



# MODEL T10025 16" PLANER BLADE SHARPENING JIG INSTRUCTION SHEET

## Introduction

The Model T10025 16" Planer Blade Sharpening Jig for the Model T10010 Wet Grinder sharpens planer, jointer, and other blades up to 16" long.

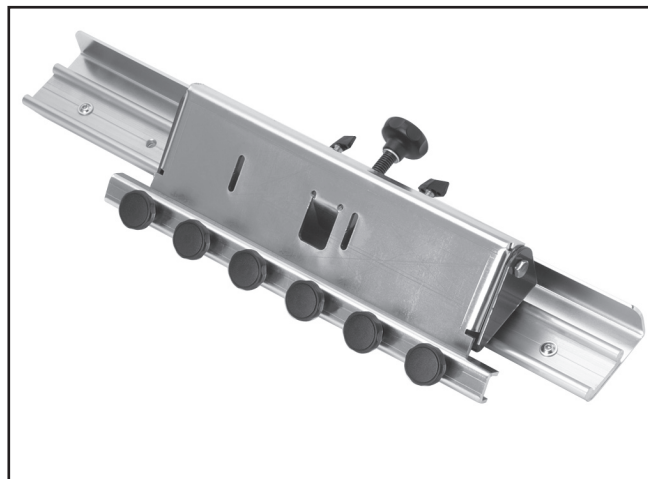


Figure 1. T10025 Accessory Kit.

## Unpacking

The Model T10025 16" Planer Blade Sharpening Jig was carefully packed when it left our warehouse. If you discover any parts are damaged after you have signed for delivery, *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.* When you are completely satisfied with the condition of your shipment, you should inventory the contents.

## Inventory (Figure 2)

- A. 16" Planer Blade Jig ..... 1
- B. Flange Screw M6-1 x 16 (support leg) ..... 1
- C. Flat Washers 8MM (mounting posts) ..... 2
- D. Hex Bolt M8-1.25 x 100 (support leg) ..... 1
- E. Hex Bolt M8-1.25 x 35 (support leg opt.) ... 1
- F. Hex Nuts M8-1.25 (mounting posts) ..... 2
- G. Thin Hex Nut M8-1.5 (support leg) ..... 1
- H. Attachment Posts w/Adjusting Wheels ..... 2
- I. Support Leg ..... 1

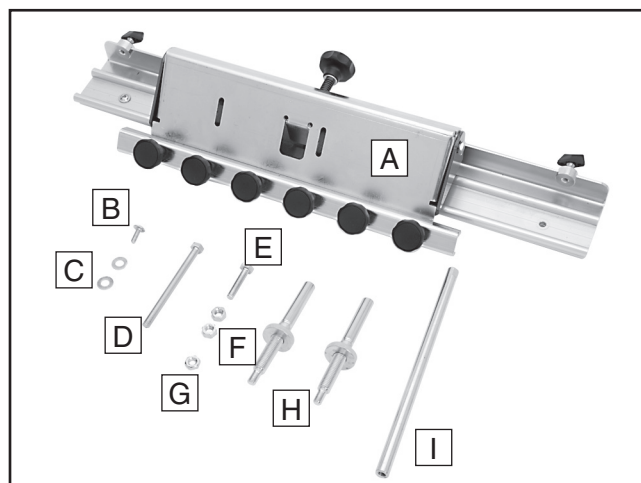


Figure 2. Inventory.

## ⚠ CAUTION

Adhere to all safety warnings outlined in the Model T10010 Wet Grinder user manual. If you are not familiar with the proper usage of the Model T10010 Wet Grinder, review the procedures and safety warnings covered in that manual. Failure to do so could result in damage to the machine or personal injury.

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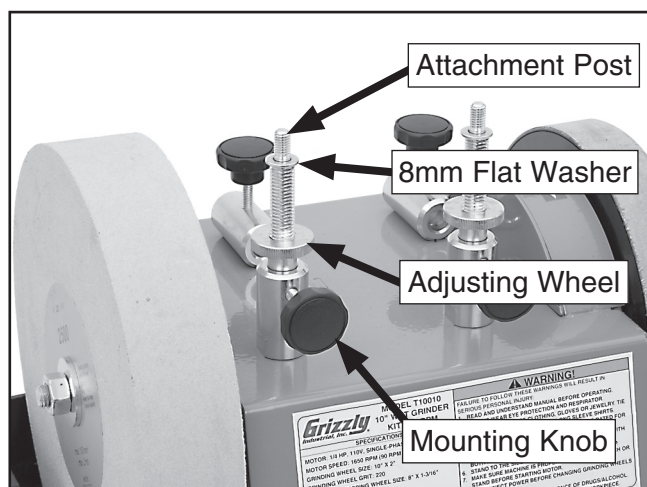
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#JB10090 PRINTED IN CHINA

# Installation

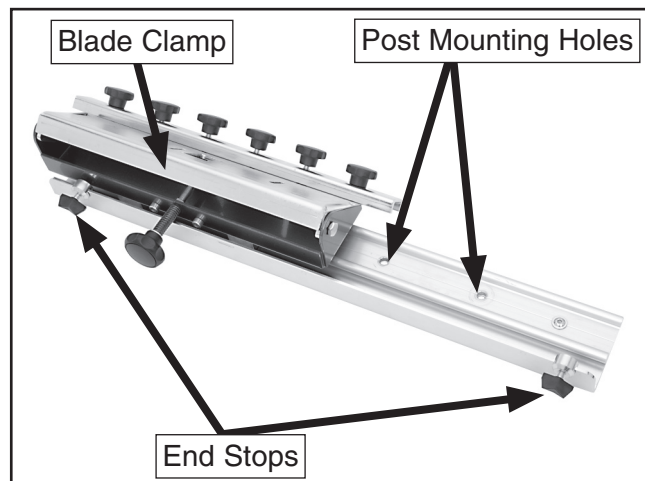
To install the 16" planer sharpening jig:

1. DISCONNECT GRINDER FROM POWER!
2. Remove the universal support from the Model T10010 Wet Grinder.
3. Insert the attachment posts in the vertical support mounts on the grinder, and turn the adjusting wheels as necessary so that the two posts are at equal heights (**Figure 3**).



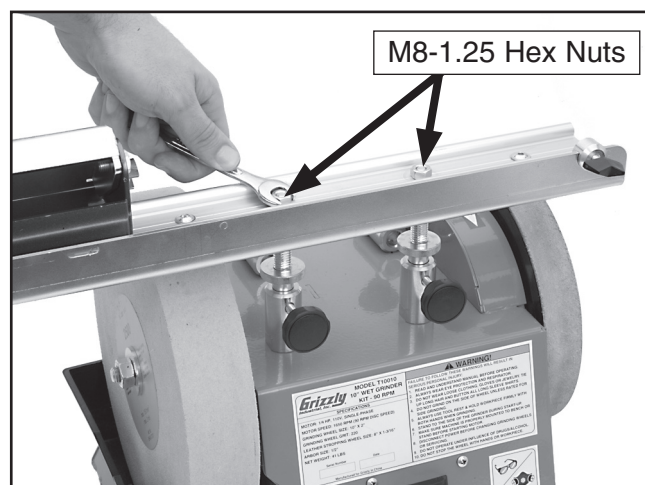
**Figure 3.** Mounting posts.

4. Tighten the mounting knobs, making sure the knob threads tighten against the flat portion of the attachment post.
5. Place one 8mm flat washer onto each mounting post.
6. Slide the blade clamp, as shown in **Figure 4**, to expose the post mounting holes. Adjust the end stop clamps if necessary to attain the necessary clearance.



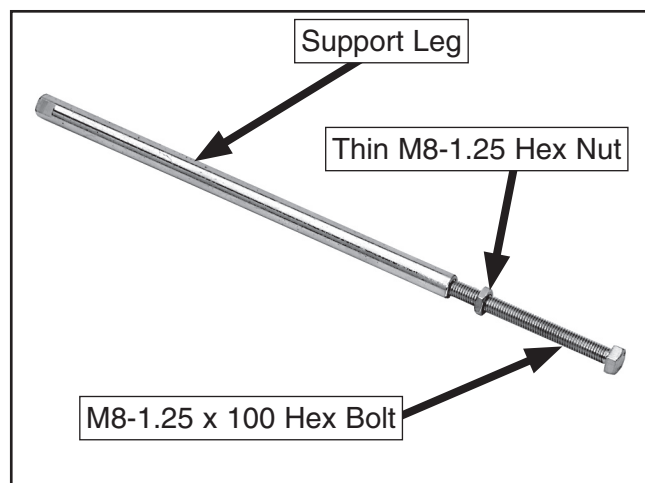
**Figure 4.** Post mounting holes.

7. Position the jig over the mounting posts and secure it with the M8-1.25 hex nuts (**Figure 5**).



**Figure 5.** Securing sharpening jig.

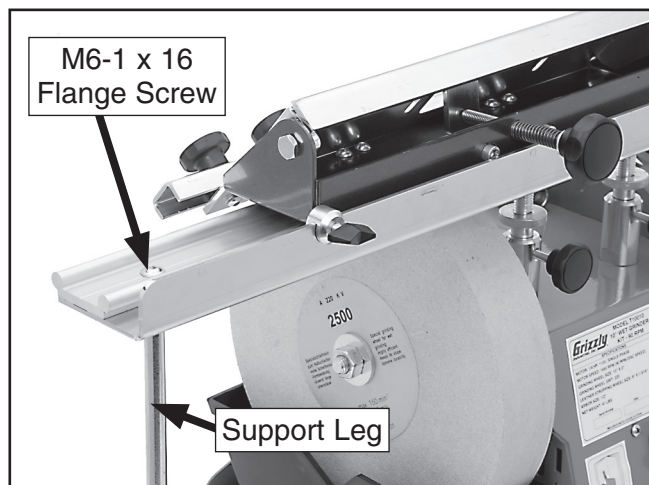
8. Thread the thin M8-1.25 hex nut onto the M8-1.25 x 100 hex bolt, then thread the hex bolt into the support leg until it stops (**Figure 6**).



**Figure 6.** Support leg.

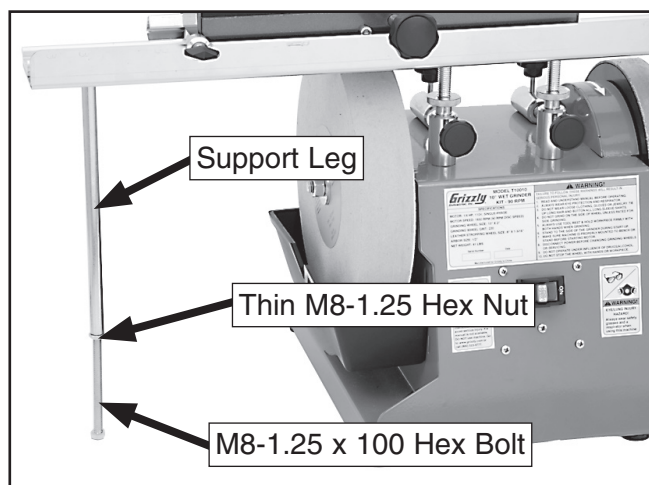


9. Attach the support leg to the sharpening jig using the M6-1 x 16 flange screw through the indicated hole (**Figure 7**).



**Figure 7.** Support leg attachment.

10. Adjust the M8-1.25 x 100 hex bolt so that it touches the bench surface and slightly supports the jig, then secure it by tightening the thin M8-1.25 hex nut against the support leg (**Figure 8**).

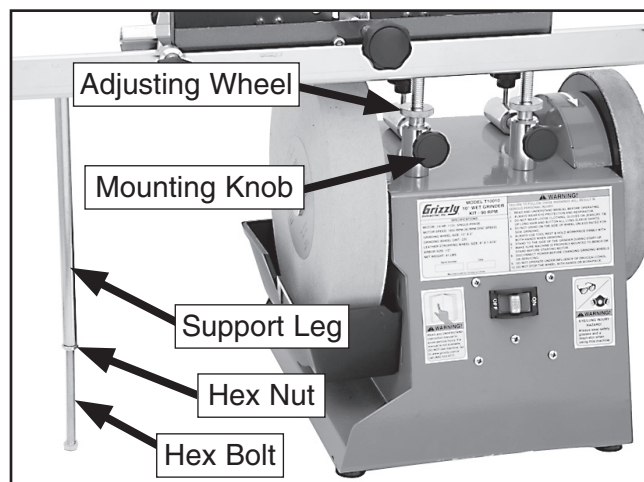


**Figure 8.** Support leg adjustment.

## Operations

**To raise or lower the sharpening jig:**

1. DISCONNECT GRINDER FROM POWER!
2. Loosen the hex nut on the support leg and both mounting knobs on the vertical support mounts (**Figure 9**).
3. In small increments, turn the hex bolt on the support leg and the adjusting wheels on both attachment posts, always keeping equal pressure on all three.
4. Once the desired position is reached, tighten both mounting knobs on the vertical support mounts and the hex nut on the support leg.



**Figure 9.** Height adjustment.

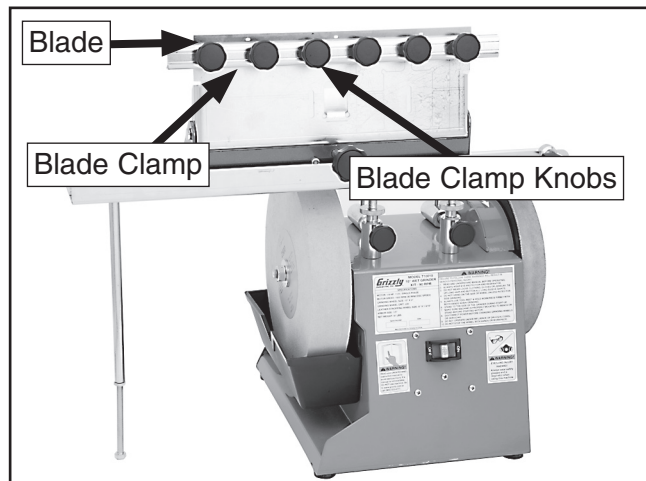


## CAUTION

Use gloves whenever handling blades and during the blade mounting and adjusting procedures outlined in these instructions. Additionally, adhere to all safety warnings outlined in the Model T10010 Wet Grinder user manual. Failure to do so could result in personal injury.

### To mount a blade in the blade clamp:

1. DISCONNECT GRINDER FROM POWER!
2. Rotate the blade clamp to the upright position (**Figure 10**).

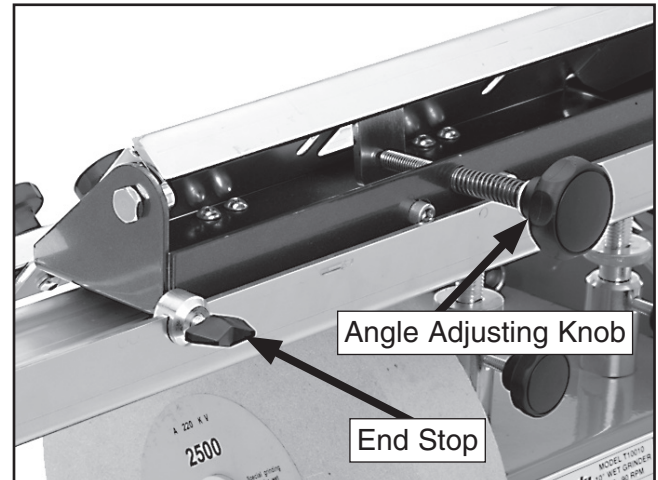


**Figure 10.** Blade mounting.

3. Loosen the blade clamp knobs so that the blade can be inserted into the blade clamp.
4. Slide the blade into the clamp and evenly tighten all of the clamping knobs.
5. Carefully rotate the blade clamp downward until it comes to a stop.
  - If the blade touches the grinding wheel, then raise the support leg and both mounting posts equally until space can just be seen between blade and the grinding wheel.
  - If the blade doesn't touch the grinding wheel and is more than  $\frac{1}{16}$ " above the wheel, then lower the support leg and both mounting posts equally until open space can just be seen between the blade and the grinding wheel.

### To set the grinding angle of the blade:

1. DISCONNECT GRINDER FROM POWER!
2. Turn the angle adjusting knob to adjust the grinding angle (**Figure 11**). Once the desired angle is attained, re-adjust the height as outlined in **Step 5** in the previous instructions "To mount a blade in the blade clamp."



**Figure 11.** Angle adjusting knob.

3. Check the grinding angle again and re-adjust if necessary.

### To set the end stops:

Slide the blade clamp back and forth along the jig to see if the entire blade surface passes over the grinding wheel.

- If the blade does not travel far enough, then the end stop must be adjusted outward. Loosen the end stop knob and slide the end stop outward. Refer to **Figure 11** for end stop identification.
- If the blade travels too far and passes the grinding wheel entirely, then the end stop must be adjusted inward. Loosen the end stop knob and slide the end stop inward.

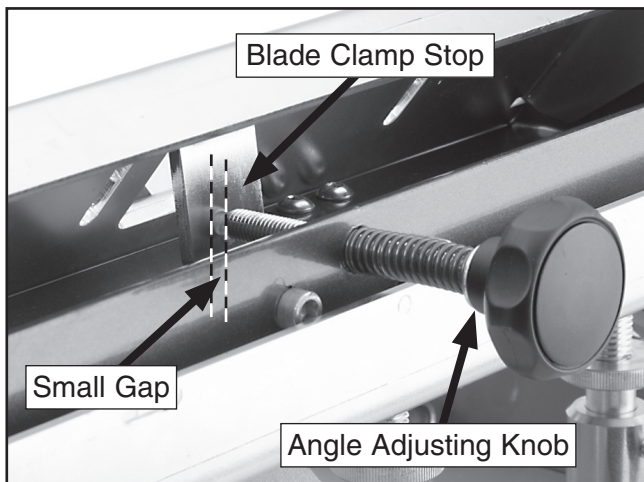
The ideal end stop position allows the entire surface of the blade to cross the grinding wheel but never leaves more than half of the grinding wheel untouched.





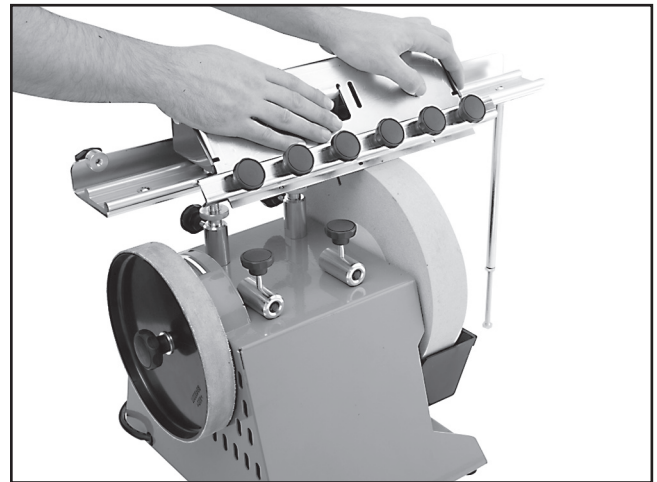
### To sharpen a blade:

1. DISCONNECT GRINDER FROM POWER!
2. Be sure the sharpening jig height and grinding angle are properly set according to the previous instructions, and make sure that the blade is securely mounted in the blade clamp.
3. Lower the height of the sharpening jig approximately  $\frac{1}{8}$ ". The blade should rest directly on the grinding wheel, and a small gap should exist between the angle adjusting knob and the blade clamp stop (**Figure 12**). This gap allows the blade to lower as it is sharpened.



**Figure 12.** Adjusting knob gap.

4. Grasp the blade clamp knobs, rotate the blade clamp up so the blade is clear of the grinding wheel, connect the grinder to power, and turn it **ON**.
5. When the grinding wheel has reached full speed, grasp the blade clamp knobs and lower the blade onto the wheel. Reposition your hands as shown in **Figure 13** and immediately begin sliding the blade clamp back-and-forth in a smooth and steady motion, from one end stop to the other. (It is not necessary to put pressure on the blade clamp as the weight of the clamp and blade will provide sufficient pressure.) Continue this motion until the blade clamp stop comes to rest on the angle adjusting knob, then immediately lift the blade clamp and turn the grinder **OFF**.

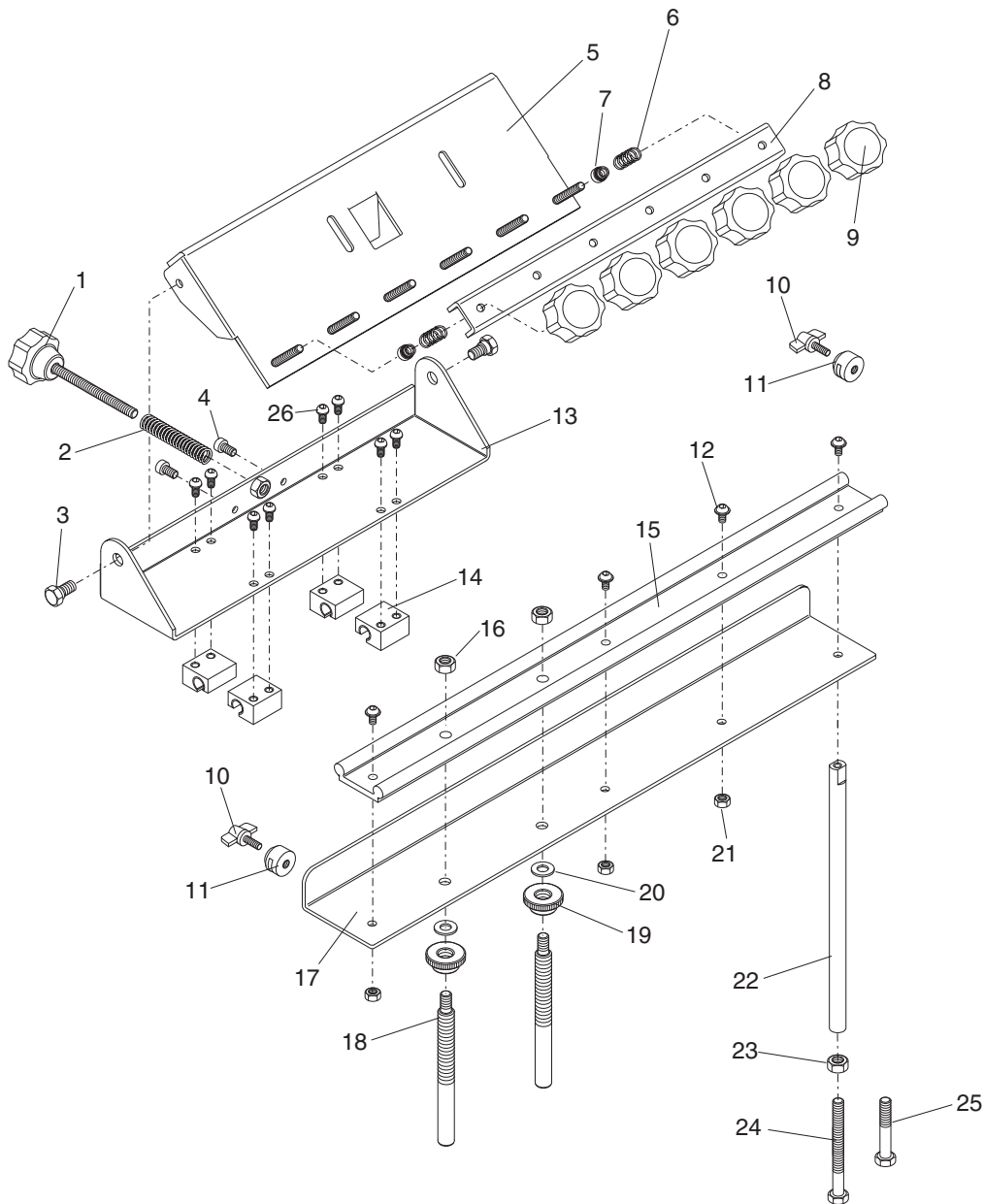


**Figure 13.** Proper hand position.

6. DISCONNECT GRINDER FROM POWER.
7. Inspect blade. If further grinding is required, repeat **Steps 3-7** until blade is completely sharpened.



# T10025 Parts Breakdown and List



REF	PART #	DESCRIPTION
1	PT10025001	ANGLE ADJUSTING KNOB
2	PT10025002	COMPRESSION SPRING
3	PB87M	HEX BOLT M8-1.25 X 15
4	PSB28M	CAP SCREW M6-1 X 15
5	PT10025005	HINGE PLATE
6	PT10025006	COMPRESSION SPRING
7	PT10025007	BLADE STOP SPACER
8	PT10025008	BLADE CLAMP
9	PT10025009	FEMALE KNOB M6-1
10	PT10025010	WING KNOB M6-1 X 12
11	PT10025011	END STOP
12	PSB115M	BUTTON HD CAP SCR M6-1 X 16
13	PT10025013	JIG

REF	PART #	DESCRIPTION
14	PT10025014	SLIDER BLOCKS
15	PT10025015	SLIDER RAIL
16	PN03M	HEX NUT M8-1.25
17	PT10025017	MOUNTING PLATE
18	PT10025018	ATTACHMENT POST
19	PT10025019	ADJUSTING WHEEL
20	PW01M	FLAT WASHER 8MM
21	PN01M	HEX NUT M6-1
22	PT10025022	SUPPORT LEG
23	PT10025023	THIN HEX NUT M8-1.25
24	PB45M	HEX BOLT M8-1.25 X 100
25	PB20M	HEX BOLT M8-1.25 X 35
26	PSBS09M	BUTTON HD CAP SCR M6-1 X 12