

VEVOR[®]

TOUGH TOOLS, HALF PRICE

Technical Support and E-Warranty Certificate

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MORTISING ATTACHMENT KIT

INSTRUCTIONS

MODEL:DPA65

We continue to be committed to provide you tools with competitive price.

"Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and does not necessarily mean to cover all categories of tools offered by us. You are kindly reminded to verify carefully when you are placing an order with us if you are actually saving half in comparison with the top major brands.

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NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

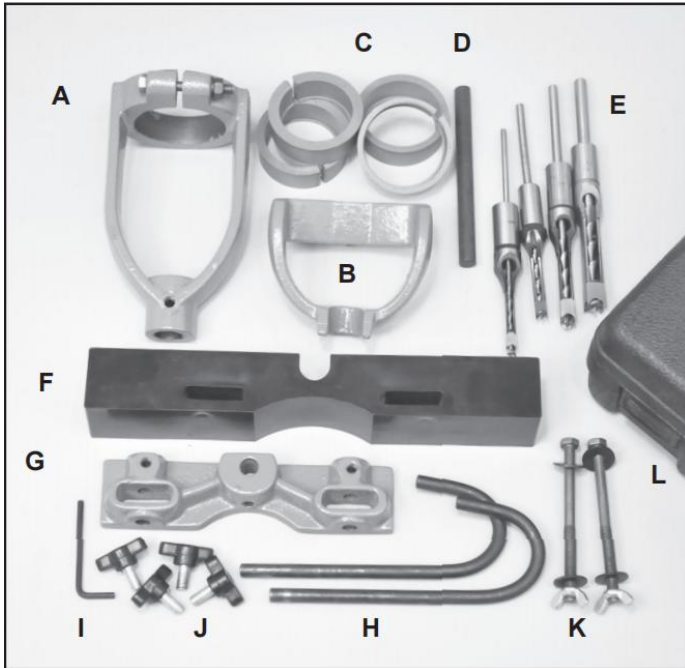
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This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

	<p>Warning-To reduce the risk of injury, user must read instructions manual carefully.</p>
	<p>This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions:(1)This device may not cause harmful interference, and (2)this device must accept any interference received, including interference that may cause undesired operation.</p>
 	<p>This product is subject to the provision of European Directive 2012/19/EC. The symbol showing a wheeled bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to a collection point for recycling electrical and electronic devices</p>

INTRODUCTION

- The Mortising Attachment converts your Drill Press in to an accurate mortising machine. It is ideal for drilling square holes for mortise & tenon joints that are commonly used in furniture, cabinets, sash, pattern shops and other woodworking plants.
- The Mortising Attachment Kit can be installed on most any drill press with a collar size of: 52.5mm, 55mm, 60mm, or 65mm.
- The name of the kit inventory.



- A. Chisel Holder Assembly *1
- B. Hold Down Bracke *1
- C. Bushings *4
- D. Hold Down Rod *1
- E. Chisels & Drill Bits (1/4, 5/8, 3/8, 1/2) *4
- F. Fence *1
- G. Rod Holding Casting *1
- H. Curved Guide Rods *1
- I. Hex Wrench 4mm *1
- J. Large Wing Nuts *4
- K. 5/16-18 x 4 Hex Bolts *2
Washers *4 Wing Nuts *2
- L. Carry Case with *1
- M. Instructions (not shown) *1



WARNING

THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ALL ADJUSTMENTS ARE COMPLETE.

INSTALLATION INSTRUCTIONS

● MOUNTING ON THE DRILL PRESS TABLE.

We recommend installing a 1/2" plywood panel 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. The plywood will prevent damage to the the mortising chisel and drill bit if it should strike the metal drill press table by accident. It is also a simple way to increase the size of the drill press table to hold your projects.

● MOUNTING THE CHISEL HOLDER.

1. Mount the Chisel Holder (A) onto, or just above the base of the Drill Press quill, with the holder's fastening bolt facing outward, away from the drill press column. For a proper fit, a Bushing (C) may be required to be inserted within the chisel holder's top collar.
2. Once installed, tighten the nut and bolt on the chisel holder to keep the attachment from slipping.

● Install mortise and tenon chisels and drill bits.

1. Four sizes of Hollow Chisel Mortising Chisels and Bits (E) are included with the kit - 1/4", 5/8", 3/8" and 1/2". Use only the correct combination of the chisels with their corresponding bit. These tools are supplied factory ground, and **MUST** be sharpened before use. If either one is dull, there will be excessive friction with heat build-up, which will make the drilling operation difficult and damage the tools. Consult woodworking books or magazine articles on the proper techniques to putting sharp edges on these items.

2. No bushings are required to install the drill bit shanks into the chisel holder's collar, as they both have the same diameter. The shank of the chisel will be held by the drill press keyed chuck, just as a normal drill bit would be held.

●INSTALLING THE BIT AND CHISEL.

1. Insert the drill bit through the chisel and into the drill press' keyed chuck. Hand tighten the chuck only.
2. Insert the chisel into the chisel holder, and secure it in place with the wing nut. NOTE: Clamp the chisel so that its shoulder is about 1/32" below the bottom of the holder.
3. Push the drill bit up into the drill chuck as far as it will go, and fasten it in place with the chuck key. The end of the drill bit should be up against the end of the square chisel.
4. Loosen the wing nut securing the chisel and move the chisel upward to take up the 1/32" space previously left in Step 2. Tighten the chisel in place. This method assures that there is proper clearance between the cutting lips of the drill bit and the points of the chisel.

When in use, the square chisel will cut into the wood, forcing the cut material inwards. The drill bit then cuts out the center of the hole and directs the chisel cut material up out of the hole in a single motion.

The Hex Bolts (K) supplied with the Kit are long enough to go through the hold down bracket, fence, plywood and drill press table. Insert the hex bolt through the slots in each. Use washers under the hex head bolt, and under the wing nut to distribute the holding pressure.

●ASSEMBLE THE HOLD DOWN BRACKE.

1. Insert the Hold Down Rod (D) into the center hole of the Rod Holding Casting (G), and secure it in place with the Hex Screw. A 4mm Hex Wrench (I) is supplied for this.
2. Slide the Hold Down Bracket (B) down onto the hold down rod. The hold down can be adjusted up and down on the rod as needed to apply slight pressure down onto your work that is being drilled. This bracket will keep your project held down when the mortising chisel & bit are released and

pulled out of the hole that they were drilling.

● **INSTALL THE CURVED GUIDE ROD.**

1. Insert the two Curved Guide Rods (H) into the horizontal holes that are on either side of the rod holding casting, and secure them in position with the supplied wing nuts.
2. The guide rods should be positioned on the front face of your work, so that they put pressure against the wood and push your project against the fence.



Schematic diagram of the finished assembly

●SET UP.

1. Place your work piece on the drill press table and adjust the table height so that the mortising chisel & bit are about 1/2" above the work.
2. Determine the depth of the mortise that you want to cut, and set the drill press depth stop to this distance.
3. Set the fence distance so that the chisel & bit are in the location that you want for drilling the mortise.

Mark your work piece with the exact location of the mortise(s) that need to be drilled.

Secure your work in place against the fence with the guide rods, and also with the hold down bracket.

Move the fence in or out until the chisel aligns perfectly with the mortise lines that are marked on your work.

Secure the fence in position with the two hex bolts that run through the casting, fence and drill press table.

●Operation.

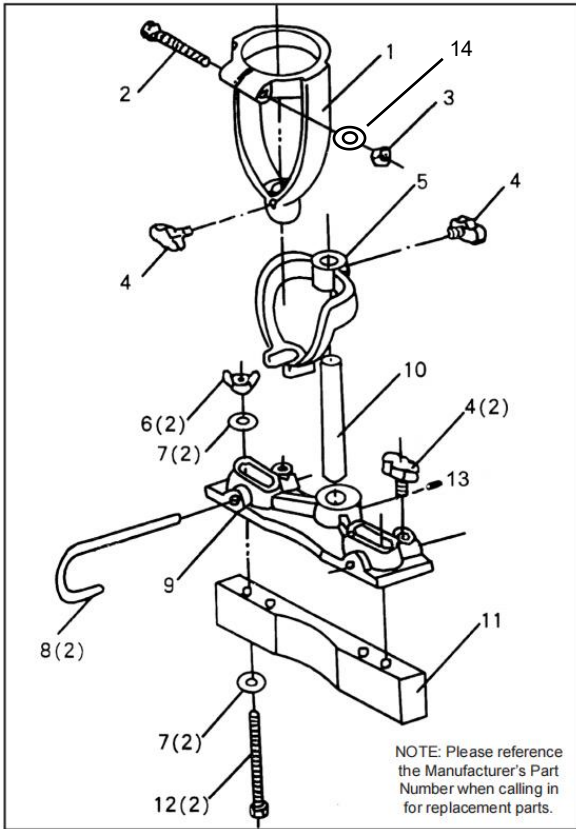
1. Best drill press speeds are between 650 to 1800 RPM.
2. Use lower speeds on hardwoods.
3. Make sure the chisel is square/parallel to the fence.
4. Test drill on scrap stock of the same woods of your project to set the mortising positions, and drill press speed.
5. First cut the outside, ends of the mortise, then make overlapping cuts between the two to finish the mortise.
6. Raise the chisel often to clear chips and prevent clogging.



WARNING

KNOW YOUR POWER TOOL. Read your Drill Press' manual to learn the tool's operation, applications, capabilities and its specific potential safety hazards.

●Exploded view of the product part.



●PARTS LIST.

KEY NO	DESCRIPTION	KEY NO	DESCRIPTION
1	Chisel Holder	2	5/16-18 x 2-1/2" Bolt
3	5/16-18 Hex Nut	4	Wing Nut with Treaded Stud
5	Hold Down Bracket	6	5/16-18 Wing Nut
7	Washer	8	Curved Guide Rods
9	Rod Holding Casting	10	Hold Down Steel Rod
11	Fence	12	5/16-18 x 4" Bolt
13	Hex Screw	14	Washer
15	Chisels & Drill Bits (1/4, 5/8, 3/8, 1/2) *4 (not shown)		

CALIFORNIA PROPOSITION 65 WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

Note: Specifications, photos, drawings, and information in this book manual represents the current model at the time the manual was written. Changes and improvements may be made at any time without obligation. Modification of previously delivered units by VEVOR.



Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local amenity tip and place into the appropriate recycling bin.



Only for EU countries

**Do not dispose of electric tools together with household waste material!
In observance of European Directive 2002/96/EC on waste electrical and electronic equipment and its implementation in accordance with national law, electric tools that have reached the end of their life must be collected separately and returned to an environmentally compatible recycling facility.**

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