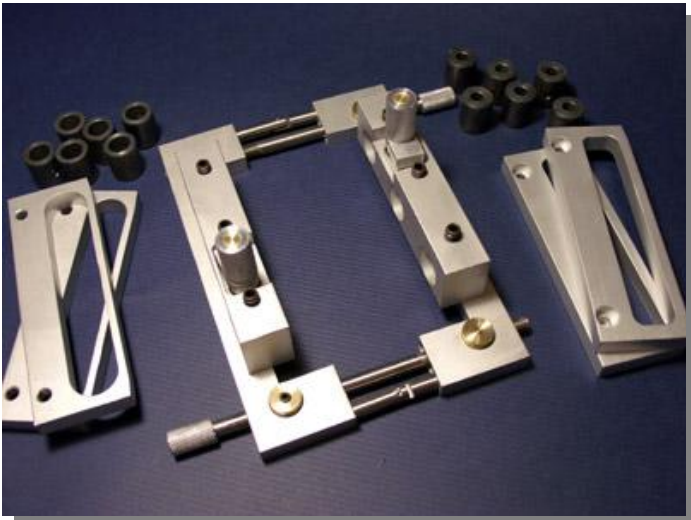


## COMBINATION SLOT HEAD FIXTURE

This Combination slot head fixture is all you need in one tool! Its dual-sided, self centering design takes the guesswork out of headstocks alignment! No measuring required simply clamp it the headstock, drill the machine holes and cut the slots all in one setup. Two sets of drill bushing are included, one for a 1/4 inch and 13/32 inch drill. The templates that are included are our standard size, but custom sizes can be machined to your specifications.

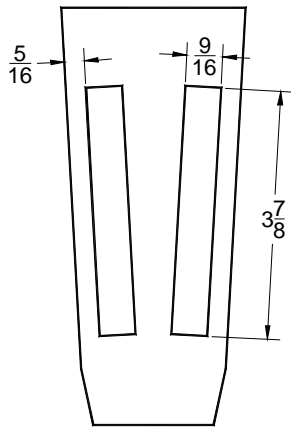


### S A F E T Y

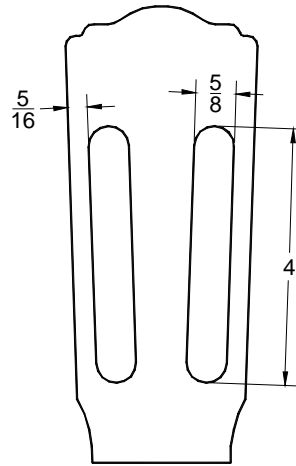
#### W A R N I N G

- |  |   |
|--|---|
| <ol style="list-style-type: none"> <li>1. <b>ALWAYS</b> wear safety glasses or a face shield.</li> <li>2. <b>DO NOT</b> wear loose clothing, gloves, neckties, or jewelry. Wear protective cover on hair and prevent contact with moving tool. These items can get caught in tool during operation and pull operator into moving part.</li> <li>3. <b>KEEP</b> children away.</li> <li>4. <b>KEEP</b> visitors at a safe distance.</li> <li>5. <b>WEAR</b> a dust mask all times.</li> <li>6. <b>ALWAYS</b> turn off motor before making any adjustments.</li> </ol> | <ol style="list-style-type: none"> <li>7. <b>NEVER</b> leave running tool unattended.</li> <li>8. <b>ALWAYS</b> make sure all screws are tight and any hardware is removed from or near tool before starting.</li> <li>9. <b>SECURE</b> all work pieces before starting.</li> <li>10. <b>ALWAYS</b> keep cutters bit sharp.</li> <li>11. <b>ALWAYS</b> keep work area clean.</li> <li>12. <b>DO NOT</b> operate tool if under the influence of drugs or alcohol.</li> <li>13. <b>DO NOT</b> adjust tool while running.</li> </ol> |
|--|---|

## STANDARD SLOTS



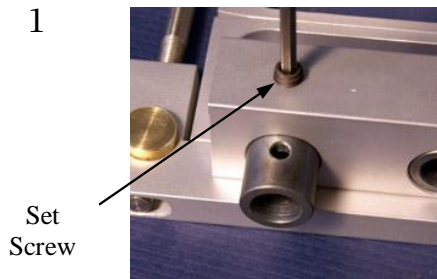
STEEL



CLASSICAL

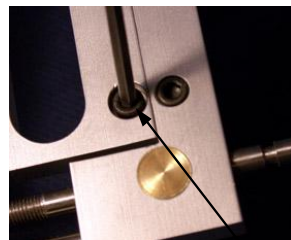
## SET UP

1



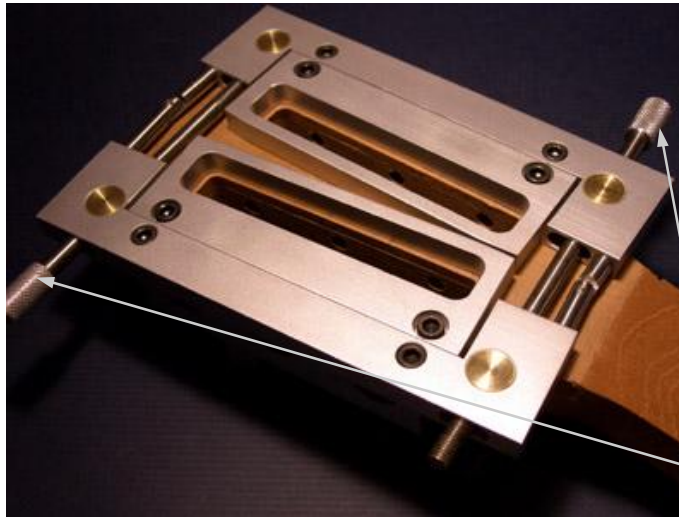
To exchange drill bushings, loosen 1/4-20 dog nose set screw until bushing comes out replace and tighten. Make sure that the hole in the bushing is aligned with the set screw. Do not over tighten.

2



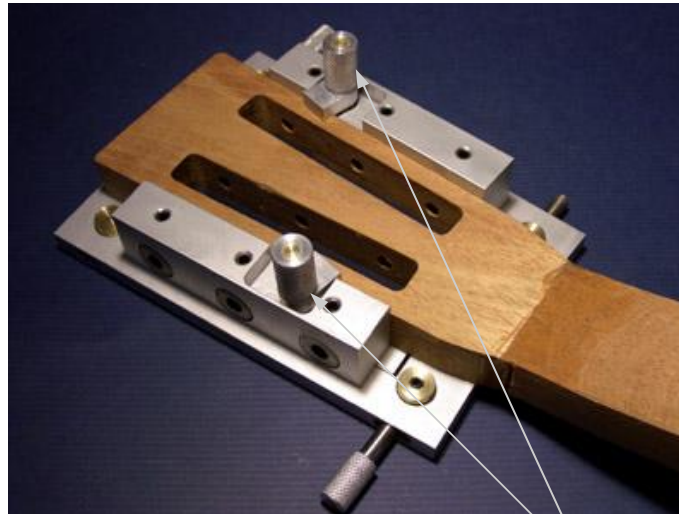
To exchange templates simply loosen screws replace template and tighten screws. If you have an offset template make sure that the template is aligned with respect to the drill bushings.

## O P E R A T I O N



Place the head stock in tool, position head stock to where you would like to place the slots and machine holes, then tighten the two side knobs until the tool is tight on the head stock sides. The tool will automatically center itself, one side will be the same as the other.

Side clamping knobs



Once the head stock is clamped in place, tighten the Back clamping knobs this will insure that the headstock is secure.

Set drill depth using a drill stop.

At this time drill out the machine holes before cutting the slots.

Back clamping knobs

The templates are designed for a 3/8 OD guide with a 1/4 inch spiral down cut bit (that is 1/16 inch template offset). We strongly recommend to first remove most of the material before routing the final cut. This can be done by using a larger template guide (7/16 OD or over) and using the same 1/4 inch bit, or using any template guide-router bit combination that will leave approx. 1/32 to 1/16 inch of material on all sides of the slot so that a small amount of material is removed for the final cut.

*Make sure that the template bushing does not come out of the template, you don't want the router bit to touch the template sides.*

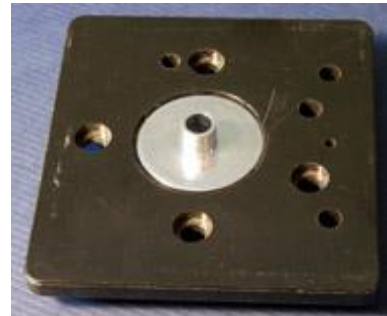
When removing material for the rough cut make **small depth increments**, don't try to cut the whole depth at once. Always use air supply to blow out slot during rough cut, the material has no where to go and will accumulate.

**SET UP (Porter Cable Trim Router)  
(Template Guide installation)**

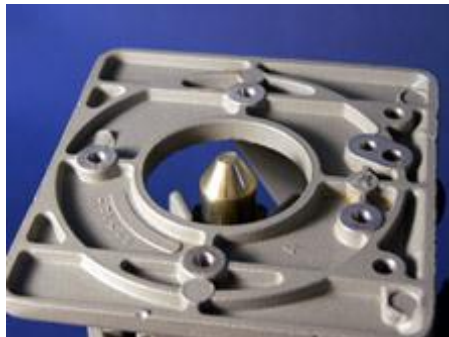
1



Remove the rub plate from your router and mount the template guide on the plate. Make sure to tighten ring thoroughly. Do not use any channel locks or equivalent on the bushing to tighten.



2



If you have a centering bit place it in the router and hand tighten only. Make sure that the centering bit is all way down.

3

Place the rub plate back onto the router base, move the depth control until the centering bit touches the inside of the template guide, then tighten depth control.



4



Re-mount the four philips head screws and remove the centering bit.

SET UP (Porter Cable Trim Router Continued)  
 (Template Guide installation)

5



Place the 1/4 spiral down cut bit into the router, move the depth all way down. The bit should stick out a little more than 1- 1/8 inch from base plate to tip, then tighten.

6

With the depth control move the bit back so only a small amount is sticking out. **When rough cutting, only cut with small depth.**



7



**For the final cut move bit to it's full length . Take your time and cut with a with even motion.** Picture shows the back side of the tool, so you can see the extended router bit.