



instructions for installation and operation

MORTISING ATTACHMENT

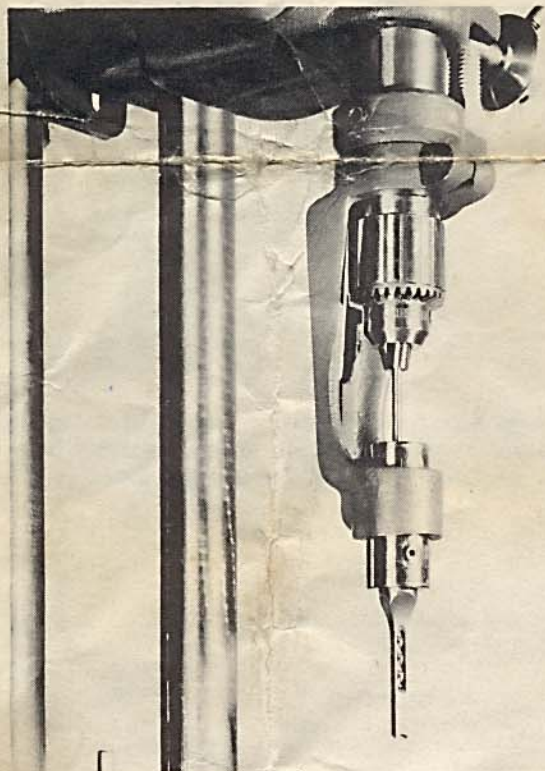
To mount:

1 Slip mortising attachment over end of gauge collar so arm of casting faces the tubular ways.

Note: If your SHOPSMITH has a serial number below 8699, extend the quill 2" and lock. Move the gauge collar back until the end of the quill protrudes beyond the gauge collar $\frac{3}{8}$ ". This is not necessary if the serial number of your SHOPSMITH is above 8699.

2 Secure mortising attachment on gauge collar by tightening Allen set screw.

3 Turn headstock pulley by hand until spindle tip tapered flat faces away from the ways.

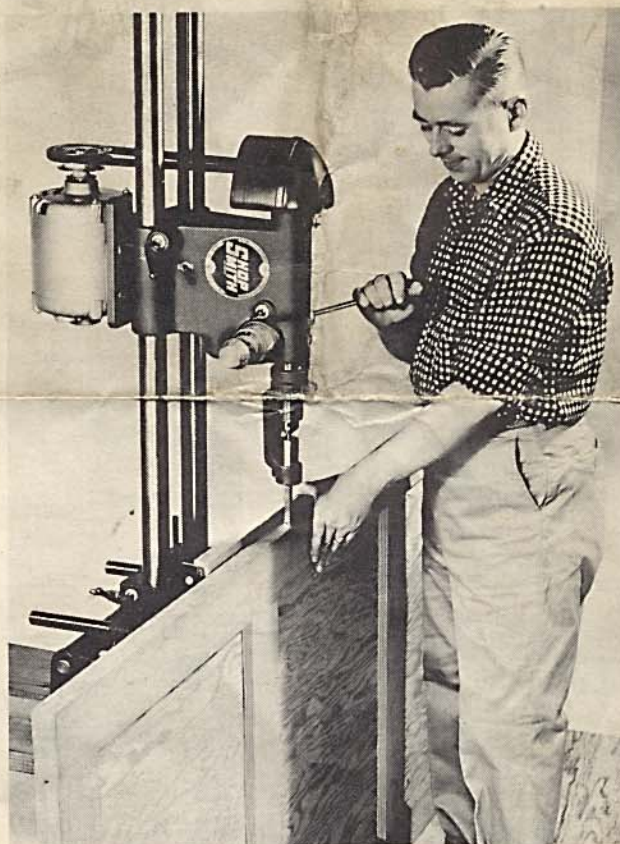


mortising attachment, chuck, bit and chisel in position

4 Mount Jacobs chuck on the spindle. Make sure set screw seats firmly on tapered flat. Insert mortising chisel shank into adjustable sleeve of mortising attachment. Secure with set screw.

5 Insert bit through chisel and into Jacobs chuck. Secure with Jacobs chuck key.

6 Locate adjustable sleeve which holds the chisel so that cutting edge of the chisel is $\frac{1}{16}$ " above cutting edge of the bit. Lock sleeve in casting by tightening Allen set screw.



mortising for door lock set with SHOPSMITH in vertical "floor drill press" position

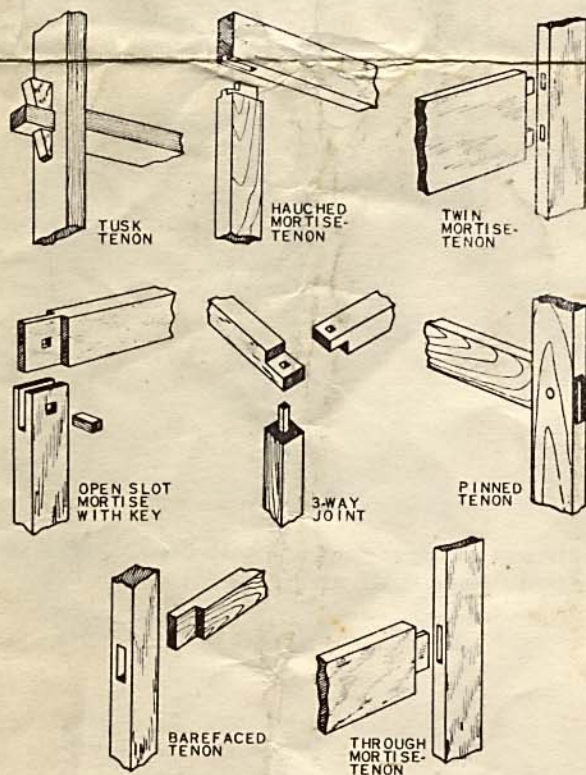
Important: SHOPSMITH mortising bits and chisels are especially designed for SHOPSMITH. If you can't buy SHOPSMITH bits and chisels, buy a type which measures (when assembled) at least 4" but not more than 5" from chisel collar to end of bit shank.

To cut mortise: After cut is laid out on work, adjust rip fence on table so the work will be properly located and braced. Use a square to make certain mortising chisel is square with rip fence. Advance quill to proper depth of cut and set gauge rod stop nuts. If cut is to be made all the way through work, place a board underneath work to prevent bit from hitting table.

It is sometimes difficult to remove the chisel from the work, especially after making the first cut. Therefore clamp the work securely to the table or fence or use the mortising hold-down.

Position and clamp work piece. By advancing quill bring chisel down to begin mortise cut. Chisel should be lifted several times before completing cut to clear the chips and cool the tool. After first cut has been made, shift work sideways about $\frac{3}{4}$ chisel width and make a second cut. By properly positioning the work piece and making several cuts, a mortise longer and wider than the chisel can easily be made.

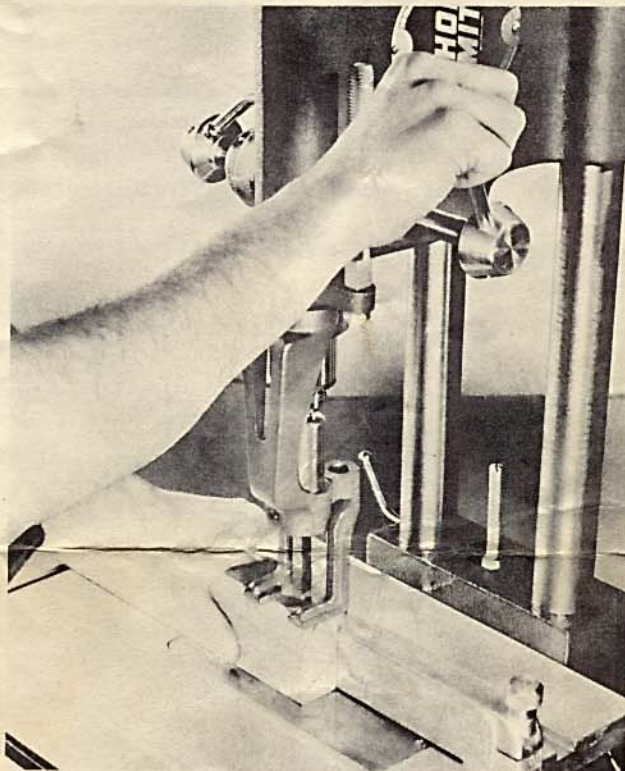
For most operations use second pulley step or medium speed.



typical mortise joints

To use SHOPSMITH mortising hold-down:

- 1 Mount hold-down in hole on top of rip fence and lock in position by tightening Allen set screw.
- 2 Adjust for height of work piece by sliding casting on steel supporting rod.
- 3 Use a spacer block when necessary on cuts close to the edge of a workpiece to space work away from rip fence and provide proper clearance between mortising attachment and hold-down casting.



mortising attachment, chisel and hold-down in typical application—attach frame casting in reverse position for mortising work close to fence

Mortising attachment parts list

part no.	description	list price	shpg. wt. lbs. ozs.
130-1	Mortising attachment frame	\$2.50	1 10
130-1S	$\frac{3}{8}$ - 16 x $\frac{3}{8}$ Allen set screw	.10	3
130-2	Chisel sleeve	1.25	10
130-2S	$\frac{1}{4}$ - 28 x $\frac{1}{4}$ Allen set screw	.10	3
130-3	$\frac{1}{4}$ - 20 x $1\frac{1}{4}$ Allen socket head cap screw	.25	3