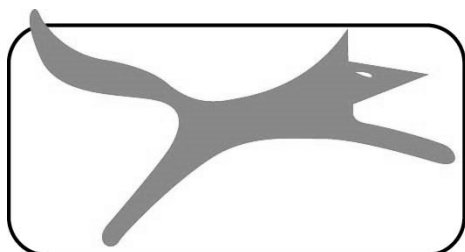


3/4" BENCH TOP MORTICER Model F14-651



ASSEMBLY AND OPERATING INSTRUCTIONS



FOX

3/4" Bench Top Morticer

FOX MODEL F14-651

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ATTENTION :

- Read the instructions for use carefully before using the machine
- This device meets current safety standards for electrical machines.
- Incorrect use may result in injury. Anyone not familiar with the instructions for use should not use the machine. Keep these instructions for use safe.

SAFETY INSTRUCTIONS

ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOCKET BEFORE ATTEMPTING ANY MAINTENANCE.



Keep a safe working zone for both staff and equipment. NO CHILDREN must be allowed in the working zone under any circumstance.

The machine must be always disconnected when not in use. Use the on/off switches on the machine. Always disconnect the machine by pulling the plug, do not pull the power cord.

Before using the machine, remove all tools used for setup and keep them away from your working zone. Reconnect the machine. Check that the working zone is clear and that there is plenty room to work with the wood.

Ensure you are in good working position. If the work will produce dust or small pieces, wear safety gear, protective glasses, gloves, a mask and ear defenders. If you have long hair, tie it up. Do not wear watches or bracelets. Wear shoes with good grip and remember to never place your fingers too near the blade.



Do not use the machine if you are tired or distracted because you risk injury.



Do not use this machine anywhere containing flammable liquids and/or volatile gases.

1. Keep your working area clean. Untidy working zones and busy workbenches invite injuries.
2. **Avoid** a dangerous environment. Do not expose machines to rain and not use them in wet places. Ensure your working zone is well lit. Do not use the machine where there is gas or flammable liquids.
3. **Protect yourself** from electric shocks. Avoid touching earthed surfaces.
4. **Keep** children and visitors well away from the working area.
5. **Tidy** up any tools not in use. When tools are not used, they should be kept in a dry, locked place, out of reach of children.
6. **Do not force** the machine. It will work better when used with the pressure it was designed for.
7. **Use** the correct tools. Do not force a small tool to do the work of a bigger tool. For example, do not use a circular saw to cut branches or logs.
8. **Wear** appropriate clothing. Avoid loose clothing, and remove jewellery which could become caught in moving parts.

- Non-slip shoes are particularly recommended when working outside. Keep long hair tied up.
9. **Always** wear safety glasses. Also wear a mask if operating the machine creates dust.
 10. **Do not** mistreat the power cord. Never use the power cord to pull out the plug. Keep the power cord away from heat, oil and sharp edges.
 11. **Do not** bend over the machine. Keep your balance at all times.
 12. **Keep** tools in good condition. Clean tools to obtain the best results with them. **Follow instructions** to grease and change accessories. Regularly check the power cord and replace it if damaged. Keep handles dry, clean and free from oil and grease.
 13. **Disconnect** the tool when not in use, before the maintenance and while changing accessories such as blades, drills, etc.
 14. **Remove** all maintenance tools. Get used to checking that all maintenance tools are removed before using the machine.
 15. **Avoid** accidentally starting the machine. Make sure that the switch is in the "OFF" position before connecting the power.
 16. **If** the machine is used outside, use only extension leads designed for outdoor use.
 17. **Be observant.** Use common sense when operating machinery. Do not use the tool when tired.
 18. **Inspect** parts before use. Before continuing to use the tool, inspect any protective parts) which could be damaged to make sure that they work well. Verify that the moving parts are properly aligned, and are not jammed or broken. Check the assembly and any other conditions which may affect the correct functioning of the machine. Any damaged part or guard must be repaired or replaced by an approved after-sales service centre. Do not use the tool if the switch does not work correctly.
 19. **Warning:** the use of any non-recommended accessory can present a health risk.
 20. **Have the machine repaired** by a qualified person. This machine is built according to relevant safety requirements. Repairs must only be made by a qualified person using original spare parts, otherwise it may be very dangerous for the user.
 21. **Keep these instructions safe.**

SPECIFIC SAFETY INSTRUCTIONS FOR MORTICERS

1. **Do not operate this machine** until it is assembled and installed according to the instructions.
2. **Obtain advice** from a qualified person if you are not familiar with the operation of this machine.
3. **Follow** all wiring codes and recommended electrical connections.
4. **Make certain** the machine is fastened to a supporting surface to prevent it from tipping over during operation.
5. **Never** turn the morticer on before clearing the table of all objects (tools, scrap pieces, etc.).
6. **Always** keep hands, fingers and hair away from the rotating bit.
7. **Do not** attempt to mortise material that does not have a flat surface, unless a suitable support is used.
8. **Always** position the clamp directly over the workpiece to prevent the workpiece from lifting during operation.
9. **Always** support the workpiece securely against the fence to prevent rotation.
10. **Be sure** the drill bit is sharp, not damaged and properly secured in the chuck before operation.
11. **Make sure** the chuck key is removed before starting the machine.
12. **Never** turn on the power with the drill bit or chisel in contact with the workpiece.
13. **Never** perform layout, assembly or set-up work on the table while the morticer is operating.
14. **Adjust** the depth stop to avoid drilling into the table.
15. **Always** turn off the power before removing scrap pieces from the table.
16. **Shut off** the power, remove the drill bit and chisel and clean the table before leaving the machine.
17. **For your own safety**, do not wear gloves when operating the machine.
18. **Should** any part of your tool be missing, damaged or fail in any way, or any electrical component fail to perform properly, shut off the machine and remove the plug from the power supply outlet. Replace missing, damaged or failed parts before resuming operation.
19. **The use** of attachments and accessories not recommended by ourselves may result in the risk of injuries.
20. **Turn** the machine off and disconnect it from the power supply before installing or removing accessories, before adjusting or changing set-ups or when making repairs.
21. **Turn** the machine off, disconnect it from the power supply and clean the table and work area before leaving the machine. Lock the switch in the "Off" position to prevent unauthorised use.
22. **Keep these instructions safe.**

SPECIFICATIONS

Motor :	370W – 240V
Spindle speed :	1400rpm
Max mortising depth :	76mm
Chisel capacity :	6-12mm
Drill chuck capacity :	1-13mm
Table size :	340x150mm
Spindle to fence (max) :	65mm
Chisel to table (max) :	210mm
Turn headstock :	0-360°
Dimensions (h x l x d) :	760x370x260mm
Weight :	31kg

ELECTRICAL CONNECTIONS

EXTENSION CORDS

Before using an extension cord, ensure the insulation is not cut or worn. Immediately repair or replace a damaged or frayed cord.



ATTENTION :

Extension cords must be removed from the work area or located so that they will not get caught in parts, tools or other objects while using the tool.

This appliance must be grounded. If it should malfunction or break down while in use, grounding provides a path of least resistance for the electrical current and reduces the risk of electrical shock to the operator. This appliance has a power cord with equipment-grounding conductor and grounding plug. The plug must be inserted into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a qualified electrician or service person if you are in doubt as to whether the outlet is properly grounded.

Do not modify the plug provided with the machine. If it will not fit the outlet, have a proper outlet installed by a qualified electrician.

ENVIRONMENTAL PROTECTION

INFORMATION FOR USERS

In accordance with art. 13 of Legislative Decree 25th July 2005, no. 151 "Implementation of Directives 2002/95/EEC, 2002/96/EEC and 2003/108/EEC, relative to reducing the use of hazardous substances in electric and electronic appliances and the disposal of waste", please take note of the following:

- The crossed out wheellie bin symbol found on the appliance or the packaging indicates that the product must be disposed separately from ordinary household waste when it reaches the end of its working life.
- The user must consign the unwanted appliance to an authorised waste disposal centre for electric and electronic goods, or alternatively, hand it over to the relative dealer at the moment of purchasing a new appliance of the same type on a basis of a one to one ratio.
- Differentiated disposal to enable possible recycling or environmentally compatible elimination of the appliance, helps to limit undesirable effects on health and environment and promotes the reuse and/or recycling of the materials that compose the appliance.

WARNING!

In accordance with the relative legislation in force in the country of use, sanctions will be imposed on the user if the appliance is disposed of illegally.



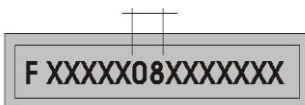
SYMBOLS



Read the instruction manual carefully



Use personal protection devices
(goggles, dust mask, earphones)



Serial number / year of production

UNPACKING AND CLEANING

Unpack your morticer carefully, taking care with the loose parts.

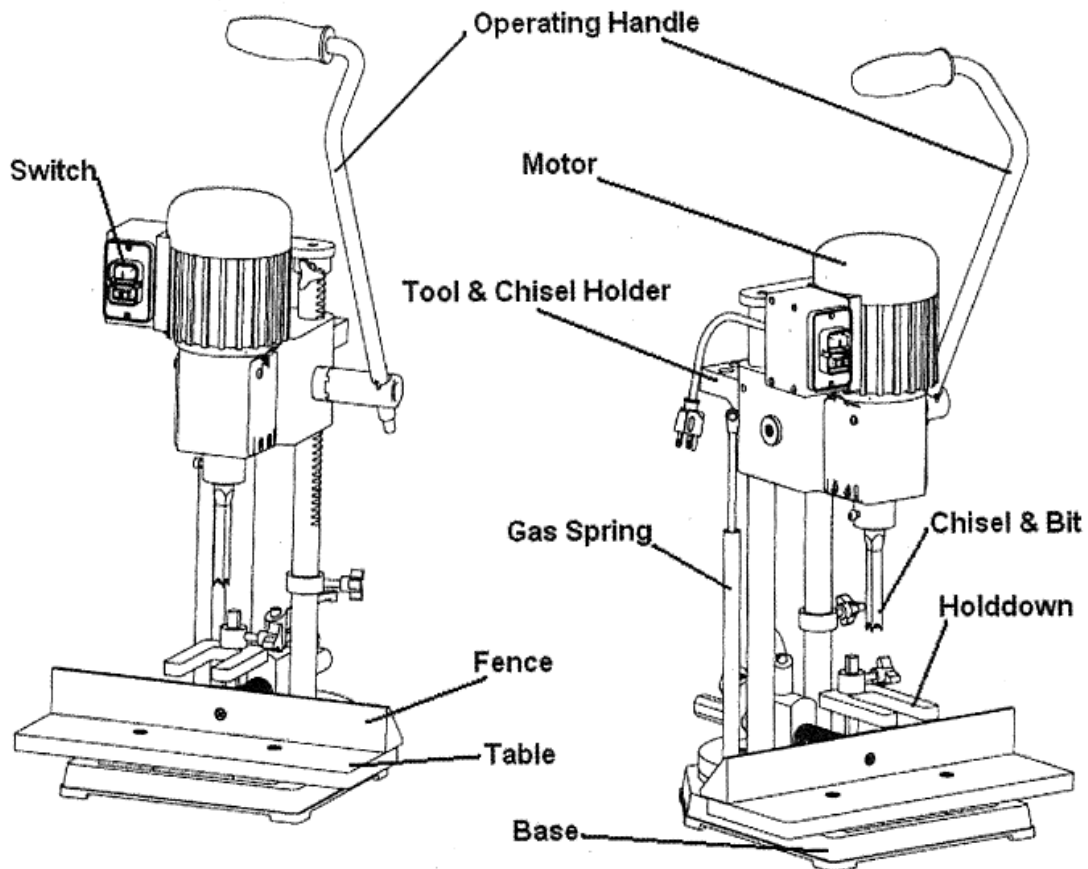
Note : if any parts are damaged or missing, do not connect the machine to the power and do not switch it on until the missing/damaged parts are replaced.

Do not throw away the cardboard box until you are sure the machine is working correctly.

Remove the protective coating from all unpainted surfaces. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the unpainted surfaces with a good quality household floor paste wax.

Note: all illustrations are representative only and may not depict the actual labelling or accessories and may be intended to illustrate technique only.

KNOW YOUR MORTICER



SETTING UP THE MORTICER

Warning! For your own safety, do not connect the machine to the power source until the machine is completely assembled and you have read and understood the entire instruction manual.

Caution: the morticer represents a heavy load that must be lifted from the bottom. Seek assistance before beginning assembly.

Mounting

The F14-651 Bench Top Morticer can be mounted to any workbench sturdy enough to support the combined weight of the machine and workpiece and which allows a comfortable working height. The bench should be located where plenty of working clearance exists for larger workpieces. The morticing machine must be bolted to the bench, and to help avoid a tipping hazard should be bolted away from the front edge. The morticing machine has a pivoting feature which allows the head and column assembly to pivot around the base. For this reason, the machine should be located near enough to one end of the bench top to allow morticing long workpieces.

1. Plan the placement of the morticer. Take measurements of the base and lay out a pencil drawing for the best location on the workbench.
2. Seek assistance and lift the morticing machine onto the workbench. Lift the morticing machine from its base only. Slide it over the pencil layout. Re-check for proper working clearance and adjust as necessary. The morticing machine may be secured with 5/16" lag bolts or through bolts with washers and nuts (not supplied).
3. Use the mounting holes in the base as drill guides and drill holes. Drill a 1/4" hole for 5/16" lag bolts. For through bolts drill a 5/16" hole.
4. Secure the base with the bolts.

Hand Lever

Attaching the hand lever requires the use of the 4 and 5mm Allen wrenches supplied.

1. Locate the shouldered bolt, clutch and small spring.
2. Insert the spring into the clutch and place the clutch on the hub.

3. Secure the spring and clutch using the shouldered bolt. Insert the bolt and tighten. Refer to Fig. 1 for the layout of the parts.
4. Loosen the setscrew securing the collar closest to the end of the hand lever and remove the collar.
5. Insert the end of the hand lever into the smaller slot in the clutch. Slide the collar back onto the end of the hand lever and secure by tightening the setscrew. The lower collar should be set below the clutch by 1" to allow working clearances when the lever is swung out for indexing.

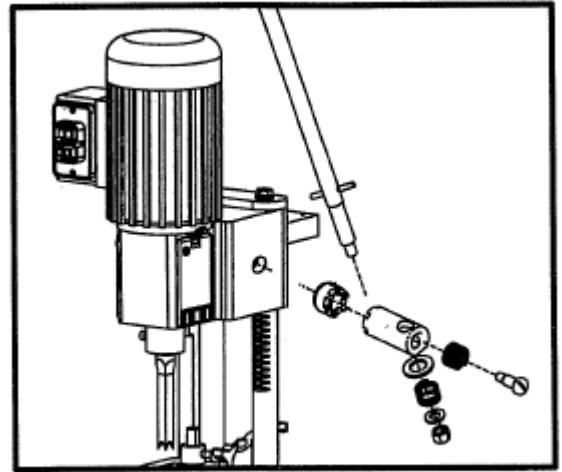


Fig.1

The hand lever can be adjusted for height by moving both of the collars up or down. Adjust these collars to accommodate the most comfortable height for operation.

Gas Spring

The gas spring can be secured to three different locations along the side or back of the left column. Each location offers a different range of motion for the morticing head. In the instructions below, we will cover only the side location. Further explanation will follow in the adjustments section.

Caution: position depth stop to touch the table and secure with lock knob before indexing the hand lever. The head may drop suddenly, causing injury.

1. Adjust the depth stop lever until it touches the table surface.
2. Lift the head using the hand lever. If necessary, index the lever (Fig. 2) to make multiple turns of the hub so the head moves to its highest elevation. Be sure to position the depth stop rod so that it touches the base of the machine and lock it in place before indexing the handle. This ensures the weight of the head casting is supported while adjustments are made.

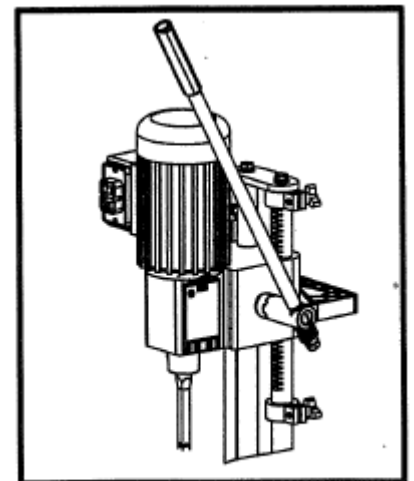


Fig.2

3. The gas spring ends snap into place over the ball-end junction. It may be necessary to compress the gas spring slightly to align the sockets in the gas spring with the ball-end junction. See Fig. 3.

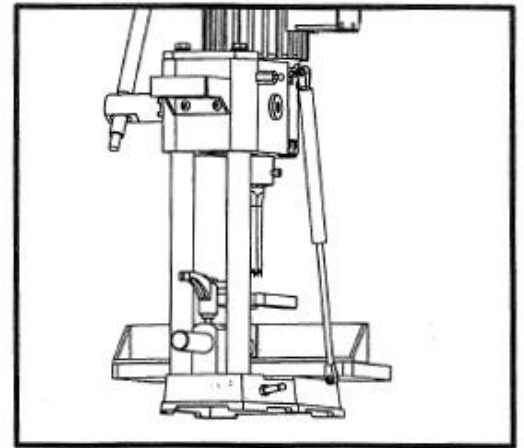


Fig.3

Work Table

1. Secure the wooden work table with the two Phillips head screws provided. See Fig. 4.

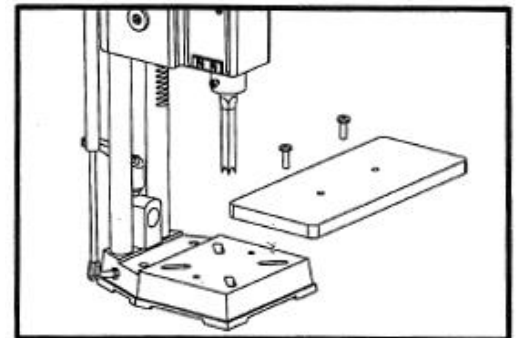


Fig.4

Fence

1. The fence comes with a micro-adjustable stop attached to the fence support rod, which retains a spring. Loosen the setscrew with the 4mm provided and remove the stop but not the spring.
2. Slide the support rod into the mounting block located between the columns.
3. Replace the micro-adjustable stop and secure with setscrew. See Fig. 5.

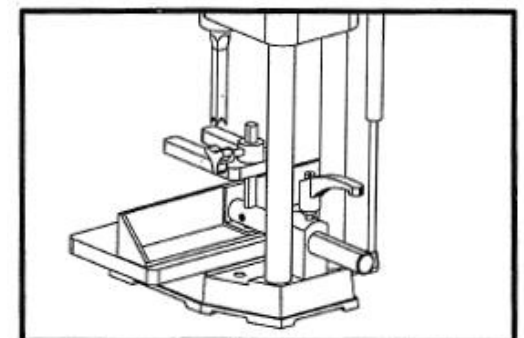


Fig.5

Hold Down

The hold down acts as a clamp, holding the workpiece to the table surface. This helps to keep the workpiece from raising when extracting the chisel after a cut is made. The hold down must be used.

1. Support the head with the hand lever and unlock the depth stop lock knob. Allow the depth stop rod to touch the base surface and secure the rod in place.
2. The hold down support rod has a flat portion along its length. Place the completely round portion into the fence. Do not tighten the screw in the fence at this time.
3. The hold down bracket may be placed on the support rod in two positions. If placed on the support rod, the bracket will hold down a workpiece slightly taller than the fence. When placed in the position shown in Fig. 6, the bracket will hold down a workpiece that measures $3/8$ " less than the height of the support rod.

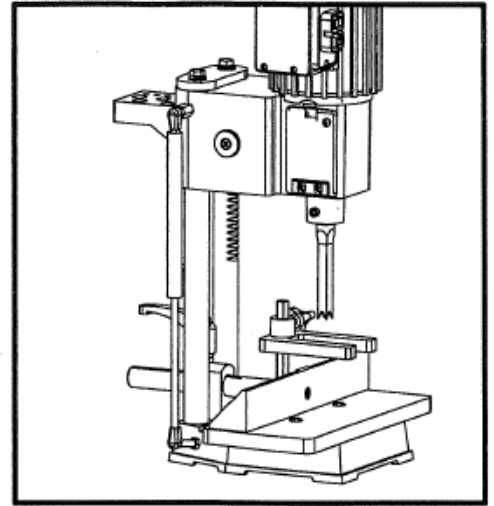


Fig.6

Warning! Always unplug the mortising machine before changing chisels. Failure to do so may result in serious personal injury.

Installing chisels

Select the size needed for your project and follow the instructions below.

1. Support the head with the hand lever and unlock the depth stop lock knob. Allow the depth stop rod to touch the base surface and secure the rod in place.
2. Remove the hold down bracket from the support rod and move the fence to the back edge of the worktable.
3. Protect your hands. Use gloves or wrap a shop towel around the sharp end of the chisel.
4. Slide the end of the chisel housing into the bushing located just under the chuck. Make sure the opening in the chisel face is away from the operator.
5. Tighten the cap screw to the side of the chisel mount with the 5mm Allen wrench provided.
6. Tighten the drill bit into the drill chuck with the chuck key provided. Make sure the drilling end of the drill bit is positioned just outside the end of the chisel housing.
7. Place a straight, tall board against the fence and adjust the fence until the board touches the back edge of the chisel. Tighten the lock handle for the fence.
8. Loosen the cap screw holding the chisel housing and rotate the chisel until the back surface is parallel with the board. Tighten the cap screw.

ADJUSTMENTS

Gas Spring Locations

The gas spring can be positioned in one of three locations to allow clearance for different board thicknesses or to mortise a board on edge. Using your 3/8" chisel you can drill 76mm board at most.

Gas Spring Placement

Swinging the handle out will cause the head casting to fall when the gas spring is removed. The gas spring supports the weight of the head casting and the hand lever regulates its height. However, if the handle is pulled while the gas spring is removed, the head will drop suddenly. Please read the caution below.

CAUTION: position the depth stop rod to touch the table and secure with the lock knob before removing the gas spring. The head may drop suddenly, causing injury.

Upon determining which location the gas spring is to be placed, follow the instructions below.

1. Support the head with the hand lever and unlock the depth stop lock knob. Allow the depth stop rod to touch the base surface and secure the depth stop rod in place.
2. The gas spring ends will snap off of the ball-end junctions. Remove the gas spring.
3. Snap the gas spring into place over the desired ball-end junction locations. It may be necessary to compress gas spring slightly or to further lift or lower the head using the handle to align the sockets in the gas spring with the ball-end junctions.

Pivot Feature

The head and column assembly can be adjusted for morticing off of the base. This will allow the morticing machine to accommodate a larger workpiece than those previously listed.

To change the position of the head and column assembly:

1. Support the head with the hand lever and unlock the depth stop lock knob. Allow the depth stop rod to touch the base surface and secure the rod in place.
2. Loosen the two hex nuts in the pivoting base.
3. Rotate the assembly to the desired angle.

4. Tighten the hex nuts.
5. The worktable should be removed before operating the machine.

Secure the workpiece with clamps before using the machine. See Fig. 7.

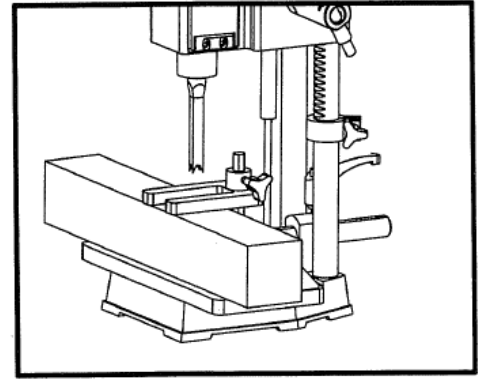


Fig.7

Fence Adjustments

The fence is supplied with a fine adjusting assembly, a spring and a collar. These enable centring of the chisel to the workpiece quickly and accurately.

1. Support the head with the hand lever and unlock the depth stop lock knob. Allow the depth stop rod to touch the base surface and secure the rod in place.
2. Loosen the locking lever for the fence.
3. Use a pencil to mark the mortice on the workpiece.
4. Install the morticing chisel with the drill bit. The drill bit must be positioned so the end extends beyond the chisel body for proper chip clearance.
5. Place the workpiece against the fence and position the fence so the chisel is near the pencilled mark. Lock the fence.
6. Loosen the setscrew holding the micro-adjustment block on the fence mounting rod and move the block until the screw fits into the back of the support block.
7. Unlock the fence and rotate the micro-adjustable knob until the chisel lines up with the pencilled in lines.

Wider Stock

1. Remove the morticing chisel and drill bit.
2. Loosen and remove the two hex nuts on the top of the pivot base.
3. Carefully lift the head stock assembly until the pivot base clears the locking studs. Lay the assembly on its side on the workbench.
4. Remove the three cap screws holding the support block to the pivot base. Loosen the two screws, then you can rotate the head to the position you want.
5. Re-position the support block to position B.
6. Re-attach the support block with the three cap screws.

Test Run

Once assembly is complete and adjustments are done to your satisfaction, you are ready to test run the machine.

WARNING! Always wear safety glasses when operating this morticing machine. Failure to comply may result in serious personal injury.

Make sure the starting switch is off. The paddle is down for off. Make sure all the fasteners and lock handles are tight. Plug in the power cord. Pull the START paddle. Make sure that your finger is poised over the paddle just in case there is a problem. The morticing machine should run smoothly, with little or no vibration or rubbing noise. Normally there is some noise generated by the drill bit turning inside the chisel. If noise is excessive, it is likely the drill bit needs to be lowered a little inside the chisel. Any strange or unnatural noises require you to stop the machine, wait for it to stop moving, unplug the machine, investigate and correct the problem before further operation.

WARNING! DO NOT attempt to investigate or adjust the machine while it is running. Wait until the machine is turned off, unplugged and all moving parts have come to a stop before proceeding.

MACHINE OPERATION

1. Support the head with the hand lever and unlock the depth stop lock knob. Allow the depth stop rod to touch the base surface and secure the rod in place.
2. Check the set-up of the morticing machine to ensure the head height and range of motion is sufficient. Also, check fasteners and locks.
3. Adjust the depth stop rod to correct depth for producing blind mortices. In Fig. 8, the head is lowered so the chisel rests on the workpiece. The depth stop rod is adjusted using a measuring tape to the desired depth. The chisel is lowered until the chisel is even with a depth line on the workpiece. The fence is adjusted before and after the depth stop is locked.

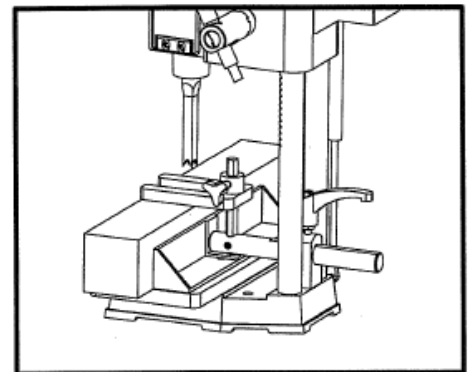


Fig.8

CAUTION: The chisel will become hot during operation. Use gloves or wait until the chisel has cooled before removing. Serious personal injury may occur.

4. Carefully mark the outline of the mortice on the workpiece. Align the fence and workpiece so the chisel aligns with the markings. See section on Fence Adjustments. A sacrificial board should be used under the workpiece whenever through holes are produced, to minimise tear out and protect the worktable.
5. Test the positioning setup with a piece of scrap lumber of the same dimensions as the workpiece. Position the hold down on top of the workpiece and secure with the cap screw. Do not mortice without a hold down.
6. Turn the power ON.

7. Lower the head by pulling the hand lever down with your right hand. Be sure not to feed the chisel too fast or too slow. Feeding too fast can cause the drill bit to clog with chips causing the motor to slow down and overheat. Feeding too slow may cause excessive heat, ruining the chisel. However, it is normal for some discolouring of the chisel to occur due to heat generated during use.
8. When the desired depth is achieved, move the hand lever back to its original position. The workpiece should remain in place while this is done.
9. Check the placement of the hole on the test piece and adjust the fence if necessary. Continue with the actual workpiece when the desired accuracy of placement is achieved.
10. When making rectangular mortises, we recommend you follow the sequence of cuts. Please note that cuts 5, 6 and 7 will only use a portion of the chisel and so the chisel should be positioned over the centre of each space.

MAINTENANCE

General

WARNING! Disconnect power to the machine when performing any maintenance or repairs. Failure to do this may result in serious personal injury.

Regular periodic maintenance on your morticing machine will ensure its optimum performance. Make a habit of inspecting the machine each time you use it. Check for the following conditions and repair or replace when necessary.

1. Loose mounting bolts
2. Worn switch
3. Worn or damaged cords and plugs
4. Any other condition that could hamper the safe operation of this machine

Fence and Chisels

The cast iron fence and steel chisels/bits can be kept rust-free with regular applications of products like Boeshield T-9. For long term storage, you may want to consider products like Kleen Bore's Rust Guardit.

Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. Do not lubricate them.

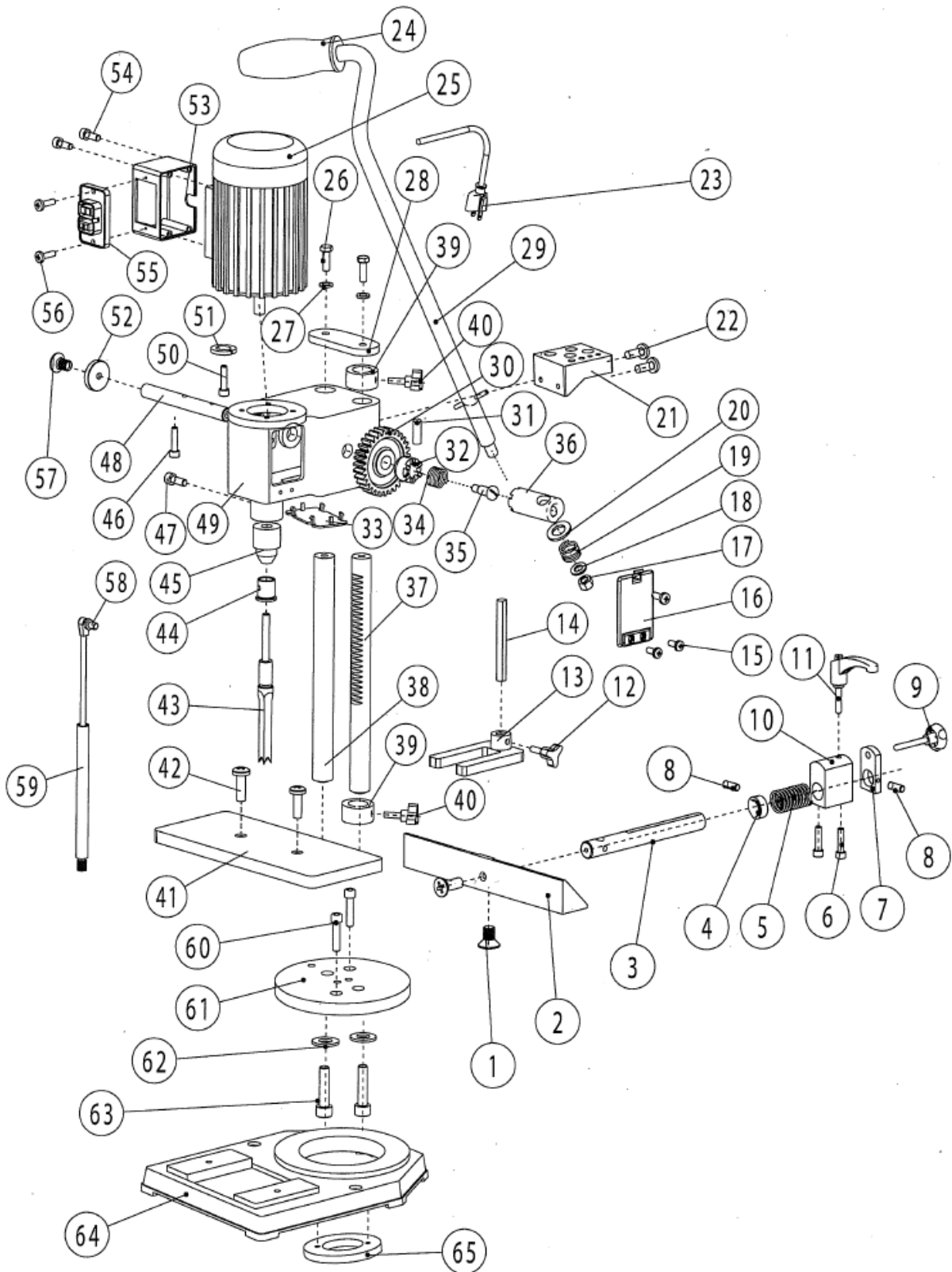
For other items on this machine, such as the gear, base and columns, an occasional application of light machine oil is all this is necessary. Before applying lubricant, clean off sawdust and wood chips.

Your goal is to achieve adequate lubrication. Too much lubrication will attract dirt and sawdust. Various parts of your machine could lose their freedom of movement as a result.

Lubricating Drill Bits

The drill bits for morticing chisels operate under extreme conditions. A small amount of beeswax applied to the drill bit can aid in reducing heat and expelling chips. It is important that a small amount is used and none is applied to the chisel. Beeswax surfaces will impede the adhesion of glues and finishes.

PARTS DIAGRAM



PARTS LIST

Part NO.	DESCRIPTION	Q'TY	Part NO.	DESCRIPTION	Q'TY
1	Lock Washer	2	34	Spring	1
2	Fence	2	35	Screw	1
3	Guide Column	1	36	Connecting Bend B	1
4	Collar	1	37	Gear Column	1
5	Spring	1	38	Guide Column	1
6	Screw	1	39	Depth Set Guide	2
7	Stop Bracket	1	40	Lock Handel	2
8	Screw	2	41	Wood Table	1
9	Screw	1	42	Screw	2
10	Guide Bracket	1	43	Chisel	1
11	Lock Handle	1	44	Chisel Bushing	1
12	Knob	1	45	Chuck	1
13	Hold Down Clamp	1	46	Screw	1
14	Guide Column	1	47	Screw	1
15	Screw	6	48	Gear Shaft	1
16	Cover	2	49	Gear Casing	1
17	Nut	1	50	Screw	4
18	Washer	1	51	Lock Washer	4
19	Spring	1	52	Cover	1
20	Washer	1	53	Switch Box	1
21	Tool Rack	1	54	Screw	4
22	Screw	2	55	Switch	1
23	Power Cord	1	56	Screw	2
24	Handel Gloves	1	57	Screw	1
25	Motor	1	58	Screw	1
26	Bolt	2	59	Gas Spring	1
27	Lock Washer	2	60	Cap Screw	2
28	Step Plate	1	61	Rotary Table Top	1
29	Handle	1	62	Washer	2
30	Gear	1	63	Hex Bolt	2
31	Pin	1	64	Base	1
32	Connecting Bend A	1	65	Plate	1
33	Cover	1	66		

DART TOOL GROUP GUARANTEE

DART TOOL GROUP takes pride in the quality of the power tools it supplies. The component parts of our tools are inspected at various stages of production and each finished tool is subjected to a final check before being packaged for shipment. Because of our confidence in our engineering quality, DART TOOL GROUP agrees to repair or replace any part or parts of FOX Power Tools and accessories which, upon examination, prove to be defective in workmanship or material. The warranty period for the FOX branded products is one year for parts and labour and three years for parts only. The guarantee does not include repair, labour or parts requiring replacement because of misuse, abuse, or normal wear and tear. Repairs made by other than the factory, DART TOOL GROUP service centre or authorised FOX service dealers relieves DART TOOL GROUP of further liability under this guarantee. THIS GUARANTEE IS MADE EXPRESSLY IN PLACE OF ALL OTHER GUARANTEES OR WARRANTIES, EXPRESSED OR IMPLIED, WITH RESPECT TO QUALITY, MERCHANTABILITY, OR FITNESS FOR A PARTICULAR PURPOSE.



CE DECLARATION OF CONFORMITY OF THE MANUFACTURER
SERRACON

WHEATFIELD ROAD

DUNNIKIER BUSINESS PARK

KIRKCALDY, UK, KY1 3PD

Tel. +44 (0) 1592 652946 Fax: +44 (0) 1592 654854

Declares that the: 3/4" BENCH TOP MORTICER (F14-651)

is in compliance with the regulations included in the Directives: CEE 2006/42-2004/108-2006/95

Person authorized to create the technical file: **Robert Paterson**



06.05.2011

The Director

Robert Paterson