

HOLLOW CHISEL MORTISER OPERATING AND MAINTENANCE INSTRUCTIONS

SPECIFICATIONS

Capacity	1/4" to 1"
Chisel Stroke Max.	4"
Max. Distance between Chisel and Table	15"
Max. Distance between Chisel Center and Fence	4-1/8"
Table Size	6" x 36"
Vertical Adjustment of Table	12"
Longitudinal Travel of Table	12"
Cross Adjustment of Table	4-1/2"
Table Tilts Both Sides	45°
Clamping Width	6"
Totally Enclosed Motor	3600 Rpm
Net Weight	875 lb
Shipping Weight	1050 lb

EQUIPMENT INCLUDED WITH THE MACHINE

The mortiser is equipped with a 1-1/2 H.P., completely enclosed motor, mounted integral on the machine, 3 phase, 208/220, 440 or 550 volts, 60 cycles, 3600 Rpm.

Magnetic starter and start-stop push button station.

- 1- 3/8" Chisel and Bit — 4" Blade
- 2- Chisel Bushings and Wrenches

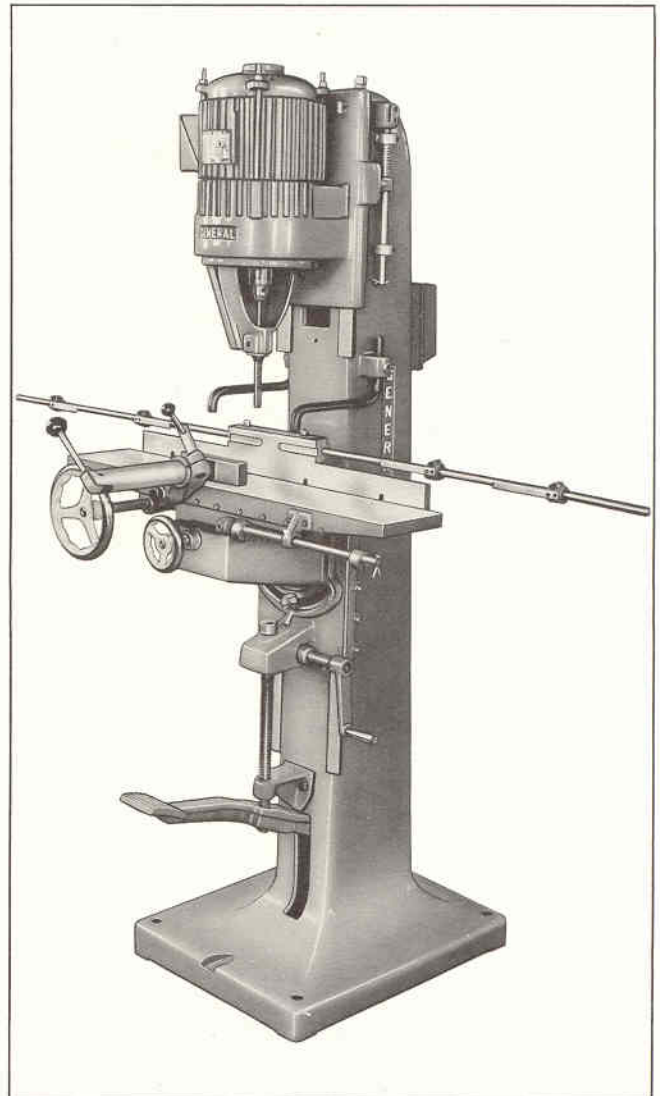
OPTIONAL EQUIPMENT

6 ft. Layout rod with 4 adjustable stops.

Hollow Chisel & Bit:

1/4" x 4"	5/8" x 4"
5/16" x 4"	3/4" x 4"
3/8" x 4"	7/8" x 4"
7/16" x 4"	1" x 4"
1/2" x 4"	

The General Hollow Chisel Mortiser is a well designed, efficient and sturdily built machine which gives high quality work, it is well adapted for use in Vocational Training Schools and in all kinds of woodworking plants such as sash and door shops, furniture factories, etc. This machine can be quickly converted into a single borer, thus serving two purposes. It has been carefully tested and inspected before shipment. However, it is imperative that you take a few moments to read and familiarize yourself with these instructions and they will probably save you a lot of time and trouble.



INSTALLATION

The machine is shipped in a wooden crate and wrapped with waterproof paper. All machined surfaces are covered with special grease to prevent rusting. This protective covering should be removed with "Varsol" or similar product but do not use paint solvent as it will damage the finish.

GENERAL MFG. CO. LTD
DRUMMONDVILLE, QUE.

No. 220 MORTISER OUTLINE

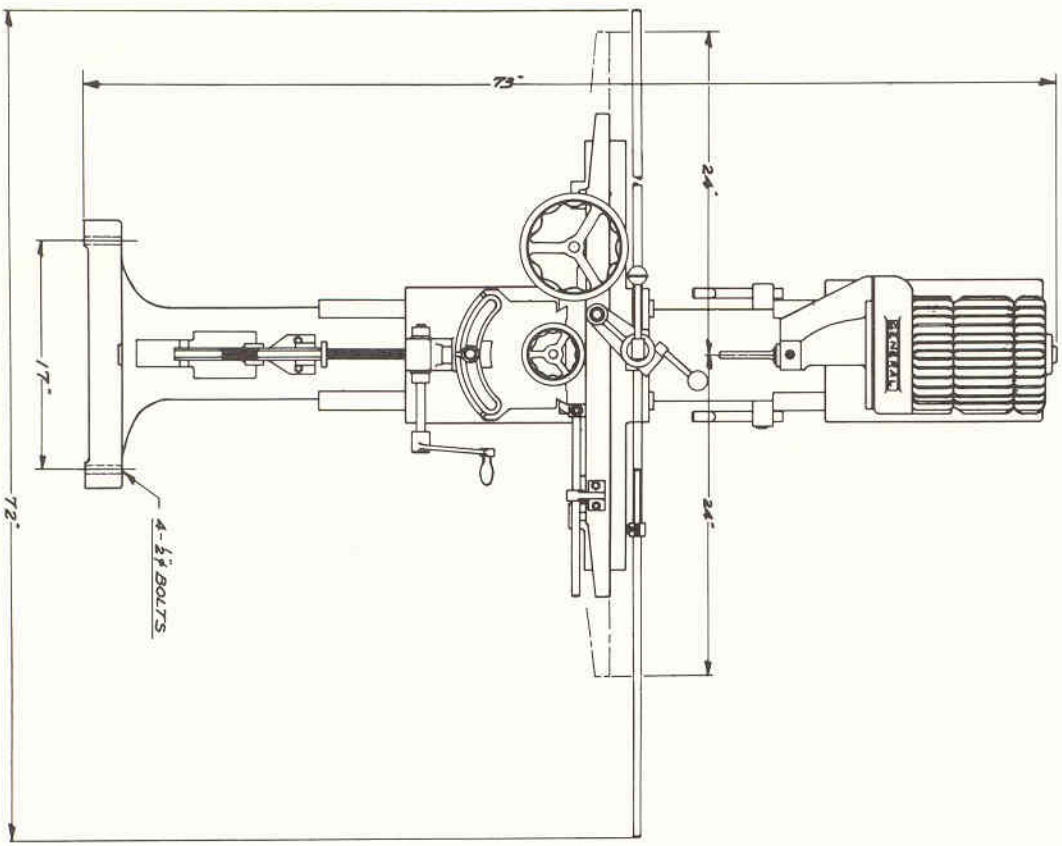


FIG. 1

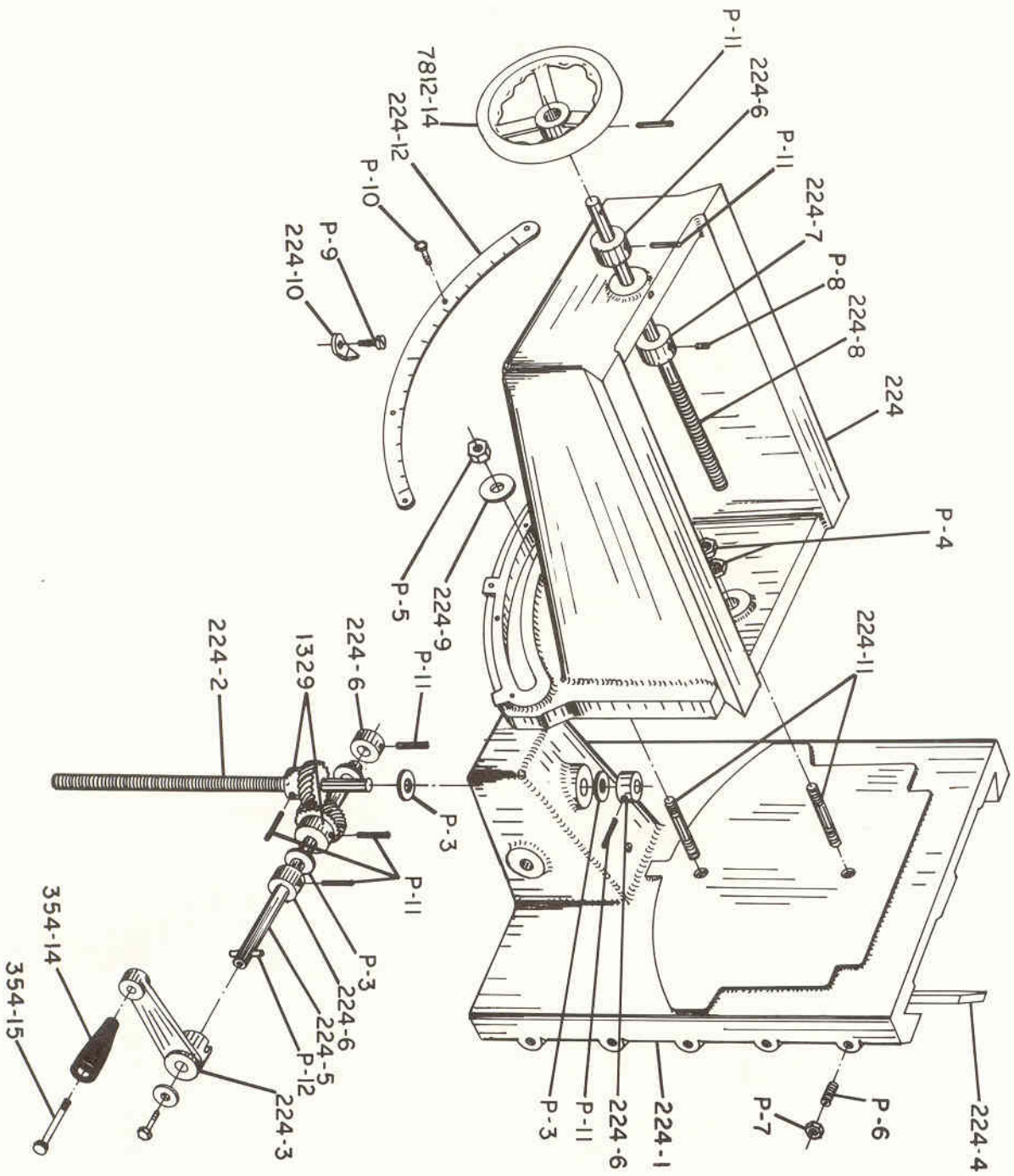


FIG. 2 KNEE

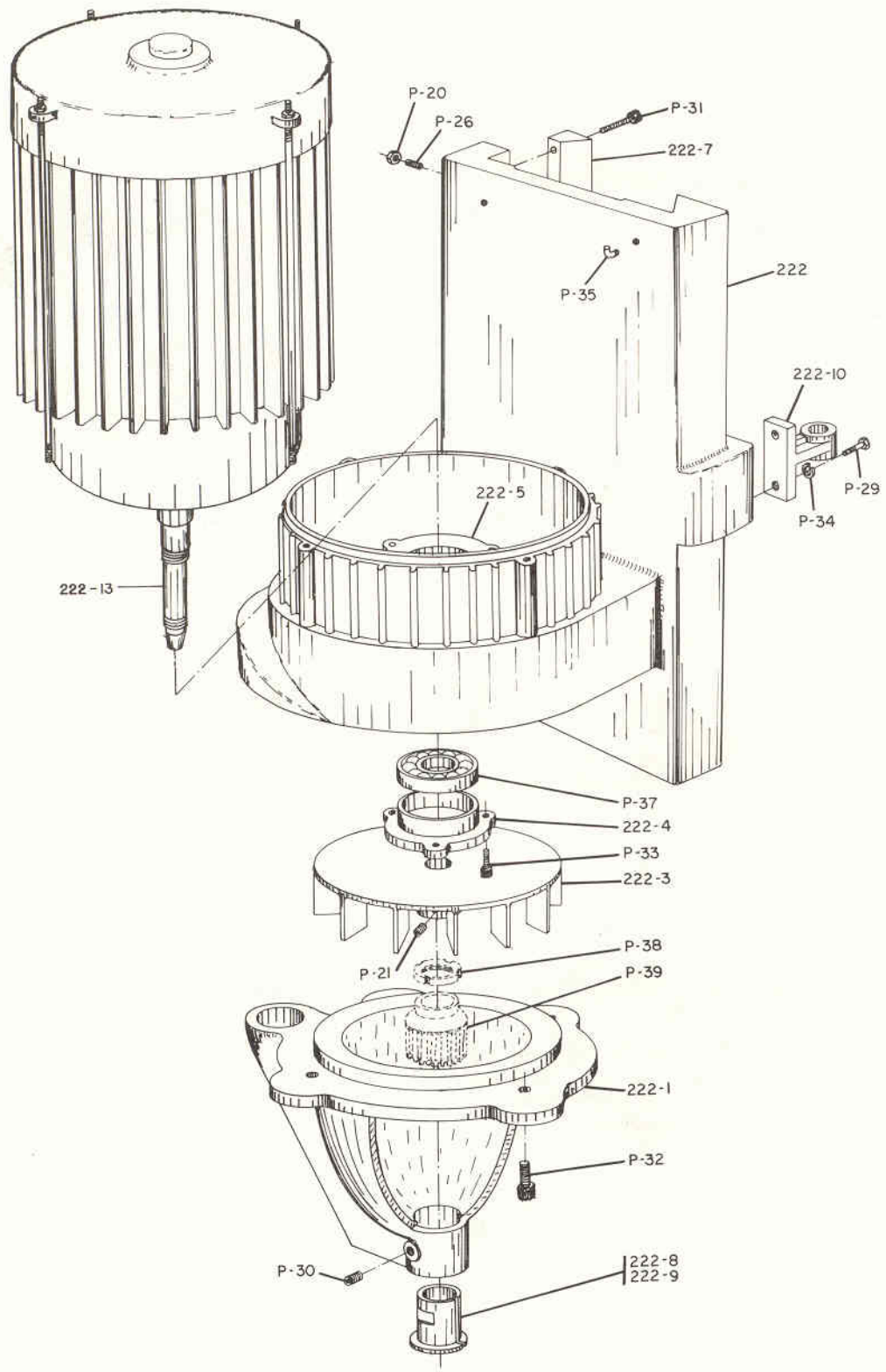


FIG.3 HEAD MORTISER MODEL 220

FOUNDATION

If the floor consists of 4" to 6" concrete, no special foundation is needed to install the machine. A good wooden floor is also satisfactory in such a case lag screws may be used. Outline of figure 1 gives the spacing of the foundation bolts.

IMPORTANT

This mortising machine is particularly adapted for use in all kinds of woodworking plants. Locate in clean, dry and well ventilated building if possible. Motor and electrical connections should be protected when not in operation or if exposed to weather elements. The mortiser requires the minimum amount of attention in service. Periodic or regular inspections are recommended to insure that the machine is in proper adjustment.

WIRING

All wiring is completed at the factory and it is only necessary to bring the power line to the machine to put it in operation. Motors and starters are supplied as per customer's requirements and can be 208/220, 440 or 550 volts, 60 cycles. Be sure that the line voltage is the same as stamped on the motor and starter.

LUBRICATION

The slides and gibs should be lubricated every 4 hours of continuous operation. Lubricate with S.A.E. 20 oil.

TABLE

The table is raised and lowered with handle (224-3) mounted under the table in front of the machine. The table moves both lengthwise and crosswise by means of the front handwheels (223-9). The horizontal movement is accurately determined by the two adjustable stops directly in front of the table. The table can be tilted to 45° either right or left for angle mortise. The table and table knee have adjustable gibs to insure correct sliding fit and to take up wear.

The fence has vertical adjustment and is fitted with a lip hold-down. It is also provided with a layout stop rod with spring stops.

Two adjustable prong hold-downs are carried from the machine column. The work is held on the table by a quick adjustable clamp. This device will hold work against the table while chisel & bit is raised.

HEAD

The head operates on ways of the column and is provided with an adjustable gib to insure correct sliding fit and to compensate for any wear. The drive motor is mounted on the head carriage and forms part of it. It is operated by a start-stop push button mounted conveniently on the head. A blower fan mounted on the spindle of the motor provides an air blast for chips removal and cooling of the mortising-tool. A key chuck is mounted on the spindle to drive bits up to 1/2" dia. The mortising head assembly is moved up and down on the ways by means of a foot pedal extending in the column and connected by a draw bar.

The foot pedal spring tension is regulated with screw (221-1) on top of the column. To adjust the screw (221-1), turn to right to increase tension and to left to decrease. The head assembly is returned in position by means of a coil spring (221-2). The travel of the carriage is adjusted by means of stop to the side of it for setting depth of mortise. The stroke of the head is 4" but can be adjusted to operate from 0" to 4" by changing the position of the collars (221-9). By moving the collar down, stroke is shortened. By moving collar up, stroke is lengthened.

The hollow chisel is held in the head with a set screw which clamps against hollow chisel bushing (222-9). Bit is held in the key chuck, mounted direct on the motor shaft. Before inserting bit in chuck, it should be checked for burrs or loose particles that might keep it from centering properly. The end of the bit should be set with approximately 1/16" between chisel and bit.

CLAMP

The clamp is of the quick acting type adjustable for different thicknesses of material and mounted on a swivelling bracket. When clamp is adjusted to the right tightness of material, the stock can be clamped or removed by the simple action of the clamp handle.

ACCESSORY

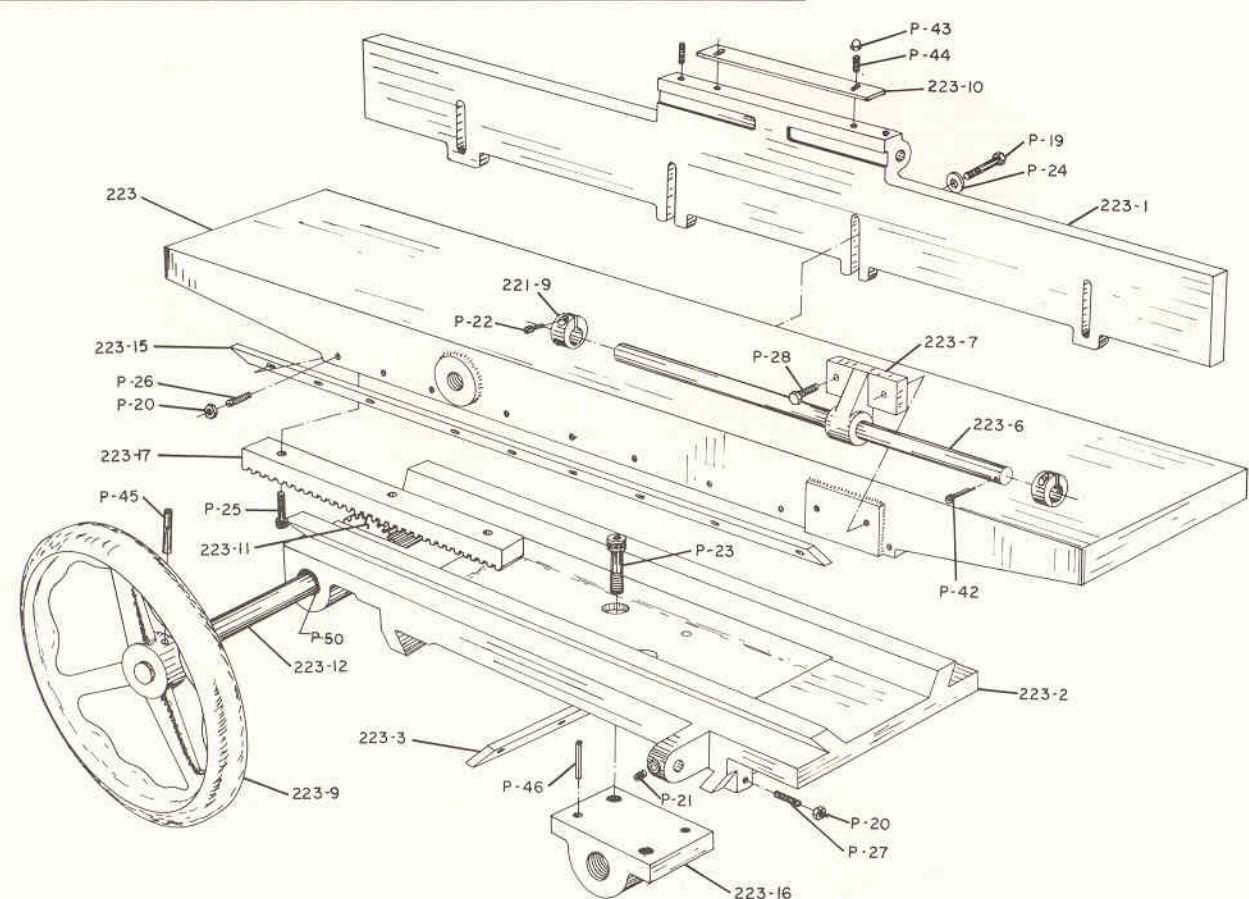
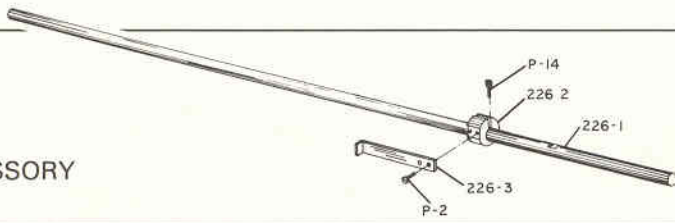


FIG. 4 TABLE

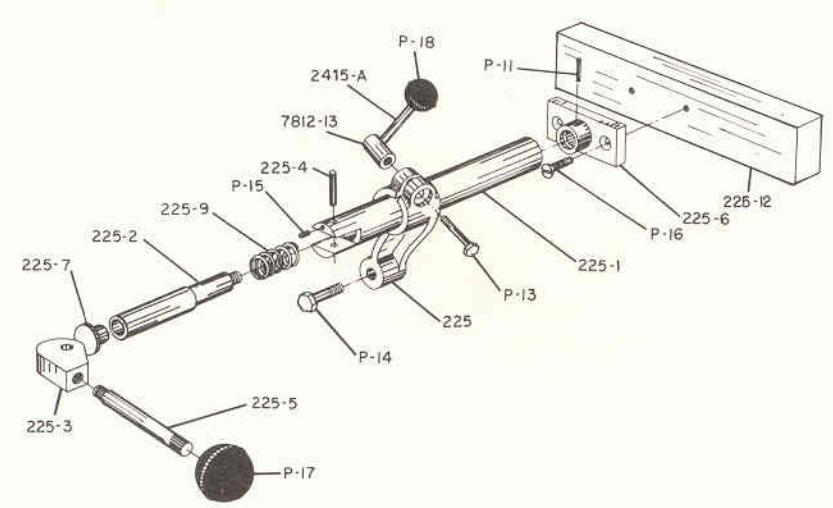


FIG. 5 CLAMP

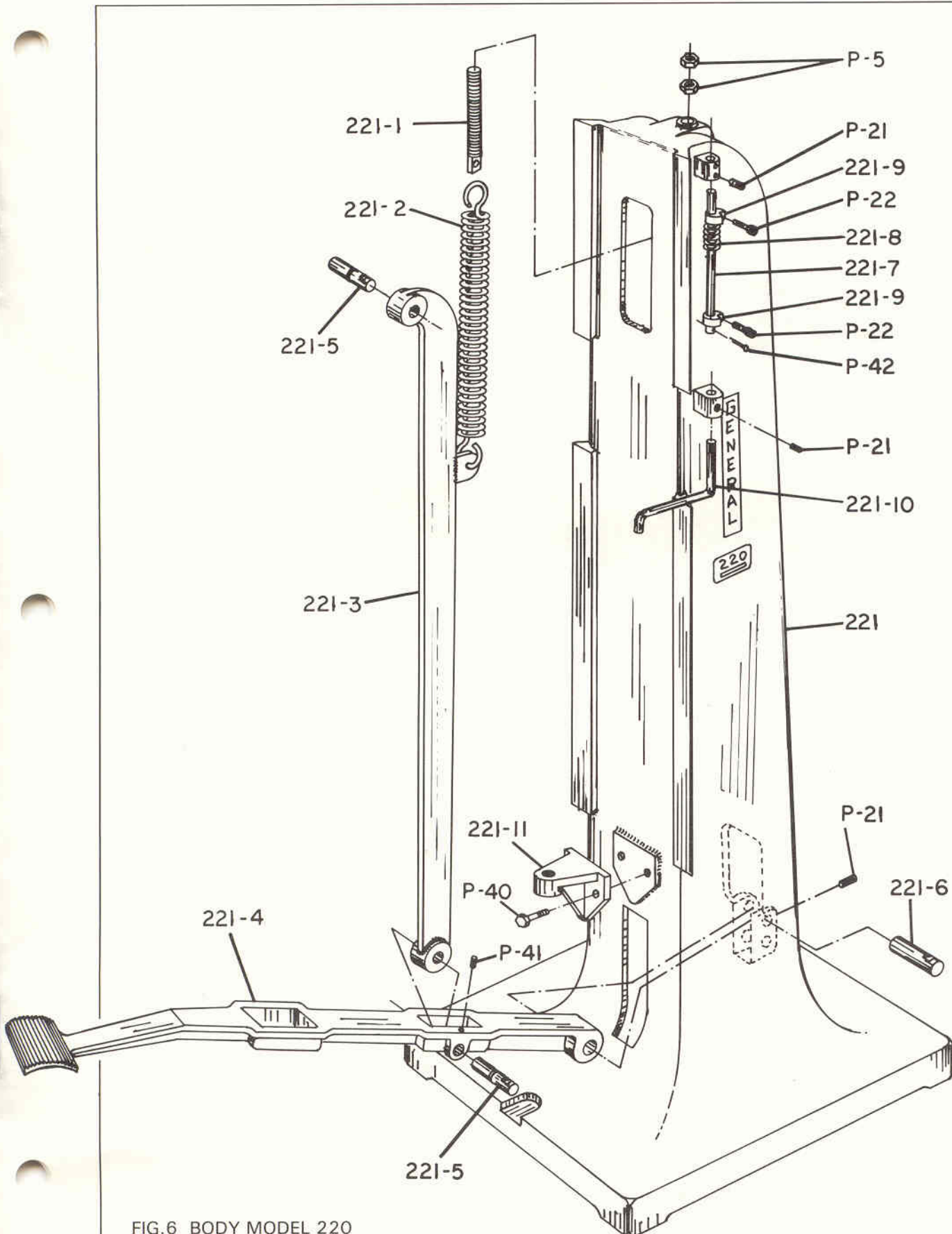


FIG.6 BODY MODEL 220

