

### MOUNTING -

1. Mount the wood table and fence to the drill press table and fasten in place with the special screws furnished - see Figure 2. There are two sets of mounting holes - the ones that are countersunk. Mount the table so that the countersink is on top - see Figure 2. Use the set that lines up with the slots in your drill press table.

2. The shaping cutters are mounted to the drill press spindle with No. W6-6A adapter. To mount adapter, remove chuck and knurled collar, place adapter on spindle and replace knurled collar, locking adapter to spindle.

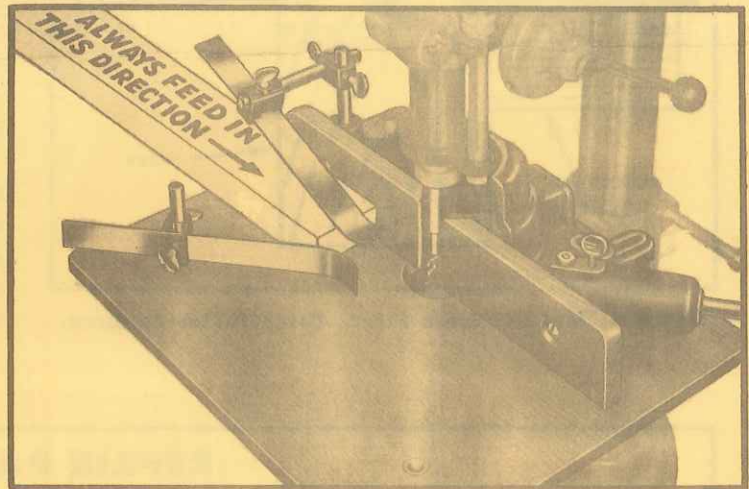


Figure 1 W80 Shaping Attachment

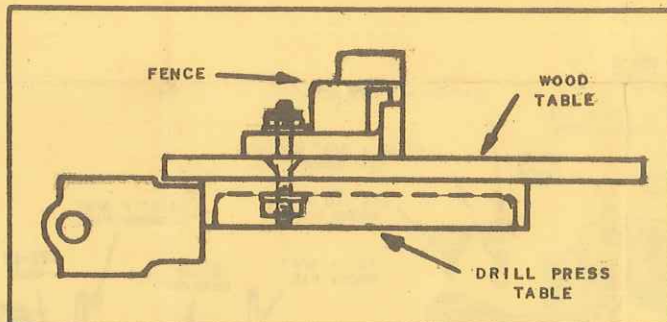


Figure 2 Method of Mounting Shaping Table and Fence to Drill Press Table.

edge is to be shaped, the faces of the fence must be in straight alignment - see Figure 3. (2) If edge of stock is rough, and shaping covers complete edge, the in-feed fence is set back to cut stock to finish size - the out-feed fence is lined up with the bottom of the shape on the cutter - see Figure 3. In either of the two positions move wood facings as close to cutter as possible.

The spring hold-downs hold the work against both the fence and table. Do not set hold-downs too tightly against the work - the work must pass the cutters smoothly and evenly.

### SPEEDS -

Use the faster speeds on your drill press. If higher speeds are required for smoother finishes, use the Atlas Hi-Lo Speed Attachment.

### OPERATION -

#### **ALWAYS FEED WORK AGAINST CUTTER ROTATION.**

**SHAPING WITH THE FENCE** - With the drill press head in normal position, Figure 1, the work is fed from the left.

Adjust the table, or spindle, to cut the shaping form desired on the work. It may be necessary to remove one of the drill press feed handles - see Figure 1.

Adjust fence in one of these two positions - (1) If work is to finished size and only a portion of

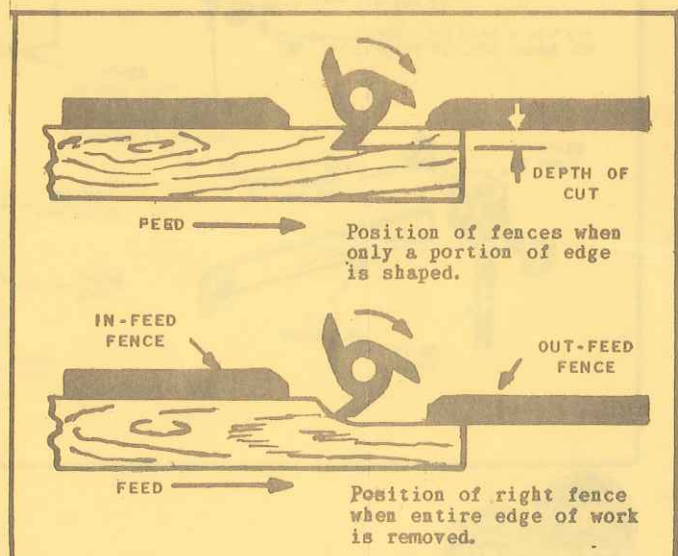


Figure 3 Diagram Shows How Shaper Fence Must Be Adjusted For Various Cuts.

Always make a trial cut on scrap wood to check depth and position of cut.

reaches the end of the work, see Figure 4.

Always shape the end grain first using a follow-up block. The block minimizes splintering as the cut

### IRREGULAR SHAPING -

Remove the fence and hold-downs. The work rides against depth collars which limits the depth of cut.

Select the collar that will give the correct depth of cut - collars may be placed above, below or between two cutters. Lock the collar and cutter on the adapter. It's recommended, whenever possible to make cuts from the bottom of the cutter - it's much safer and will produce better work.

Use a starting pin as a fulcrum to support the work until it's been fed into the depth collar. As soon as the cut is started swing the work away from the pin. Do not try to hold the work on both the collar and the pin.

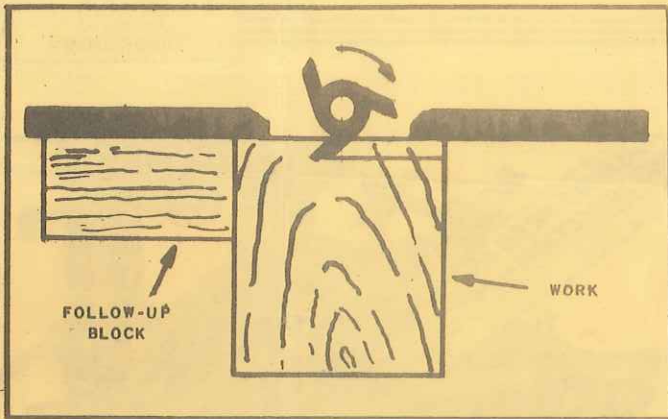
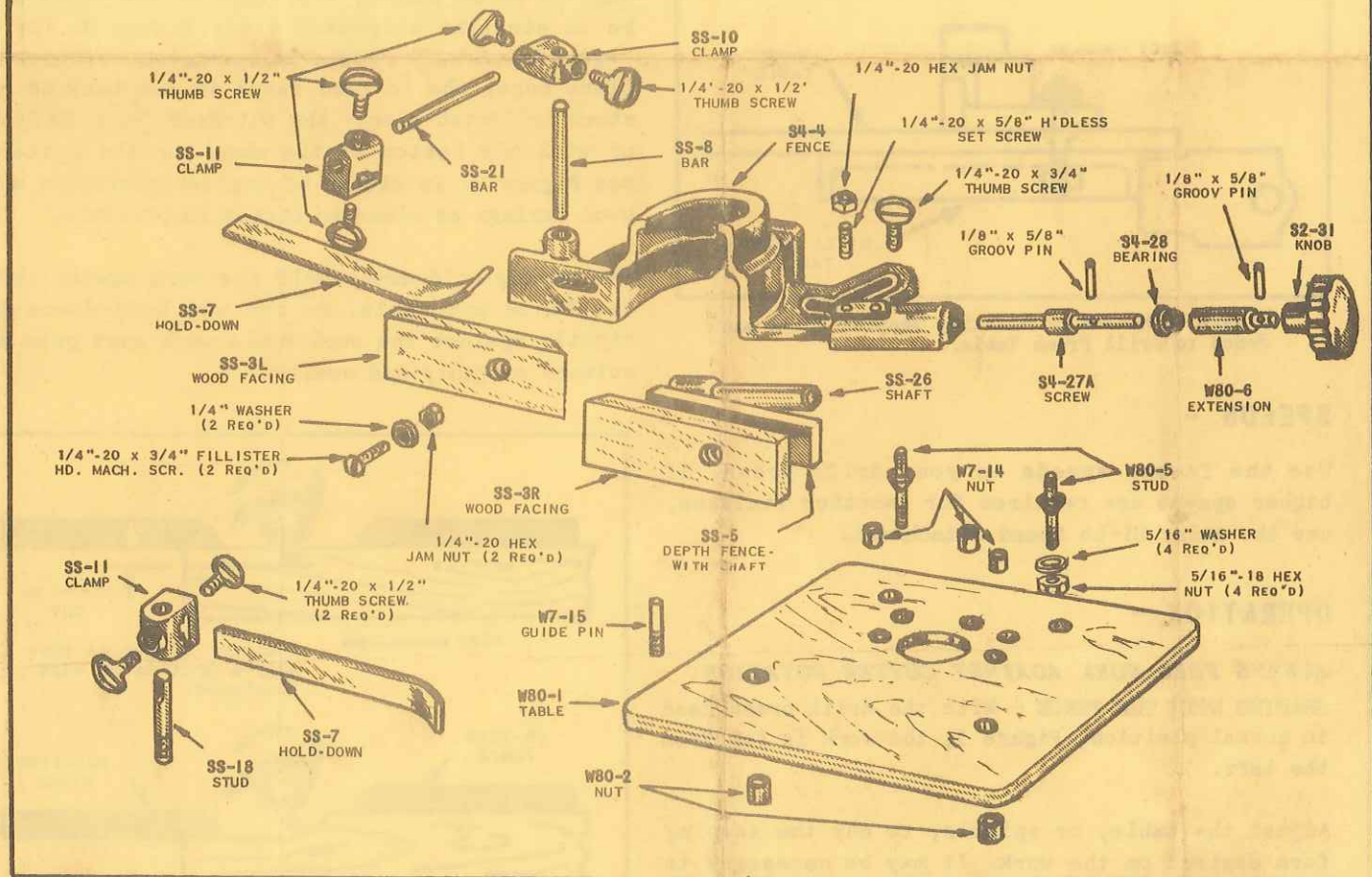


Figure 4 Feed End Grain First, Using Follow-Up Block.

## REPAIR PARTS LIST

Order all parts by PART NUMBER and NAME. Standard parts, such as screws, nuts and washers, shown without part numbers, should be purchased locally.



ATLAS PRESS COMPANY

KALAMAZOO, MICHIGAN, U.S.A.

*1/4" x 8" x 13*