

Double Insulated Plate Joiner

Instruction manual



**MODEL
557**

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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(Locations où vous trouverez les pièces de rechange nécessaires ainsi qu'un service d'entretien)

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288 Southwest 43rd Street
Phone: (425) 251-8680
Fax: (425) 251-9337

Authorized Service Stations are located in many large cities. Telephone 800-487-8665 or 801-541-6042 for assistance locating one. Parts and accessories for Porter-Cable products should be obtained by contacting any Porter-Cable Distributor, Authorized Service Center, or Porter-Cable Factory Service Center. If you do not have access to any of these, call 888-848-5175 and you will be directed to the nearest Porter-Cable Factory Service Center. Las Estaciones de Servicio Autorizadas están ubicadas en muchas grandes ciudades. Llame al 800-487-8665 o al 801-541-6042 para obtener asistencia a fin de localizar una. Las piezas y los accesorios para los productos Porter-Cable deben obtenerse contactando en contacto con cualquier distribuidor Porter-Cable, Centro de Servicio Autorizado o Centro de Servicio de Fábrica Porter-Cable. Si no tiene acceso a ninguna de estas opciones, llame al 888-848-5175 y le dirigiran al Centro de Servicio de Fábrica Porter-Cable más cercano. Des centres de service agréés sont situés dans beaucoup de grandes villes. Appelez au 800-487-8665 ou au 801-541-6042 pour obtenir ce centre de service agréé ou au 888-848-5175 pour obtenir ce centre de service agréé. Porter-Cable s'adresse à tout distributeur Porter-Cable, centre de service agréé ou centre de service d'usine Porter-Cable. Si vous n'avez accès à aucun de ces centres, appelez le 888-848-5175 et on vous dirigera vers le centre de service d'usine Porter-Cable le plus proche.

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Phone: (403) 735-6166
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GENERAL SAFETY RULES

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.

WORK AREA

1. **Keep your work area clean and well lit.** Cluttered benches and dark areas invite accidents.
2. **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust.** Power tools create sparks which may ignite the dust or fumes.
3. **Keep bystanders, children, and visitors away while operating a power tool.** Distractions can cause you to lose control.

ELECTRICAL SAFETY

1. **Double insulated tools are equipped with a polarized plug (one blade is wider than the other). This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install a polarized outlet. Do not change the plug in any way.** Double Insulated eliminates the need for the three wire grounded power cord and grounded power supply system.
2. **Avoid body contact with grounded surfaces such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is grounded.
3. **Don't expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
4. **Do not abuse the cord. Never use the cord to carry the tools or pull the plug from an outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately.** Damaged cords increase the risk of electric shock.
5. **When operating a power tool outside, use an outdoor extension cord marked "W-A" or "W".** These cords are rated for outdoor use and reduce the risk of electric shock.

PERSONAL SAFETY

1. **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.
2. **Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves away from moving parts.** Loose clothes, jewelry, or long hair can be caught in moving parts.
3. **Avoid accidental starting. Be sure switch is OFF before plugging in.** Carrying tools with your finger on the switch or plugging in tools that have the switch ON invites accidents.
4. **Remove adjusting keys or switches before turning the tool ON.** A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.

5. **Do not overreach. Keep proper footing and balance at all times.** Proper footing and balance enable better control of the tool in unexpected situations.

6. **Use safety equipment. Always wear eye protection.** Dust mask, non-skid safety shoes, hard hat, or hearing protection must be used for appropriate conditions.

TOOLS USE AND CARE

1. **Use clamps or other practical way to secure and support the workpiece to a stable platform.** Holding the work by hand or against your body is unstable and may lead to loss of control.
2. **Do not force tool. Use the correct tool for your application.** The correct tool will do the job better and safer at the rate for which it is designed.
3. **Do not use tool if switch does not turn it ON or OFF.** A tool that cannot be controlled with the switch is dangerous and must be repaired.
4. **Disconnect the plug from the power source before making any adjustments, changing accessories, or storing the tool.** Such preventive safety measures reduce the risk of starting the tool accidentally.
5. **Store idle tools out of reach of children and other untrained persons.** Tools are dangerous in the hands of untrained users.
6. **Maintain tools with care. Keep cutting tools sharp and clean.** Properly maintained tools, with sharp cutting edges are less likely to bind and are easier to control.
7. **Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tool's operation. If damaged, have the tool serviced before using.** Many accidents are caused by poorly maintained tools.
8. **Use only accessories that are recommended by the manufacturer for your model.** Accessories that may be suitable for one tool may become hazardous when used on another tool.

SERVICE

1. **Tool service must be performed only by qualified repair personnel.** Service or maintenance performed by unqualified personnel may result in a risk of injury.
2. **When servicing a tool, use only identical replacement parts. Follow instructions in the Maintenance Section of this manual.** Use of unauthorized parts or failure to follow Maintenance Instructions may create a risk of electric shock or injury.











SPECIFIC SAFETY RULES AND SYMBOLS

1. **Keep guards (base) in working order.** Check operation before each use. Do not use if guard does not close briskly over blade. **CAUTION:** If machine is dropped, guard may distort restricting operation. Keep slide mechanism free of wood chips. Occasionally lubricate ways with light machine oil. **DO NOT OVERLUBRICATE** as this creates excessive sawdust buildup.
2. **Keep blades clean and sharp.** Sharp blades minimize stalling and kickback.
3. **DANGER: Keep hands away from cutting area.** Keep hands away from blade. Do not reach underneath work while blade is rotating. **CAUTION:** Blades coast after being turned off.

4. **Guard against kickback.** Release switch immediately if blade binds or motor stalls. Keep blade sharp. Do not force tool. Stay alert and exercise control.
5. **Use only correct blades in mounting.** Do not use blades with incorrect size holes. Never use defective or incorrect blades, washers or bolts.
6. **Avoid cutting nails and knots.** Inspect for and remove all nails from lumber before cutting. Try to layout cuts between knots.
7. **WARNING: Blade may protrude through workpiece,** keep hands and all body parts away from blade area during operation.
8. **Some wood contains preservatives which can be toxic.** Take extra care to prevent inhalation and skin contact when working with these materials. Request, and follow, any safety information available from your material supplier.
9. **WARNING:** There are certain applications for which this tool was designed. Porter-Cable strongly recommends that this tool 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 tool until you have written Porter-Cable and we have advised you.

Technical Service Manager
 Porter-Cable Corporation
 4825 Highway 45 North
 P. O. Box 2468
 Jackson, TN 38302-2468

SYMBOL DEFINITION

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

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.

EXTENSION CORD SELECTION

If an extension cord is used, make sure the conductor size is large enough to prevent excessive voltage drop which will cause loss of power and possible motor damage. A table of recommended extension cord sizes will be found in this section. This table is based on limiting line voltage drop to 5 volts (10 volts for 230 volts) at 150% of rated amperes.

If an extension cord is to be used outdoors it must be marked with the suffix W-A following the cord type designation. For example – SJTW-A to indicate it is acceptable for outdoor use.

RECOMMENDED EXTENSION CORD SIZES FOR USE WITH PORTABLE ELECTRIC TOOLS

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

FUNCTIONAL DESCRIPTION

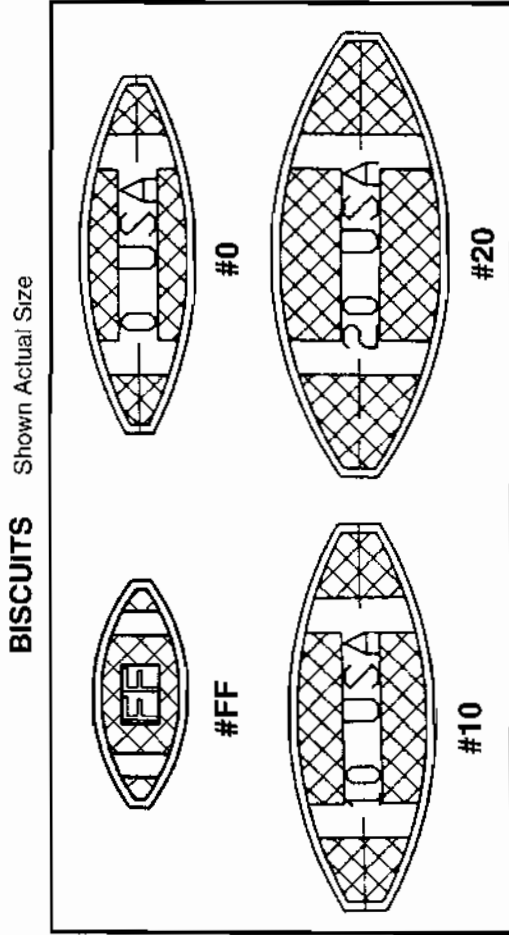
FOREWORD

Model 557 is designed to cut the grooves required for Porter-Cable biscuit sizes "FF", "0", "10", and "20". Adjustments are also provided which allow the machine to cut grooves for the following plate joiner accessories sold by other manufacturers: #6 biscuits, Duplex accessories, and Simplex accessories.

SELECTING THE BISCUIT

Biscuits are $\frac{5}{16}$ " thick. They are available from Porter-Cable in four sizes as shown below. Five of each size are furnished with your Plate Joiner.

Choose the largest biscuit that will accommodate the type of joint being made.



TO START AND STOP MACHINE

CAUTION: Make sure switch is OFF and power circuit voltage is the same as that shown on the specification plate.

1. Connect machine to power circuit.
2. Grip machine firmly to resist starting torque, and squeeze trigger switch (A) Fig. 1, to START machine.
3. Release trigger switch to STOP machine.
4. Switch Lock: the trigger switch may be locked in the ON position as follows:
 - Squeeze trigger switch to START motor and depress lock button (B) Fig. 1, while releasing trigger switch. Release lock button.
 - To STOP machine: squeeze trigger switch and release, while leaving lock button free to spring out.

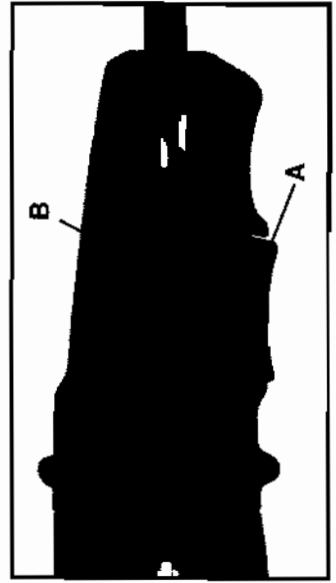


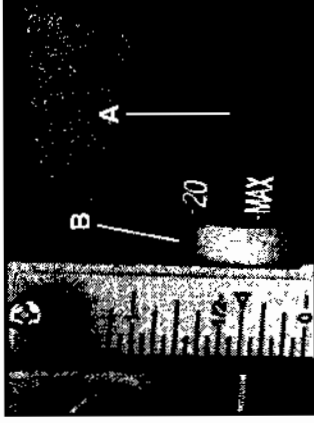
Fig. 1

ADJUSTING DEPTH OF GROOVE

A "quick set" depth adjusting turret (A) Fig. 2, provides for quick changes in depth of cut to accommodate the various sizes of available biscuits and other accessories. To set depth of cut: rotate depth adjusting turret until desired size marking on turret aligns with the index mark (B) Fig. 2. The following depth settings are provided:

- 0 For "0" size accessories
- 10 For "10" size accessories
- 20 For "20" size accessories
- MAX For "6" size accessories, provides maximum depth of cut with 4" blade
- FF For Porter-Cable "FF" biscuits
- D For "Duplex" accessories
- S For "Simplex" accessories

Fig. 2



FINE ADJUSTMENT (Depth of Groove)

The "quick set" depth adjustment is adjusted at the factory to produce joints with nominal clearance (biscuit to groove). A fine adjustment is provided allowing the operator to reduce or increase the clearance as desired. Adjust as follows:

1. Use an $\frac{7}{16}$ " wrench to loosen lock-nut (A) Fig. 3.
2. Rotate fine adjustment knob (B) Fig. 3, to desired position (rotate knob clockwise to reduce depth of cut, rotate knob counterclockwise to increase depth of cut).
3. While holding adjustment knob in desired position: tighten lock-nut firmly.

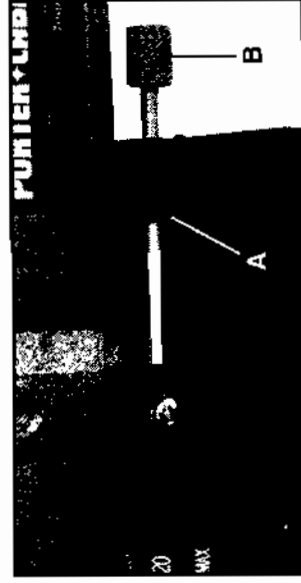


Fig. 3

ADJUSTABLE FENCE

Model 557 is equipped with an integral, adjustable fence which:

- Provides micro height adjustment, distance scale indexes to top of cut, to center of cut, and to bottom of cut.
- Tilts 0° through 135°, with an adjustable stop at 90°.
- Does not have to be removed to make "flush" cuts.

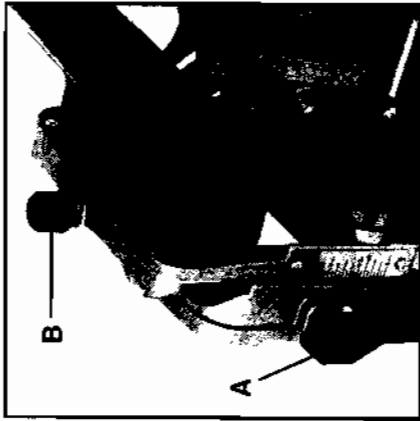


Fig. 4

Height Adjustment (see Figs. 4 & 5)

1. Loosen locking knob (A), and rotate knob (B) to position the fence as desired, (rotate knob clockwise to raise fence, rotate knob counterclockwise to lower fence).
2. The depth scale (C), indicates the distance from the top edge of the workpiece to the blade:
 - The line across the center of the index block (D), indicates the distance to the center of the blade.
 - The top edge of the index block (D), indicates the distance to the bottom of the blade.
 - The bottom edge of the index block (D), indicates the distance to the top of the blade.
3. Once fence is in desired position, tighten knob (A), to secure in place.

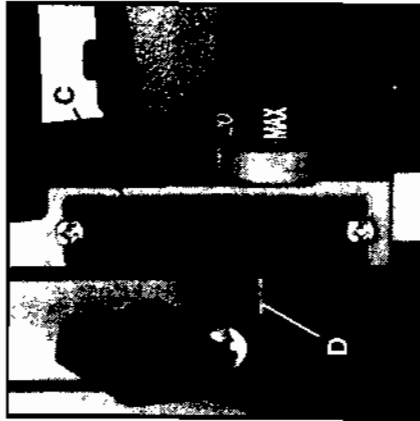


Fig. 5

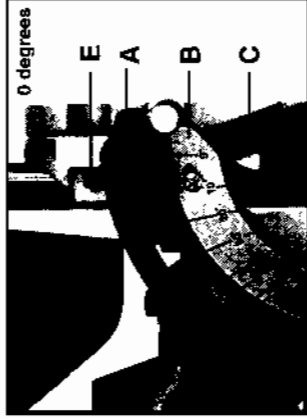


Fig. 6

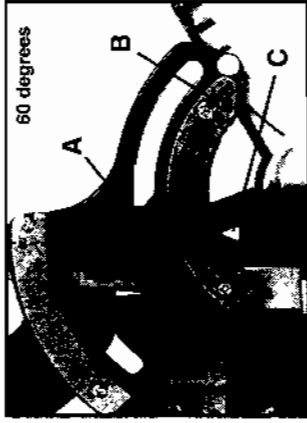


Fig. 7

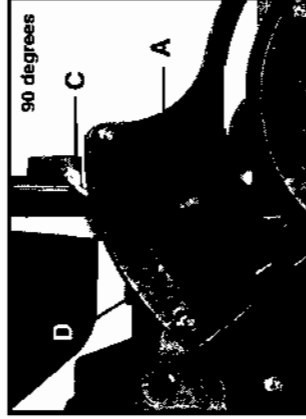


Fig. 8

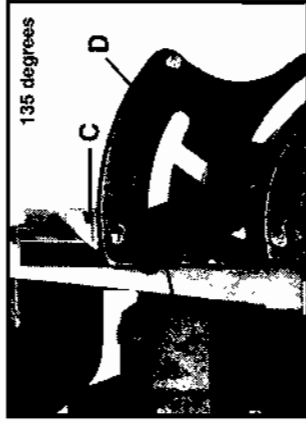


Fig. 9

BLADES (2" and 4")

Model 557 is shipped with a 4" diameter blade installed. This blade is used for all operations except for the "FF" biscuit. The "FF" biscuit requires that the 2" blade (furnished with the machine), be installed as follows:

CAUTION: Disconnect machine from power source.

1. Loosen four blade cover retaining screws (A) Fig. 10, and remove blade cover.
2. Depress and hold spindle lock button (B) Fig. 11, while rotating blade by hand until spindle lock engages.
3. Continue to hold spindle lock button while using the spanner wrench (furnished with machine), to remove blade retaining flange, (by rotating flange counterclockwise).

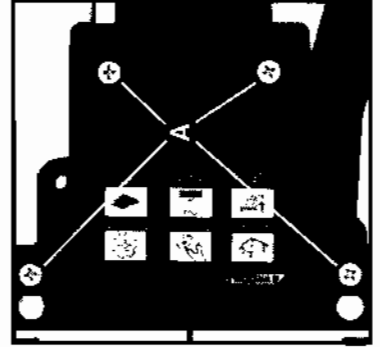


Fig. 10

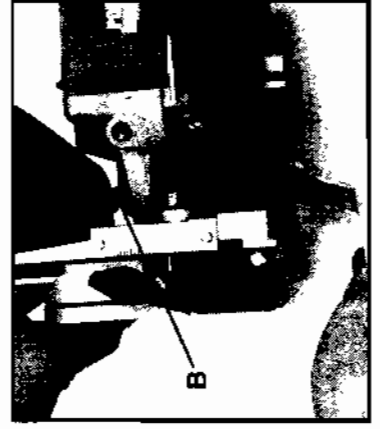


Fig. 11

Angle Adjustment (see Figs. 6, 7, 8 & 9)

1. Loosen locking knob (A).
2. For angles between 0° and 90°: swing fence downward until desired angle on lower scale (B), aligns with lower index mark (E). Tighten knob (A), to secure in place.
3. For angles between 90° and 135°: swing fence downward until the "gate" between the upper scale (D), and lower scale (B), aligns with locking knob. Swing scale arm down to align knob with upper scale. Move fence until desired angle on upper scale (D), aligns with upper index mark (E). Tighten knob (A), to secure in place.

FINE ADJUSTMENT (90° Position)

The adjustable 90° stop is factory adjusted for 90° and should not require additional adjustment. If "fine tuning" of the stop position is required: use a 3/64" hex wrench (not furnished), to rotate set-screw (E) Fig. 6, as required. Rotate the set-screw clockwise to reduce the angle of the fence, rotate the set-screw counterclockwise to increase the angle of the fence.

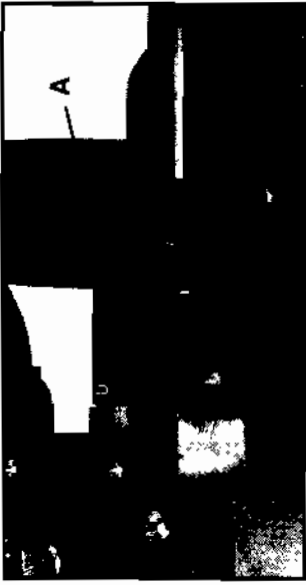


Fig. 12

4. Remove blade and store in a safe place for future use.
5. Place 2" diameter blade (furnished with machine), onto blade mounting flange (orient with teeth facing in same direction as directional arrow cast in housing, see Fig. 14).
6. Position blade retaining flange (flat side out), to spindle and rotate clockwise until hand-tight.
7. Depress and hold spindle lock button (B) Fig. 11, while rotating blade by hand until spindle lock engages.
8. Continue to hold spindle lock button while using the spanner wrench (furnished with machine), to tighten blade retaining flange securely, (by rotating flange clockwise).
9. Rotate the "quick set" depth adjusting turret (A) Fig. 12, to the "FF" position.
10. Lift safety lever (A) Fig. 13, fully retract the plunge mechanism, and reposition the safety lever as shown in Fig. 14. **Slowly** release pressure on plunge mechanism.
11. Reposition blade cover plate to machine, and secure in place with the four retaining screws (removed in step 1).

WARNING: Do not operate machine without blade cover installed.

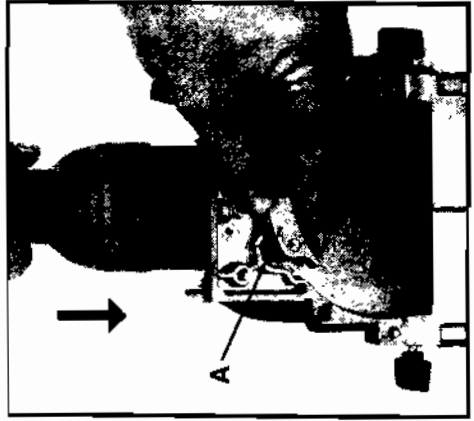


Fig. 13



Fig. 14

ASSEMBLY

ALIGNMENT PLATE (For Narrow Stock)

When joining narrow material, it will be necessary to install the alignment plate (A) Fig. 15, (furnished with machine). The alignment plate provides added support for narrow material, and has index marks to aid in centering the cut in the narrow material. Index marks are provided for 1½" wide, and 2" wide material. Install alignment plate as follows:

CAUTION: Disconnect machine from power source.

1. Align alignment plate with fence (see Fig. 15).
 2. Slide alignment plate onto fence until it is seated (see Fig. 16).
- NOTE:** When alignment plate is installed; increase machine depth setting by ⅜" (to allow for thickness of the alignment plate).
3. To remove alignment plate: lift lightly on the alignment plate and slide off fence.



Fig. 15



Fig. 16

"DOUBLE" BISCUITS

The alignment plate may also be used as a spacer to produce a groove that is wide enough to accept two biscuits. After cutting a groove (or a group of grooves), in the normal fashion; install the alignment plate and repeat the cuts. This will double the width of each groove so that two biscuits can be installed in each groove.

DUST PORT

The machine is equipped with a dust port (A) Fig. 17. A large volume of sawdust and chips will be exhausted from this port during machine operation. A directional dust nozzle and a dust bag are furnished with the machine. A standard 1" vacuum hose can also be connected to the dust port to facilitate dust collection.

CAUTION: Do not operate the machine without a directional nozzle, or a dust bag, or a vacuum hose attached to the dust port.

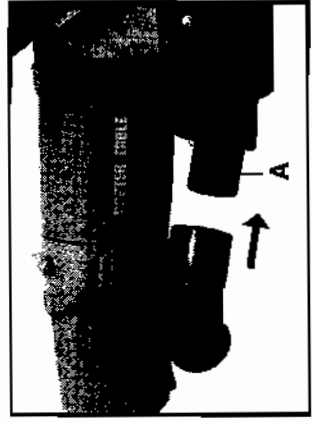


Fig. 17

Directional Dust Nozzle

The directional nozzle pushes onto the dust port (see Fig. 17). The nozzle can be rotated 360° to direct the dust and chips away from the operator.

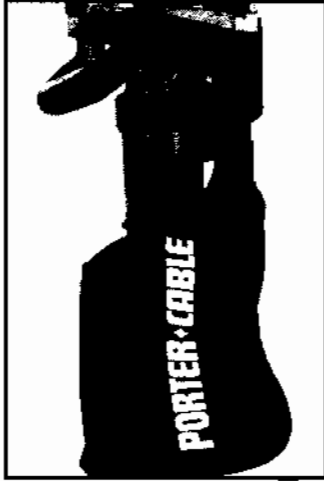


Fig. 18

Dust Bag

The dust bag pushes onto the dust port (see Fig. 18). The bag is equipped with a zipper to ease emptying of the collected material.

Vacuum Hose

A standard 1" vacuum hose (like Porter-Cable #39332), can be attached to the dust port to provide a means for connecting the machine to your vacuum cleaner or dust collection system.

"DUPLEX" HINGES

The 557 can be used to make the mortises required for installing "duplex" hinges. To accomplish this, you must make a spacer and attach it to the 557 fence. The spacer can be made of scrap 3/4" thick wood. Cut the spacer to approximately 3 3/8" by 5 1/4", and attach it to the fence with two 3/4" long wood screws (see Fig. 18A).



Fig. 18A

#6 BISCUITS

With the 4" blade installed, set the depth adjusting turret to the MAX position. Two cuts will be required to produce each groove for a #6 biscuit. The centerlines of these two cuts should be spaced 1/4" apart. When laying-out these cuts, mark the first cut centerline, move over 1/4" and mark the second cut centerline.

OPERATION

POSITIONING GROOVES

The number of grooves (biscuits) used in a joint may be varied to provide the strength required for the particular application. Typically, the center of the first groove is positioned approximately two inches from the edge of the work with additional grooves spaced at three to six inches on centers.

In most cases, one line of grooves (biscuits) positioned approximately along the centerline of the material is used. On thicker material, an additional row(s) of biscuits may be used for added strength. The possibilities are almost endless. Position the two workpieces (to be joined) in the relationship desired after joining. Mark the centerline of each groove required as shown in Fig. 19. Use a square to assure accuracy.

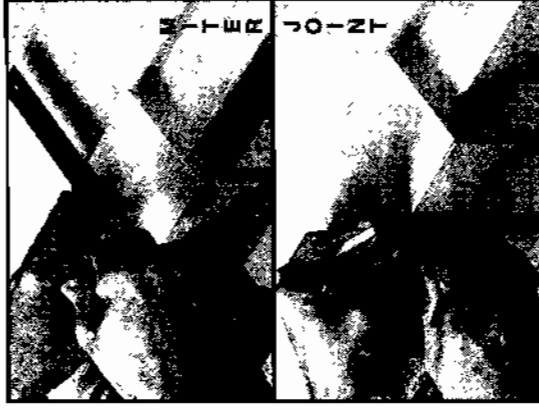


Fig. 19

PRACTICE CUTS

After each set-up or adjustment to the machine, it is recommended you make several practice cuts in scrap material to verify desired operation.

CORNER JOINTS

1. Layout groove positions as described in POSITIONING GROOVES.
2. Set depth stop turret to desired biscuit (or other accessory), size.
3. Set the tilt fence to the 90° position (see Angle Adjustment Section of this manual).
4. Set fence height adjustment to desired height (usually 1/2 the material thickness), (see Height Adjustment Section of this manual).
5. Clamp the workpiece securely.
6. Position machine to workpiece with bottom of fence resting on workpiece. Align guide notch (A) or (B) Fig. 20, with a groove centerline. Apply pressure to auxiliary handle (C) Fig. 20, to keep front of machine and fence in firm contact with workpiece.

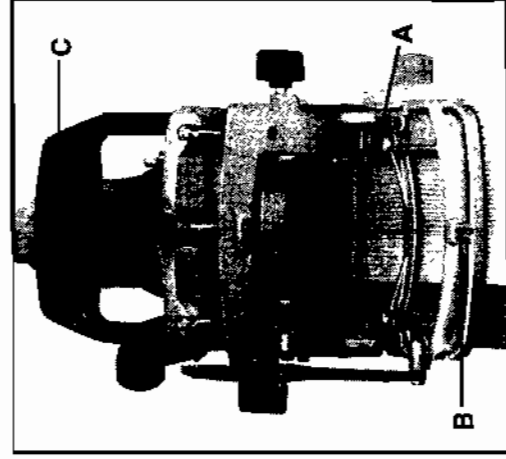


Fig. 20

7. Hold machine firmly as shown in Fig. 21, squeeze trigger switch to start machine.
8. At a slow, steady pace, push machine forward in base as far as depth stop allows.
9. Release trigger switch to stop machine and remove machine from work.
10. Repeat steps 6 through 9 until all the grooves for this joint are completed.

NOTE: Assemble all joints and verify alignments before applying glue (see Fig. 22).

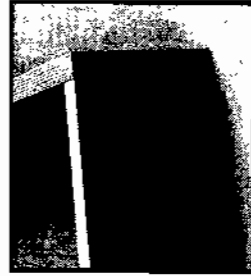
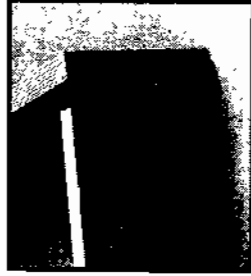


Fig. 22

SURFACE ("T") JOINTS

1. Layout groove positions as described in POSITIONING GROOVES.
2. Set depth stop turret to desired biscuit (or other accessory), size.
3. Mark centerline of joint on workpiece "A" (see Fig. 23).
4. Clamp a straight edge guide to the workpiece, $\frac{3}{8}$ " back from the joint centerline (as marked in Step 2). Clamp workpiece securely (see Fig. 24).



Fig. 23



Fig. 24

5. Set tilt fence to 0° position (see Angle Adjustment Section of this manual).
6. Position machine to workpiece with bottom of base against straight edge and guide notch (C) Fig. 25, aligned with a groove centerline. Apply pressure to auxiliary handle (D) Fig. 25 to hold machine firmly in place.
7. Hold machine firmly as shown in Fig. 21. Squeeze trigger switch to start machine.

8. At a slow, steady pace, push machine forward in base as far as depth stop allows.
9. Release trigger switch to stop machine and remove machine from work.
10. Repeat steps 5 through 8 until all the grooves in workpiece "A" are completed.
11. Follow steps 3 through 10 of CORNER JOINTS Section to complete required grooves in workpiece "B" Fig. 23.

NOTE: Assemble all joints and verify alignments before applying glue (see Fig. 26).

BUTT JOINTS

Machine adjustment and operation for producing butt joints (see Fig. 19), is the same as for CORNER JOINTS.

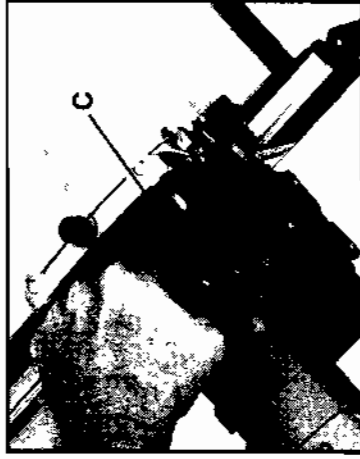


Fig. 25

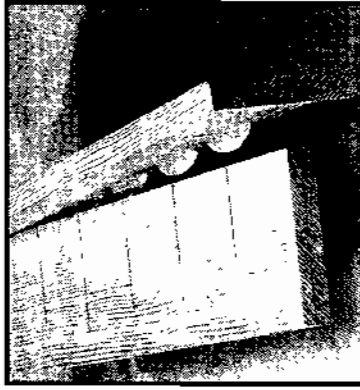


Fig. 26

MITER JOINTS

1. Layout groove positions as described in POSITIONING GROOVES.
2. Set depth stop turret to desired biscuit (or other accessory), size.
3. Set the tilt fence to desired angle (see Angle Adjustment Section of this manual).
4. Set fence height adjustment to desired height (see Height Adjustment Section of this manual).
5. Clamp workpiece securely.
6. Position machine to workpiece utilizing either guide notch (A) or (B) Fig. 27, to align machine with a groove centerline. Apply pressure to auxiliary handle (C) Fig. 27, to hold machine firmly in place.

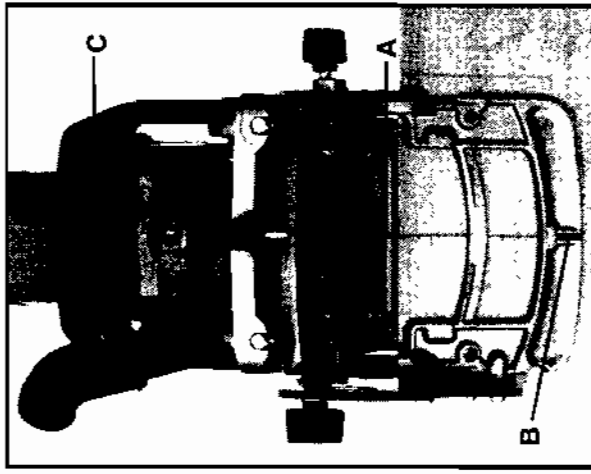


Fig. 27

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; worn parts replaced, when necessary; relubricated with fresh lubricant, if required; reassembled with new brushes; and performance tested.

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 AND REPAIRS

All quality tools will eventually require servicing or replacement of parts due to wear from normal use. These operations, including brush inspection and replacement, should **ONLY** be performed by either an AUTHORIZED PORTER-CABLE SERVICE STATION or a PORTER-CABLE SERVICE CENTER. All repairs made by these agencies are fully guaranteed against defective material and workmanship. We cannot guarantee repairs made or attempted by anyone other than these agencies.

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

For safest operation, it is recommended that only these accessories be used with this product.

WARNING: Do not use accessories other than those shown in chart. Use of such accessories could be hazardous.

883175	Dust Bag
886492	Directional Nozzle
888776	Alignment Plate (for narrow material)
482333	Blade Wrench
886485	Carrying Case
5558	4" Blade
5559	2" Blade

BISCUITS

5563	"FF"	Tube of 175
5560	"0"	Tube of 150
5551	"0"	Box of 1000
5561	"10"	Tube of 125
5552	"10"	Box of 1000
5562	"20"	Tube of 100
5553	"20"	Box of 1000
5554	Assorted	Box of 1000



Fig. 29

7. Hold machine firmly as shown in Fig. 28, and squeeze trigger switch to start machine.
8. At a slow, steady pace, push machine forward in base as far as depth stop allows.
9. Release trigger switch to stop machine and remove machine from work.
10. Repeat Steps 5 through 8 until all the grooves for this joint are completed.

NOTE: Assemble all joints and verify alignments before applying glue (see Fig. 29).

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.

CAUTION: Wear 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 AND LUBRICATION

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 SERVICE CENTER.

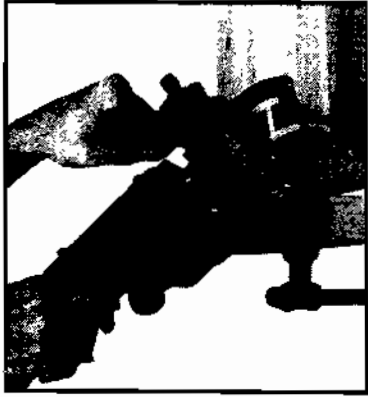


Fig. 28

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, P.O. Box 2468, Jackson, Tennessee 38302-2468; 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.