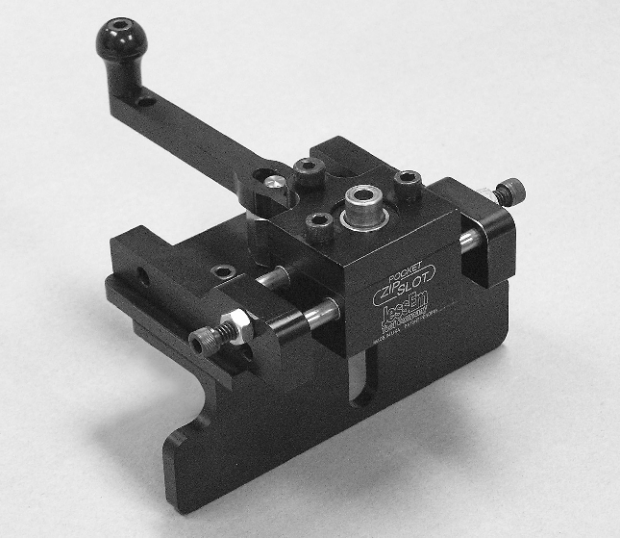
POCKET ZIPSLOT™ Mortise Mill

User Manual

Model #08200



Thank you for choosing this product from JessEm Tool Company. We appreciate your support and hope that our product serves you well. This product is designed to provide many years of reliable service provided it is used as intended and taken care of.

This user manual will assist you in assembly and general operation of this product. It is not our intent to teach you about woodworking. It is assumed that you are an experienced woodworker with the basic skills and experience necessary to use this product safely. If after reading the following instructions, if you are unsure or uncomfortable about safely using this product we urge you to seek additional information through widely available woodworking books or classes.

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IMPORTANT!

WARNING - THIS PRODUCT IS FOR USE WITH A HAND DRILL ONLY!

WARNING - DO NOT ATTEMPT TO USE THE MORTISE DRILL BIT (or any drill bit) IN ANY TYPE OF ROUTER DEVICE AS SERIOUS INJURY MAY OCCCUR.

READ ADDITIONAL WARNINGS ON PAGE 2 BEFORE USING THIS PRODUCT

IMPORTANT!

Read and understand the contents of this manual before assembly or operation of this product.

As part of our Continuous Product Improvement Policy, JessEm products are always advancing in design and function. Therefore there may be differences between what is shown in our catalogs, website or at retail display and what is sold at time of purchase. We reserve the right to make positive changes to our products at our discretion.

ADDITIONAL RECOMMENDED TOOLS AND ACCESSORIES

1/2" Hand Drill - Corded or Cordless 1,200 RPM (Min.)

Vacuum (such as Shop Vac)

Bench Vise for holding jig and workpiece

IMPORTANT SAFETY PRECAUTIONS

WARNING - DO NOT ATTEMPT TO USE THE MORTISE DRILL BIT (or any drill bit) IN ANY TYPE OF ROUTER DEVICE AS SERIOUS INJURY MAY OCCCUR.
Drill bits are not designed for the high-RPM output of a Router and could cause the drill bit to bend and break and cause serious bodily injury. The mortise drill bits are for use in a hand drill only.
DO NOT USE A ROUTER OF ANY TYPE WITH THIS PRODUCT. This product's guide bushing and bearings are not designed for the high-RPM output of any power router device.

- Before operating any machinery or power tool, read and understand all safety instructions in the owner's manual for the tool or machine.
- If you do not have a manual, contact the manufacturer and obtain one before using any tool or machine.
- Always wear eye protection in compliance with ANSI safety standards when operating any power tools or machinery.
- Always use proper guards and safety devices when operating power tools and machinery.
- Carefully check drill bits before each use. Do not use if damage or defect is suspected.
- Do not exceed the recommended RPM for any drill bit.
- Do not wear loose clothing or jewelry that may catch on tools, machinery or equipment.
- Unplug the tool or machine when mounting or making any adjustments to mechanical performance.

OVERVIEW OF THE POCKET ZIP SLOT MORTISE MILL By JessEm Tool Company

The Pocket Zip Slot Mortise Mill is a unique joinery system designed to cut mortises in wood for the purpose of mortise and loose tenon joinery. This product offers a means of accurately positioning mortises in two workpieces that can then be joined with a loose tenon.

The Model 8200 comes with a 1/4" diameter mortising drill bit and matching 1/4" drill guide bushing.

CONTENTS OF PARTS BAG

(1) - 3/16" hex wrench
(1) - 1/8" hex wrench
(1) 3/8" I.D. stop collar w/set screw
(5) Pre-cut tenons

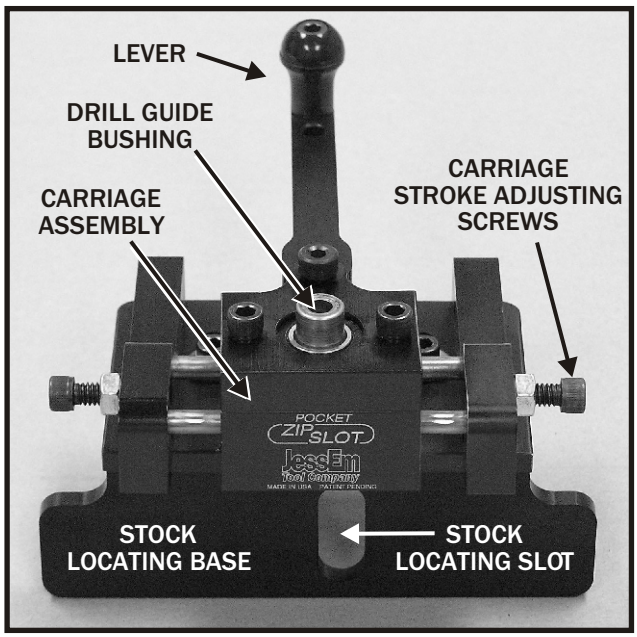

FIG. 1

SETTING UP THE POCKET ZIP SLOT

There are two easy steps you need to take to set-up the Pocket Zip Slot Mortise Mill.

1. Set the carriage plate to position the mortise in center of the workpiece.

2. Position the workpiece by aligning the Pocket Zip Slot with locating mark you scribe onto the workpiece.

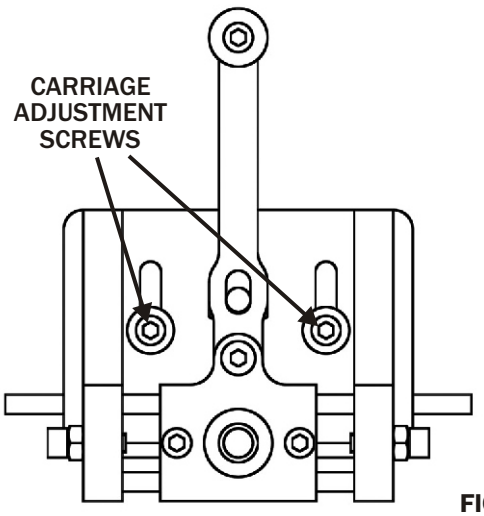

FIG. 2

TOP VIEW

ADJUSTING THE CARRIAGE PLATE

1. Adjust the carriage plate by loosening the two 1/4-20 socket head cap screws (Fig. 2) using the 3/16" hex wrench provided. Then slide the plate to offset the carriage from the stock locating base. Keep in mind that the dotted line (Letter "A", Fig. 3) represents the front edge of the carriage plate, which is also the centerline of the drill bit.

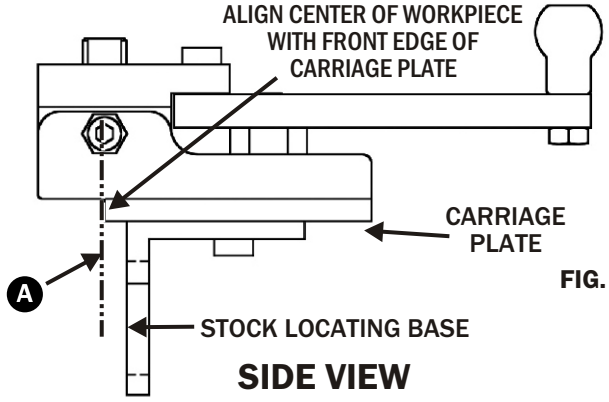

FIG. 3

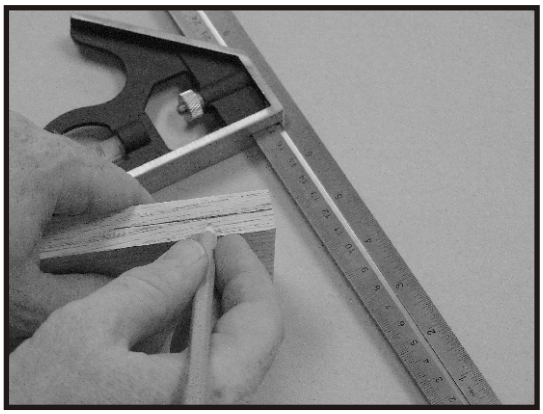

FIG. 4

2. You can scribe a line along the center of the workpiece to locate the position of the carriage plate (Fig. 4). Or you can set the offset of the carriage plate (Letter "A" Fig. 3) by measuring half the thickness of the workpiece. For example, if you are centering a mortise in 3/4" stock, set the carriage plate to offset the stock locating base 3/8 of an inch.

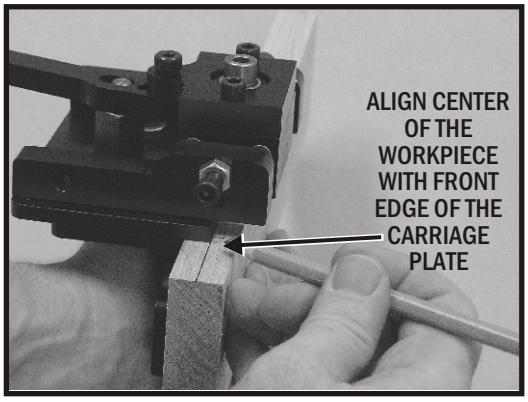

FIG. 5

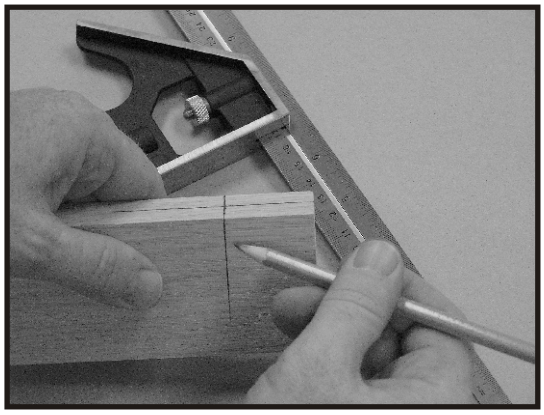

FIG. 6

POSITIONING THE POCKET ZIP SLOT ON THE WORKPIECE.

1. Scribe a line on the side of the workpiece to locate the "center" of the mortise you want to cut (Fig. 6). Then position the Pocket Zip Slot onto the workpiece and align this mark with the right side of the slot in the stock locating base (Fig. 7).

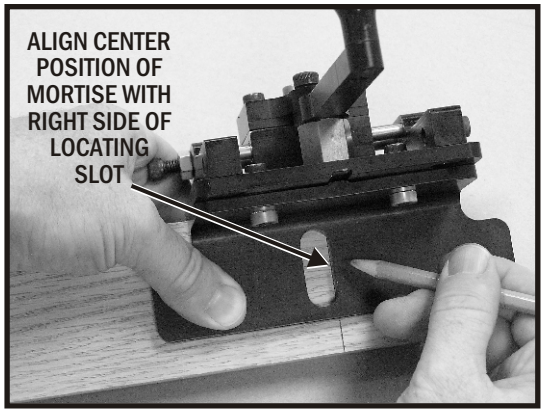

FIG. 7

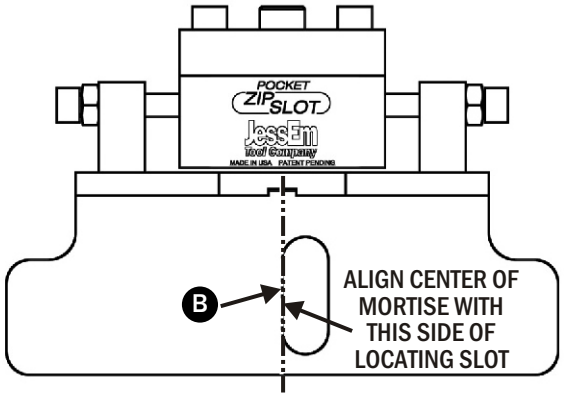

FIG. 8

2. When determining the position of the mortise, keep in mind that the right side (when viewed from the back) of the stock locating slot represents the center of the mortise (Fig. 7). The dotted line (Letter "B" Fig. 8) also represents the center of the mortise, Which is also the center line of the drill bit.

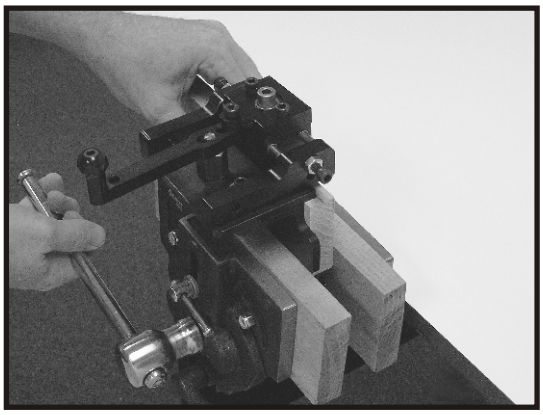

FIG. 9

SECURE THE POCKET ZIP SLOT IN A VISE

1. Continue to hold the Pocket Zip Slot positioned onto the workpiece and place together into a bench vise to hold the two pieces securely in position.

FIG. 10

INSTALLING THE MORTISE DRILL BIT AND STOP COLLAR

1. Slide the stop collar onto the drill bit and using the 1/8" hex wrench, tighten the set screw to secure the stop collar in position. Because of the length of the drill guide bushing, thickness of carriage plate, etc., you will need to add 2.4 inches to the desired depth of the mortise you are cutting (Fig. 10).

2. Insert the drill bit into the drill chuck and tighten the bit securely (Fig. 10).

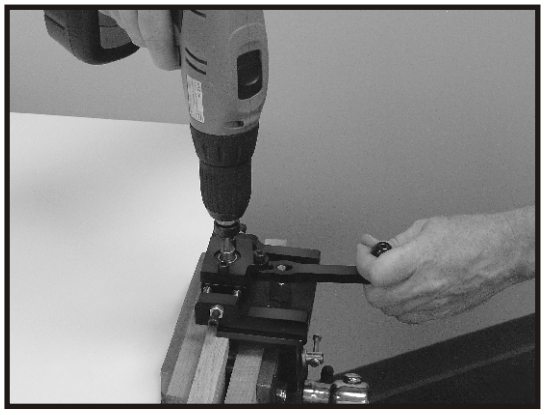

FIG. 11

MILLING THE MORTISE

1. With one hand holding the drill, insert the drill into the drill guide bushing. Place your other hand on the handle for the lever. As you pull the trigger on the drill begin moving the lever from side to side (Fig. 11). You should begin milling the mortise with very little to no downward pressure on the drill as you slide the lever from one end of the mortise to the other. This will give a cleaner cut to the top edge of the mortise. Once past the surface you can apply a little more downward pressure as needed. Continue milling with drill running and moving the lever from side to side until the desired depth is accomplished.

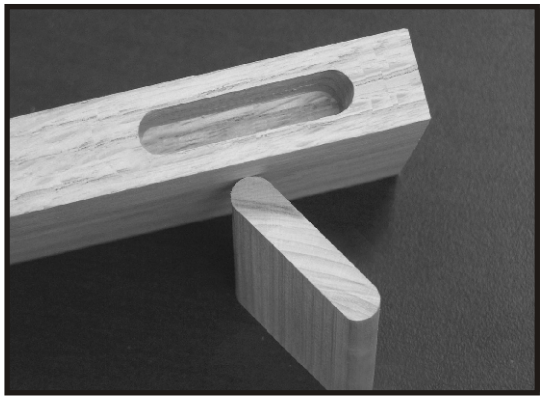

FIG. 12

CHECKING THE TENON FIT AND ALIGNMENT

Due to the variables in aligning the position of the mortises it will be necessary to make test cuts and check for the desired fit of the tenons in the mortise. Small adjustments to the length of the mortise can be made with the carriage stroke adjustment screws (Fig. 1). Once the correct positioning is determined, repeatable accuracy is easy to achieve with the Pocket Zip Slot Mortise Mill (Fig. 12).