

HORIZONTAL BORING SAFETY

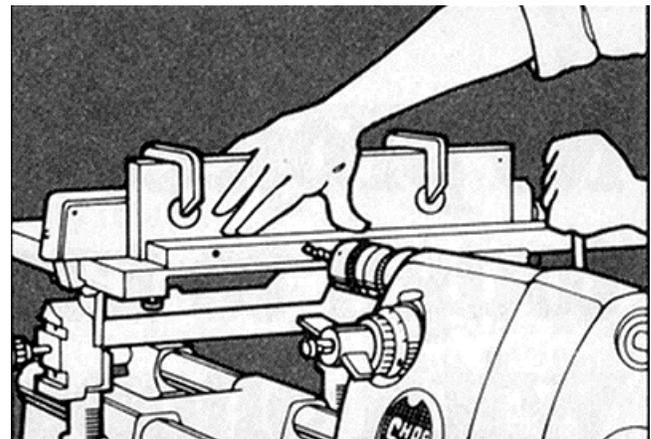
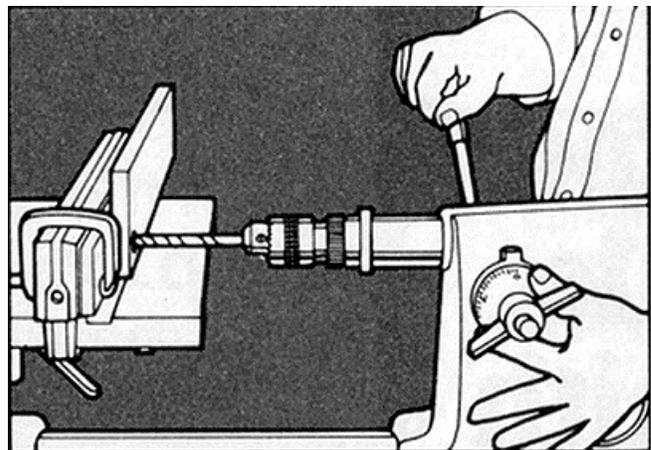
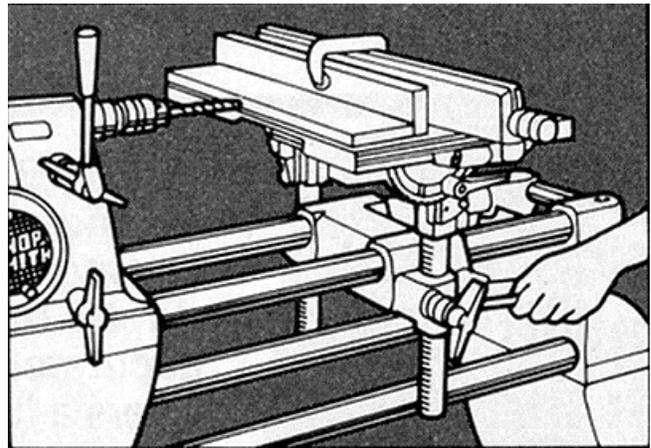
1: Set up the MARK V in the Horizontal Boring configuration. Turn on the MARK V and set the Sped Dial to the appropriate speed for the size of hole you're drilling.

SIZE OF HOLE	HARDWOOD SETTING	SOFT WOOD SETTING
Up to 1/4"	J	K
9/32" to 1/2"	I	J
17/32" to 3/4"	F	H
23/32" to 1"	C	E
Over 1"	SLOW	A

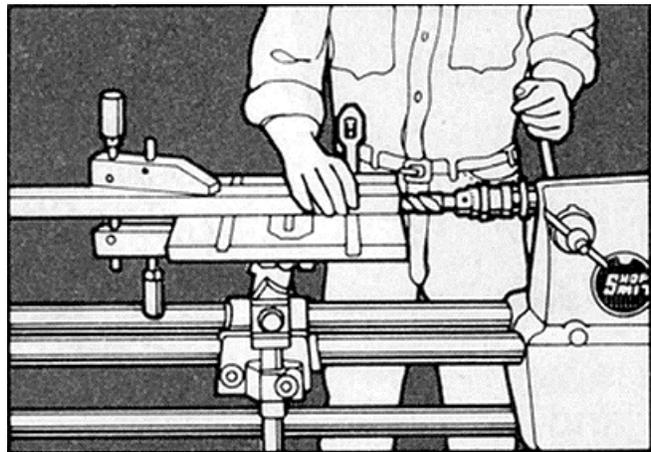
Turn off the MARK V and mount a drill bit in the Chuck. **Remove the chuck key.** Mount the Rip Fence on the Worktable for use as a backstop. Clamp a scrap piece of stock to the Rip Fence to prevent boring into the Fence Face. Adjust the Fence location to position your stock 1/4" to 1/2" away from the tip of your Drill Bit. **Clamp the stock to the Worktable.** Adjust the Table height to set the up/down position of your hole.

2: Through Boring. Extend the MARK V Quill until the tip of your Drill Bit touches your stock. Set your Depth Control for the proper hole depth – and to keep your Bit from drilling into the Fence face. Allow the Quill to retract. Turn on the MARK V and allow it to come up to the set speed. Feed the bit into your stock **slowly** while maintaining a steady pressure. **Stop** when the depth control halts the Quill travel. Retract the Quill. Turn off the MARK V and allow it to come to a full stop before removing your stock.

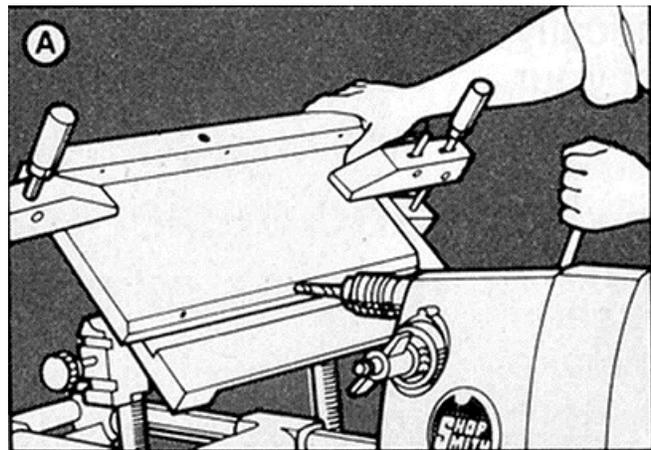
3: Stop Boring. Follow the same procedures outlined in step 2 for through boring...except...set the Depth Control to stop your Bit at the desired depth setting. Although no scrap block is needed, since you won't be drilling all the way through your stock., using one will help keep your stock from sliding during the boring process. Tighten the Table Height Lock so the Table doesn't move. Don't over-tighten



4: End Grain Boring. Use your Miter Gauge to hold your stock square to your Bit while boring your holes. If your stock is less than 30" long, mount the Rip Fence to the Worktable or Extension Table for use as a backstop. If your stock is longer than 30", clamp it firmly to the Table to keep your stock from slipping. Reduce your speed slightly, as end grain boring can be difficult.



5: Angle Boring. (See A) Tilt the Worktable in toward the Headstock at any angle from 90-degrees to "0". Mount your Rip Fence for use as a backstop. To keep your stock from sliding, clamp it firmly to the Worktable surface. Use your Miter Gauge to grasp smaller pieces of stock.. If your angle is acute, clamp scrap blocks to the Table and/or Fence for protection (See B). Another way to angle bore small and narrow stock is to use the Miter Gauge. Simply adjust the Gauge to the required angle and clamp your stock to the Worktable surface.



- **NEVER** leave the key in the Drill Chuck.
- **NEVER** use dull, damaged or bent Drill Bits.
- Always use the proper speed setting.
- **NEVER** try to stop the machine by grabbing the rotating Drill Chuck, even if the machine is turned off.
- **NEVER** use a Drill Bit with a tapered square shank.

