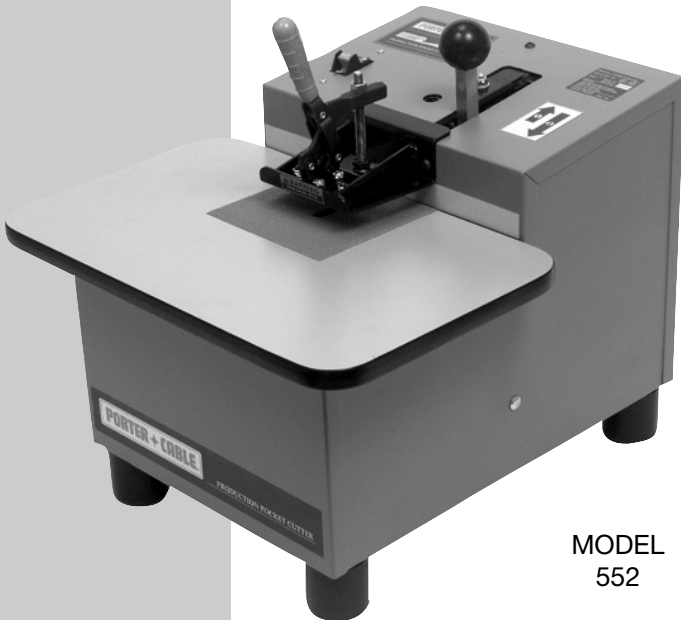


Instruction manual

Production POCKET CUTTER®



MODEL
552

To learn more about Porter-Cable
visit our website at:

<http://www.porter-cable.com>

PORTER-CABLE
PROFESSIONAL POWER TOOLS

IMPORTANT

Please make certain that the person who is to use this equipment carefully reads and understands these instructions before starting operations.

The Model and Serial No. plate is located on the main housing of the tool. Record these numbers in the spaces below and retain for future reference.

Model No. _____

Type _____

Serial No. _____

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IMPORTANT SAFETY INSTRUCTIONS

▲WARNING Read and understand all warnings and operating instructions before using any tool or equipment. When using tools or equipment, basic safety precautions should always be followed to reduce the risk of personal injury. Improper operation, maintenance or modification of tools or equipment could result in serious injury and property damage. There are certain applications for which tools and equipment are designed. Porter-Cable strongly recommends that this product NOT be modified and/or used for any application other than for which it was designed.

If you have any questions relative to its application DO NOT use the product until you have written Porter-Cable and we have advised you.

Online contact form at www.porter-cable.com

Postal Mail: Technical Service Manager
Porter-Cable Corporation
4825 Highway 45 North
Jackson, TN 38305

Information regarding the safe and proper operation of this tool is available from the following sources:

Power Tool Institute
1300 Sumner Avenue, Cleveland, OH 44115-2851
www.powertoolinstitute.org

National Safety Council
1121 Spring Lake Drive, Itasca, IL 60143-3201

American National Standards Institute, 25 West 43rd Street, 4 floor, New York, NY 10036 www.ansi.org ANSI 01.1 Safety Requirements for Woodworking Machines, and the U.S. Department of Labor regulations www.osha.gov

SAVE THESE INSTRUCTIONS!

SAFETY GUIDELINES - DEFINITIONS

It is important for you to read and understand this manual. The information it contains relates to protecting YOUR SAFETY and PREVENTING PROBLEMS. The symbols below are used to help you recognize this information.



▲ DANGER

indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

▲ WARNING

indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

▲ CAUTION

indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

CAUTION

used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

CALIFORNIA PROPOSITION 65

▲ WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known (to the State of California) to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead-based paints
- crystalline silica from bricks and cement and other masonry products
- arsenic and chromium from chemically-treated lumber

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, always wear NIOSH/OSHA approved, properly fitting face mask or respirator when using such tools.

GROUNDING INSTRUCTIONS

1. All grounded, cord-connected tools:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and matching 3-conductor receptacles that accept the tool's plug, as shown in Fig. A.

Repair or replace damaged or worn cord immediately.

2. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating less than 150 volts:

If the tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. A, the tool will have a grounding plug that looks like the plug illustrated in Fig. A.

A temporary adapter, which looks like the adapter illustrated in Fig. B, may be used to connect this plug to a matching 2-conductor receptacle as shown in Fig.

B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box. Whenever the adapter is used, it must be held in place with a metal screw. **NOTE: In Canada, the use of a temporary adapter is not permitted by the Canadian Electric Code.**

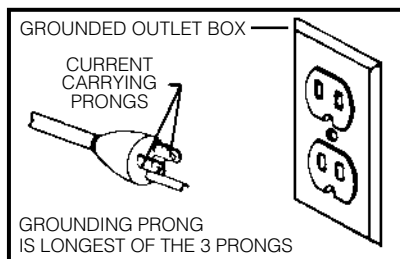


Fig. A

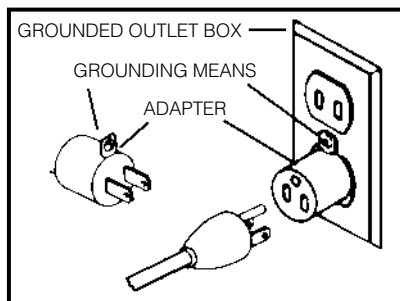


Fig. B

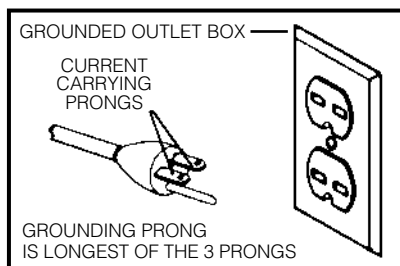


Fig. C

3. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating between 150 - 250 volts, inclusive:

If the tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. C, the tool will have a grounding plug that looks like the plug illustrated in Fig. C. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be re-connected for use on a different type of electric circuit, the re-connection should be made by qualified service personnel; and after re-connection, the tool should comply with all local codes and ordinances.

⚠ WARNING IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE HAVE A QUALIFIED ELECTRICIAN CHECK THE RECEPTACLE. NEVER REMOVE GROUNDED PRONG FROM POWER PLUG.

EXTENSION CORDS

⚠ CAUTION Use proper extension cords. Make sure your extension cord is in good condition and is a 3-wire extension cord which has a 3-prong grounding type plug and matching receptacle which will accept the tool's plug. When using an extension cord, be sure to use one heavy enough to carry the current of the tool. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Fig. D, shows the correct gauge to use depending on the cord length. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

		Length of Cord in Feet									
		115V	25 Ft.	50 Ft.	100 Ft.	150 Ft.	200 Ft.	250 Ft.	300 Ft.	400 Ft.	500 Ft.
		230V	50 Ft.	100 Ft.	200 Ft.	300 Ft.	400 Ft.	500 Ft.	600 Ft.	800 Ft.	1000 Ft.
Nameplate Ampere Rating	0-2	18	18	18	16	16	14	14	12	12	
	2-3	18	18	16	14	14	12	12	10	10	
	3-4	18	18	16	14	12	12	10	10	8	
	4-5	18	18	14	12	12	10	10	8	8	
	5-6	18	16	14	12	10	10	8	8	6	
	6-8	18	16	12	10	10	8	6	6	6	
	8-10	18	14	12	10	8	8	6	6	4	
	10-12	16	14	10	8	8	6	6	4	4	
	12-14	16	12	10	8	6	6	4	4	2	
	14-16	16	12	10	8	6	6	4	4	2	
	16-18	14	12	8	8	6	4	4	2	2	
18-20	14	12	8	6	6	4	4	2	2		

Fig. D

IMPORTANT SAFETY INSTRUCTIONS

WARNING READ AND UNDERSTAND ALL INSTRUCTIONS.

Failure to follow all instructions listed below, may result in electric shock, fire and/or serious personal injury.











SAVE THESE INSTRUCTIONS.

- 1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.
- 2. KEEP GUARDS IN PLACE** and in working order.
- 3. ALWAYS WEAR EYE PROTECTION.** Wear safety glasses. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use MSHA/NIOSH approved face or dust mask if cutting operation is dusty. These safety glasses must conform to ANSI Z87.1 requirements.
NOTE: Approved glasses have Z87 printed or stamped on them.
- 4. REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on".
- 5. KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 6. DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.
- 7. KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
- 8. MAKE WORKSHOP CHILDPROOF** – with padlocks, master switches, or by removing starter keys.
- 9. DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
- 10. USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
- 11. WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
- 13. DON'T OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- 15. DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.
- 16. USE RECOMMENDED ACCESSORIES.** The use of accessories and attachments not recommended by Delta may cause hazards or risk of injury to persons.
- 17. REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord. In the event of a power failure, move switch to the "OFF" position.
- 18. NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
- 19. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

20. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
21. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
22. **STAY ALERT, WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE WHEN OPERATING A POWER TOOL. DO NOT USE TOOL WHILE TIRED OR UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR MEDICATION.** A moment of inattention while operating power tools may result in serious personal injury.
23. **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
24. **⚠ WARNING USE OF THIS TOOL CAN GENERATE AND DISBURSE DUST OR OTHER AIRBORNE PARTICLES, INCLUDING WOOD DUST, CRYSTALLINE SILICA DUST AND ASBESTOS DUST.** Direct particles away from face and body. Always operate tool in well ventilated area and provide for proper dust removal. Use dust collection system wherever possible. Exposure to the dust may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. Allowing dust to get into your mouth or eyes, or lay on your skin may promote absorption of harmful material. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.
25. **WEAR S3.19 EAR PROTECTION** to safeguard against possible hearing loss.
SAVE THESE INSTRUCTIONS.

ADDITIONAL SPECIFIC SAFETY RULES

1. **ALWAYS DISCONNECT MACHINE** from power source and make sure all rotation has stopped before making adjustments or changing bits. Rotation of cutter is noted by direction arrow label.
2. **USE RECOMMENDED BITS.** Use Porter-Cable pocket cutting bit and pilot hole bit ONLY. Use of other bits could cause personal injury and damage to machine or work.
3. **“BOTTOM” BITS IN COLLETS.** Both the pocket cutting bit and the pilot hole bit MUST be “bottomed” in the collets. Failure to “bottom” the bits could cause personal injury and damage to machine and work.
4. **TIGHTEN COLLET NUTS SECURELY** to prevent bits from slipping during use.
5. **KEEP HANDS CLEAR** of cutter area when motors are running to prevent personal injury.
6. **DO NOT ATTEMPT TO CUT** a workpiece that is smaller than $\frac{1}{2}$ " thick, or $1\frac{1}{2}$ " wide, or $1\frac{1}{2}$ " long. A smaller workpiece will not be properly held by the work clamp: the workpiece could be ejected from the machine causing personal injury.
7. **ALWAYS CLAMP WORK SECURELY** using the work clamp. Check to insure that each workpiece is held securely against the fence and the table. Variations in material thickness can require readjustment of the work clamp. Use $\frac{1}{8}$ " thick shim on table when working with a thin ($\frac{1}{2}$ " to $\frac{5}{8}$ " thick) workpiece (see Fig. 18).
8. **CLEAN CHIPS AND DUST FROM UNDER MACHINE** to avoid risk of fire. Do not allow chips to pile up into the machine: clean area before top of chip pile reaches bottom of machine cabinet.
9. **CLEAN MOTORS DAILY.** Disconnect machine from power source, tip machine onto its back, and use dry, compressed air to blow dust out of both motors. **⚠ WARNING** Wear ANSI Z87.1 safety glasses when using compressed air.
10. **NEVER TOUCH BITS** after use, since they may be extremely hot.
11. **NEVER TIGHTEN** collet nut without bit installed. This will deform collet.

SYMBOL	DEFINITION
V	volts
A	amperes
Hz	hertz
W	watts
kW	kilowatts
μ F	microfarads
l	liters
kg	kilograms
N/cm ²	newtons per square centimeter
Pa	pascals
h	hours
min	minutes
s	seconds
	alternating current
3 	three-phase alternating current
3N 	three-phase alternating current with neutral
	direct current
n_0	no load speed
	alternating or direct current
	Class II Construction
	splash-proof construction
	watertight construction
.../min	revolutions or reciprocation per minute

SAVE THESE INSTRUCTIONS.

REPLACEMENT PARTS

When servicing use only identical replacement parts.

MOTOR

Many Porter-Cable tools will operate on either D.C., or single phase 25 to 60 cycle A.C. current and voltage within plus or minus 5 percent of that shown on the specification plate on the tool. Several models, however, are designed for A.C. current only. Refer to the specification plate on your tool for proper voltage and current rating.

CAUTION Do not operate your tool on a current on which the voltage is not within correct limits. Do not operate tools rated A.C. only on D.C. current. To do so may seriously damage the tool.

FUNCTIONAL DESCRIPTION

FOREWORD

Porter-Cable Model 552 is a compact, high speed, production Pocket Cutter[®]. It cuts a $\frac{3}{8}$ " wide pocket and drills a $\frac{9}{64}$ " pilot hole in one quick, hand operated, cycle. It accepts materials that are $\frac{1}{2}$ " to $\frac{15}{16}$ " thick*, and works well in hardwood, softwood, high pressure plastic laminate, particle board, MDF, and melamine.

*NOTE: A $\frac{1}{8}$ " thick spacer must be attached to the table top when cutting materials $\frac{1}{2}$ " to $\frac{5}{8}$ " thick. Material must be at least $\frac{1}{2}$ " thick, and at least $1\frac{1}{2}$ " wide, and at least $1\frac{1}{2}$ " long.

CARTON CONTENTS

1. Carefully remove all of the components from the carton. We recommend you retain all packing materials until after you have inspected and satisfactorily operated the machine.

▲WARNING Do not connect the machine to the power source until you read and understand this entire instruction manual.

2. Locate each of the items listed below (see Fig. 1).

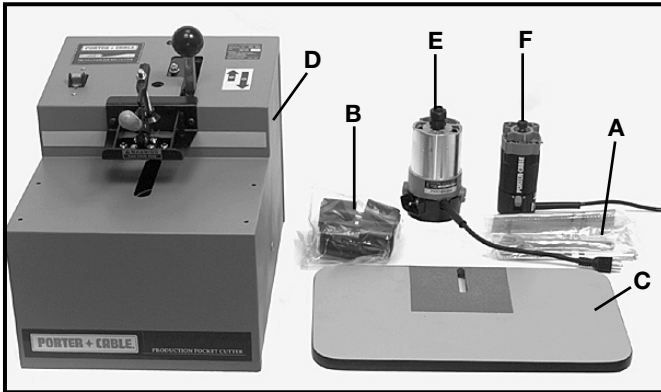


Fig. 1

A) Literature/Hardware Package containing:

- * Square Drive, Screwdriver Bit
- * $\frac{3}{8}$ " Pocket Cutting Bit
- * $1\frac{1}{8}$ " Wrenches (set of two)
- * $\frac{1}{16}$ " and $\frac{7}{16}$ " Wrench
- * $\frac{9}{64}$ " Pilot Hole Drill Bit
- * Drill Motor Mounting Screw ($\frac{1}{4}$ "-20 \times $\frac{1}{2}$ " long, flat head, machine screw)
- * $\frac{5}{32}$ " Hex Wrench

B) Hardware Package containing:

- * Machine Feet (four pcs.)
- * $\frac{5}{16}$ " \times 18 Hex Nuts (four pcs.)
- * $\frac{5}{16}$ " Flat Washers (four pcs.)
- * $\frac{1}{4}$ "-20 \times $\frac{5}{8}$ " Machine Screws (four pcs.)

C) Table Top

D) Cabinet Assembly

E) Pocket Cutting Motor

F) Drill Motor

3. Place the Cabinet Assembly onto a sturdy, level work table.
4. Familiarize yourself with all features and controls as shown in Fig. 2.

- A Switch
- B Work Clamp
- C Feed Lever
- D Table
- E Fence

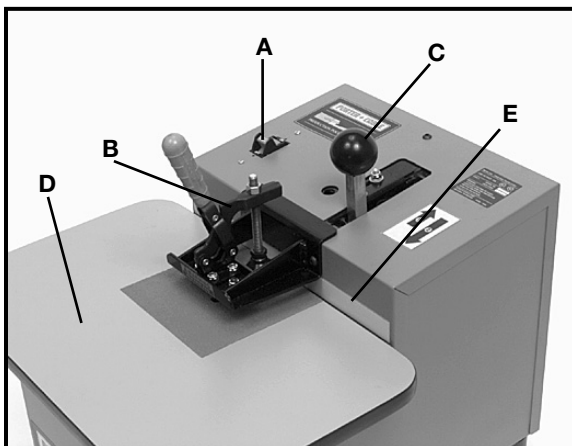


Fig. 2

ASSEMBLY

ASSEMBLY TOOLS REQUIRED - see list of the assembly tools provided in the **CARTON CONTENTS** section of this Manual.

ASSEMBLY TIME ESTIMATE - 1~2 Hours.

INSTALL PILOT HOLE DRILL BIT

⚠ WARNING Disconnect drill motor from power source and place switch in the "OFF" position.

1. Clean and insert shank of drill bit into the collet of the drill motor (see Fig. 3), until shank bottoms.

⚠ CAUTION The bit must be fully bottomed in the collet.

2. Depress spindle lock (A) Fig. 3, and rotate collet nut (B) Fig. 3, clockwise by hand until lock engages hole in motor spindle.
3. While holding spindle lock engaged, tighten collet nut securely by turning **CLOCKWISE** using the $1\frac{1}{16}$ " wrench provided.

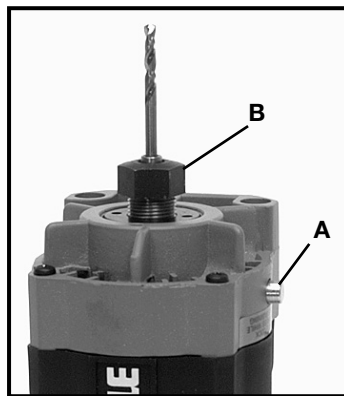


Fig. 3

NEVER TIGHTEN COLLET WITHOUT BIT INSERTED, TO DO SO MAY CAUSE DAMAGE TO THE COLLET.

INSTALL POCKET CUTTING BIT

⚠ WARNING Disconnect pocket cutting motor from power source and place switch in the "OFF" position.

1. Clean and insert shank of pocket cutting bit into the collet of the pocket cutting motor (see Fig. 4), until shank bottoms.

⚠ CAUTION The bit must be fully bottomed in the collet.

2. Lay motor on its side on the bench with the collet pointing AWAY from you.
3. Place one of the 1¹/₈" wrenches on the flats of the chuck with the opposite end of the wrench resting on the bench to your left (see Fig. 4).
4. Place the other 1¹/₈" wrench on the collet nut and tighten securely by turning COUNTERCLOCKWISE as shown in Fig. 4.

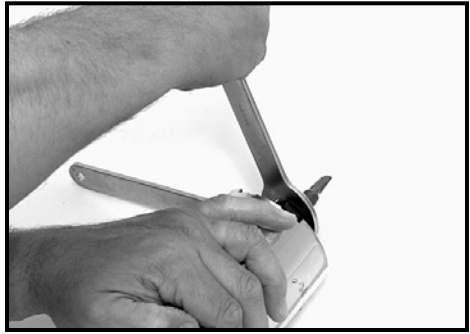


Fig. 4

NEVER TIGHTEN COLLET WITHOUT BIT INSERTED,
TO DO SO MAY CAUSE DAMAGE TO THE COLLET.

INSTALL TABLE TOP

1. Tilt cabinet assembly onto its back (see Fig. 5).
2. Position table top to the top of cabinet assembly as shown in Fig. 5.
3. Use four (1/4" x 5/8" long), machine screws to secure table top to cabinet assembly. Insert the screws through bottom of cabinet assembly (see Fig. 6), start all four screws and then tighten each securely with a phillips screwdriver.



Fig. 5

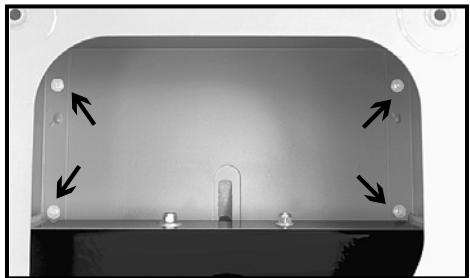


Fig. 6

INSTALL FEET

NOTE: The cabinet assembly should still be positioned on its back as described in step #1 of INSTALL TABLE TOP Section.

1. Locate the four feet, four flat washers, and four 5/16-18 hex nuts.
2. Position the stud on one of the feet through one of the four holes in the base of the cabinet (see Fig. 7).
3. Place a flat washer onto the stud and secure with one of the hex nuts. Tighten firmly.
4. Repeat steps 2 and 3 to assemble the three remaining feet (see Fig. 8).



Fig. 7

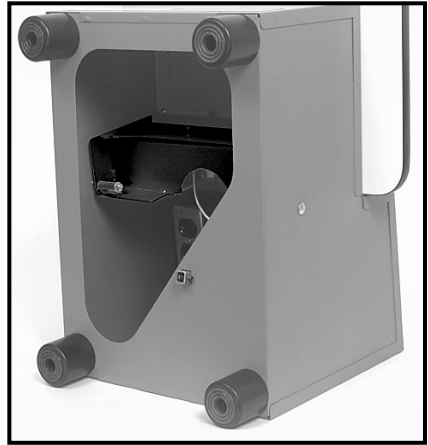


Fig. 8

INSTALL DRILL MOTOR

NOTE: The cabinet assembly should still be positioned on its back as described in step #1 of INSTALL TABLE TOP Section.

⚠ WARNING Disconnect drill motor and machine from power source and place switches in the "OFF" position.

1. Place the (1/4"-20 x 1/2" long, flat head), motor mounting screw onto the 5/32" hex wrench (see Fig. 9).
2. Position the screw through access hole in the top of cabinet (see Fig. 9), and into the hole in the motor mounting bracket. Hold screw and wrench in this position.
3. Position drill motor into cabinet as shown in Fig. 10, and secure in place with the mounting screw.

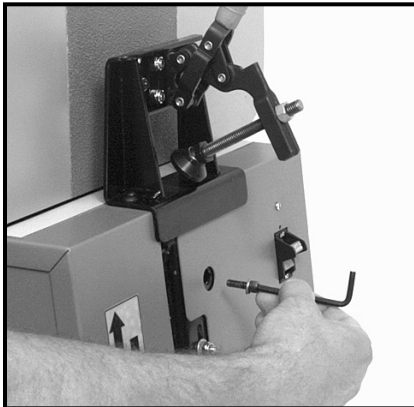


Fig. 9

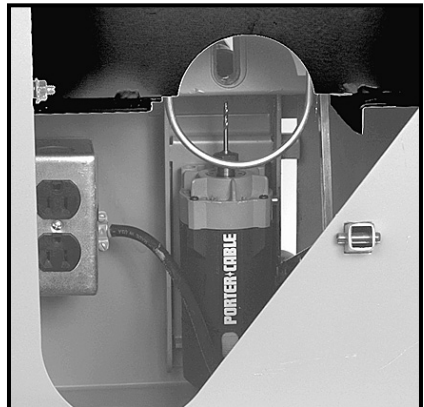


Fig. 10

4. Plug drill motor power cord into receptacle (see Fig. 11).
- ⚠ WARNING** Make sure machine power cord is not connected to power source.
5. Move drill motor switch (A) Fig. 11, to the "ON" position.

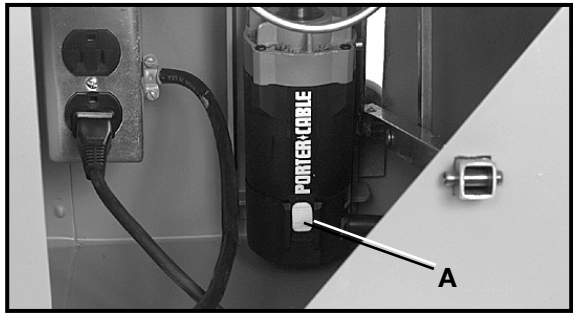


Fig. 11

INSTALL POCKET CUTTING MOTOR

⚠ WARNING Disconnect pocket cutting motor and machine from power source and place switches in the "OFF" position.

1. Loosen motor clamp nut (A) Fig. 12: use the $\frac{7}{16}$ " wrench to rotate clamp nut counterclockwise several turns to loosen clamp.
2. Orient motor as shown in Fig. 13, and insert into clamp. Seat motor into mounting bracket: the upper motor housing (A) Fig. 14, must touch the mounting bracket (B) Fig. 14.
3. Tighten the motor clamp nut firmly.
4. Insert motor power cord into receptacle (see Fig. 15).

⚠ WARNING Make sure machine power cord is not connected to power source.

5. Set motor switch (A) Fig. 15, to the "ON" position.

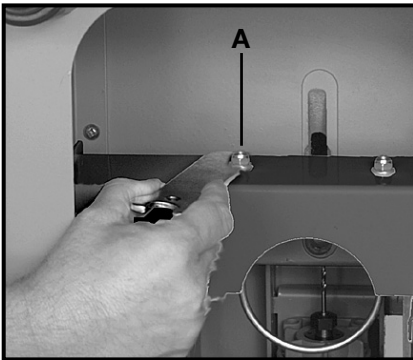


Fig. 12

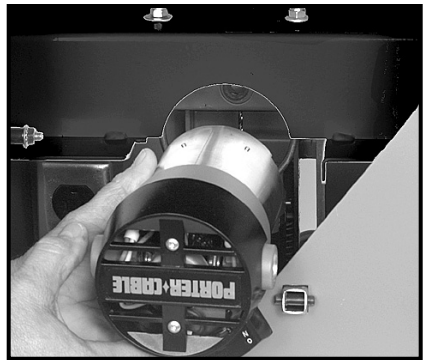


Fig. 13

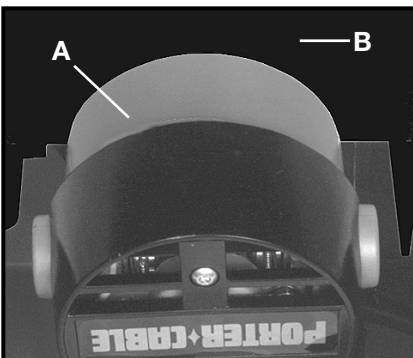


Fig. 14



Fig. 15

OPERATION

TO START AND STOP MOTORS

▲WARNING Before connecting to power source ALWAYS MAKE SURE THE SWITCH IS IN THE "OFF" POSITION and that the power circuit is the same as that specified on the specification plate of the machine.

1. Connect the machine power cord to the power source.

▲WARNING Make sure hands, workpiece, and all foreign objects are clear of the cutter area.

2. Move switch (A) Fig. 16, to "ON" position to start motors.
3. Move switch to "OFF" position to stop motors.

TO LOCK SWITCH

The switch button acts as a key. It may be removed to lock the switch in the "OFF" position:

▲WARNING Disconnect machine from power circuit to prevent accidental start-up while removing switch button.

1. Place switch in the "OFF" position.
2. Pull the button from the switch (see Fig. 17).
3. Make sure switch is in "OFF" position. (If the switch has moved to the "ON" position: it can be returned to the "OFF" position without re-installing the button).

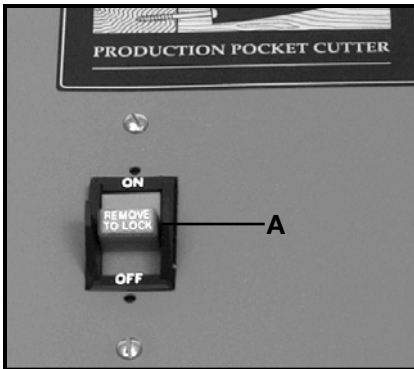


Fig. 16



Fig. 17

TO ADJUST WORK CLAMP

The work clamp must be adjusted to securely hold the workpiece in the machine. Variations in thickness of work may make it necessary to re-adjust the clamp. The clamp should "snap" closed and hold the workpiece securely. If the clamp will not close: then it must be loosened. If the clamp closes too easily (does not hold work securely), it must be tightened.

IMPORTANT: When using thin material (between $\frac{1}{2}$ " and $\frac{5}{8}$ " thick), a shim is required. Make the shim from $\frac{1}{8}$ " thick material (plywood or hardboard). The shim should be approximately the same size as the table top. Firmly clamp the shim to the top of the table (see Fig. 18). Place the thin workpiece on top of the shim, clamp in place with the work clamp, and make pocket cut in normal fashion (a slot will be cut through the shim).

⚠ CAUTION Do not attempt to pocket cut thin materials ($\frac{1}{2}$ " to $\frac{5}{8}$ " thick), without using a shim. The bit could hit the clamp causing personal injury and damage to machine.

⚠ WARNING Switch machine "OFF", disconnect from power source, and make sure all rotation has stopped before making adjustments.

1. Place workpiece under open work clamp (see Fig. 18).
2. Close work clamp by pushing forward firmly on the lever (A) Fig. 18.
3. Pull on workpiece to determine if it is held securely.

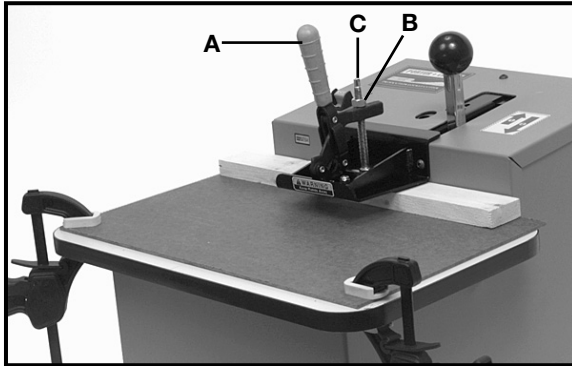


Fig. 18

If adjustment is required:

4. Loosen the jam nut (B) Fig. 18, by turning counterclockwise.
5. Adjust clamp:

To loosen clamp, turn clamp screw assembly (C) Fig. 18, counterclockwise. To tighten clamp, turn clamp screw assembly (C) Fig. 18, clockwise.

As you turn the clamp screw: open and close the clamp (against the workpiece), to determine when the adjustment is correct.

6. Hold the clamp screw while you tighten the jam nut (to lock the adjustment in this position).
7. Repeat steps 1 through 6 until the workpiece is held securely.

TO MAKE A POCKET CUT

1. Determine the desired location of the pocket(s), and mark location(s) on the face side of the workpiece.

⚠ CAUTION Do not attempt to cut a workpiece that is smaller than $\frac{1}{2}$ " thick, or $1\frac{1}{2}$ " wide, or $1\frac{1}{2}$ " long. A smaller workpiece will not be properly held by the work clamp: the workpiece could be ejected from the machine causing personal injury.

2. Place the workpiece into the machine, face side up, aligning the mark on the workpiece with the center notch (A) Fig. 19, on the machine, and seat the work firmly against the fence.

NOTE: There are three notches on the machine. The center notch indicates the position of the drill and pocket cutting bits. The other two notches are positioned $\frac{3}{8}$ " to each side of the center notch. These notches can be used to center two pocket cuts on a rail (or similar workpiece). Mark the center line of the workpiece. Make two pocket cuts: one cut aligning the mark with the left notch and one

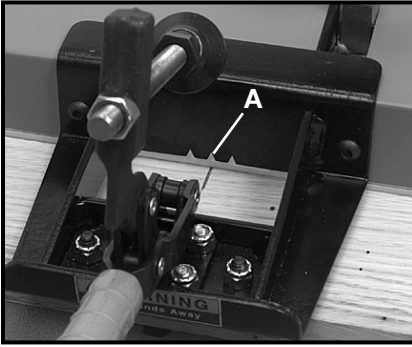


Fig. 19

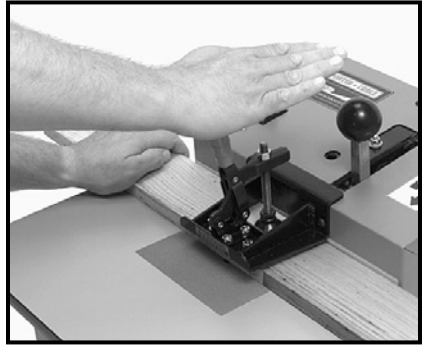


Fig. 20

cut aligning the mark with the right notch. This will produce two pockets, spaced $\frac{3}{4}$ " on centers, and centered on the workpiece.

3. Close the work clamp and pull on the workpiece to assure that it is clamped securely (Fig. 20).

▲WARNING Do not proceed unless work is securely clamped. See TO ADJUST WORK CLAMP section if necessary.

4. Move switch to "ON" position (to start motors).

▲WARNING Keep hands clear of cutter area when motors are running to prevent personal injury.

5. Grasp knob and push operating lever (A) Fig. 21, forward (in direction of arrow #1) until it hits the forward stop (B) Fig. 21.

6. Pull lever back (in direction of arrow #2) until it contacts rear stop (C) Fig. 22.

NOTE: Steps 5 and 6 should be performed smoothly and quickly. Each motion should require approximately one second. Jerky or excessively fast movement will cause a rough cut. Moving too slowly will overheat the bits.

7. Release the operating lever. It will return to the neutral position.
8. Open the work clamp and remove workpiece from machine.
9. Repeat steps 1 through 8 as necessary to complete desired cuts.
10. Move switch to "OFF" position after last cut is completed.

CAUTION Clean chips and dust from under machine. Do not allow chips to pile up into the machine: clean area before top of chip pile reaches bottom of machine cabinet.

▲WARNING Clean motors daily. Disconnect machine from power source, tip machine onto its back, and use dry, compressed air to blow dust out of both motors. Wear ANSI Z87.1 safety glasses when using compressed air.

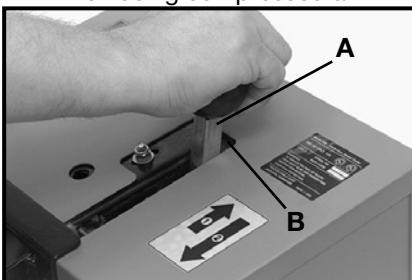


Fig. 21

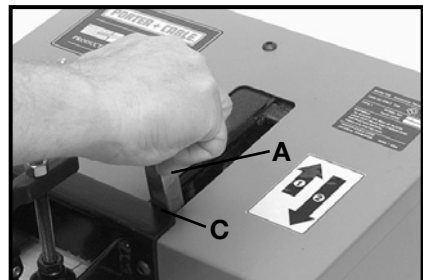


Fig. 22

TO ADJUST POCKET CUT

Alignment of the pocket cut to the drilled pilot hole, and the distance between the end of the pocket and the edge of the material, are both adjusted to nominal specifications at the factory. These normally require no further adjustment, but both can be “fine tuned” to meet your specific needs.

ALIGNMENT OF POCKET TO PILOT HOLE:

▲ WARNING Disconnect machine from power circuit before making any adjustments.

1. Tilt machine onto its back (see Fig. 23).
2. Cut a piece of scrap material to approximately 4" by 4".
3. Lift the machine operating lever (A) Fig. 23, and insert the piece of scrap wood as shown in Fig. 23.
4. Determine the direction (left or right, as viewed in Fig. 24), and amount of pocket movement required to align pocket with pilot hole.
5. Locate the adjusting screw (A) Fig. 25, reach into bottom of machine and locate the screw by “feel” (see Fig. 26).

This screw is made of nylon, and is equipped with a jam nut to lock it in place. The end of this screw contacts the inside of the machine cabinet and controls the (left to right), position of the pocket cutting motor.

6. Rotate the adjusting screw counterclockwise (by hand), to release jam nut. Turn jam nut counterclockwise a few turns.
7. Rotate the adjusting screw as required to align pocket to pilot hole:
One turn of the screw will move the pocket approximately $\frac{3}{64}$ ". Clockwise rotation of the screw will move the pocket to the right (as viewed in Fig. 24). Counterclockwise rotation of the screw will move the pocket to the left (as viewed in Fig. 24).

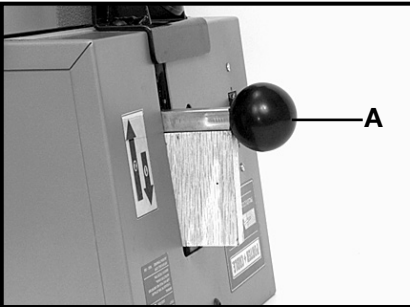


Fig. 23

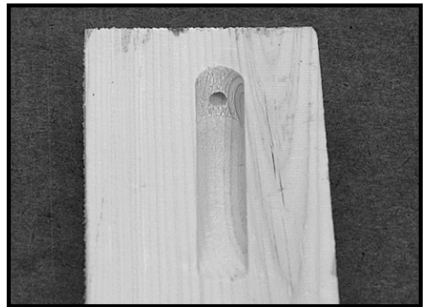


Fig. 24

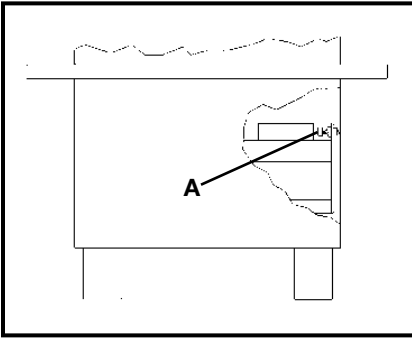


Fig. 25

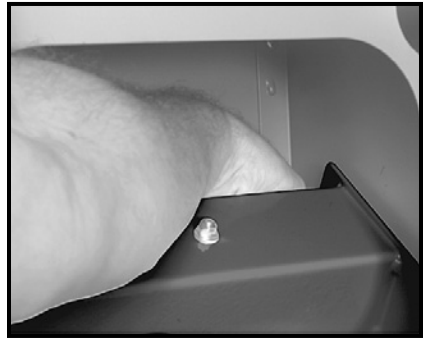


Fig. 26

8. Tighten jam nut (by hand) to lock adjusting screw.
9. Make a test cut (see TO MAKE A POCKET CUT), to verify alignment. Repeat alignment process if necessary.

DISTANCE BETWEEN POCKET AND EDGE OF MATERIAL:

⚠ WARNING Disconnect machine from power circuit before making any adjustments.

1. Determine amount and direction of adjustment required:
Move the rear stop (B) Fig. 28, toward the rear of the machine to reduce dimension (A) Fig. 27. Move the rear stop toward the front of the machine to increase dimension (A) Fig. 27. Move the rear stop 1½ times as far as the desired change to workpiece.
2. Use 7/16" wrench to loosen lock nut (A) Fig. 28.
3. Move rear stop as required, and re-tighten lock nut.
4. Make a test cut (see TO MAKE A POCKET CUT), to verify correction. Repeat adjustment process if necessary.

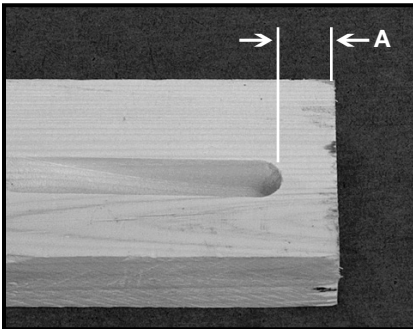


Fig. 27

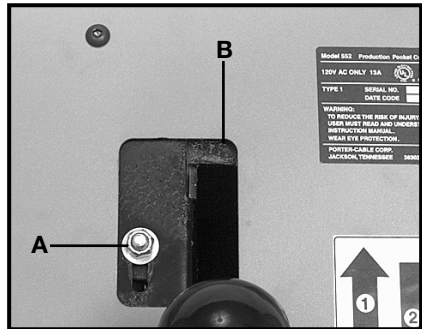


Fig. 28

TROUBLESHOOTING

For assistance with your tool, visit our website at www.porter-cable.com for a list of service centers or call the Porter-Cable help line at 1-800-487-8665.

MAINTENANCE

KEEP TOOL CLEAN

Periodically blow out all air passages with dry compressed air. All plastic parts should be cleaned with a soft damp cloth. NEVER use solvents to clean plastic parts. They could possibly dissolve or otherwise damage the material.

⚠ WARNING Wear ANSI Z87.1 safety glasses while using compressed air.

FAILURE TO START

Should your tool fail to start, check to make sure the prongs on the cord plug are making good contact in the outlet. Also, check for blown fuses or open circuit breakers in the line.

LUBRICATION

This tool has been lubricated with a sufficient amount of high grade lubricant for the life of the unit under normal operating conditions. No further lubrication is necessary.

BRUSH INSPECTION (If applicable)

For your continued safety and electrical protection, brush inspection and replacement on this tool should ONLY be performed by an AUTHORIZED PORTER-CABLE SERVICE STATION or a PORTER-CABLE•DELTA FACTORY SERVICE CENTER.

At approximately 100 hours of use, take or send your tool to your nearest authorized Porter-Cable Service Station to be thoroughly cleaned and inspected. Have worn parts replaced and lubricated with fresh lubricant. Have new brushes installed, and test the tool for performance.

Any loss of power before the above maintenance check may indicate the need for immediate servicing of your tool. DO NOT CONTINUE TO OPERATE TOOL UNDER THIS CONDITION. If proper operating voltage is present, return your tool to the service station for immediate service.

SERVICE

REPLACEMENT PARTS

When servicing use only identical replacement parts.

SERVICE AND REPAIRS

All quality tools will eventually require servicing or replacement of parts due to wear from normal use. For assistance with your tool, visit our website at www.porter-cable.com for a list of service centers or call the Customer Care Department at 1-800-487-8665. All repairs made by our service centers are fully guaranteed against defective material and workmanship. We cannot guarantee repairs made or attempted by others.

Should you have any questions about your tool, feel free to write us at any time. In any communications, please give all information shown on the nameplate of your tool (model number, type, serial number, etc.).

ACCESSORIES

A complete line of accessories is available from your Porter-Cable•Delta Supplier, Porter-Cable•Delta Factory Service Centers, and Porter-Cable Authorized Service Stations. Please visit our Web Site www.porter-cable.com for a catalog or for the name of your nearest supplier.

▲ WARNING

Since accessories other than those offered by Porter-Cable•Delta have not been tested with this product, use of such accessories could be hazardous. For safest operation, only Porter-Cable•Delta recommended accessories should be used with this product.

WARRANTY

PORTER-CABLE LIMITED ONE YEAR WARRANTY

Porter-Cable warrants its Professional Power Tools for a period of one year from the date of original purchase. We will repair or replace at our option, any part or parts of the product and accessories covered under this warranty which, after examination, proves to be defective in workmanship or material during the warranty period. For repair or replacement return the complete tool or accessory, transportation prepaid, to your nearest Porter-Cable Service Center or Authorized Service Station. Proof of purchase may be required. This warranty does not apply to repair or replacement required due to misuse, abuse, normal wear and tear or repairs attempted or made by other than our Service Centers or Authorized Service Stations.

ANY IMPLIED WARRANTY, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WILL LAST ONLY FOR ONE (1) YEAR FROM THE DATE OF PURCHASE.

To obtain information on warranty performance please write to: PORTER-CABLE CORPORATION, 4825 Highway 45 North, Jackson, Tennessee 38305; Attention: Product Service. THE FOREGOING OBLIGATION IS PORTER-CABLE'S SOLE LIABILITY UNDER THIS OR ANY IMPLIED WARRANTY AND UNDER NO CIRCUMSTANCES SHALL PORTER-CABLE BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES. Some states do not allow limitations on how long an implied warranty lasts or the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

This warranty gives you specific legal rights and you may also have other legal rights which vary from state to state.

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**Parts and Repair Service for Porter-Cable • Delta Power Tools are Available at These Locations
(Obtenga Refacción de Partes o Servicio para su Herramienta en los Sigüientes Centros de Porter-Cable • Delta)
(Locations où vous trouverez les pièces de rechange nécessaires ainsi qu'un service d'entretien)**

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Fax: (602) 279-5470

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Fax: (909) 390-5554

San Diego 92111
7290 Clairemont Mesa Blvd.
Phone: (858) 279-2011
Fax: (858) 279-0362

San Leandro 94577 (Oakland)
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Fax: (510) 357-7939

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Fax: (303) 922-0245

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Fax: (954) 321-6638

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Fax: (813) 888-5997

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Suite 112
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Fax: (404) 608-1123

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Phone: (630) 424-8805
Fax: (630) 424-8895

Woodridge 60517 (Chicago)
2033 West 75th Street
Phone: (630) 910-9200
Fax: (630) 910-0360

KANSAS

Overland Park 66214
9201 Quivira Road
Phone: (913) 495-4330
Fax: (913) 495-4378

MARYLAND

Elkridge 21075 (Baltimore)
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Fax: (410) 799-9398

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Franklin Industrial Park
101E Constitution Blvd.
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Fax: (508) 528-8089

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30475 Stephenson Highway
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Fax: (704) 708-4625

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1948 Schrock Road
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Fax: (614) 895-3187

Cleveland 44125
8001 Sweet Valley Drive Unit #19
Phone: (216) 447-9030
Fax: (216) 447-3097

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14811 North East Airport Way
Phone: (503) 255-6556
Fax: (503) 255-6543

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520 North York Road
Phone: (215) 658-1430
Fax: (215) 658-1433

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Phone: (972) 446-2996
Fax: (972) 446-8157

Houston 77022-2122
536 East Tidwell Rd.
Phone: (713) 692-7111
Fax: (713) 692-1107

WASHINGTON

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3320 West Valley HWY, North
Building D, Suite 111
Phone: (253) 333-8353
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