



# MODEL T27665 ARBOR PRESS INSTRUCTIONS

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

## Introduction

The Model T27665 Arbor Press is designed to perform press jobs, such as staking, riveting, and installing/removing bearings. The ram accepts dies, inserts, and other tooling for custom work.



Figure 1. Model T27665 arbor press.

## Specifications

Press Capacity .....	5 Tons
Throat Depth.....	12 <sup>1</sup> / <sub>4</sub> "
Maximum Workpiece Height .....	17 <sup>5</sup> / <sub>16</sub> "
Ram Size .....	3" x 2 <sup>1</sup> / <sub>4</sub> "
Bore Size .....	1 <sup>1</sup> / <sub>2</sub> "
Body .....	Cast Iron
Ram .....	Steel
Overall Size .....	12 <sup>1</sup> / <sub>4</sub> " W x 23 <sup>5</sup> / <sub>8</sub> " D x 30" H
Weight .....	238 lbs.

	<p><b>! WARNING</b> Material under pressure could fly apart and cause impact injuries. Always wear safety glasses when using this press.</p>
	<p>Keep hands and fingers away from ram when applying downward pressure to avoid pinching injuries.</p>

<p style="text-align: center;"><b>NOTICE</b></p> <p>This arbor press is designed to only be used for small parts. Do not use this arbor press for operations beyond its capacity or modify it for increased leverage which can lead to failure of arbor press and possible injury.</p>
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## Small Item Inventory

Description	Qty
A. Hex Wrench 6mm.....	1
B. Hex Wrench 8mm.....	1
C. Open-End Wrench 17/19mm .....	1

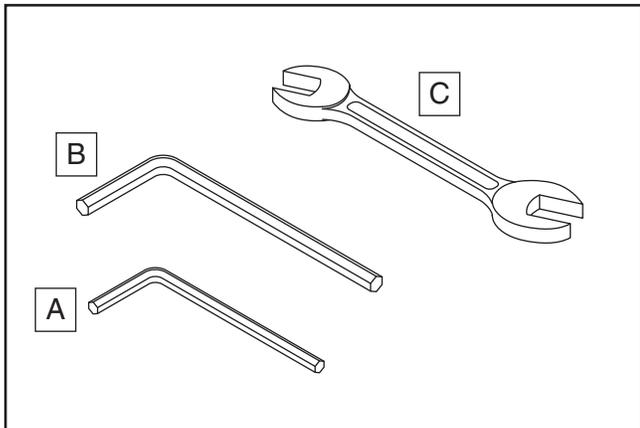


Figure 2. Small item inventory.



## Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

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

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

### Before cleaning, gather the following:

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

### Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat rust preventative with a liberal amount of cleaner/degreaser (see **Page 7** for offerings from Grizzly), then let it soak for 5–10 minutes.
3. Wipe off surfaces. If your cleaner/degreaser is effective, rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with a rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

## NOTICE

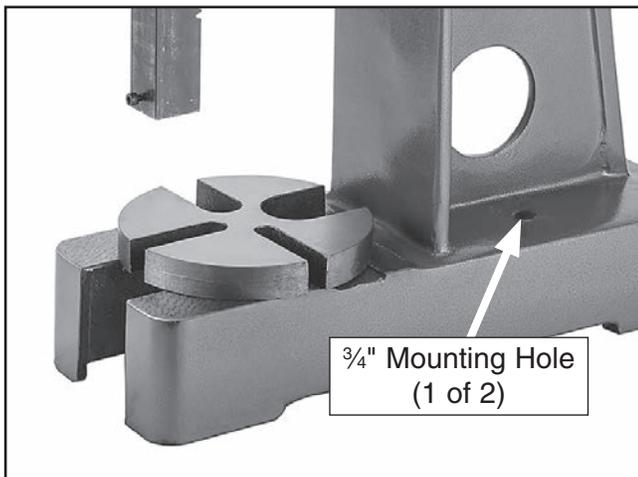
Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.



## Mounting

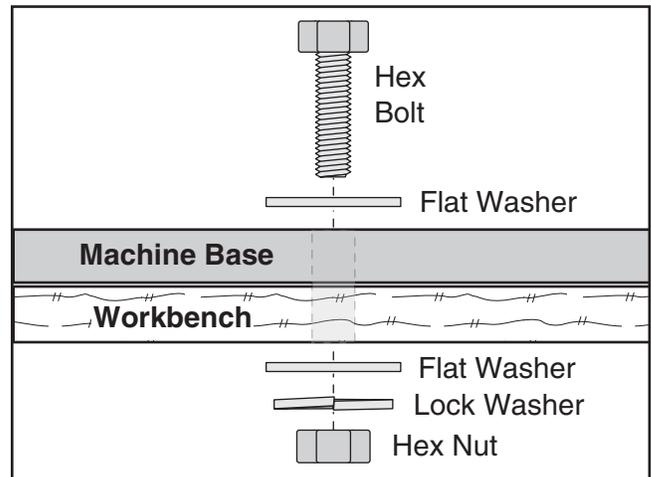
Because of the dynamic forces involved in operating the arbor press, we strongly recommend mounting it to a benchtop or other stable working surface to prevent it from moving during operation and causing accidental injury or damage.

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



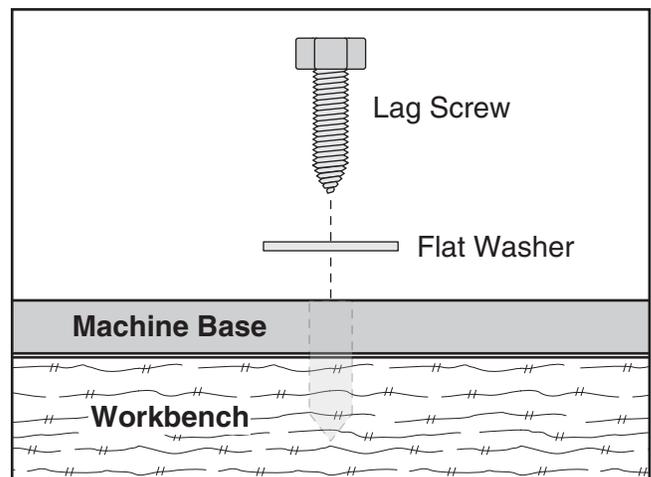
**Figure 3.** Location of mounting holes in base.

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



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

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



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



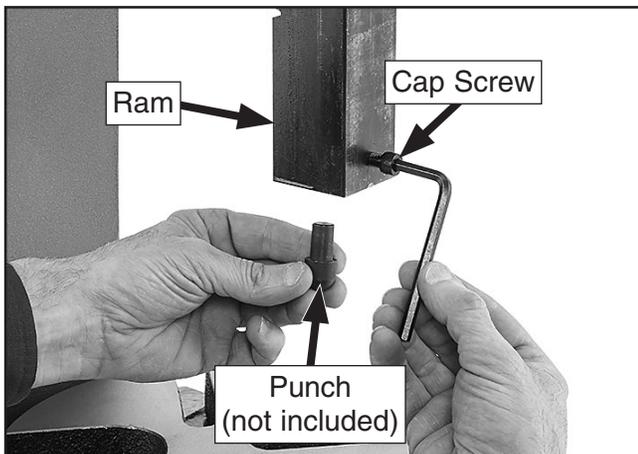
## Inserting Press Punch

The ram accepts 1/2" diameter punch inserts. Ram inserts allow a variety of pressing options, with round, square, and pointed punches available. The ram can act as a press without a punch insert.

### To change punches:

1. Use an 8mm hex wrench to loosen cap screw at base of ram, as shown in **Figure 6**.
2. Insert punch until it is fully seated in ram, then tighten cap screw.

**Note:** Punch removal may be difficult due to the force applied to the punch during pressing. Lightly tapping the side of the punch with a hammer can help loosen it for removal.



**Figure 6.** Typical example of inserting punch into ram.

## Adjusting Ram Play

Cap screws and jam nuts on the front and left side of the ram housing (see **Figure 7**) adjust the amount of ram free-play. The ideal adjustment allows the ram to move with very little play but not be overly stiff.

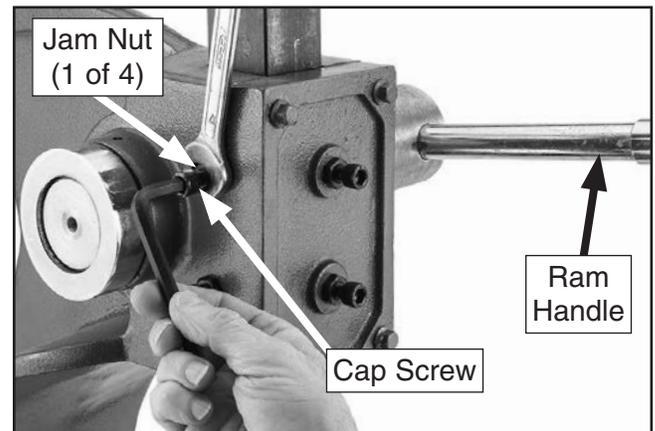
### Tools Needed

	Qty
Hex Wrench 8mm.....	1
Open-End Wrench 17mm.....	1

### To adjust ram play:

1. Loosen jam nut shown in **Figure 7**.

**Note:** If possible, keep one hand on ram handle, as loosening jam nut and cap screws too quickly may allow handle to spin freely.



**Figure 7.** Cap screws and jam nuts used to adjust ram free-play.

2. Equally adjust each pair of cap screws a small amount (turn hex wrench clockwise to decrease free-play, counterclockwise to increase free-play).
3. Use ram handle to move ram up and down a few times to check adjustment. If necessary, further adjust cap screws as in **Step 2**.
4. When satisfied with amount of ram free-play, retighten jam nuts without moving cap screws.



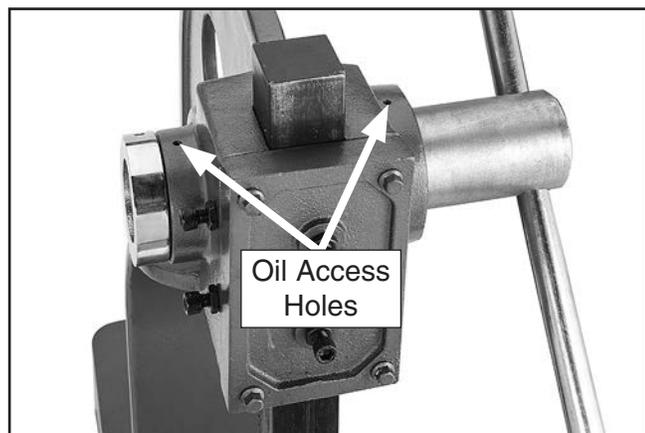
## Cleaning & Protecting

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

## Oiling Pinion Hub Shaft

Oil Type .....T26685 or ISO 32 Equivalent  
Oil Amount..... 1–2 Pumps  
Lubrication Frequency.....8 Hrs. of Operation

Proper lubrication of the pinion hub shaft is done with a pump-type oil can with a cone tip through the oil access holes (see **Figure 8**).



**Figure 8.** Location of oil access holes for lubricating pinion hub shaft.

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

## Greasing Ram Rack and Pinion

Grease.....T23964 or NLGI#2 Equivalent  
Grease Amount ..... As Needed  
Lubrication Frequency .....40 Hrs. of Operation

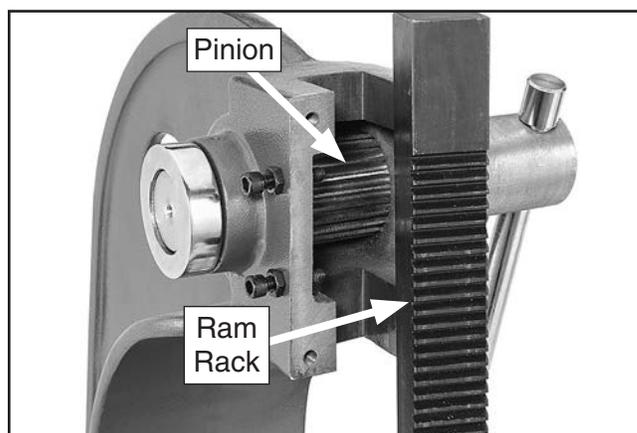
### Tools Needed

Qty

Open-End Wrench or Socket 12mm ..... 1

### To grease rack and pinion:

1. Remove front plate, then remove ram to expose pinion and rack (see **Figure 9**).

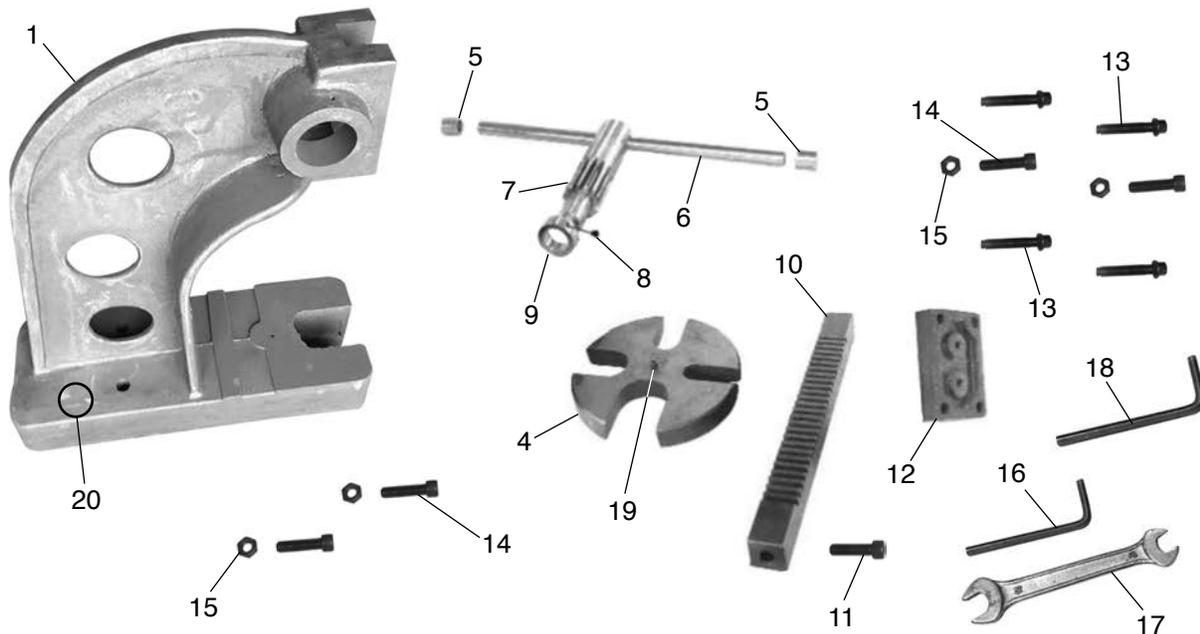


**Figure 9.** Ram rack and pinion exposed after removing front plate.

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



## Arbor Press Breakdown & Parts List



REF	PART #	DESCRIPTION
1	PT27665001	BODY
4	PT27665004	TABLE
5	PT27665005	HANDLE CAP
6	PT27665006	SLIDING HANDLE
7	PT27665007	SPLINE SHAFT
8	PT27665008	SET SCREW M8-1.25 X 10
9	PT27665009	LOCK COLLAR
10	PT27665010	RAM
11	PT27665011	CAP SCREW M8-1.25 X 30

REF	PART #	DESCRIPTION
12	PT27665012	FRONT PLATE
13	PT27665013	FLANGE BOLT M10-1.5 X 40
14	PT27665014	CAP SCREW M10-1.5 X 40
15	PT27665015	HEX NUT M10-1.5
16	PT27665016	HEX WRENCH 6MM
17	PT27665017	OPEN-END WRENCH 17/19MM
18	PT27665018	HEX WRENCH 8MM
19	PT27665019	ROLL PIN 8 X 18
20	PT27665020	TOUCH-UP PAINT, GRIZZLY GREEN

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/parts](http://www.grizzly.com/parts) to check for availability.



## Accessories

### **!WARNING**

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

### **NOTICE**

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

#### **T26419—Syn-O-Gen Grease**

Syn-O-Gen Multi-purpose Synthetic Grease is formulated with 100% pure synthesized hydrocarbon base stocks. Superior lubricating properties coupled with extremely low pour point and extremely high temperature oxidation and thermal stability produce a grease that is unmatched in performance for numerous applications. These properties make Syn-O-Gen non-melting, tacky, and water resistant, with outstanding extreme pressure, rust and corrosion protection.



Figure 10. Syn-O-Gen Multi-Purpose Synthetic Grease.

#### **G2544—Solvent Cleaner & Degreaser**

#### **T23692—Orange Power Degreaser**

Great products for removing shipping grease.



Figure 11. Cleaner & degreasers.

#### **H7617—High-Pressure Oil Can w/Flex Nozzle**

Whether you're lubricating cutting tools or maintaining machinery in top operating condition, you'll appreciate this High Pressure Oil Can. Holds 5 ounces of oil and has a trigger-activated, high-pressure pump. Colors may vary.



Figure 12. H7617 High-Pressure Oil Can.

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



Figure 13. Moly-D Multi-Function Machine Oil - ISO 32, 1 Gallon.

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