil, rust, paint, or other film must be removed chemically or with water. Make sure to dry off parts with a rag after cleaning.
- Apply buffing compounds in small amounts at a time. Apply paste-type compounds with a wand or directly to the part. For wax-based polishing stick-type compounds, press compound on the wheel for a couple of seconds while machine is running. Avoid using too much compound.
- Put your workpiece under wheel when you are loading compound on the buffing wheel. This way, you will catch any compound that would normally be wasted on floor.
- To begin buffing, slowly feed workpiece into buffing wheel workpiece contact zone (see **Figure 12**). Contacting workpiece on areas outside of the correct area may flip workpiece out of your hands. Hold workpiece tightly at all times while buffing. Placing one hand near contact point will give you better control.



**Figure 12.** Workpiece contact zone.

- Keep buffering wheels raked out before each use and when buildup gets heavy during use. Raking means to clean buffering wheels with a wheel rake to remove built-up compounds and metal particles. **ALWAYS** use light pressure when raking wheels!
- Do not mix two different compounds on same wheel. For best results, use a separate wheel for each compound.
- Always use an upward stroke with heavy to moderate pressure for cutting. Use a downward stroke with light pressure for polishing (see **Figure 13**).



**Figure 13.** Cutting and polishing strokes.

- Wear safety equipment when buffering. If polisher forces workpiece out of your hand, be prepared for it to come flying at you! Wear safety glasses or a face shield and a heavy leather apron. Also, wear a dust mask to protect your lungs from microscopic particulate that will be flying off wheel.

## NOTICE

Use caution when polishing plated metals; there is a chance that thinly-plated materials could be damaged. Light pressure is all that is needed for quality work.



# Selecting Buffing Wheels

Buffing wheels are available for most types of metals and for different stages in the buffing process. Below are pictures and descriptions of common wheel types:

## Loose Muslin

Soft feather-edged muslin stitched together near the center leaves the outer edge to provide a wide angle, fine polishing surface. Perfect for polishing stainless steel, chrome, gold or silver.



## Laminated Sisal

Designed for rough cutting, sisal works well with various steels, copper, aluminum, and brass to remove scratches and prepare the piece for polishing.



## Spiral Sewn

Consist of layers of 100% unbleached cotton sheeting that are spiral sewn  $\frac{1}{8}$ " apart. Works well for initial polish on brass, stainless steel, aluminum, bronze and cast iron.

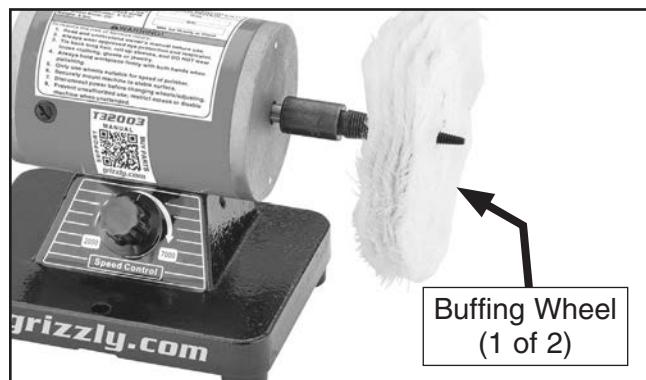


# Installing/Removing Buffing Wheel

The tapered spindle sleeves on each end of the spindle make it easy to swap out different buffing wheels for different projects. Their tapered design also allows for a range of bore thicknesses, especially useful for polishing wheels that may break down after a lot of polishing use. If the bore of a wheel wears and becomes larger, simply install it farther onto the spindle sleeve.

## To install/remove buffing wheel:

1. DISCONNECT MACHINE FROM POWER!
2. Remove buffing wheels by holding shaft stationary and turning left wheel clockwise off of shaft and right wheel counterclockwise.
3. Thread a buffing wheel onto either tapered spindle sleeve (see **Figure 14**).



**Figure 14.** Buffing wheel threaded onto tapered spindle sleeve.

**Note:** Left spindle sleeve has left-hand threads so buffing wheel threads counterclockwise onto sleeve.



# Selecting Buffing Compounds

Most colors of abrasives have similar applications, but always check with the manufacturer of your particular compound.

Grizzly offers the following compounds:

**Red Rouge** — Made for fine polishing on brass and gold. Provides an excellent shine when used with the loose muslin buffing wheel.

**Green (Extra Fine)** — Great for extra-fine polishing on most metals to bring out that mirror finish. Works best with loose muslin and spiral sewn buffing wheels.

**White** — Great for ivory, plastic and resins when used successively with the soft spiral sewn and soft airway buffing wheels.

**Black** — Designed to be used with sisal and air-way hard buffing wheels, this compound is perfect for the initial rough cut on stainless steel and iron.

**Tripoli** — A true middle-of-the-road abrasive, Tripoli provides an excellent medium cut for brass, aluminum and zinc alloy.

**Green (Fine)** — Slightly more abrasive than the extra-fine green, this green compound is great for a medium-to-fine polish with most softer metals.

## Buffing Compound Sequence Key

Compound Type	Plastics Soft Metals			Thin Plating Gold Silver			Chrome & Nickel Plate			Copper Brass Aluminum			Iron Steel Stainless Steel		
	R	F	P	R	F	P	R	F	P	R	F	P	R	F	P
Tripoli	X							X		X					
Dark Rouge							X			X					X
White Rouge		X	X								X	X			
Black Rouge													X	X	

Buffing Sequence: R = Rough F = Final Cut, Initial Polish P = Final Polish

# Loading Compound

Select a buffering compound and buffering wheel that is suitable for the workpiece and each sequence of the buffering or polishing operation.

## To load compound on wheels:

1. Select buffering wheel suitable for workpiece (refer to **Selecting Buffering Wheels on Page 18**). Follow directions on **Page 18** to install wheel.

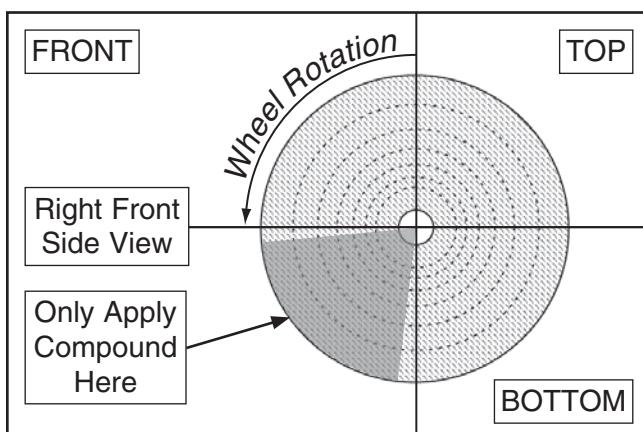
2. Select buffering compound suitable to material (refer to **Selecting Buffering Compounds and Buffering Compound Sequence Key**).

**Note:** Make sure buffering wheel is free of any compound used in prior buffering operation. Clean with a buffering wheel rake if necessary (see **Cleaning on Page 22**).

3. Put on safety glasses, face shield, and respirator, then connect machine to power.

4. Stand to side of buffering wheel and turn machine **ON**. Allow wheel to reach full speed.

5. Apply buffering compound to rotating face of wheel, as shown in **Figure 15**. Only hold compound to wheel for 2–5 seconds. The polisher is now ready for buffering/polishing.



**Figure 15.** Location where buffering compound should contact wheel.

6. Turn machine **OFF** when operation is complete.



# SECTION 5: 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.

### G2582—Buffing Compound Set

Set includes one 5 oz. bar of each of the following compounds: Black Emery Cake, Tripoli Brown rouge, White Rouge & Red Rouge. Low cost – must have! Due to their nature, colors may vary.



Figure 16. Model G2582 Buffing Compound Set.

### H4383—Buffing Wheel Rake with Handle

### H4384—Replacement Rake

Great for removing dried compound from buffing wheels. Simply guide the rake across the spinning buff.

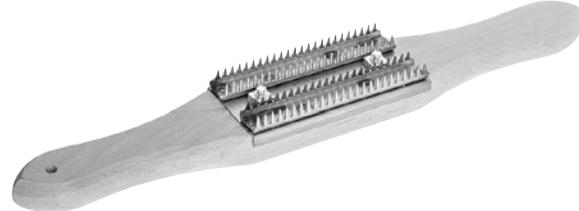


Figure 17. Buffing wheel rake with handle.

### Buffing Wheels

MODEL	TYPE	SIZE	MAX RPM
D2494	Spiral Sewn	3" x 40 Ply x 1/4"	5,000
D2495	Spiral Sewn	4" x 40 Ply x 1/4"	5,000
D2509	Muslin	3" x 40 Ply x 1/4"	5,000
D2510	Muslin	4" x 40 Ply x 1/4"	5,000

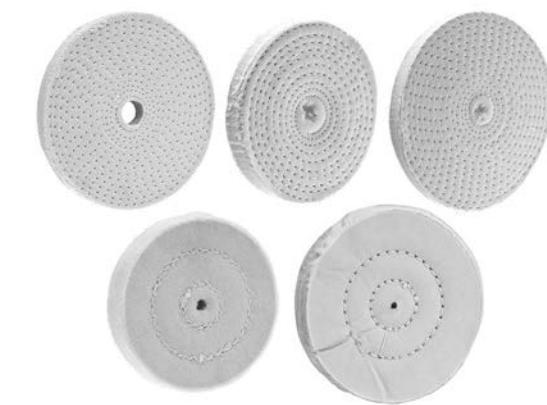


Figure 18. Replacement buffing wheels.

order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777



## Basic Eye Protection

T32323—Woodturners Face Shield

T32401—EDGE Brazeau Safety Glasses, Clear

T32402—EDGE Khor G2 Safety Glasses, Tint

T32404—EDGE Mazeno Safety Glasses, Clear



Figure 19. Assortment of basic eye protection.

## T30024—Powered Respirator Kit

Breathing wood dust could cause severe respiratory illnesses. This kit is a lightweight, comfortable, and easy-to-carry device for protecting the airway from small particulates.



Figure 20. T30024 Powered Respirator Kit.

T32002—3" Variable-Speed Mini Benchtop Grinder/Buffer with Rotary Shaft

T32005—2" Mini Benchtop Cut-Off Saw

T32006—Variable-Speed Mini Benchtop Drill Press

Sometimes smaller is better, and that's definitely the case with our lineup of pint-sized hobby machines. Whether you're into making doll furniture, model train sets, jewelry, or custom ammunition, these space saving, lightweight machines are just what you need for your delicate work.

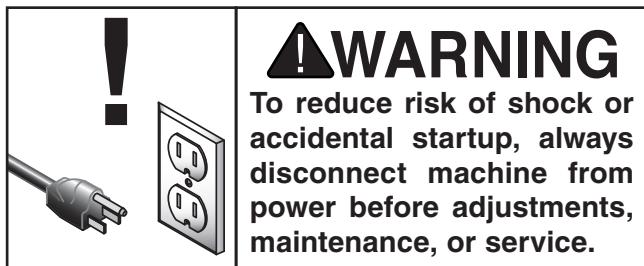


Figure 21. Grizzly hobby machines.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



# SECTION 6: MAINTENANCE



## Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

### Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Damaged spindle shaft.
- Damaged buffering wheels.
- Worn or damaged wires.
- Any other unsafe condition.

### Weekly Maintenance

- Worn or damaged cord.
- Worn ON/OFF switch.
- Worn variable-speed dial.

### Monthly Check

- Clean/vacuum dust buildup off motor.

## Cleaning

Cleaning the Model T32003 is relatively easy. Vacuum excess debris and wipe off the remaining dust with a dry cloth. Wipe down spindle with a non-staining lubricant after cleaning.

To clean buffering wheels, use a buffering wheel rake to remove dried compound. Guide the rake across the spinning buffering wheel using light pressure, as shown in **Figure 22**.



**Figure 22.** Removing compound from buffering wheel with buffering wheel rake.

## Lubrication

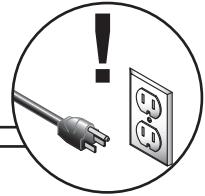
The bearings inside the Model T32003 are sealed and permanently lubricated. Simply leave them alone unless they need replacing.



# SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** Please gather the serial number and manufacture date of your machine before calling.

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply fuse/breaker trips immediately after startup.	<ol style="list-style-type: none"><li>Power supply circuit breaker tripped or fuse blown.</li><li>Wiring broken, disconnected, or corroded.</li><li>Motor brushes at fault.</li><li>Circuit board at fault.</li><li>Motor at fault.</li></ol>	<ol style="list-style-type: none"><li>Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.</li><li>Fix broken or disconnected/corroded wires (<a href="#">Page 10</a>).</li><li>Remove/replace brushes (<a href="#">Page 24</a>).</li><li>Replace.</li><li>Test/repair/replace.</li></ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"><li>Machine undersized for task.</li><li>Buffing wheel too large/wide or exceeds recommended wheel rating.</li><li>Motor brushes at fault.</li><li>Motor overheated.</li><li>Circuit board at fault.</li><li>Motor or motor bearings at fault.</li></ol>	<ol style="list-style-type: none"><li>Use new buffering wheel; reduce feed rate.</li><li>Replace with smaller wheel or reduce wheel width.</li><li>Remove/replace brushes (<a href="#">Page 24</a>).</li><li>Clean motor, let cool, and reduce workload.</li><li>Test/repair/replace.</li><li>Test/repair/replace.</li></ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"><li>Buffing wheel loose or worn.</li><li>Tapered spindle sleeves dislodged.</li><li>Machine incorrectly mounted to workbench.</li><li>Motor or component loose.</li><li>Motor shaft bent.</li><li>Motor or motor bearings at fault.</li></ol>	<ol style="list-style-type: none"><li>Replace buffering wheel (<a href="#">Page 20</a>).</li><li>Reattach spindle sleeves (<a href="#">Page 14</a>).</li><li>Adjust feet, shim, or tighten mounting hardware.</li><li>Replace damaged bolts/nuts or tighten if loose.</li><li>Test with dial indicator and replace motor.</li><li>Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li></ol>

### Operation

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"><li>Operator using too much pressure.</li><li>RPM too low.</li></ol>	<ol style="list-style-type: none"><li>Use less pressure when buffering.</li><li>Increase buffering wheel RPM.</li></ol>
Poor results from buffering/polishing operation.	<ol style="list-style-type: none"><li>Workpiece contains residue or contaminants.</li><li>Contaminated buffering compounds on wheel.</li><li>Wrong buffering compound for material.</li><li>Workpiece not held firmly.</li><li>Incorrect stroke for buffering compound/wheel/material.</li><li>Incorrect type of buffering wheel.</li></ol>	<ol style="list-style-type: none"><li>Dirt, oil, rust, paint, or other film must be removed chemically or with water. Dry parts before buffering.</li><li>DO NOT mix different compounds on same wheel. Use separate wheel for each compound. Remove compound with buffering wheel rake (<a href="#">Page 22</a>).</li><li>Use correct buffering compound (<a href="#">Page 19</a>).</li><li>Use a holding device to firmly secure workpiece.</li><li>Use upward stroke with heavy pressure for cutting; use downward stroke with light pressure for polishing.</li><li>Use correct buffering wheel (<a href="#">Page 18</a>).</li></ol>



# Replacing Motor Brushes

This machine is equipped with a universal motor that uses two carbon brushes to transmit electrical current inside the motor.

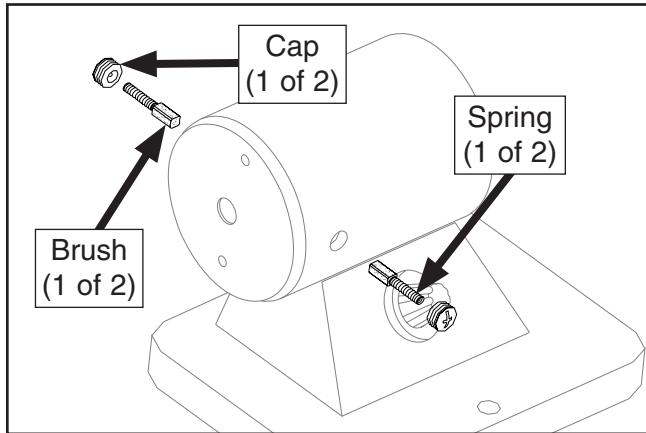
These brushes are considered to be regular "wear items" or "consumables" that will need to be replaced during the life of the motor. The frequency of required replacement is related to how much the motor is used and how hard it is pushed.

Replace both carbon brushes at the same time when the motor no longer reaches full power, or when the brushes measure less than  $\frac{3}{16}$ " long (new brushes are  $\frac{3}{8}$ " long).

Items Needed	Qty
Phillips Head Screwdriver #2 .....	1
Carbon Brushes (PN PT32003014).....	1 Pair

## To replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Remove brush caps, brush springs, and worn brushes from motor (see **Figure 23**).



**Figure 23.** Location of motor brushes.

3. Replace both motor brushes and re-install with springs and brush caps.



# SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

## ⚠️WARNING

### Wiring Safety Instructions

**SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

**MODIFICATIONS.** Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

**WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

**CIRCUIT REQUIREMENTS.** You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

**WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

**MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

**EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

#### NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

#### COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW	Yg	BLUE	Bw
GREEN	Gn	GRAY	Gy	GREEN		WHITE	
RED	Rd	ORANGE	Or	PURPLE	Pu	TUR- QUOISE	Tu
				PINK	Pk		



# Wiring Diagram

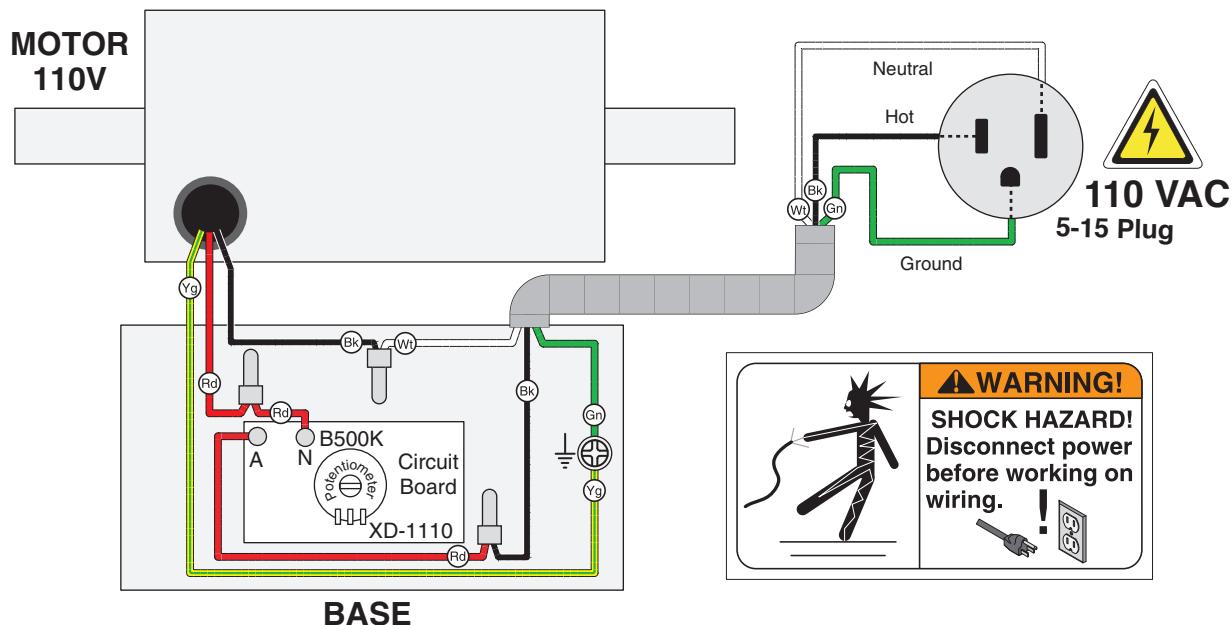


Figure 24. Base wiring.

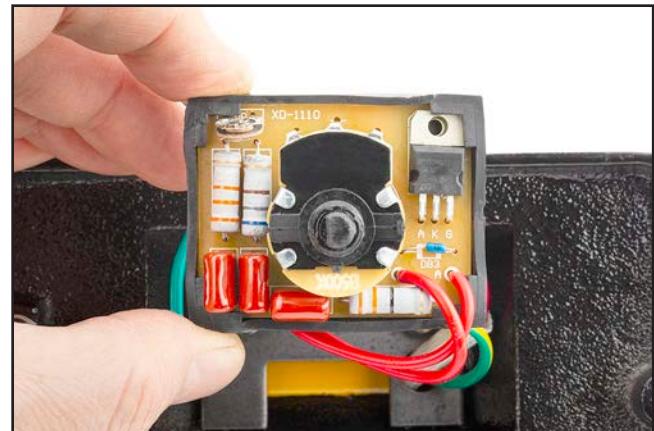


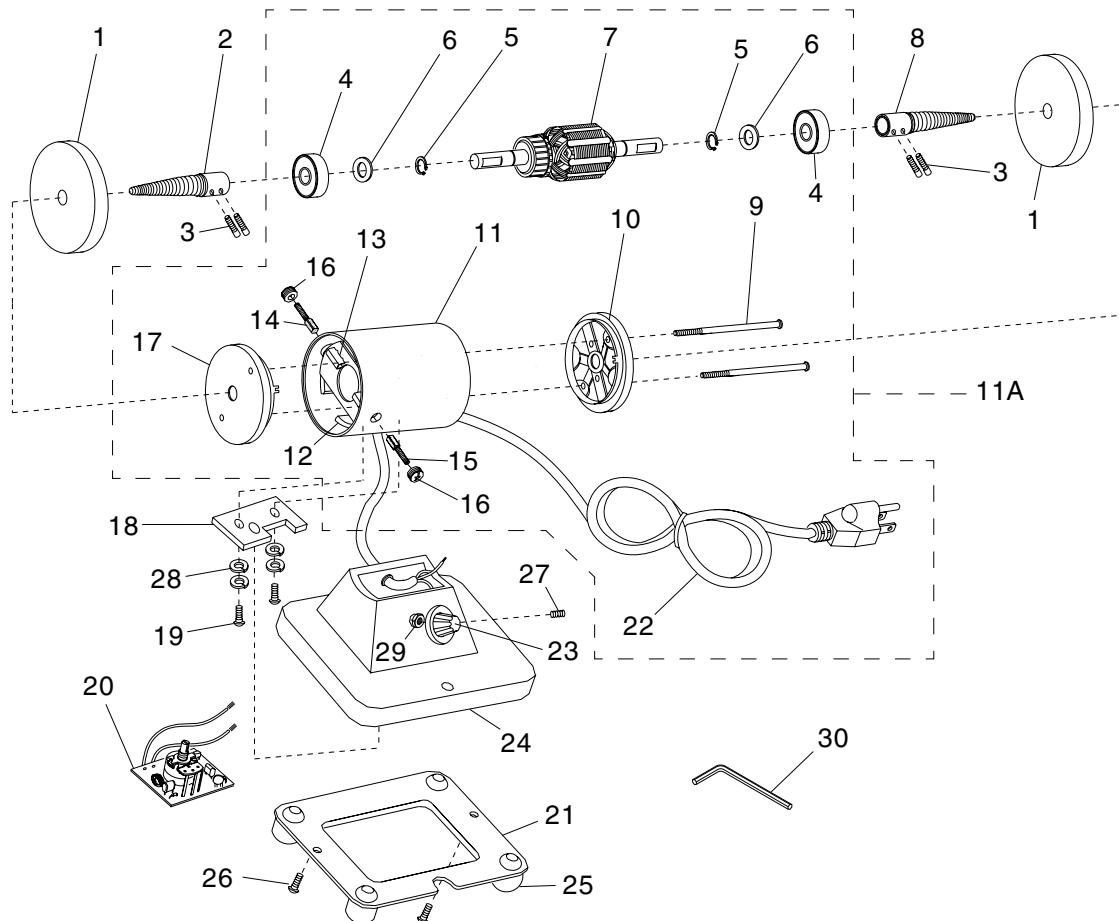
Figure 25. Circuit board.



# SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call (800) 523-4777 or visit [www.grizzly.com/part](http://www.grizzly.com/part)s to check for availability.

## Main



### REF PART # DESCRIPTION

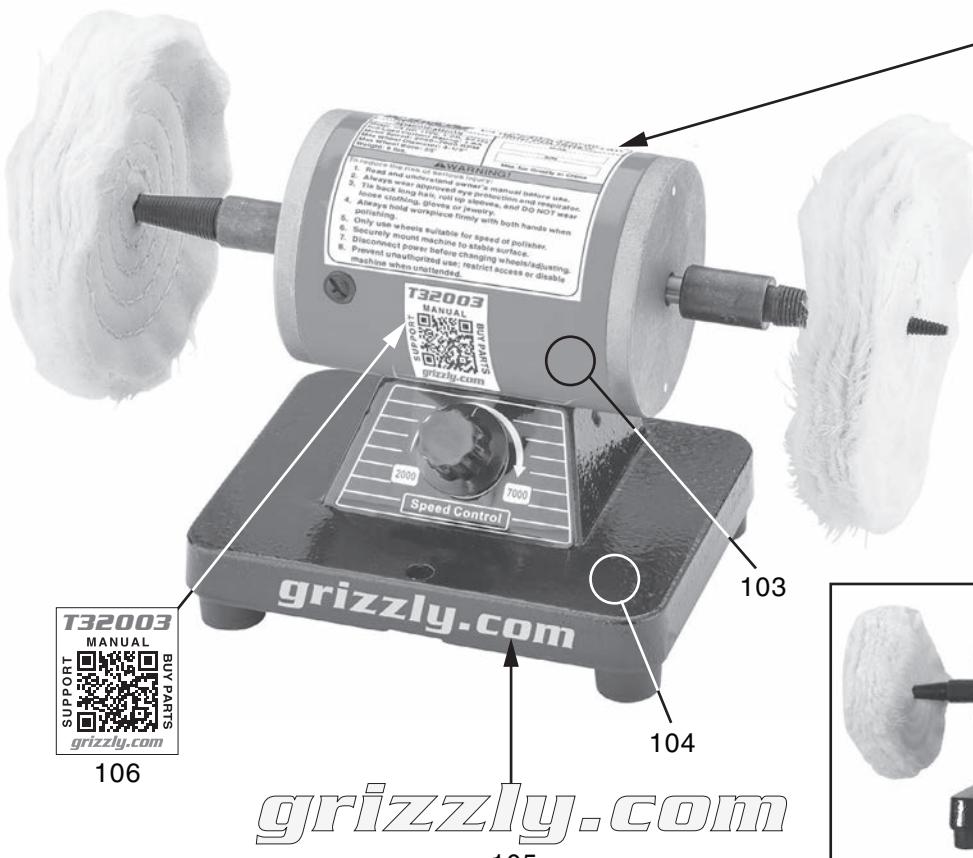
1	PT32003001	BUFFING WHEEL 4-1/2" X 1/2" X 5/16"
2	PT32003002	TAPERED SPINDLE SLEEVE (LH)
3	PT32003003	SET SCREW M4-.7 X 6
4	PT32003004	BALL BEARING 608ZZ
5	PT32003005	EXT RETAINING RING 7MM
6	PT32003006	WAVY WASHER 12MM
7	PT32003007	ROTOR
8	PT32003008	TAPERED SPINDLE SLEEVE (RH)
9	PT32003009	SHOULDER SCREW M4-.7 X 38, 4 X 68
10	PT32003010	MOTOR COVER (RH)
11A	PT32003011A	MOTOR ASSEMBLY
11	PT32003011	MOTOR HOUSING
12	PT32003012	MAGNET
13	PT32003013	BRUSH HOLDER
14	PT32003014	MOTOR BRUSH (1 PAIR)
15	PT32003015	COMPRESSION SPRING 0.4 X 4 X 22

### REF PART # DESCRIPTION

16	PT32003016	BRUSH CAP
17	PT32003017	MOTOR COVER (LH)
18	PT32003018	JUNCTION PLATE
19	PT32003019	PHLP HD SCR M5-.8 X 12
20	PT32003020	CIRCUIT BOARD XD-1110
21	PT32003021	BASE STAND
22	PT32003022	POWER CORD 18G 3W 72" 5-15P
23	PT32003023	VARIABLE-SPEED DIAL
24	PT32003024	BASE
25	PT32003025	RUBBER FOOT
26	PT32003026	PHLP HD SCR M4-.7 X 6
27	PT32003027	SET SCREW M4-.7 X 5 SLOTTED
28	PT32003028	LOCK WASHER 5MM
29	PT32003029	SPEED DIAL HEX NUT M9
30	PT32003030	HEX WRENCH 2MM

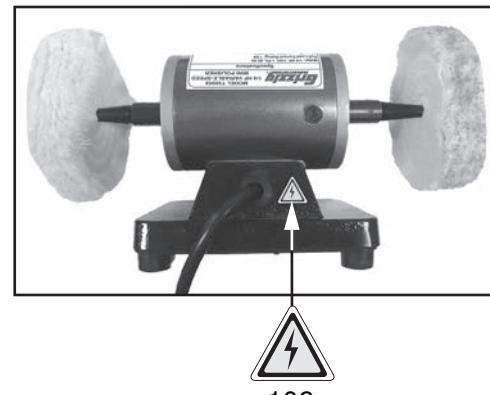


# Labels & Cosmetics



<b>Grizzly</b> Industrial		MODEL T32003 1/4 HP VS MINI BENCHTOP POLISHER
<b>Specifications</b>		Date
Motor: 1/4 HP, 110V, 1.8A, 60 Hz		S/N
Motor Speed: 2000–7000 RPM		Mfd. for Grizzly in China
Max Wheel Diameter: 4-1/2"		
Max Wheel Thickness: 2"		
Max Wheel Bore: 3/8"		
Weight: 6 lbs.		
<b>WARNING!</b>		
To reduce the risk of serious injury:		
1. Read and understand owner's manual before operating.		
2. Always wear approved eye protection and respirator.		
3. Tie back long hair, roll up sleeves, and DO NOT wear loose clothing, gloves, or jewelry.		
4. Always hold workpiece firmly with both hands when polishing.		
5. Only use wheels suitable for speed of polisher.		
6. Securely mount machine to stable surface.		
7. Disconnect power before changing wheels/adjusting.		
8. Prevent unauthorized use; restrict access or disable machine when unattended.		

101



102

REF	PART #	DESCRIPTION
101	PT32003101	MACHINE ID LABEL
102	PT32003102	ELECTRICITY LABEL
103	PT32003103	TOUCH-UP PAINT, GRIZZLY GREEN

REF	PART #	DESCRIPTION
104	PT32003104	TOUCH-UP PAINT, GRIZZLY BLACK
105	PT32003105	GRIZZLY.COM LABEL
106	PT32003106	QR CODE LABEL

## ⚠ WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or [www.grizzly.com](http://www.grizzly.com).



# WARRANTY & 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.

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/forms/warranty>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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