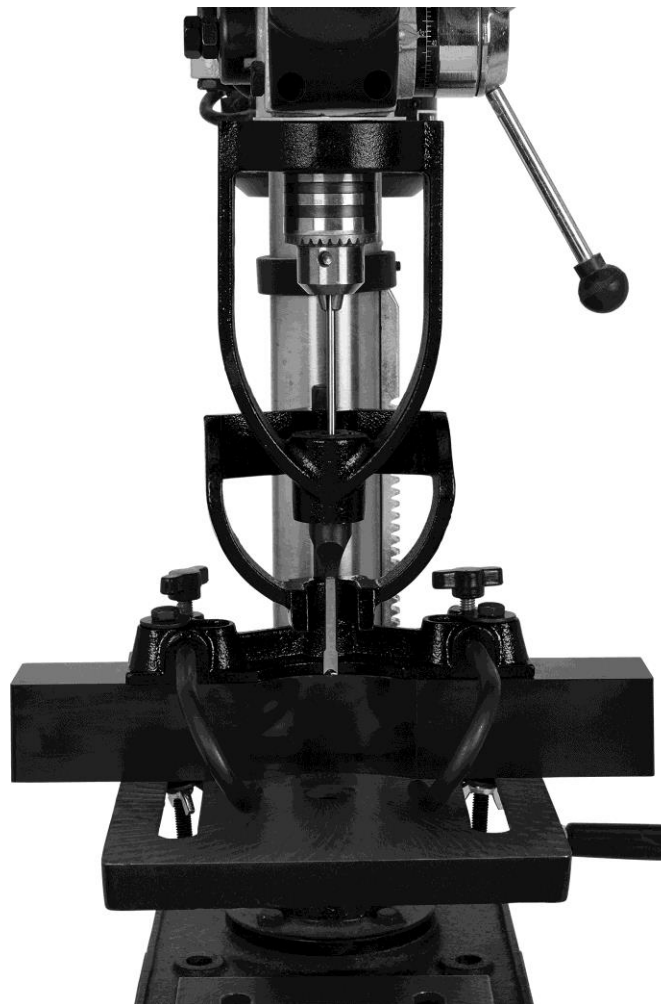


KLUTCH

Mortising Attachment

Owner's Manual



! **WARNING:** Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

Item #57860

READ & SAVE THESE INSTRUCTIONS

Thank you very much for choosing a Klutch™ product!

For future reference, please complete the owner's record below:

Serial Number/Lot Date Code: _____

Purchase Date: _____

Save the receipt, warranty, and this manual. It is important that you read the entire manual to become familiar with this product before you begin using it.

This mortising attachment is designed for certain applications only. Northern Tool & Equipment is not responsible for issues arising from modification or improper use of this product such as an application for which it was not designed. We strongly recommend that this product not be modified and/or used for any application other than that for which it was designed.

For technical questions, please call **1-800-222-5381**.

Table of Contents

Intended Use.....	4
Technical Specifications	4
Important Safety Information	4
Assembly Instructions.....	6
Operating Instructions.....	7
Maintenance	8
Troubleshooting.....	8
Parts Diagram.....	9
Parts List.....	9
Replacement Parts	10
Limited Warranty.....	11

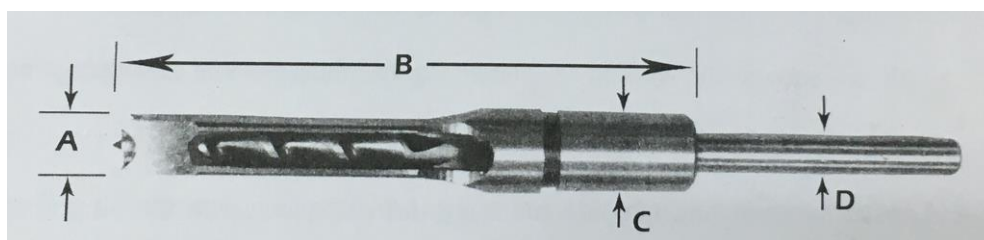
Intended Use

The Klutch Mortising Attachment converts a drill press into an accurate mortising machine for woodworking applications. It allows you to easily and accurately chisel professional-looking mortises.

Technical Specifications

Property	Specification
Ship Weight (lb.)	14

Mortising Chisels Specification



Part Number	Chisel Size	A Length	B Length	C Length	D Length
0	1/4"	1/4" (6.6mm)	4 3/8" (111mm)	3/4" (19mm)	3/16" (4.6mm)
1	3/8"	3/8" (9.5mm)	5 1/2" (139mm)	3/4" (19mm)	9/32" (7mm)
2	1/2"	1/2" (12.7mm)	5 1/2" (139mm)	3/4" (19mm)	3/8" (9.6mm)
3	5/8"	5/8" (15.8mm)	5 1/2" (139mm)	3/4" (19mm)	1/2" (12.3mm)

Important Safety Information

⚠WARNING

- Read and understand all instructions. Failure to follow all instructions may result in serious injury or property damage.
- The warnings, cautions, and instructions in this manual cannot cover all possible conditions or situations that could occur. Exercise common sense and caution when using this tool. Always be aware of the environment and ensure that the tool is used in a safe and responsible manner.
- Do not allow persons to operate or assemble the product until they have read this manual and have developed a thorough understanding of how it works.
- Do not modify this product in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the product. There are specific applications for which the product was designed.
- Use the right tool for the job. DO NOT attempt to force small equipment to do the work of larger industrial equipment. There are certain applications for which this equipment was designed. It will be a safer experience and do the job better at the capacity for which it was intended. DO NOT use

this equipment for a purpose for which it was not intended.

- Industrial or commercial applications must follow OSHA requirements.

⚠WARNING

WORK AREA SAFETY

- Inspect the work area before each use. Keep work area clean, dry, free of clutter, and well-lit. Cluttered, wet, or dark work areas can result in injury. Using the product in confined work areas may put you dangerously close to cutting tools and rotating parts.
- Do not use the product where there is a risk of causing a fire or an explosion; e.g., in the presence of flammable liquids, gases, or dust. The product can create sparks, which may ignite the flammable liquids, gases, or dust.
- Keep children and bystanders away from the work area while operating the tool. Do not allow children to handle the product.

⚠WARNING

PERSONAL SAFETY

- Stay alert, watch what you are doing, and use common sense when operating the tool. Do not use the tool while you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating the tool may result in serious personal injury.
- Dress properly. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts.
- Wear the proper personal protective equipment when necessary. Use ANSI Z87.1 compliant safety goggles (not safety glasses) with side shields, or when needed, a face shield. Use a dust mask in dusty work conditions. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate. This applies to all persons in the work area.
- Do not overreach. Keep proper footing and balance at all times.
- Keep hands clear from mortising attachment during use.
- Use lock stop button before making adjustments.

⚠CAUTION

MORTISSING ATTACHMENT USE AND CARE

- Do not force the mortising attachment. Products are safer and do a better job when used in the manner for which they are designed. Plan your work, and use the correct product for the job.
- Check for damaged parts before each use. Carefully check that the product will operate properly and perform its intended function. Replace damaged or worn parts immediately. Never operate the product with a damaged part.
- Store the mortising attachment when it is not in use. Store it in a dry, secure place out of the reach

of children. Inspect the tool for good working condition prior to storage and before re-use.

- Use only accessories that are recommended by the manufacturer for use with your product. Accessories that may be suitable for one product may create a risk of injury when used with another tool. Never use an accessory that has a lower operating speed or operating pressure than the tool itself.
- Keep guards in place and in working order. Never operate the product without the guards in place.

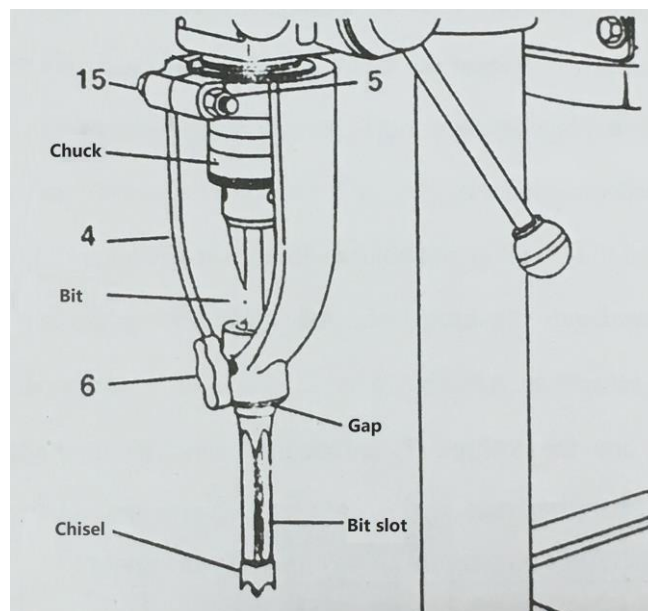
Assembly Instructions

⚠WARNING

- Allow the proper clearance between the cutting lips of the bit and points of the chisel.
- Always store chisels and bits when not use, to protect them from damage.

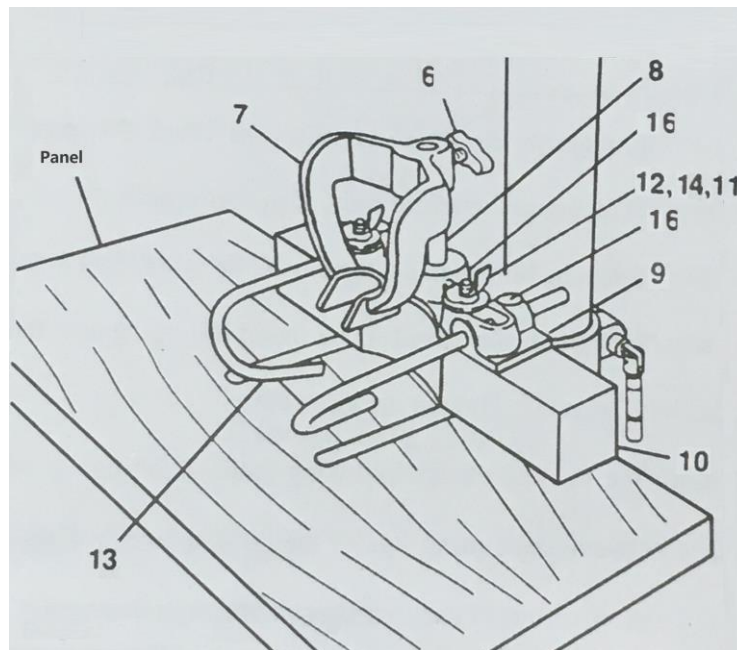
Mounting the chisel holder on the quill:

1. Choose the correct split ring bushing for your drill press. Position the split ring bushing in the chisel holder (#4) with the flange of the bushing against the top of the chisel holder. Align the slot against the top of the chisel holder. Align the slot against the bushing with the gap in the chisel holder.
2. Mount the chisel holder (#4) over the base of the quill. Make sure that the slot in the bushing is still aligned with the gap in the chisel holder.
3. Secure the chisel holder using the 2 3/8" screw (#15) and the hex nut (#5).
4. Insert the bit through the chisel and into the chuck. Position the chisel with the bit slot facing to the left or tighten the drill press.
5. Push the bit up until the bit is against the chisel. Secure the bit in the chuck.
6. Loosen the knob (#6) holding the chisel. Push the chisel up against the chisel holder eliminating the 1/32" gap. Tighten the knob (#6).



Mounting on the drill press table:

1. A minimum of 1-2" thick plywood panel should be installed between the fence and top of the drill press table to prevent damage to the bit and chisel when cutting the mortise. Drill a mounting hole in the plywood to match the slots in the drill press table.
2. Place a washer (#12) on each of the 4-1/4" screws (#14). Feed screws from underneath the drill press, through the plywood, fence (#10), and rod holder (#9). Secure with washers (#12) and wing nuts (#11).
3. Secure the steel rod (#8) to the rod holder with the set screw (#16).
4. Insert the curved rods (#13) through the rod holder and secure them in place by tightening the set screws (#16).
5. Slide the arm (#7) onto the steel rod (#8) and secure it in place with the knob (#6).



Operating Instructions

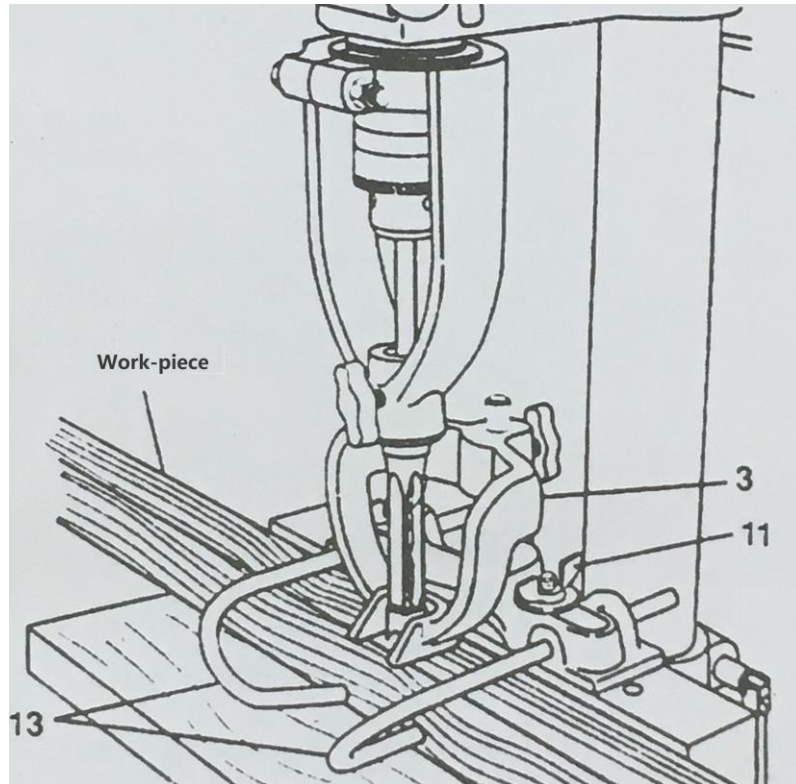
⚠WARNING

- Do not attempt to cut a mortise deeper than the depth capacity listed in the chart for each chisel. Cutting a mortise beyond these limits could result in damage to the bit and chisel.
- Keep hands clear from mortising attachment during use.
- Use lock stop button before making adjustments.

1. Place the work piece on the drill press table and adjust the height of the table to provide a 1/2" gap between the top of the work piece and the points on the chisel.
2. Run chisel down along the side of the work piece to gauge the depth of the mortise. Adjust the depth stop on the drill press to control the depth of the cut.
3. Adjust the two curved rods (#13) to hold the work piece against the fence. Position the arm against the work piece. Tighten the curved rods and the arm to apply light pressure on the work piece. The work piece must be able to slide against the fence.

4. Loosen the two wing nuts (#11) and align the work piece with the bit and chisel. Slide the work piece along the fence to make sure the cut is along the required line. Once aligned, tighten the wing nuts.
5. When cutting a mortise, cut the ends first. Then make subsequent cuts between these holes. The cuts may overlap and the chisel's bit slot should face the previously cut hole.

Note: For best results, the spindle speed should be between 650 to 1800 RPMs.
 Use the slower speed for larger bits and chisels and when mortising harder woods.
 Use the faster speed for smaller bits and chisels and when mortising softer woods.



Maintenance

Maintain the product by adopting a program of conscientious repair and maintenance in accordance with the following recommended procedures. It is recommended that the general condition of any tool be examined before it is used. Keep your tool in good repair. Keep all cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control. Keep handles dry, clean, and free from oil and grease. The following chart is based on a normal operation schedule.

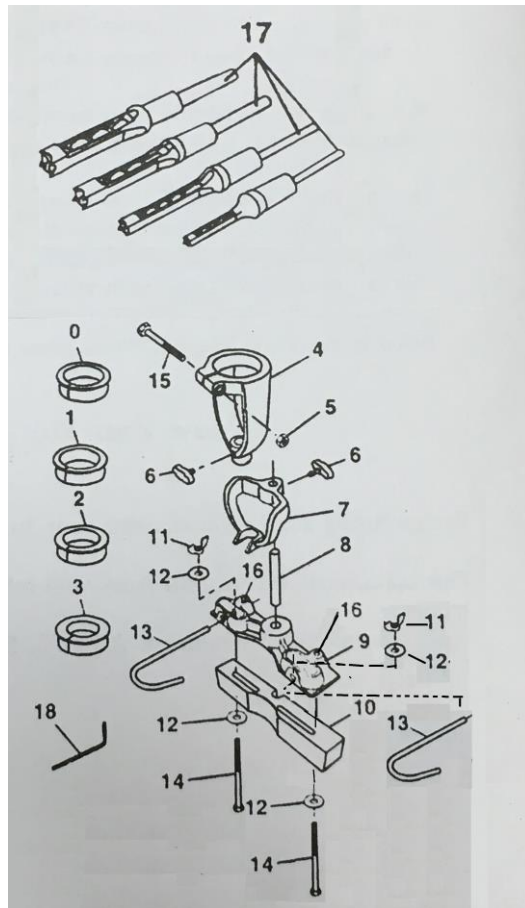
Maintenance Interval	Maintenance Point
Every three months	Clean the wood clips. Check and clean all parts.

Troubleshooting

Use the table below to troubleshoot problems before contacting service personnel or your local dealer. If the problem continues after troubleshooting, call your local dealer for assistance.

Failure	Possible Cause	Corrective Action
Wood chips are getting jammed between the chisel and bit.	Chips are not properly clearing out of the chisel.	<ol style="list-style-type: none"> (1) For end cuts, lift the chisel periodically when drilling. (2) Ensure the open side of the chisel is facing an already drilled area. (3) Reduce the cutting area and increase the overlap on subsequent holes.

Parts Diagram



Parts List

Reference	Part Number	Part Description	Quantity
1	0	Split-ring bushing (spindle sliding bush with inside diameter of 52.5mm / 2 1/16" on the drill press)	1
2	1	Split-ring bushing (spindle sliding bush with inside diameter of 55mm / 2 3/16" on the drill press)	1
3	2	Split-ring bushing (spindle sliding bush with inside diameter of 58mm / 2 5/16" on the drill press)	1
4	3	Split-ring bushing (spindle sliding bush with inside diameter of 60mm / 2 3/8" on the drill press)	1
5	4	Chisel holder	1

Reference	Part Number	Part Description	Quantity
6	5	Hex nut 5/16"	1
7	6	Knob with threaded stud	2
8	7	Arm	1
9	8	Steed rod	1
10	9	Rod holder	1
11	10	Fence	1
12	11	5/16" wing nut	2
13	12	Washer	4
14	13	Curved rod	2
15	14	5/16 X 4 1/4" hex screw	2
16	15	5/16 X 2 3/8" hex screw	1
17	16	#8 X 8mm set screw	2
18	17	Chisel and bit set	4
19	18	Set screw hex key	1

Replacement Parts

- For replacement parts and technical questions, please call Customer Service at **1-800-222-5381**.
- Not all product components are available for replacement. The illustrations provided are a convenient reference to the location and position of parts in the assembly sequence.
- When ordering parts, the following information will be required: item description, item model number, item serial number/item lot date code, and the replacement part reference number.
- The distributor reserves the rights to make design changes and improvements to product lines and manuals without notice.

Limited Warranty

Northern Tool and Equipment Company, Inc. ("We" or "Us") warrants to the original purchaser only ("You" or "Your") that the Klutch product purchased will be free from material defects in both materials and workmanship, normal wear and tear excepted, for a period of **one year** from date of purchase. The foregoing warranty is valid only if the installation and use of the product is strictly in accordance with product instructions. There are no other warranties, express or implied, including the warranty of merchantability or fitness for a particular purpose. If the product does not comply with this limited warranty, Your sole and exclusive remedy is that We will, at our sole option and within a commercially reasonable time, either replace the product or product component without charge to You or refund the purchase price (less shipping). This limited warranty is not transferable.

Limitations on the Warranty

This limited warranty does not cover: (a) normal wear and tear; (b) damage through abuse, neglect, misuse, or as a result of any accident or in any other manner; (c) damage from misapplication, overloading, or improper installation; (d) improper maintenance and repair; and (e) product alteration in any manner by anyone other than Us, with the sole exception of alterations made pursuant to product instructions and in a workmanlike manner.

Obligations of Purchaser

You must retain Your product purchase receipt to verify date of purchase and that You are the original purchaser. To make a warranty claim, contact Us at 1-800-222-5381, identify the product by make and model number, and follow the claim instructions that will be provided. The product and the purchase receipt must be provided to Us in order to process Your warranty claim. Any returned product that is replaced or refunded by Us becomes our property. You will be responsible for return shipping costs or costs related to Your return visit to a retail store.

Remedy Limits

Product replacement or a refund of the purchase price is Your sole remedy under this limited warranty or any other warranty related to the product. We shall not be liable for: service or labor charges or damage to Your property incurred in removing or replacing the product; any damages, including, without limitation, damages to tangible personal property or personal injury, related to Your improper use, installation, or maintenance of the product or product component; or any indirect, incidental or consequential damages of any kind for any reason.

Assumption of Risk

You acknowledge and agree that any use of the product for any purpose other than the specified use(s) stated in the product instructions is at Your own risk.

Governing Law

This limited warranty gives You specific legal rights, and You also may have other rights which vary from state to state. Some states do not allow limitations or exclusions on implied warranties or incidental or consequential damages, so the above limitations may not apply to You. This limited warranty is governed by the laws of the State of Minnesota, without regard to rules pertaining to conflicts of law. The state courts located in Dakota County, Minnesota shall have exclusive jurisdiction for any disputes relating to this warranty.

KLUTCH

Distributed by:

Northern Tool & Equipment Company, Inc.

Burnsville, Minnesota 55306

www.northerntool.com

Made in China