

READ THIS FIRST



Model T10460/62/64

*****IMPORTANT UPDATE*****

For Machines Mfd. Since 7/15
and Owner's Manual Revised 12/14

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

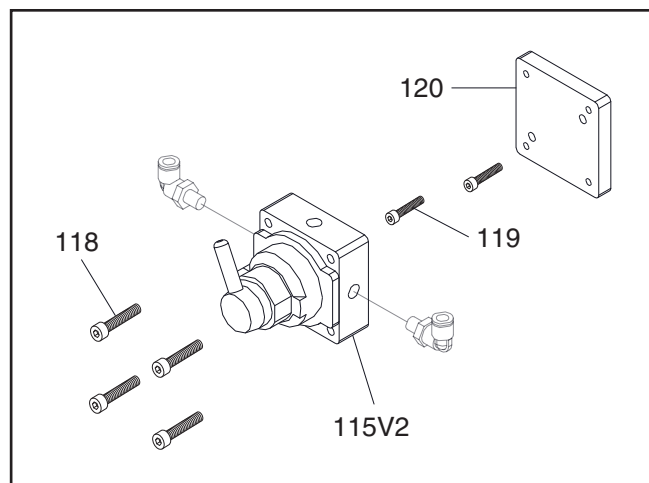
The following change was recently made to this machine since the owner's manual was printed:

- Control valve has changed.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Control Valve Parts

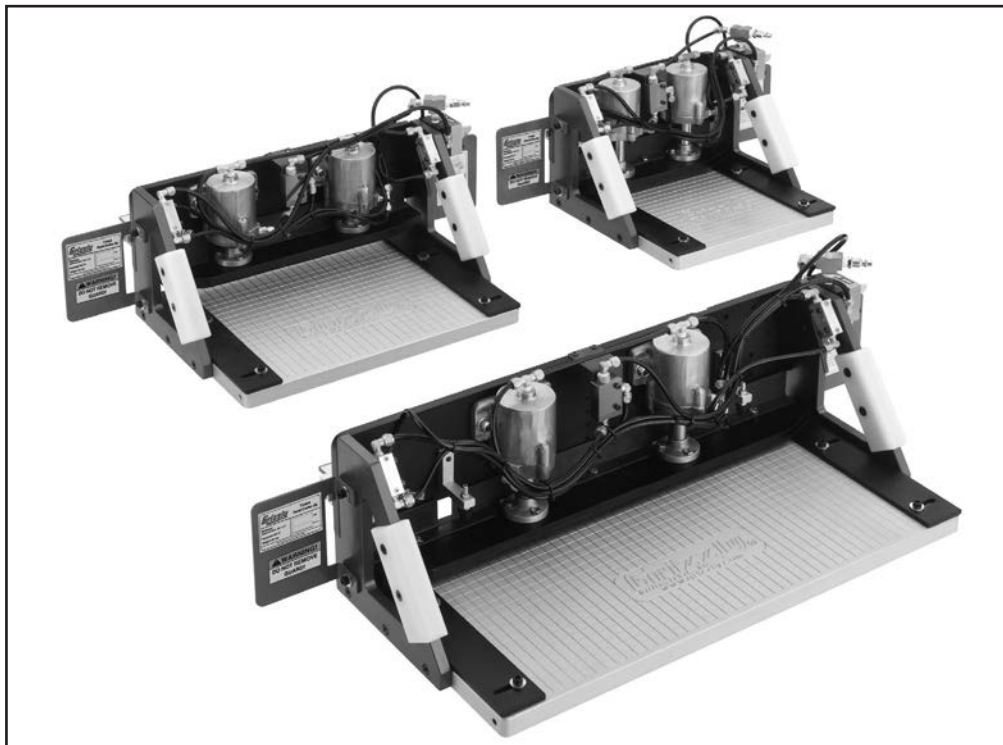


REF	PART #	DESCRIPTION
115V2	PT10460115V2	CONTROL VALVE V2.07.15
118	PT10460118	CAP SCREW M5-.8 X 30
119	PT10460119	CAP SCREW M5-.8 X 20
120	PT10460120	MOUNTING PLATE

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Grizzly **Industrial, Inc.**®

MODEL T10460, T10462 & T10464 PANEL SHAPING JIG OWNER'S MANUAL *(For models manufactured since 01/12)*



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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.

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INTRODUCTION

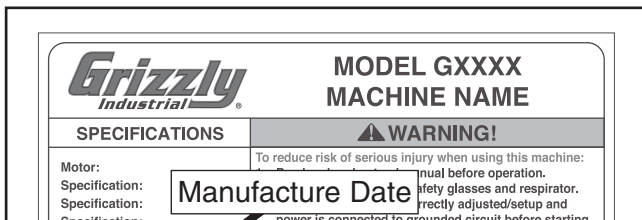
Manual Accuracy

We are proud to offer this manual with your new jig! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the jig we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your jig may not exactly match the manual**. If you find this to be the case, and the difference between the manual and jig leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your jig by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your jig.

Manufacture Date and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.



For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of jig will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: 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

Machine Description

The T10460/T10462/T10464 Panel Shaping Jig is a great addition to any shop. The jig uses pneumatic power to reliably hold the workpiece and provide a cushion of air, making movement on the table easy. The jig increases accuracy and safety when using shapers. The template holder allows templates to be quickly swapped out for efficiency, and the dual guards and power air switches keep hands safely out of the way while providing maximum control.

The T10460 has an 11½" base, the T10462 has a 16" base, and the T10464 has a 24" base.



Identification

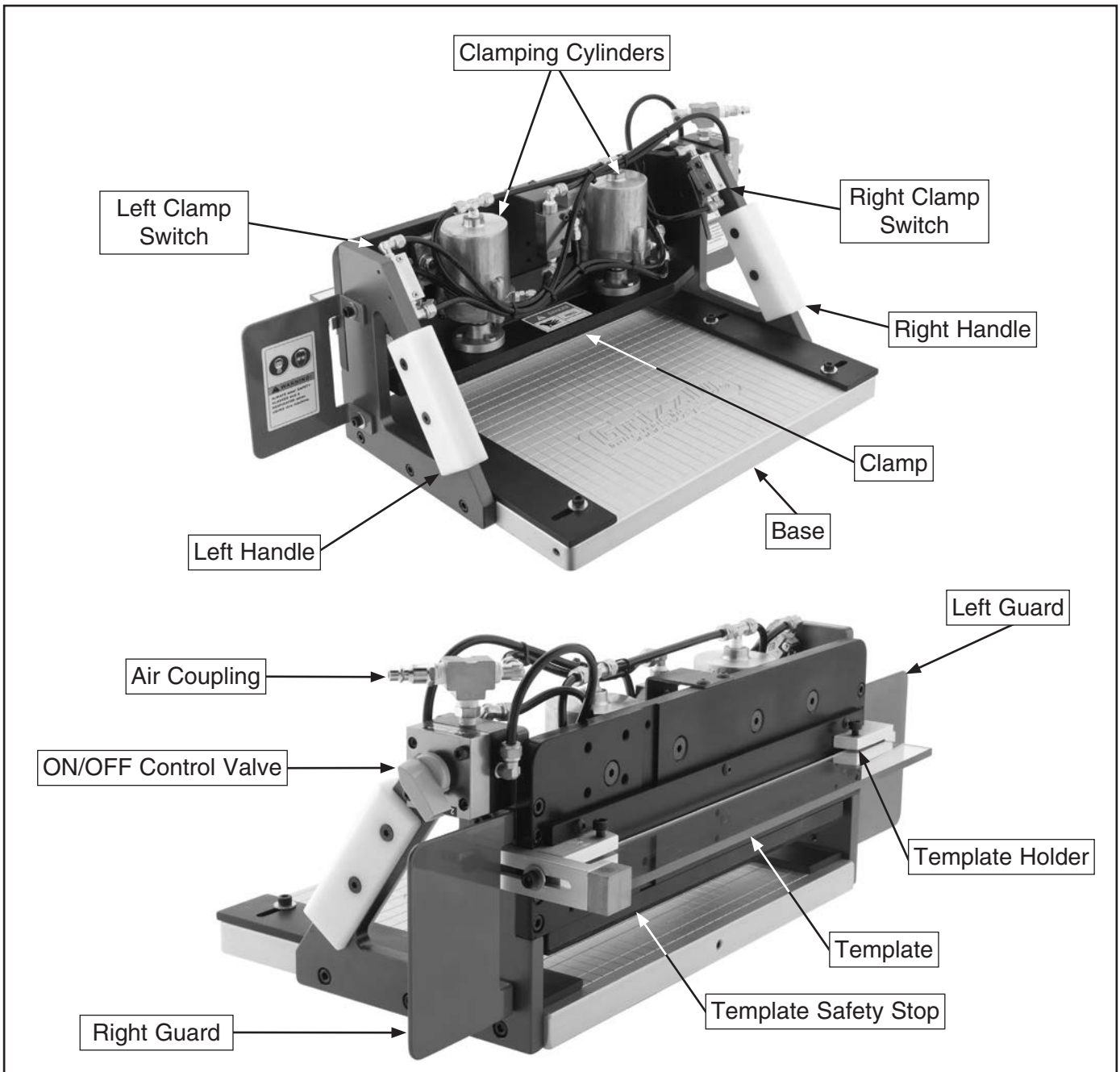
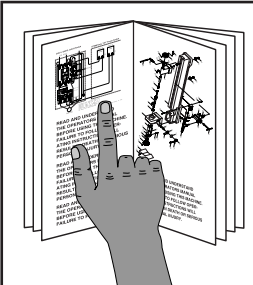


Figure 1. Identification (T10462 shown).

	<p>⚠ WARNING</p> <p>To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.</p>
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MACHINE DATA SHEET

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MODEL T10460, T10462, T10464 PANEL SHAPING JIG

Model Number	T10460	T10462	T10464
Product Dimensions			
Weight	30 lbs.	37 lbs.	56 lbs.
Width (side-to-side)/Depth (front-to-back)/Height	20 ³ / ₈ " x 12 ⁵ / ₈ " x 10"	24 ⁷ / ₈ " x 12 ⁵ / ₈ " x 10"	32 ⁷ / ₈ " x 12 ⁵ / ₈ " x 10"
Foot Print (Width/Depth)	11 ¹ / ₂ " x 11 ³ / ₄ "	16" x 11 ³ / ₄ "	24" x 11 ³ / ₄ "
Shipping Dimensions			
Type	Cardboard Box		
Weight	39 lbs.	46 lbs.	62 lbs.
Width (side-to-side)/Depth (front-to-back)/Height	19" x 14" x 13"	23" x 14" x 13"	31" x 14" x 13"
Pneumatic			
Required Air Pressure	71 PSI		
Connection Type	Male Coupling 1/4"		
Construction			
Paint	Urethane		
Material	Aircraft Aluminum		
Template Material	1/4" Plexiglass		



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.



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



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



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

NOTICE

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

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 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 avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and 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.

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.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

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.



WARNING

Additional Safety Instructions for Jig

OPERATING MACHINERY. Like all machinery, there is danger associated with operating the jig. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this jig with caution and respect to reduce the possibility of operator injury. If safety precautions are ignored, serious injury could occur.

SHOP SAFETY. Every shop environment is different. Always consider safety first, as it applies to your working conditions. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

KICKBACK. Be familiar with kickback. Kickback happens when the workpiece or jig is thrown towards the operator at a high rate of speed. Do NOT use the jig with the shaper until you understand what kickback is and how to prevent it.

HAND POSITIONING. ALWAYS control the jig with both hands on the handles. This keeps both hands behind the guards and away from the cutter to provide maximum control and reduce the risk of injury.

SAFETY GUARDS. DO NOT remove the hand guards. Guards help protect your hands during operation—as long as you are holding the handles.

TABLE SIZE. DO NOT use the jig on shaper tables that are too small or cannot support the shaper. The jig is heavy and may cause crushing injuries if it falls off the table.

STOCK LENGTH/SHAPE. DO NOT cut stock that is too small to fit fully under the clamps or is shaped in a way that it cannot be firmly clamped. Stock that is not firmly clamped increases the risk of kickback, which can result in serious personal injury or property damage.

STOCK CONDITION. ALWAYS use good stock. The danger of kickback increases when the stock has knots, holes, or foreign objects in it. Warped stock clamps unevenly and should be jointed flat before shaping.

FEEDING WORKPIECE. Feeding with excessive force is likely to result in poor cutting results and increase the risk of dangerous kickback. Always feed the workpiece against the rotation of the cutter. Never force materials through the shaper. Let the cutters do the work.

STARTING MACHINE. NEVER start the machine with the material against the cutter, as this will greatly increase the risk of kickback. Let the machine reach full speed before feeding stock into the cutter.

DEPTH OF CUT. NEVER remove too much material in one pass. Heavy cuts increase the risk of kickback. Several light passes are safer and produce a cleaner finish.

SHAPING CONTOURED WORK. Always use a rub collar and a template when doing contour shaping. DO NOT start the cut at a corner—this can lead to tear out or poor finish results. Begin towards the middle of the cut and shape outwards.

BLIND CUT WHEN POSSIBLE. Blind cuts keep the cutters on the underside of the workpiece and provide an increased safety for the operator.

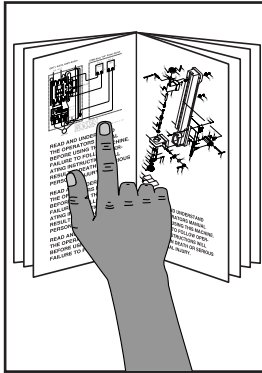
STACKED CUTS. NEVER stack cuts. The clamping pressure of the jig is not sufficient to prevent movement between the workpieces, which can lead to kickback. Material must be secured beneath the clamp during a cutting operation.

DISCONNECT AIR. ALWAYS disconnect air before adjusting or servicing the jig. Failure to do this can result in explosions or pinch hazards leading to serious personal injury and property damage.

AIR PRESSURE. Exceeding the appropriate air pressure can cause explosion, leading to impact injury or jig damage. On the other hand, insufficient air pressure will not provide the clamping pressure needed for safe operation. ALWAYS use the correct air pressure for the jig.



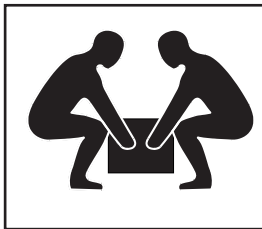
SECTION 2: SETUP



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



!WARNING
Wear safety glasses during the entire setup process!



!WARNING
This jig and its components are heavy. Get lifting help to move heavy items.

Unpacking

Your jig was carefully packaged for safe transportation. Remove the packaging materials from around your jig and inspect it. If you discover any damage, *please call us immediately at (570)546-9663.*

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, inventory the contents.



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

Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Teflon Tape	As Needed
• Disposable Shop Rags.....	As Needed

Inventory

The following is an inventory of the jig and main components. Lay the components out to 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.



Box 1: (Figure 2)	Qty
A. Jig Body (Not Shown).....	1
B. Ball Bearing Rub Collar 6208RS.....	1
C. Rub Collar Bushing Set 1/4"	1
D. Male Coupling 1/4"	1
E. Right Guard.....	1
F. Left Guard	1
G. Square Template	1
H. Template Mounting Bracket.....	1
I. Template Bracket Holder.....	1
J. Hex Wrench Set 1.5, 2, 3, 4, 5, 6, 8, 10mm	1 Ea.
K. Combo Wrench 17/19mm	1
L. Combo Wrench 10/12mm.....	1
M. Miter Bar.....	1
N. Rear Fence.....	1
O. Hardware (Not Shown)	
—Flat Washers 6mm	4
—Cap Screws M6-1 X 16.....	4
—Button Head Cap Screws M5-.8 X 16	3

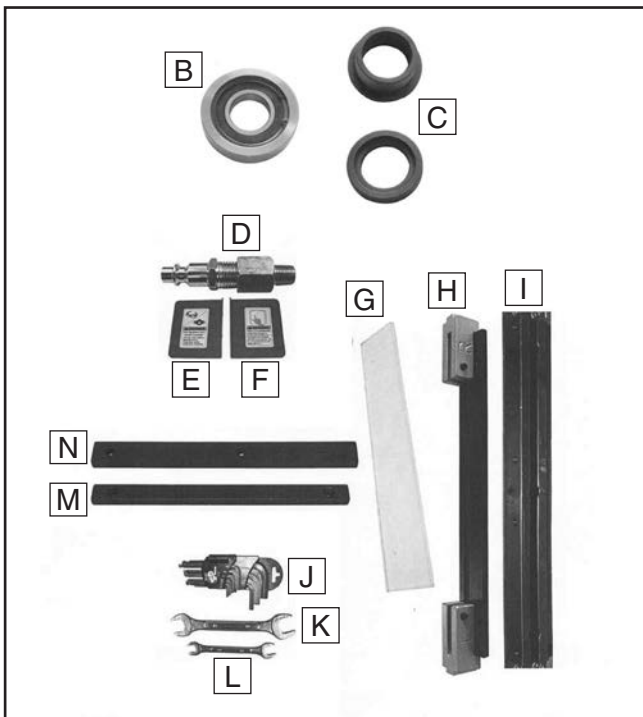


Figure 2. Jig component inventory.

NOTICE

If you cannot find an item on this list, carefully check the jig and the packaging materials. Some of these items may be pre-installed for shipping or become misplaced during unpacking.

Site Considerations

Shaper Table Size

Some shapers may require a table extension to adequately support the jig. DO NOT attempt to use the jig on router tables, as the table size will not be adequate for the jig.

Placement Location

Consider existing and anticipated needs, size of material to be processed using the jig, and space for auxiliary stands, work tables or other machinery. A mobile cart or dedicated work stand is a good idea for storing the jig away from the shaper table. See Figure 3 for the footprint sizes.

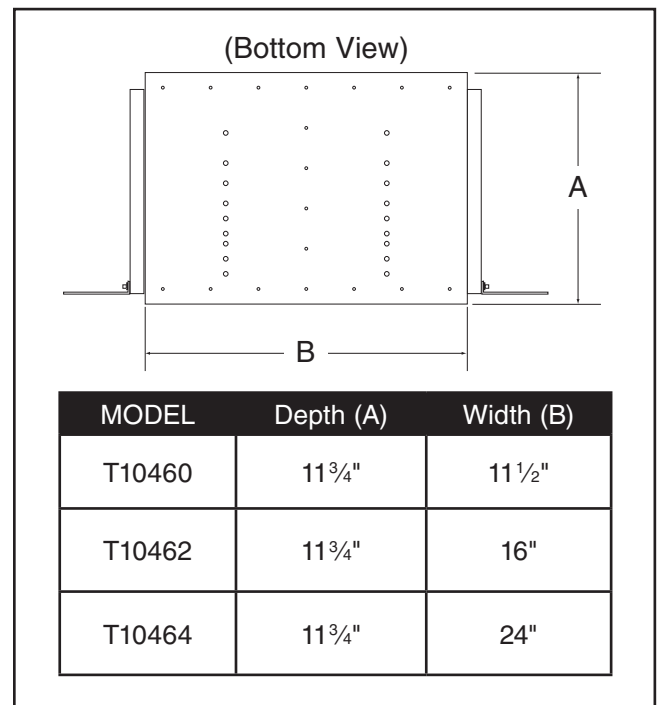
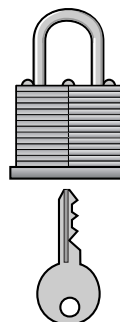


Figure 3. Base footprint sizes.



CAUTION

Children and visitors may be seriously injured if unsupervised around machinery. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.



Attaching Guards

Assemble the jig by attaching the guards with (4) M6-1 x 16 cap screws and (4) 6mm flat washers, as shown in **Figure 4**.



Figure 4. Attaching guard to jig.

Air Connection

We recommend using an air supply system similar to that illustrated in **Figure 5** for the best performance. Use an air compressor with a regulator and gauge rated for at least 90 PSI.

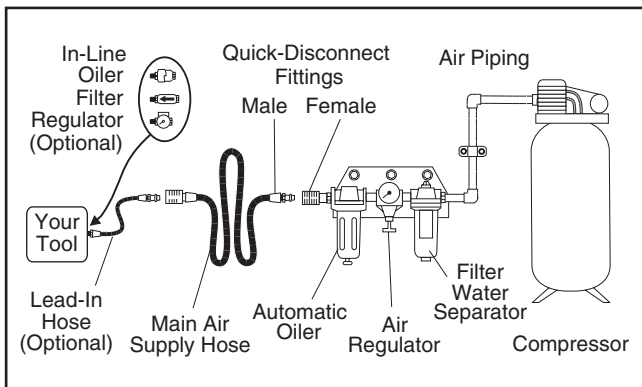


Figure 5. Recommended air supply system setup.

To connect the jig to compressed air:

1. Check the air pressure reading on the air compressor gauge. The correct setting is 90 PSI.
2. Connect the air hose from the air supply unit to the jig with a standard 1/4" NPT female quick-release coupler.

Test Run

Verify that the jig operates correctly on a shaper table or similar surface. Use a scrap piece of material for the test run.

If the jig does not operate correctly, refer to **Troubleshooting** on **Page 20**. If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To verify the jig runs correctly:

1. Make sure you have read the safety instructions in this manual, the guards are installed, and all tools and objects used during setup are cleared away from the jig.
2. Connect the jig to the air supply.
3. Turn the air control valve to **ON**.
4. Position a workpiece on the jig as if preparing it for shaping.
5. Press both switch valves. The material clamp should lower and clamp the workpiece firmly.
6. While pressing the switch valves, move the jig across the table. The jig should slide easily across the surface of the table.

—If there is too much friction, adjust the air-flow control valve to increase the airflow at the base.

—If there is too little friction, adjust the air control valve to decrease the airflow at the base.

7. Release the double switch valves. Air should stop flowing through the jig.

—If air stops flowing through the jig, proceed to **Step 9**.

—If air does not stop flowing through the jig, turn the air control valve **OFF** and call Tech Support.

8. Congratulations! The jig is ready to use.

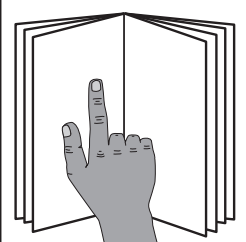



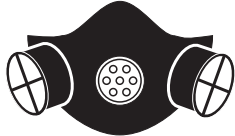
SECTION 3: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice operator with a basic understanding of how the jig is used during operation, so the jig controls and components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

	! WARNING To reduce the risk of serious injury when using this jig, read and understand this entire manual before operating.
--	--

! WARNING Damage to your eyes and lungs could result from using this jig without proper protective gear. Always wear safety glasses and a respirator when using this jig for shaping.	
	

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

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

1. Examines the workpiece to make sure it is suitable for shaping.
2. Adjusts the shaper for the intended operation.
3. Connects the jig to the air supply.
4. Clamps the workpiece in the jig.
5. With the shaper **OFF**, simulates shaping the workpiece with the jig. Makes any needed adjustments.
6. Puts on safety glasses and a respirator.
7. Starts the shaper.
8. Feeds the jig and workpiece all the way through the shaper, keeping both hands on the jig at all times until the operation is complete.
9. Stops the shaper.
10. Turns the jig **OFF** and removes the workpiece.



Workpiece Inspection

Some workpieces are not safe to use in the jig or may require modification before they are safe to use. **Before shaping, inspect all workpieces for the following:**

- **Material Type:** Only use the jig to shape materials for which the shaper is intended. Failure to do so can cause personal injury and property damage.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While shaping, these objects can become dislodged and hit the operator, cause kickback, or damage the cutterhead, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT shape the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the shaping operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid shaping them.
- **Wet or "Green" Stock:** Shaping wood with a moisture content over 20% causes unnecessary wear on the cutterhead blades, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to shape because they are unstable, unpredictable when being shaped, and cannot be properly clamped in the jig. DO NOT use workpieces with these characteristics!

Basic Controls

ON/OFF Control Valve

The ON/OFF control valve (see **Figure 6**) controls airflow from the air supply to the jig. Turning the valve **ON** allows the air to pressurize the cylinder for clamping. Turning the valve **OFF** discharges the cylinders, allowing them to return to the open position.

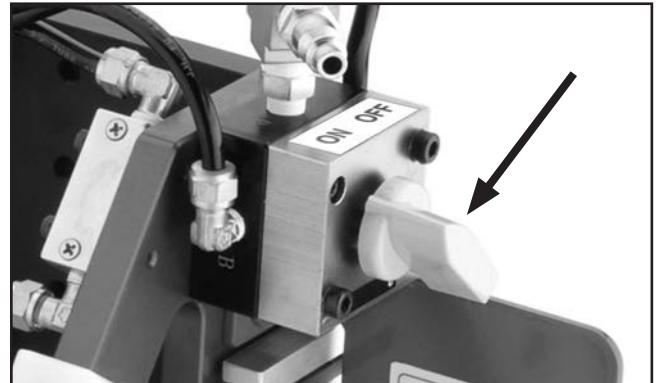


Figure 6. ON/OFF control valve.

Clamping Switches

Depressing *both* switches does two things: 1) clamps the workpiece, and 2) allows airflow to the base to provide a low-friction surface for the jig.

The switches must remain pressed for the jig to maintain constant clamping pressure on the workpiece and have a low-friction surface.

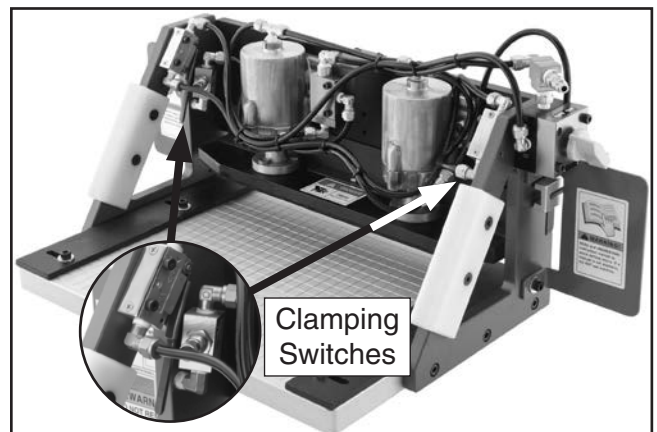


Figure 7. Clamping switch location.



Adjusting Airflow

The airflow control valve (see **Figure 8**) adjusts the amount of air flowing through the base to provide the "cushion" of air between the jig and shaper table. The lock collar secures the setting on the valve.

Adjust the valve by threading the lock collar up the control knob stem. Turn the valve counter-clockwise to increase friction or turn it clockwise to decrease friction. Thread the lock collar against the airflow control valve to lock the control knob.

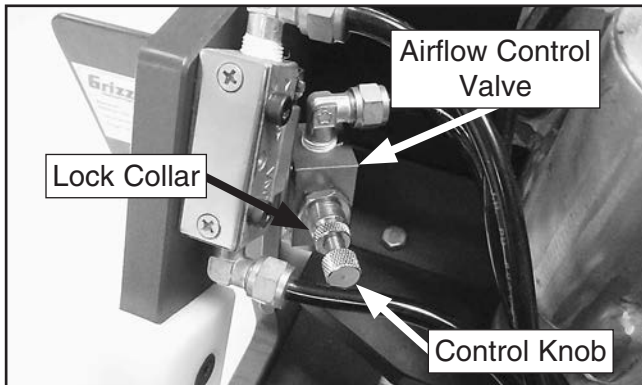


Figure 8. Airflow control valve.

Adjustments

The jig may be configured for various types of operations. Not all of the following adjustments will apply to every scenario. However, you should familiarize yourself with the following adjustments. This will clarify the jig's versatility and usefulness.

Adjusting Clamp Height

The height of the cylinder bracket may be adjusted to increase the clamping capacity of the jig.

To adjust the cylinder bracket height:

1. Remove the (6) M6-1 x 20 cap screws, as shown in **Figure 9**.

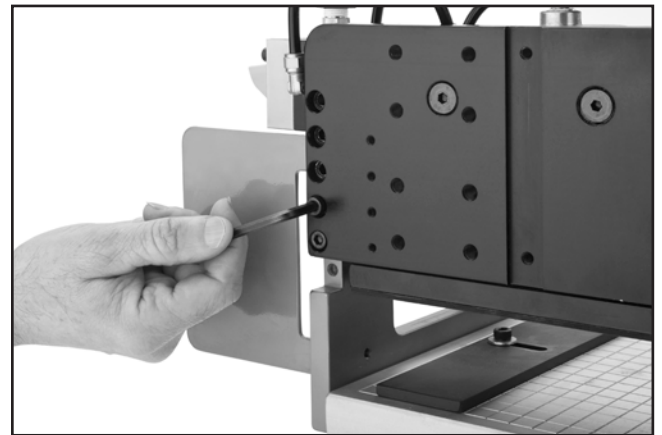


Figure 9. Adjusting the clamp height.

2. Adjust the height of the cylinder bracket to the new height.

Important: *The cylinder bracket must be fastened with the (6) M6-1 x 20 cap screws to operate safely.*

3. Re-secure the cylinder bracket at the new height by replacing the (6) M6-1 x 20 cap screws.



Positioning Workpiece

The jig has two side coping fences and a rear fence for repeatable positioning of the workpiece in the jig. They cannot be installed simultaneously. Always place the workpiece against the coping fence that is opposite the cutterhead at the beginning of the operation (see **Figure 10**).

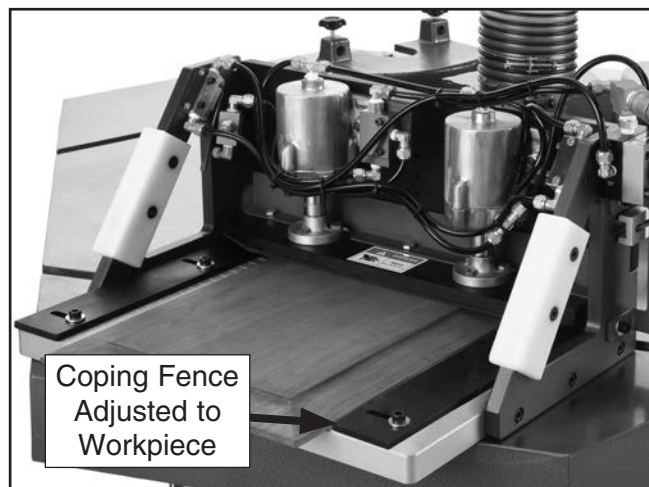


Figure 10. Workpiece positioned on jig.

To install the rear fence:

1. Remove the (4) M6-1 x 16 cap screws securing the coping fences.
2. Position the rear fence for the necessary operation.
3. Secure the rear fence in place using (2) M6-1 x 16 cap screws, as shown in **Figure 11**.



Figure 11. Securing the rear fence using M6-1 x 16 cap screw (1 of 2).

Note: To install the coping fences simply reverse the above steps.

Template Mounting Bracket

Secure the template mounting bracket to the cylinder plate with (3) M5-.8 x 16 button head cap screws, as shown in **Figure 12**.

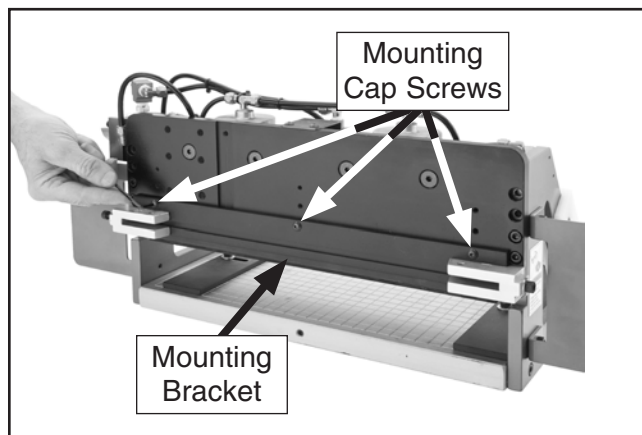


Figure 12. Installing template mounting bracket.

Installing Templates

The template mounting bracket lets you change templates for various shaping operations. To mount a template, insert it into the template mounting bracket, and secure it with the (2) M6-1 x 16 cap screws (see **Figure 13**). Position the template guard flush with the front edge of the template to protect the template from damage.

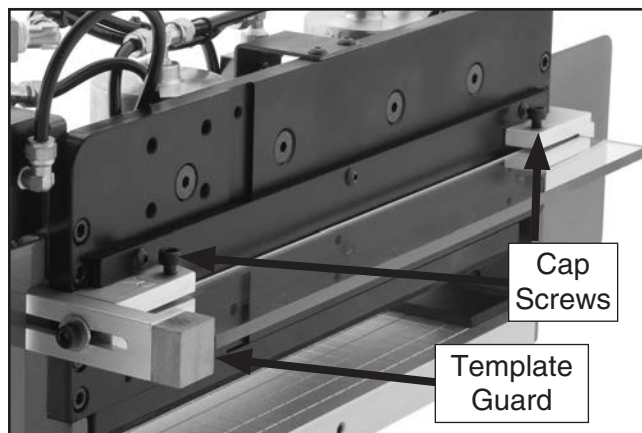


Figure 13. Installing the template.



Miter Bar

The jig can use a $\frac{3}{8} \times \frac{3}{4}$ " miter bar for straight shaping and table saw operations. Nine positions allow you to adjust the jig-to-cutterhead distance. Attach the miter bar with (2) M5-.8 x 16 button head cap screws for Models T10460/T10462 and (3) M5-.8 x 16 button head cap screws for Model T10464, as shown in **Figure 14**.

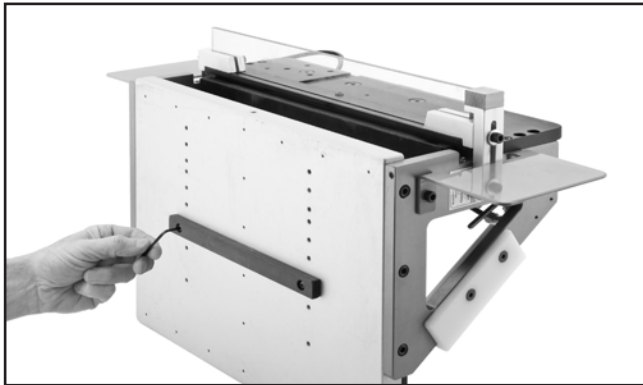


Figure 14. Attaching the miter bar to the jig.

⚠ CAUTION

Always ensure that the jig base will clear the cutterhead or kickback could occur, causing personal injury or property damage.

Vertical Fence

The jig has a vertical fence for positioning the workpiece vertically for various shaping operations. To mount the vertical fence, secure it to the cylinder bracket with (2) M6-1 x 16 cap screws, as shown in **Figure 15**.

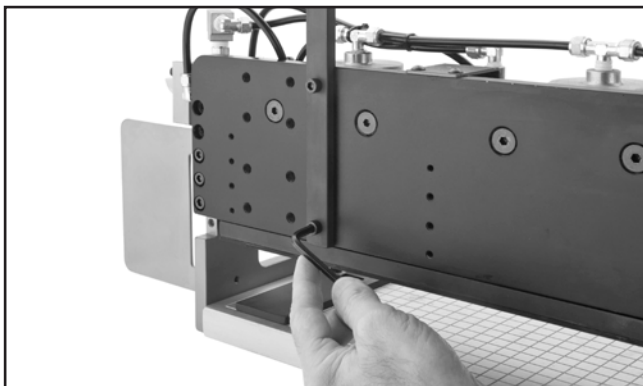


Figure 15. Installing the vertical fence.

Rub Collar

The jig comes with a 6208RS ball bearing rub collar and bushing kit (see **Figure 16**). This rub collar is designed for $1\frac{1}{4}$ " shaper spindles. Since each shaper will have different rub collar mounting instructions, refer to the shaper owner's manual for rub collar installation instructions.



Figure 16. Ball bearing rub collar and bushings.

Clamping Workpiece

With the workpiece properly positioned, turn the air control valve **ON**. Press and hold both clamping switches shown in **Figure 17**. Doing this clamps the workpiece and provides air to the base for frictionless movement.

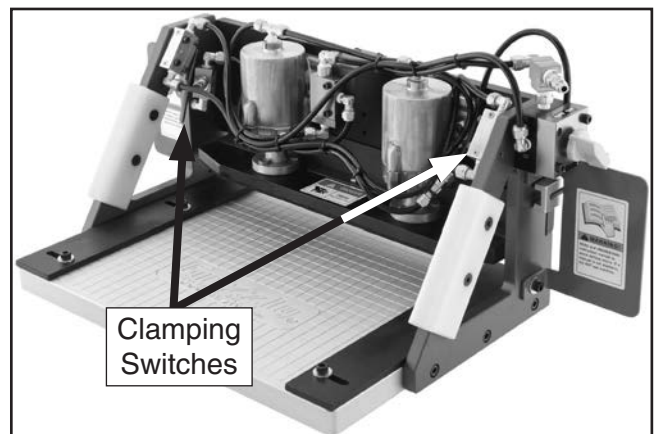


Figure 17. Clamping the workpiece.



Using Jig

Before using the jig, take time to review the owner's manual for your shaper to ensure the correct setup and operating procedures.

You are ready to begin shaping when the jig and shaper are properly adjusted, personal protective equipment is on, and safety material has been reviewed.

Tip: Use a practice piece similar to the workpiece in order to test the results before shaping the workpiece.

WARNING

Disconnect the shaper from power before making any adjustments to the shaper cutterhead or jig. Failure to do so could result in serious personal injury or property damage.

To use the jig:

1. Place the jig on the shaper table and connect it to compressed air.
2. Turn the ON/OFF valve **ON**.
3. Position the workpiece and clamp it in the jig, as shown in **Figure 18**.



Figure 18. Shaping jig prepared for use with shaper **OFF**.

Note: When using templates, always center the workpiece with the template to ensure symmetrical results. Always adjust the coping fence or use a spacer block to provide a positive stop for the workpiece.

Tip: To prevent tear-out in the workpiece shape end grain first. Wood is less likely to tear while edge-shaping, so any tearout from end grain shaping can be removed. Use a sacrificial backing block between the workpiece and the coping fence as needed to further reduce tearout (see **Figure 19**).

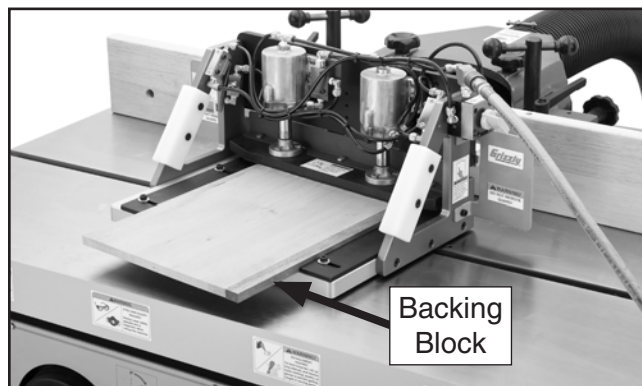


Figure 19. Backing block in place.

4. Turn the shaper **ON**.
5. While pressing both clamping switches, as shown in **Figure 20**, move the workpiece slowly against the rotation of the cutterhead until the cut is complete.

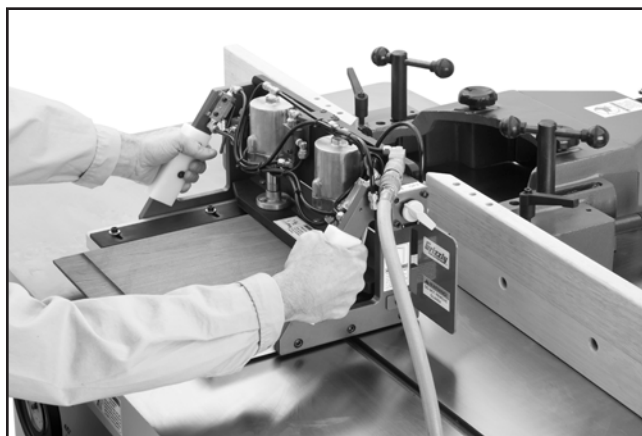


Figure 20. Shaping jig in use.

6. Turn the shaper **OFF**.
7. Turn the jig ON/OFF valve **OFF**.



SECTION 4: ACCESSORIES

⚠️ WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

T10461—T10460 Arched Door Templates
T10463—T10462 Arched Door Templates
T10465—T10464 Arched Door Templates

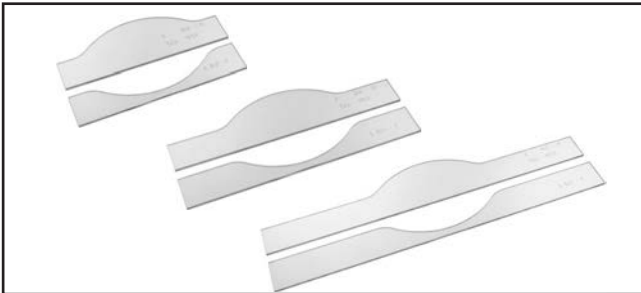


Figure 21. Models T10461, T10463, T10465 arched door templates.

T24721—Face Clamps

This quick action toggle clamp allow you to orient workpieces vertically on the panel shaping jig.



Figure 22. Model T24721 Panel Shaping Jig face clamps.

T23115—1/2" X 50' Hose Reel

Heavy-duty rubber air hose inside a heavy gauge all steel reel assembly. 8 position ratchet gear locks reel at desired hose lengths. Also has a 5-position adjustable roller outlet arm.



Figure 23. Model T23115 Hose Reel.

H7274—Pressure Regulator

Provides regulated output pressure of 0 to 125 PSI. Includes 0 to 160 PSI gauge, with 15 SCFM flow capacity at 90 PSI, 2 1/4" NPT (F) ports.



Figure 24. Model H7274 line regulator.

T20881—In-Line Lubricator

Provides automatic lubrication, extending air tool life. It attaches directly to the tool. 1/4" Female NPT inlet by 1/4" NPT outlet. 0.15 oz. bowl capacity.

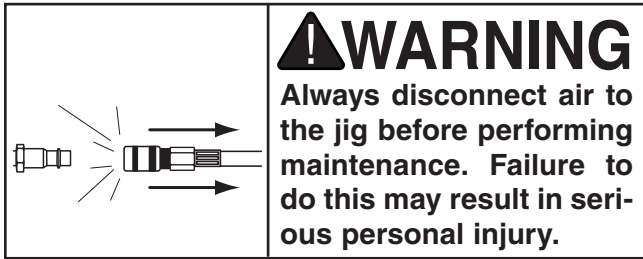


Figure 25. Model T20881 in-line lubricator.

Call 1-800-523-4777 To Order



SECTION 5: MAINTENANCE



WARNING
 Always disconnect air to the jig before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from the jig, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check

- Loose fasteners.
- Damaged or worn hoses/air lines.
- Air leaks.
- Drain water in air filter collection cups.
- Any other unsafe condition.

Weekly Maintenance

- Check/adjust lubrication level in lubricator.
- Clean/vacuum dust buildup.

Cleaning

Cleaning the Model T10460/T10462/T10464 Panel Shaping Jig is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. A light coat of machine oil will keep the aircraft aluminum body and base corrosion free.

Lubrication

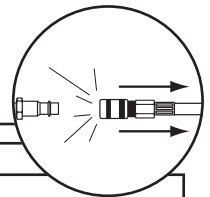
We recommend you use an in-line lubrication system for the jig. This sort of system removes moisture from the air supply before it reaches the jig and will provide lubrication to the air supply system of the jig.

SECTION 6: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your jig. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

Note: Please gather the serial number and manufacture date of your jig before calling.

Troubleshooting

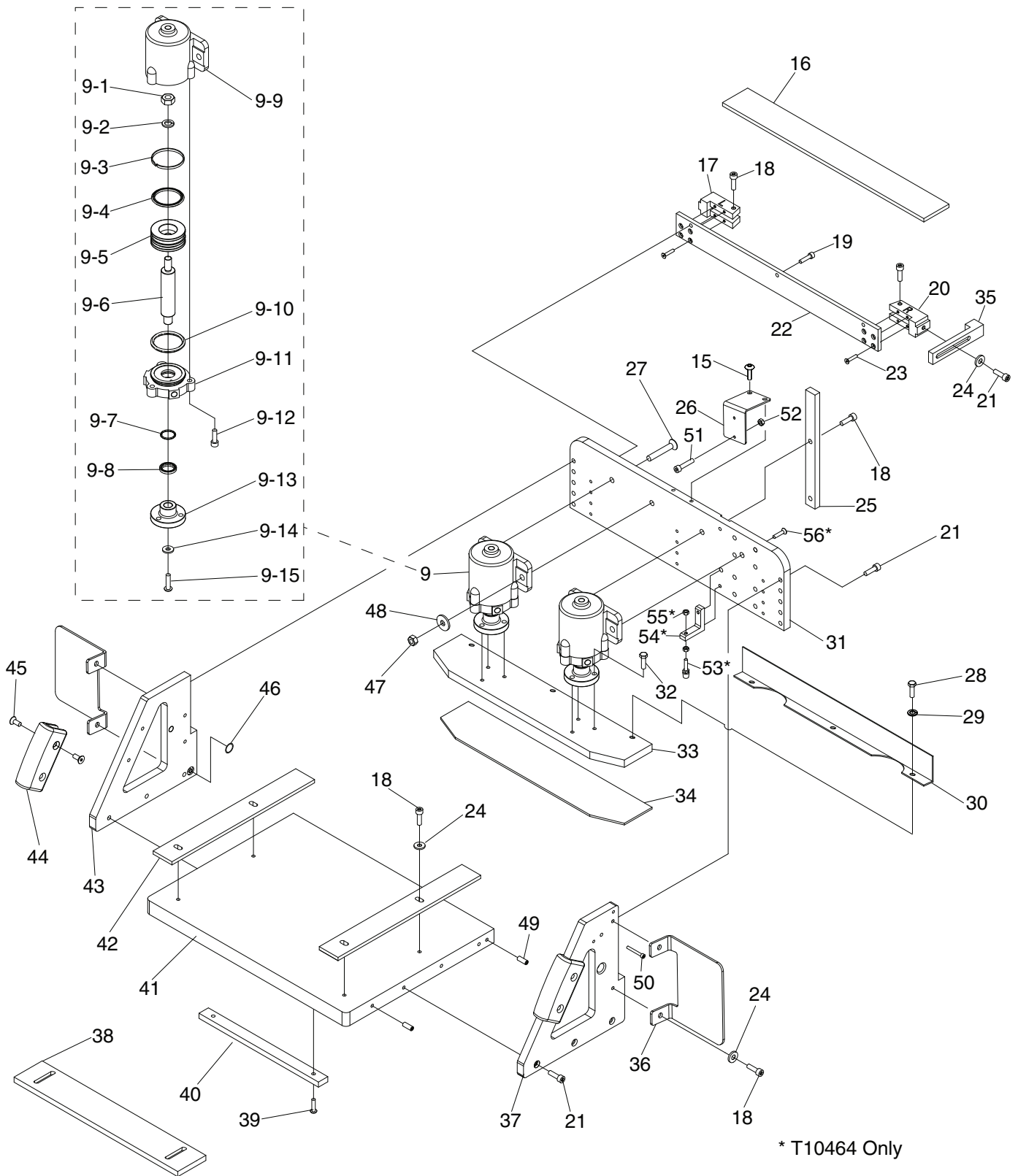


Symptom	Possible Cause	Possible Solution
Jig does not clamp workpiece.	1. Insufficient air pressure. 2. Air leak. 3. Faulty ON/OFF valve. 4. Faulty clamping switch. 5. Workpiece is warped or misshapen.	1. Adjust regulator air pressure. 2. Find and repair leak. 3. Replace ON/OFF valve. 4. Replace clamping switch. 5. Use a different workpiece.
Excessive friction when using jig on shaper.	1. Faulty airflow valve. 2. Burrs or warped base is creating contact despite air cushion.	1. Replace airflow valve. 2. Remove any burrs or replace warped base.



SECTION 7: PARTS

T10460/T10462/T10464 Main Breakdown



T10460/T10462/T10464 Parts List

REF	PART #	DESCRIPTION
9	PT10460009	CYLINDER ASSEMBLY
9-1	PN02M	HEX NUT M10-1.5
9-2	PLW06M	LOCK WASHER 10MM
9-3	PT10460009-3	WEAR RING 50 X 46 X 6
9-4	PT10460009-4	PISTON BACKING 50 X 40 X 4
9-5	PT10460009-5	PISTON
9-6	PT10460009-6	PISTON ROD
9-7	PORP020	O-RING 19.8 X 2.4 P20
9-8	PT10460009-8	O-RING DH20
9-9	PT10460009-9	CYLINDER BODY
9-10	PORG045	O-RING 44.4 X 3.1 G45
9-11	PT10460009-11	CYLINDER END COVER
9-12	PCAP07M	CAP SCREW M6-1 X 30
9-13	PT10460009-13	CLAMPING DISC
9-14	PW03M	FLAT WASHER 6MM
9-15	PCAP115M	BUTTON HD CAP SCR M6-1 X 16
15	PBHS09M	BUTTON HD CAP SCR M6-1 X 12
16	PT10460016	SQUARE TEMPLATE 11-1/2" (T10460)
16	PT10462016	SQUARE TEMPLATE 16" (T10462)
16	PT10464016	SQUARE TEMPLATE 24" (T10464)
17	PT10460017	LEFT TEMPLATE HOLDER
18	PCAP01M	CAP SCREW M6-1 X 16
19	PCAP24M	CAP SCREW M5-.8 X 16
20	PT10460020	RIGHT TEMPLATE HOLDER
21	PCAP02M	CAP SCREW M6-1 X 20
22	PT10460022	TEMPLATE RACK PLATE 12" (T10460)
22	PT10462022	TEMPLATE RACK PLATE 16" (T10462)
22	PT10464022	TEMPLATE RACK PLATE 24" (T10464)
23	PCAP23M	CAP SCREW M4-.7 X 12
24	PW03M	FLAT WASHER 6MM
25	PT10460025	VERTICAL FENCE
26	PT10460026	FIXED RACK
27	PFH36M	FLAT HD SCR M8-1.25 X 35
28	PB04M	HEX BOLT M6-1 X 10
29	PLW03M	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
30	PT10460030	CLAMPING FENCE 12" (T10460)
30	PT10462030	CLAMPING FENCE 16" (T10462)
30	PT10464030	CLAMPING FENCE 24" (T10464)
31	PT10460031	CYLINDER HOLDING PLATE (T10460)
31	PT10462031	CYLINDER HOLDING PLATE (T10462)
31	PT10464031	CYLINDER HOLDING PLATE (T10464)
32	PB08M	HEX BOLT M6-1 X 20
33	PT10460033	MATERIAL CLAMP 12" (T10460)
33	PT10462033	MATERIAL CLAMP 16" (T10462)
33	PT10464033	MATERIAL CLAMP 24" (T10464)
34	PT10460034	HOLDDOWN PAD 12" (T10460)
34	PT10462034	HOLDDOWN PAD 16" (T10462)
34	PT10464034	HOLDDOWN PAD 24" (T10464)
35	PT10460035	TEMPLATE GUARD
36	PT10460036	GUARD
37	PT10460037	RIGHT HANDLE
38	PT10460038	FENCE BACK (T10460)
38	PT10460038	FENCE BACK (T10462)
38	PT10460038	FENCE BACK (T10464)
39	PBHS16M	BUTTON HD CAP SCR M5-.8 X 16
40	PT10460040	SLIDING TABLE SUPPORT
41	PT10460041	BASE 11-1/2 X 12" (T10460)
41	PT10462041	BASE 11-1/2 X 16" (T10462)
41	PT10464041	BASE 11-1/2 X 24" (T10464)
42	PT10460042	COPE FENCE
43	PT10460043	LEFT HANDLE
44	PT10460044	GRIP
45	PFH02M	FLAT HD SCR M6-1 X 12
46	PORP009	O-RING 8.8 X 1.9 P9
47	PLN04M	LOCK NUT M8-1.25
48	PW01M	FLAT WASHER 8MM
49	PT10460049	DOWEL PIN
50	PCAP109M	CAP SCREW M5-.8 X 50
51	PCAP162M	CAP SCREW M4-.7 X 25
52	PN04M	HEX NUT M4-.7

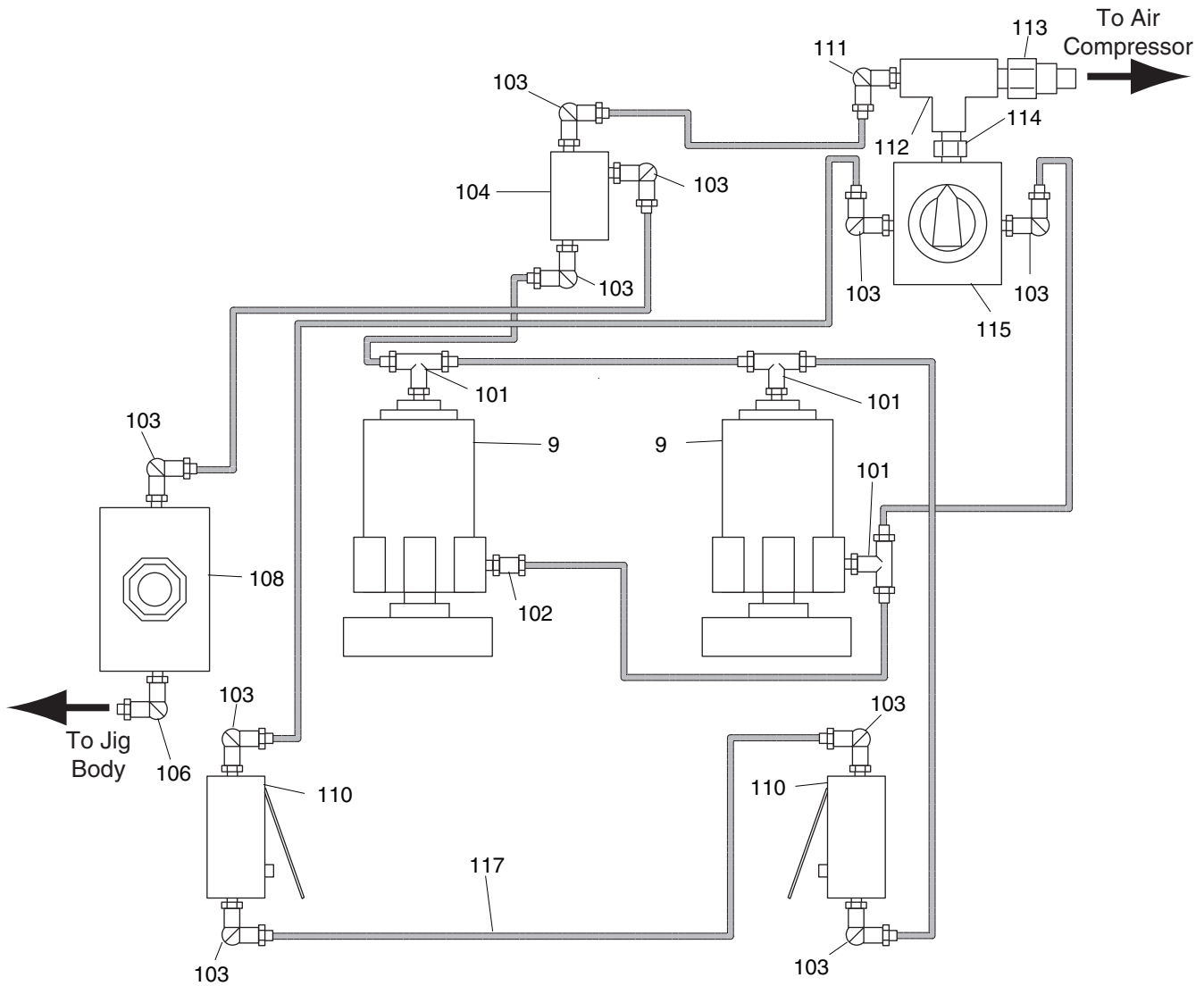
T10464 Only

REF	PART #	DESCRIPTION
53	PT10464053	RUBBER HEAD SCREW M6-1
54	PT10464054	CLAMP LIMIT SET

REF	PART #	DESCRIPTION
55	PN01M	HEX NUT M6-1
56	PFH54M	FLAT HD SCR M5-.8 X 20

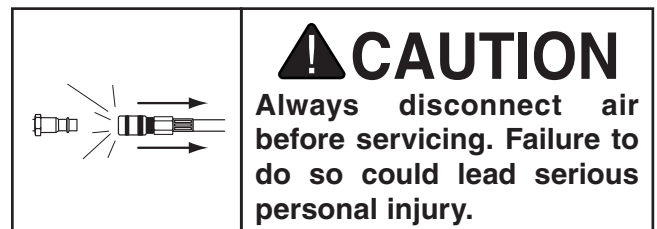


T10460/T10462/T10464 Pneumatic

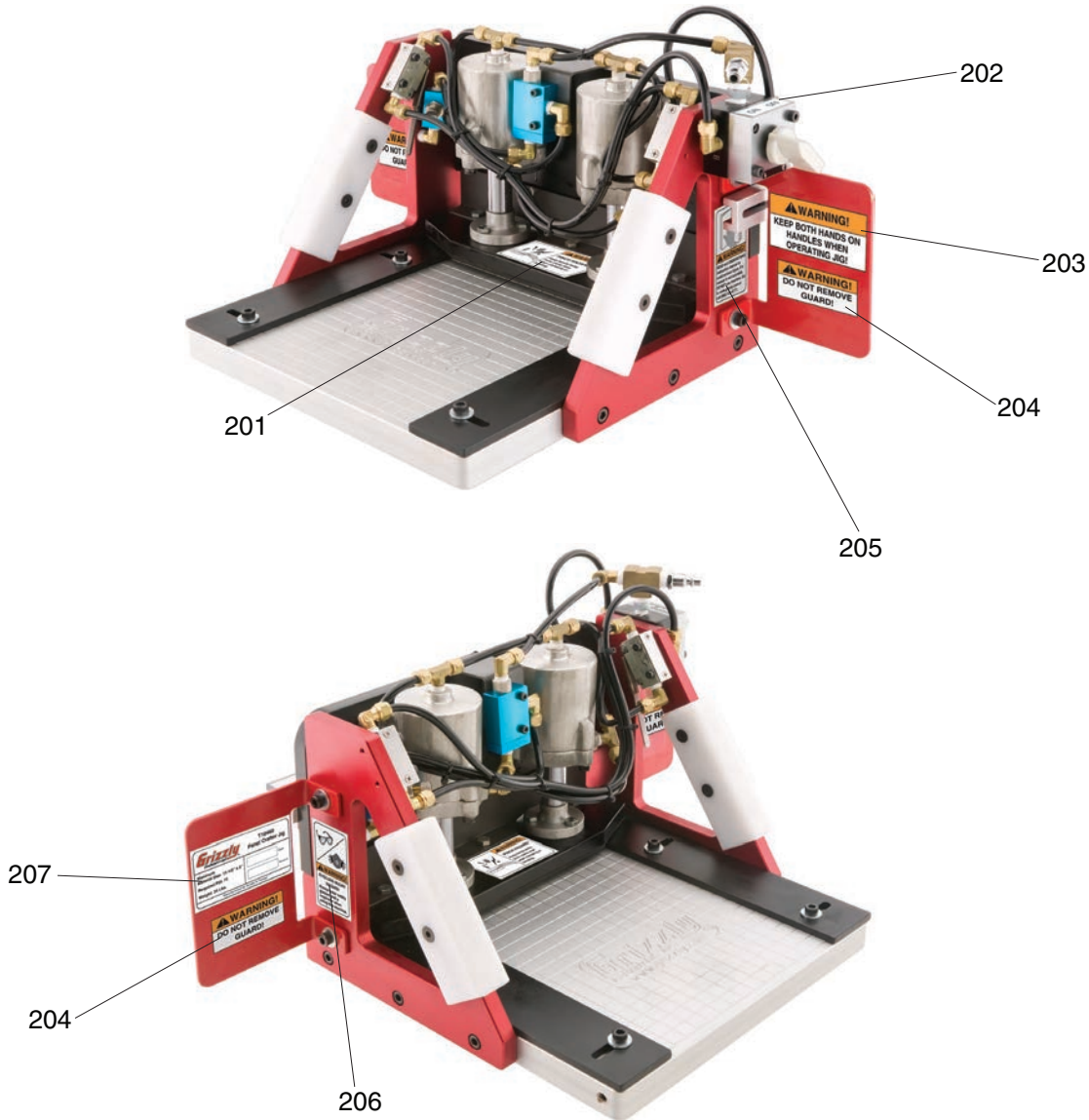


REF	PART #	DESCRIPTION
9	PT10460009	CYLINDER ASSEMBLY
101	PT10460101	T-CONNECTOR 1/8" NPT X 6 X 6MM
102	PT10460102	MALE CONNECTOR 1/8" NPT X 6MM
103	PT10460103	L-CONNECTOR 1/8" NPT X 6MM
104	PT10460104	PILOT CHECK
106	PT10460106	L-CONNECTOR 1/8" NPT X 1/8"
108	PT10460108	AIRFLOW CONTROL VALVE 1/8" NPT

REF	PART #	DESCRIPTION
110	PT10460110	DOUBLE SWITCH
111	PT10460111	L-CONNECTOR 1/4" X 6MM
112	PT10460112	BLOCK 1/4" NPT X 1/4" X 1/4"
113	PT10460113	MALE COUPLING 1/4" NPT
114	PT10460114	CONNECTION 1/4" NPT X 1/8"
115	PT10460115	CONTROL VALVE
117	PT10460117	AIR TUBING 6 X 4MM



T10460/T10462/T10464 Labels



REF	PART #	DESCRIPTION
201	PT10460201	PINCH HAZARD LABEL
202	PT10460202	ON/OFF VALVE LABEL
203	PT10460203	USE BOTH HANDS LABEL
204	PT10460204	DO NOT REMOVE GUARD LABEL
205	PT10460205	READ MANUAL LABEL

REF	PART #	DESCRIPTION
206	PT10460206	GLASSES/REGULATOR LABEL
207	PT10460207	MACHINE ID LABEL (T10460)
207	PT10462207	MACHINE ID LABEL (T10462)
207	PT10464207	MACHINE ID LABEL (T10464)

⚠️ 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.





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<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
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<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- How long have you been a woodworker/metalworker?

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10. Comments: _____

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

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

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

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

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

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