

## No. 976 MORTISING ATTACHMENT For 14" Delta and 11" Homecraft Drill Presses

The Mortising Attachment is an accessory which converts 14" and 11" Drill Presses into accurate mortising machines. It is therefore a handy accessory for use in sash, cabinet and furniture factories, pattern shops and other woodworking plants.

Under the item No. 976 the customer receives the chisel holder, base, fence and holddown bracket shown mounted on a drill press in Fig. 1. Hollow chisels, bits and bushings are not included with the attachment; these tools are available in various sizes and must be ordered separately.

Refer to Fig. 2 and Table 1 to identify the parts mentioned in the following instructions.

### TO BE USED WITH No. 974 SPINDLE

This mortising attachment is designed for use with the No. 974 spindle, which has a  $\frac{1}{2}$ -inch hole to receive round shank bits. It is the spindle commonly used for router bits, and will fit the 11" as well as the 14" drill press. This spindle may be purchased as an alternate spindle for either of these machines.

### INSTALLING SPINDLE IN 14" DRILL PRESS

To remove the spindle which is in the machine, move the table down to its lowest position or to one side. Run the quill down until the drive collar DP-250-S at the upper end of the quill is visible through the opening in the front of the head casting. Clamp the quill, release the hexagon socket set screw SP-201, and pull the spindle out of the quill.

Install the No. 974 spindle, pushing it up into the quill and through the bearing drive collar DP-250-S. Rotate the spindle to enter the splines into the pulley. Be sure that the drive pin in the collar at the lower end of the spindle engages the notches of the lower quill bearing. When the spindle has been pushed up as far as possible, press the drive collar DP-250-S down, similarly to engage the notches of the upper quill bearing, and tighten the set screw SP-201. Be careful to engage the set screw against the solid surface of the spindle, not into one of the spline grooves which would be damaged. Release the quill clamp and raise the quill to its usual top position.

### INSTALLING SPINDLE IN 11" DRILL PRESS

To remove the spindle, run the quill down until the set collar HDP-107-S above the quill is accessible through the opening in the front of the head casting. Clamp the quill in this position. While holding the spindle to avoid dropping it, release the set screw SP-201 to loosen the set collar. Swing the table to one side and raise the quill to the top of its stroke; there will be plenty of clearance for lowering the spindle out of the bearings.

Reverse the above procedure when installing the No. 974 spindle, observing these precautions: Be sure that the spindle is passed through the fiber washer DSS-77 and the set collar HDP-107-S as the upper end comes through the quill. Rotate the spindle to enter the splines into the pulley. Tighten the set screw against the solid surface of the spindle, not into a spline groove, to avoid damage.

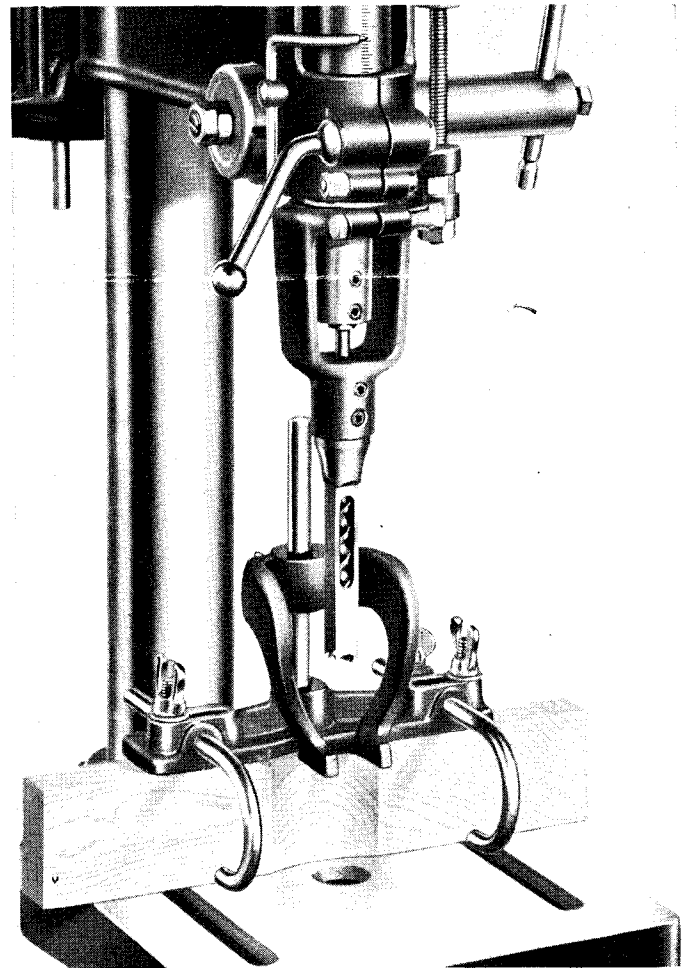


Fig. 1. Mortising Attachment No. 976 Mounted on Drill Press.

To eliminate all end play in the spindle, clamp the table at suitable height and lower the spindle against it with moderate pressure while clamping the quill. Push the set collar down against the quill while tightening the set screw. This method removes slack between thrust collar, thrust bearing and quill.