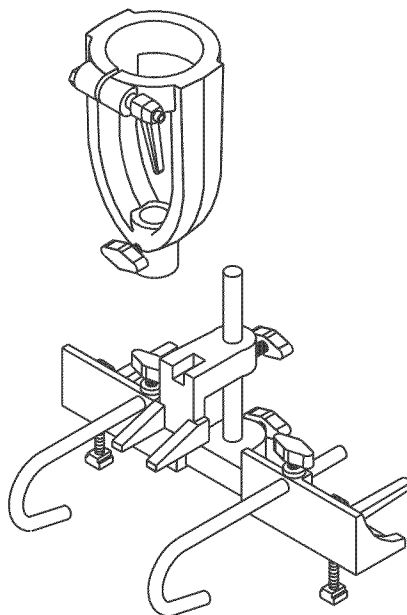


Operator's Manual



MORTISING CHISEL KIT

351.264271



CAUTION:

Read and follow all Safety Rules and Operating Instructions before First Use of this Product.

- **Safety**
- **Assembly**
- **Operation**
- **Maintenance**
- **Parts List**
- **Español**

Sears, Roebuck and Co., Hoffman Estates, IL 60179 U.S.A.

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WARRANTY

FULL ONE YEAR WARRANTY

If this product fails due to a defect in material or workmanship within one year from the date of purchase, Sears will at its option repair or replace it free of charge. Contact your nearest Sears Service Center (1-800-4-MY-HOME) to arrange for product repair, or return this product to place of purchase for replacement.

If this product is used for commercial or rental purposes, this warranty will apply for 90 days from the date of purchase.

This warranty applies only while this product is used in the United States.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

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SAFETY RULES

WARNING: For your own safety, read all of the instructions and precautions before operating tool.

CAUTION: Always follow proper operating procedures as defined in this manual even if you are familiar with use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.

BE PREPARED FOR JOB

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
- Wear protective hair covering to contain long hair.
- Wear safety shoes with non-slip soles.
- Wear safety glasses complying with United States ANSI Z87.1. Everyday

glasses have only impact resistant lenses. They are **NOT** safety glasses.

- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

PREPARE WORK AREA FOR JOB

- Keep work area clean. Cluttered work areas invite accidents.
- Work area should be properly lighted.
- Keep visitors at a safe distance from work area.
- Keep children out of workplace. Make workshop childproof. Use padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.

KNOW HOW TO USE TOOL

- Use right tool for job. Do not force tool or attachment to do a job for which it was not designed.
- Do not force tool. It will work most efficiently at the rate for which it was designed.
- Keep hands away from moving parts and cutting surfaces.
- Know your tool. Learn the tool's operation, application and specific limitations.
- Use of improper accessories may cause risk of injury to persons.
- Handle workpiece correctly. Protect hands from possible injury.
- Turn machine off if it jams. Chisel or bit jams when it digs too deeply into workpiece. (Motor force keeps it stuck in the work.)

CAUTION: Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

ASSEMBLY

Refer to Figure 1.

- Insert thumb screw (Key No. 6) into housing (Key No. 1).
- Insert rod (Key No. 9) into fence (Key No. 10) and secure in position with thumb screw.
- Mount clamp (Key No. 7) onto rod and secure in position with thumb screw.
- Insert curved rods (Key No. 11) into fence and secure in position with thumb screw.

INSTALLATION

WARNING: Disconnect drill press from power source until all assembly steps are complete.

Refer to Figures 1 and 2.

- Lower drill press spindle 2 to 3 inches. Lock spindle in position.
- Measure diameter 'A' of quill stop collar (see Figure 1):

75mm - Slide housing (Key No. 1) over quill and secure onto quill stop collar by tightening ratchet handle (Key. No. 5). Thumb screw (Key. No. 6) should face away from drill press column.

66mm - Insert 66mm split bushing (Key No. 2) into housing, then install housing onto quill. Make sure slot in bushing is aligned with slot in housing.

60mm - Insert both 66mm and 60mm split bushings (Key No. 2) into housing, then install housing onto quill.

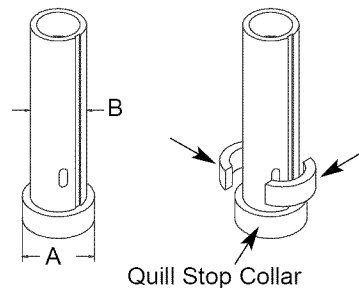


Figure 1 - Measuring Quill; Locating Two-piece Bushings

- For other quill stop collar sizes, the two-piece bushings (Key No. 3) are used. Measure diameter of quill 'B'. This kit includes three sets of two-piece bushings to fit quill diameters of 40, 48 and 50mm. Slide rubber bumper towards top of quill. (When quill is retracted, bumper will rest on top of bushings.) Select the appropriate two-piece bushing set and place on top of quill stop collar (See Figure 1).

Make sure slot formed by the two-piece bushing is facing towards the front of machine. Insert the 66mm split bushing into the housing with slot of bushing aligned with the slot of the housing. Position housing over quill and clamp housing onto the two-piece bushing, making sure that thumb screw faces away from the drill press column.

NOTE: Use only corresponding size of bit and chisel. For example $\frac{1}{4}$ " bit is used only with $\frac{1}{4}$ " chisel. Both bit and chisel must be sharp. If either one is dull, there will be excessive friction with consequent heat, damaging the points.

- Insert the bit and chisel (Key Nos. 13 and 14) through the bore in the housing (Key No. 1). Clamp the chisel so that the upper surface of its shoulder is about $\frac{1}{32}$ " below the housing and tighten thumb screw (Key No. 6) lightly. Push the bit up through the chisel as far as it will go and fasten in drill chuck securely. The slot in the chisel should face either left or right, never to front or rear.
- Release the thumb screw holding the chisel, push chisel upward to take up the $\frac{1}{32}$ " space, and then tighten the thumb screw securely. This method of mounting ensures that there is proper clearance between cutting edges of the bit and the points of the chisel.
- Fence assembly is positioned such that the chisel will travel through the notch at the bottom of the clamp (Key No. 7). Place T-nuts (Key No. 12) in the slots of drill press table underneath slots in the fence. Secure fence in position using ratchet handles and flat washers (Key Nos. 8 and 15).
- For through mortising, it is recommended that a $\frac{1}{2}$ " plywood panel be installed on the drill press table. It can be held in place by inserting it under the mortising fence. Drill holes in the plywood to match the slots in the table and fence. The plywood panel will prevent damage to the chisel if it strikes the table by accident and also serves to increase the size of the table. Secure fence with T-nuts, $\frac{5}{16}$ "-18 bolts and flat washers.

OPERATION

DESCRIPTION

Refer to Figure 1.

The Craftsman Mortising Chisel Kit converts most drill presses into an accurate mortising machine. Sturdy cast iron housing can be mounted onto a 40, 48, 50, 60, 66 or 75mm quill diameter. The $\frac{5}{8}$ " bore guides the mortising chisel which can be secured with thumb screw. This kit is used with a $\frac{5}{8}$ " capacity key chuck.

MORTISING

CAUTION: Know the accessory and the power tool. Read and understand all owner's manuals and other instructions provided.

- Raise the chisel frequently during operation to allow free discharge of chips and prevent clogging the bit.
- To ensure a clean joint, each successive cut should overlap the previous cut endwise approximately $\frac{1}{8}$ ". When cutting harder woods, increase the overlap.
- Mortise cuts, wider than the chisel, may be made by overlapping laterally.
- It is recommended that a fence or guide be used to insure straight, uniform edges along the finished cut.

- High speed should never be employed, as it will cause overheating and quickly dull the edges of both chisel and bit. Best results are obtained by using speeds ranging from 2300 to 4250 RPM, depending upon the type of stock to be cut. It is recommended that lower speeds be used for soft wood.
- Care should be exercised when feeding the tool into the work. In working with hard woods and other woods that are more difficult to machine, it is advisable to use a slower feed rate.

MAINTENANCE

SHARPENING THE CHISEL

NOTE: Best results are obtained when the chisel is sharpened with a conical-shaped mounted grinding point.

CAUTION: Do not attempt to hold the chisel in the hands.

- Chuck the conical-shaped mounted grinding point in the drill press and clamp the chisel in an adequate holding device.
- Grind the inside of the chisel only; do not bevel the outside edges. Grind only enough to remove nicks and produce a sharp edge.
- Keep all four cutting corners the same length.
- After grinding, the wire edge on the outside may be removed with a very light application of fine emery cloth, or a flat oil stone.

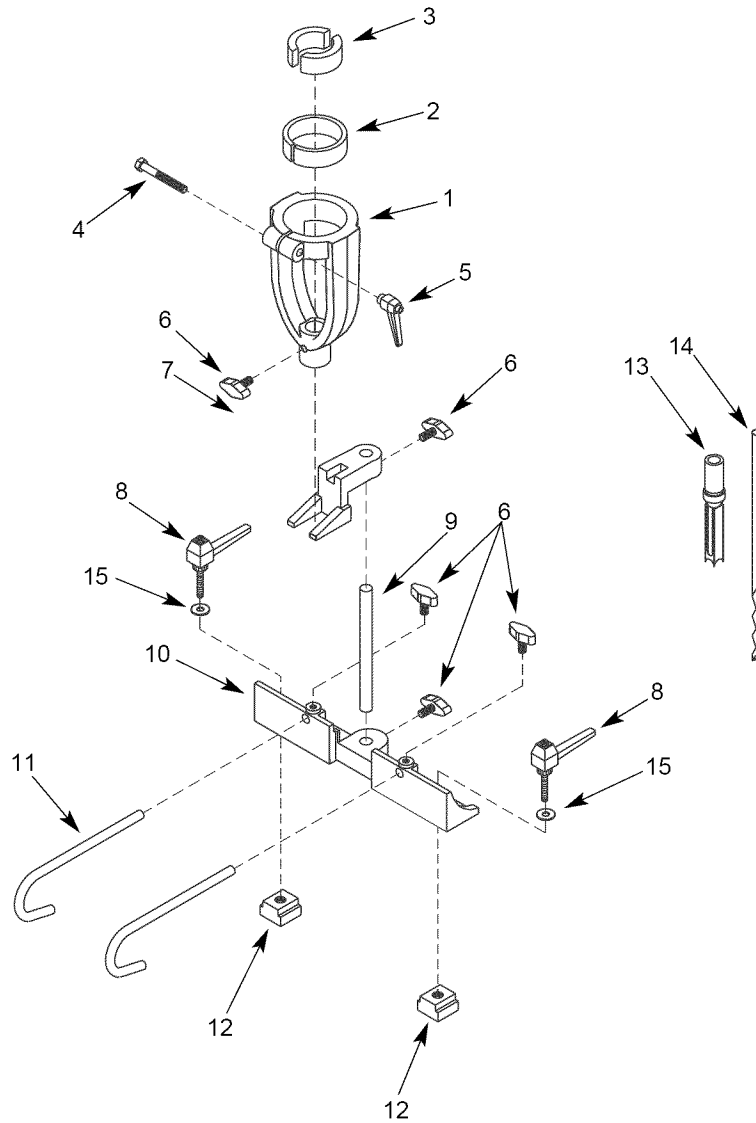
CAUTION: Do not overheat the chisel during the grinding operation, as the temper of the metal might be destroyed.

SHARPENING THE BIT

- Use a very fine file to sharpen the bit. File from below, allowing the file to pass over the top surface of the cutting lips into the channel through which the chips pass. The cutting lips should be of equal length after filing.
- File the inside lips only, and make sure they are equal in length when filing is completed.
- Never file the outside circumference of the bit. It is purposely larger in diameter at its point to minimize the chisel cut, and thus reduce the drill press feeding force required.

Model 351.264271

Figure 2 - Replacement Parts Illustration for Mortising Chisel Kit



REPLACEMENT PARTS LIST FOR MORTISING CHISEL KIT

KEY NO.	PART NO.	DESCRIPTION	QTY.
1	07115.00	Housing	1
2	08358.00	60mm Split Bushing	1
2	08359.00	66mm Split Bushing	1
3	17340.00	40mm Two-piece Bushing	1
3	17341.00	48mm Two-piece Bushing	1
3	17342.00	50mm Two-piece Bushing	1
4	STD835050	8-1.25 x 50mm Hex Head Bolt*	1
5	17343.00	Ratchet Handle	1
6	07118.00	Thumb Screw	5
7	17344.00	Clamp	1
8	17345.00	Ratchet Handle	2
9	16429.00	Rod	1
10	17346.00	Fence	1
11	16430.00	Curved Rod	2
12	17347.00	12mm T-nut	2
12	17348.00	14mm T-nut	2
13	9-26411	1/4" Mortising Bit	1
13	9-26412	5/16" Mortising Bit	1
13	9-26413	3/8" Mortising Bit	1
13	9-26414	1/2" Mortising Bit	1
14	9-26415	1/4" Mortising Chisel	1
14	9-26416	5/16" Mortising Chisel	1
14	9-26417	3/8" Mortising Chisel	1
14	9-26418	1/2" Mortising Chisel	1
15	STD851008	8mm Flat Washer*	2
Δ	17349.00	Storage Case	1
Δ	17350.01	Operator's Manual	1

* Standard hardware item available locally.

Δ Not Shown

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