



I. SAFETY INSTRUCTIONS

OPERATIONAL INSTRUCTIONS

A. Use only 1/2" diameter shank router bit

Using a smaller size shank could result in injury to operator due to the length of the shank which must protrude outside the router collet.

B. Always begin routing with router base firmly against template and router bit in a retracted position

C. DO NOT attempt to insert router bit through template slot with router running

This will greatly increase risk of injury to the operator and increase potential of permanent damage to the fixture.

D. DO NOT lift router base from template before router bit comes to a full stop

E. Avoid cutting materials with nails and knots

Inspect for and remove all nails, and try to lay out cuts between knots.

F. Make multiple shallow cuts instead of one deep cut



2. RECOMMENDED EQUIPMENT

- Minimum 1-1/2 HP Plunge Router
- 1/2" Shank Diameter Router Bit
- Appropriate Router Template Guide with a Maximum Projection from Router Base of 7/16"

3. ADJUSTMENTS

A. Mortise width

The mortise width is determined by a combination of router template guide outside diameters and router bit diameters. The most commonly used bit is a 1/2" diameter. 1-1/4" is the maximum mortise width.

Formula for mortise width:

Width = 1-3/8" – template guide diameter + bit diameter

Example: 1-3/8" – 1" + 1/2" = 7/8" mortise width

Additional examples:

For a Mortise Width of:

- 1 1/4"
- 1-1/8"
- 1"
- 7/8"
- 3/4"

You will need a Cutter Diameter of:

- 1/2"
- 1/2"
- 5/8"
- 1/2"
- 5/8"

And a Guide Diameter of:

- 5/8" (POR42045)
- 3/4" (POR42024)
- 1" (POR42030)
- 1" (POR42030)
- 1 1/4" (POR42021)

B. Mortise length

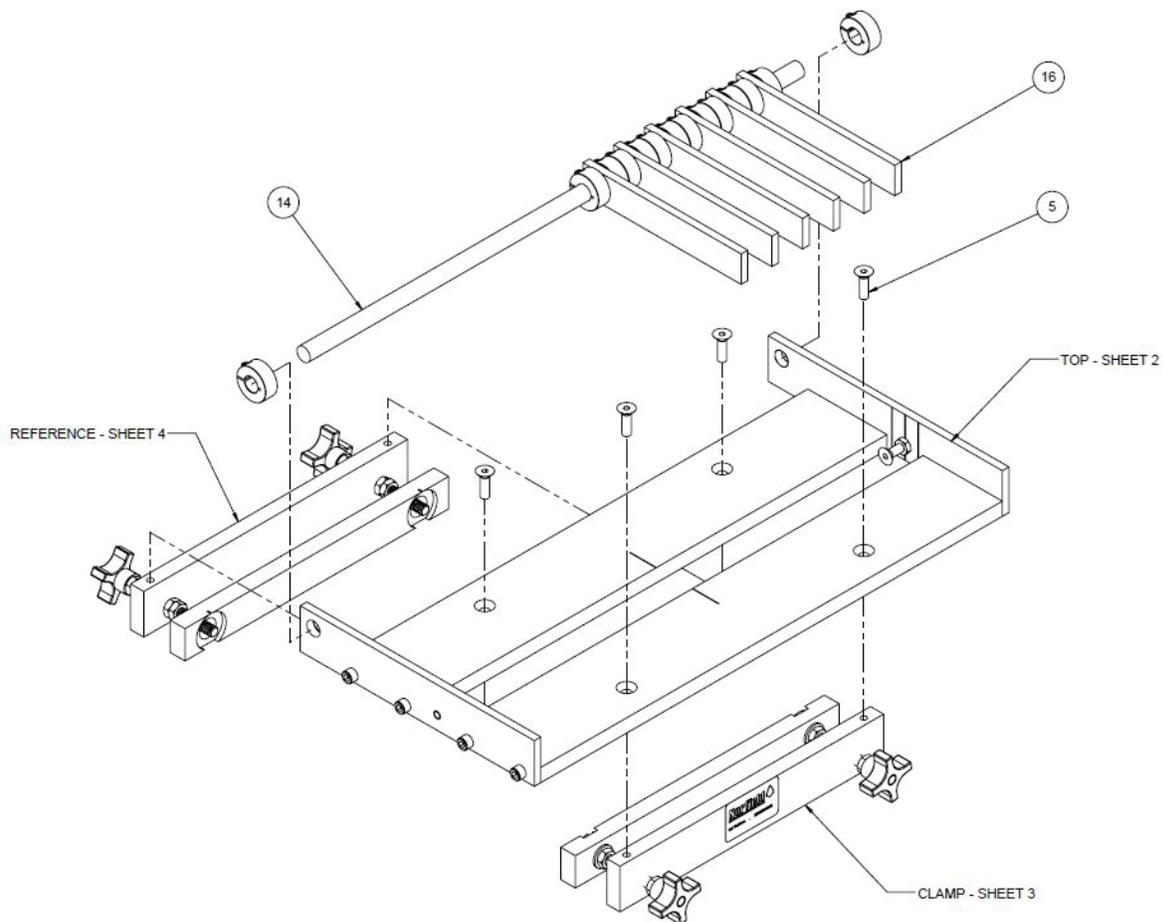
Mortise lengths are fully adjustable up to approximately 10", depending on router base diameter. The mortise length is determined by the router base contacting the stop arms. Set collars are provided to position the stop arms (3 sets) for different length mortises. End stop bolts are also provided for a fourth set of stops.

C. Cutting depth

Use the plunge stop features on the router to preset plunge depths for the various mortise depths.

4. OPERATION

Clamp fixture to the edge of the door. Centerlines are provided for alignment purposes. Select the desired set of length stops and rotate them to the fixture surface. With the router motor off and the bit retracted, place the router base on the fixture. **CAUTION:** Care needs to be taken when starting the router motor; make sure that the bit does not grab the wood, which could cause injury or damage to the tool. When the motor has reached full speed, plunge the bit to the preset stop. On deep mortises use multiple smaller cuts instead of one big cut. **CAUTION:** Let the router motor come to a complete stop before removing from the tool. This will prevent injury or damage to the tool. Additional pockets can be made using the different length stops and repeating the above procedure.



Diag#	Part#	Description	Qty	Diag#	Part#	Description	Qty
1	*****	1/4-20 x 5/8" SHCS	8	11	7703-002	PM End Plate	1
2	*****	1/4-20 Hex Jam Nut	2	12	7703-003	PM End Plate	1
3	*****	1/4-20 x 1" FHCS	2	13	7703-004	PM Side Plate	2
4	*****	5/16-18 Hex Jam Nut	16	14	7703-005	Stop Rod	1
5	*****	1/4-20 x 7/8" FH Cap Screw	4	15	7703-006	PM Clamp	2
6	*****	5/16" Flat Washer	4	16	7703-007	PM Stops	6
7	*****	1/2" Clamp Collar	14	17	8305-001	Label, Norfield	1
8	13-505	Knob	4	18	9510-350	5/16-18 x 3-1/2" Threaded Shaft	2
9	7572-004	Clamp Nut	2	19	9510-400	5/16-18 x 4" Threaded Stud	2
10	7703-001	PM Top Plate	2				

AS A REMINDER:

IMPORTANT SAFETY INSTRUCTIONS

WARNING: When using electric tools, basic precautions should be followed to reduce the risk of fire, electric shock and personal injury.

READ & FOLLOW ALL INSTRUCTIONS: This tool was designed for specific applications. Norfield Industries strongly recommends that this tool NOT be modified and/or used for applications other than those for which it was designed.

If you have any questions about additional applications or uses, DO NOT attempt those uses or modifications until you have been advised by a qualified Norfield Representative. Any and all modifications to or misuses of the tool will void all warranties.

A. Avoid dangerous environments

Do not expose equipment to rain or use in damp conditions.

Do not use tool in presence of flammable liquids or gases.

B. Dress properly

Do not wear loose clothing or jewelry. Loose clothing, drawstrings and jewelry can be caught in moving parts. Wear protective hair covering to contain long hair.

C. ALWAYS use safety glasses

D. Maintain machine tools properly

Keep cutters sharp and clean for better and safer performance.

Always use correct-size cutters.

Inspect all electrical cords periodically and replace if damaged.

E. Disconnect electrical supply cord

Always disconnect cord before servicing, cleaning, changing cutters or adding accessories.

F. Stay alert

Watch what you are doing. Use common sense. Do not operate equipment when you are tired or under the influence of medication, alcohol or drugs.

SAVE THESE INSTRUCTIONS