

Thank you for purchasing a Sealey product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.



IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS AND CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.

1. SAFETY INSTRUCTIONS

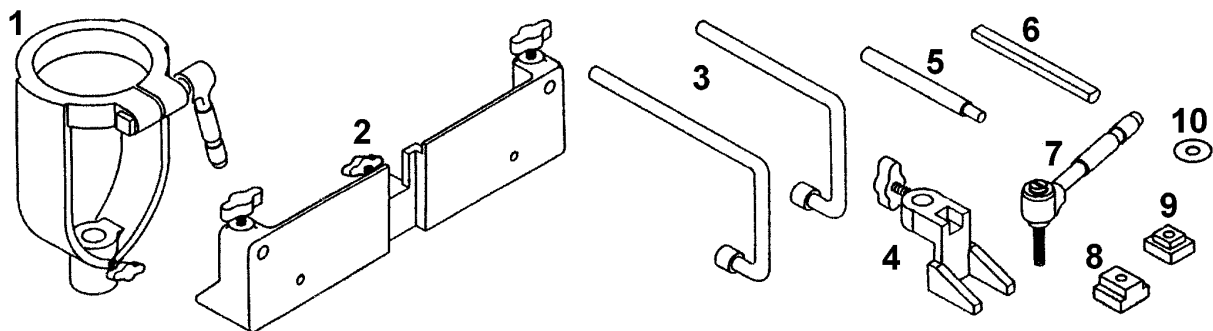
- p **WARNING!** Ensure Health & Safety, local authority and general workshop practice regulations are adhered to when using this equipment.
- 3 Familiarise yourself with the applications, limitations and potential hazards of the mortising attachment and the pillar drill that it is used with.
- p **WARNING!** Disconnect the drill from the mains power and ensure the spindle is at a complete standstill before changing accessories.
- 3 Maintain the mortising attachment in good condition.
- 3 Replace or repair damaged parts. Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.
- p **WARNING!** Keep all guards and holding screws in place, tight and in good working order. Check regularly for damaged parts. A guard or any other part that is damaged must be repaired or replaced before the tool is next used.
- 3 Keep the work area clean, uncluttered and ensure that there is adequate lighting.
- 3 Keep drill bits and chisels clean and sharp for best and safest performance.
- p **WARNING!** Always wear approved eye or face protection when using the mortising attachment. Use a face or dust mask if dust is generated.
- p **WARNING!** DO NOT wear gloves when operating a pillar drill.
- 3 Keep hands and body clear of the work table when operating the mortising attachment.
- 3 Maintain correct balance and footing. Ensure that the floor is not slippery and wear non-slip shoes.
- 3 Remove ill fitting clothing. Remove ties, watches, rings and other loose jewellery and contain and/or tie back long hair.
- 3 Keep children and unauthorised persons away from the work area.
- 3 Ensure the workpiece is correctly secured before operating the mortising attachment.
- 3 Remove adjusting keys and wrenches from the machine and its vicinity before turning it on.
- 7 **DO NOT** use the mortising attachment for any purpose other than that for which it is designed.
- 7 **DO NOT** operate the mortising attachment if any parts are damaged or missing, as this may cause failure and/or personal injury.
- 7 **DO NOT** switch the mortising attachment on whilst the bit or chisel is in contact with the workpiece.
- 7 **DO NOT** hold the workpiece by hand. Use the guides provided to secure the workpiece.
- 7 **DO NOT** allow untrained persons to operate the mortising attachment or the drill.
- 7 **DO NOT** operate the mortising attachment or the drill when you are tired or under the influence of alcohol, drugs or intoxicating medication.
- 3 When not in use store in a safe, dry, childproof area.

2. INTRODUCTION & CONTENT

The MA10/75 Mortising Attachment is designed to fit the Sealey GDM180B, GDM230F, GDM250F and PDM240F Pillar Drills and also drills, having a 75mm diameter collar, from other leading suppliers.

Content

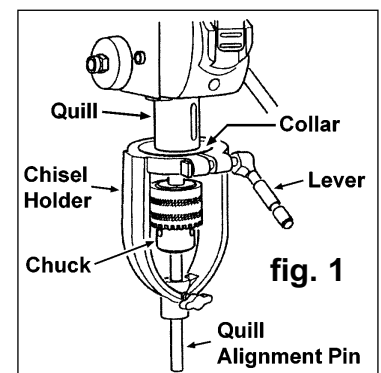
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|------------------|------------------------|----------------------|---------------------------------|
| 1. Chisel Holder | 4. Hold-down Bracket | 7. Locking Lever x 2 | 10. Flat Washer x 2 |
| 2. Fence | 5. Quill Alignment Pin | 8. Large 'T' Nut x 2 | - Mortising Bit x 3 (not shown) |
| 3. Guide Rods | 6. Hold-down Shaft | 9. Small 'T' Nut x 2 | |



3. ASSEMBLY

3.1. Chisel holder (fig. 1)

- 3.1.1. Insert the smaller diameter end of the quill alignment pin (5) into the chuck and lock in place.
- 3.1.2. Slide the chisel holder (1) over the quill alignment pin and onto the quill collar, see right.
- 3.1.3. Tighten the thumb screw onto the alignment pin and then tighten the locking lever.
- 3.1.4. Loosen the thumb screw and then open the chuck to remove the alignment pin.
- 3.1.5. Insert the drill bit shaft and the chisel shaft up through the hole at the base of the chisel holder so that the drill bit shaft enters the chuck.
- 3.1.6. With the shoulder of the chisel approximately 1/32" (0.8mm) from the bottom of the chisel holder (fig. 2), and with the chip ejection slot facing either left or right, lightly clamp chisel by tightening the thumb screw.
- 3.1.7. Push the drill bit up as far as it will go and tighten chuck jaws. Release thumb screw and push chisel up so that shoulder now contacts chisel holder, tighten thumb screw. This procedure will give the correct relationship between the cutting edges of the bit and the points of the chisel.



3.2. Fence (fig. 3)

- 3.2.1. Attach the fence to the drill table using the two locking levers, washers and 'T' nuts (see fig. 3). Use the 'T' nuts which suit the width of the table slots. Note that the locking lever can be repositioned relative to the stud by lifting the lever, against spring pressure, and then rotating and releasing.

3.3. Hold-down bracket (fig.4)

- 3.3.1. Ensure that the hold-down shaft is firmly clamped into the fence, by knob 'A' (fig. 4), with the flat of the shaft facing the rear, as shown.
3.3.2. Mount the hold-down bracket onto the hold-down shaft, as shown, and clamp with knob 'B' (fig. 4).

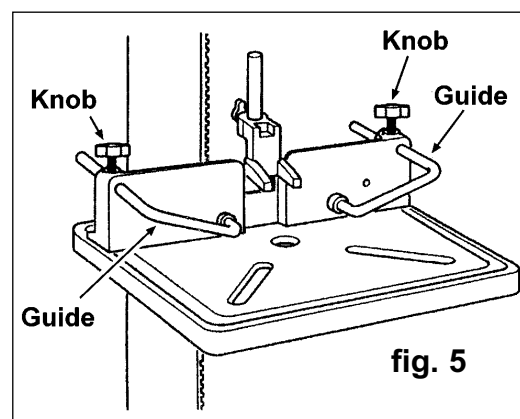
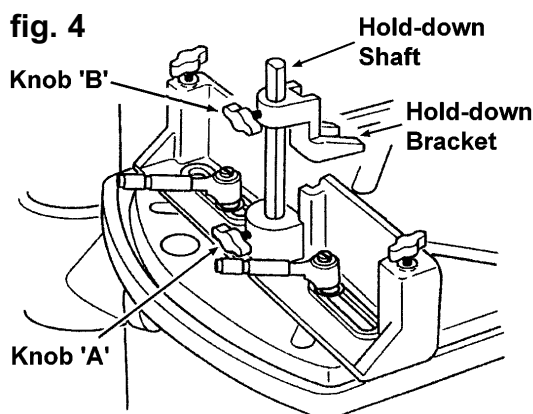
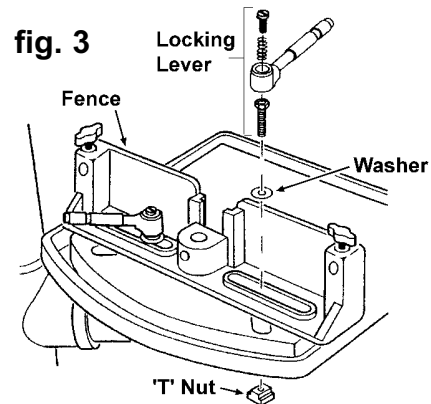
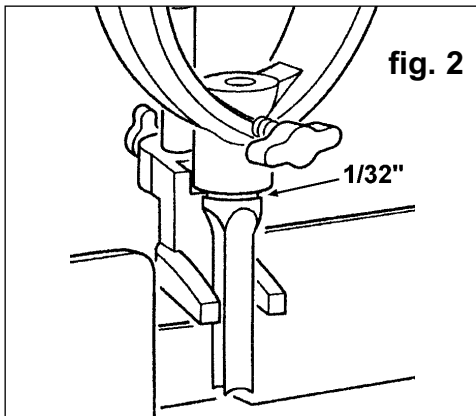
3.4. Guides (fig. 5)

- 3.4.1. Insert the workpiece guide rods through the holes in the fence, as shown, and lock with the clamp knobs.

4. OPERATION

Note: If the mortise is to go right through the workpiece, place a strip of wood under the workpiece to prevent the chisel and bit striking the drill table.

- 4.1. Place the workpiece on the drill table and set the table height so that the end of the mortise chisel clears the top of the workpiece by approximately 1/2" (12mm). Set the drill depth stop to give the required depth of mortise.
4.2. Use the guides to hold the workpiece against the fence and then lower the hold-down bracket onto the top of the workpiece. Check that all clamp knobs are tight. The workpiece must be held in place yet be free to slide along the face of the fence.
4.3. Loosen the two fence locking levers and move fence as necessary to align the workpiece with the mortising chisel. Tighten locking levers. Slide the workpiece along the fence to ensure that the chisel follows, and is square to, the required mortise outline.
4.4. Set the drill speed in the range 650 to 1900rpm, using the lower speeds for hard woods and the higher speeds for soft woods.
4.5. Start the mortising by first making the two end cuts and then remove the remaining material using cuts which overlap by approximately 1/8" (3mm). After each cut slide the workpiece along the fence ready for the next cut.
4.6. Raise the chisel and drill frequently during each cut to allow the swarf to clear.



NOTE: It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

IMPORTANT: No liability is accepted for incorrect use of product.

WARRANTY: Guarantee is 12 months from purchase date, proof of which will be required for any claim.

INFORMATION: For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.



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