



Operating Instructions and Parts Manual JBM-5 Benchttop Mortiser



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1.0 Warranty and Service

JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

2.0 Table of Contents

1.0 Warranty and Service.....	2
2.0 Table of Contents.....	3
3.0 About this manual	3
4.0 IMPORTANT SAFETY INSTRUCTIONS	4
5.0 Electrical requirements.....	5
6.0 Specifications.....	6
6.1 Mounting dimensions	7
7.0 Unpacking.....	7
7.1 Contents	7
8.0 Assembly.....	7
9.0 Installing.....	7
10.0 Adjustments	8
10.1 On-Off switch.....	8
10.2 Handle adjustment	8
10.3 Fence adjustment.....	8
10.4 Hold down adjustment.....	8
10.5 Depth stop rod adjustment	8
10.6 180° Head rotation	8
10.7 Chuck key holder.....	8
10.8 Bit shank length.....	8
10.9 Spindle adaptor	9
10.10 Chisel and bit adjustment.....	9
10.11 Adjusting chisel parallel to workpiece.....	10
11.0 Operation	10
12.0 Storage.....	10
13.0 Optional accessories.....	10
14.0 Replacement Parts.....	10
14.1 JBM-5 Benchtop Mortiser – Exploded View	11
14.2 JBM-5 Benchtop Mortiser – Parts List.....	12
15.0 Chisel specifications.....	14

3.0 About this manual

This manual is provided by JET covering the safe operation and maintenance procedures for a JET Model JBM-5 Mortiser. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide consistent, long-term operation if used in accordance with instructions set forth in this manual.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

Register your product using the provided mail-in card or register online: <http://www.jettools.com>



4.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. KEEP GUARDS IN PLACE and in order.
2. REMOVE ADJUSTING KEYS AND WRENCHES. Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
3. KEEP THE WORK AREA CLEAN. Cluttered areas and benches invite accidents.
4. DO NOT USE IN A DANGEROUS ENVIRONMENT. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. KEEP CHILDREN AWAY. All visitors should be kept safe distance from the work area.
6. MAKE THE WORKSHOP KID PROOF with padlocks, master switches, or by removing starter keys.
7. DON'T FORCE THE TOOL. It will do the job better and more safely at the rate for which it was designed.
8. USE THE RIGHT TOOL. Don't force a tool or attachment to do a job for which it was not designed.
9. USE THE PROPER EXTENSION CORD. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in the line voltage resulting in loss of power and overheating. For runs up to 25 feet, use a 16 AWG or larger gauge cord. For runs up to 50 feet, use a 16 AWG or larger cord. For runs up to 100 feet, use a 14 AWG or larger cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
10. WEAR PROPER APPAREL. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
11. ALWAYS USE SAFETY GLASSES. Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
12. SECURE WORK. Use clamps or a vise to hold the work when it's practical. It's safer than using your hand and it frees both hands to operate the tool.
13. DON'T OVERREACH. Keep proper footing and balance at all times.
14. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. DISCONNECT TOOLS before servicing; when changing accessories, such as blades, bits cutters, and the like.
16. REDUCE THE RISK OF UNINTENTIONAL STARTING. Make sure the switch is in the off position before plugging in the machine.
17. USE RECOMMENDED ACCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may cause a risk of injury.
18. NEVER STAND ON A TOOL. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
19. CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine 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 THE TOOL RUNNING UNATTENDED. TURN THE POWER OFF. Don't leave the tool until it comes to a complete stop.

22. **WARNING:** Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards to avoid inhaling dust generated from wood products.
23. Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. (California Health and Safety Code Section 25249.6)

5.0 Electrical requirements

This machine must be grounded. 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 a 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 three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.*

Repair or replace a damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Figure A below. The tool has a grounding plug that looks like the grounding plug as illustrated in Figure A below. A temporary adapter, which looks like the adapter as illustrated in Figure B below, may be used to connect this plug to a two-hole receptacle, as shown in Figure B if a properly grounded outlet is not available.** The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. The green colored rigid ear or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box.

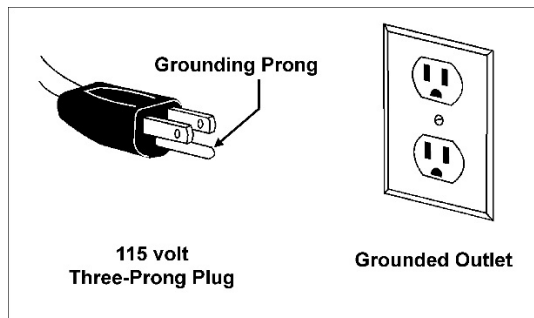


Figure A

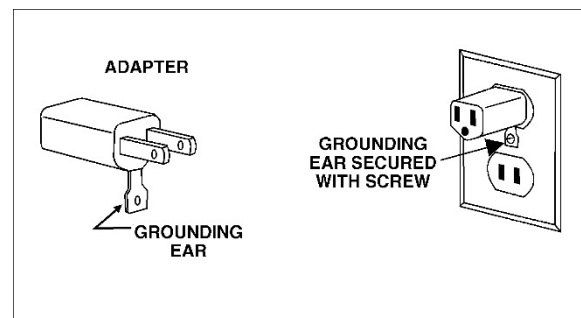


Figure B

* Canadian electrical codes require extension cords to be certified SJT type or better.

** In Canada, the use of a temporary adaptor is not permitted by the Canadian Electrical Code, C22.1.

6.0 Specifications

Table 1

Model number	708580
Stock number	JBM-5
Motor and electricals	
Motor type	TEFC
Horsepower	1/2 HP (0.37 kW)
Motor Phase	single
Motor Voltage	115V
Cycle	60 Hz
Listed FLA (full load amps)	6 A
On/off switch	Toggle, with removable safety key
Motor speed	1750 RPM
Power transfer	Direct drive
Power cord	SJT 3x18AWG 300V, 6 ft. (183cm) with plug
Recommended circuit size ¹	10 A
Capacities	
Chuck capacity (i.e. maximum bit shank diameter)	3/8 in.
Chisel capacity	1/2 x 1/2 in.
Chisel shank capacity	5/8 and 3/4 in.
Head stroke	4-3/4 in. (121 mm)
Chisel center to fence maximum	3-3/16 in. (81 mm)
Capacity under hold down	4 in. (102 mm)
Dimensions	
Fence size L x W	1-9/16 x 13-3/4 in. (40 x 350 mm)
Table size	13-1/2 x 6 in. (343 x 153 mm)
Base size	7-5/8 x 12-3/16 in. (199 x 310 mm)
Bushing sizes	5/8 and 3/4 in.
Overall height, assembled	Maximum 30 in. (762mm) ; minimum 21 in. (534mm)
Main materials	
Head and base	Cast iron and steel
Table	MDF
Column	Steel
Weights	
Net weight	44 lbs. (20 kg)
Shipping weight	51 lbs. (24 kg)

¹ subject to local/national electrical codes.

L = length, W = width, H = height

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

6.1 Mounting dimensions

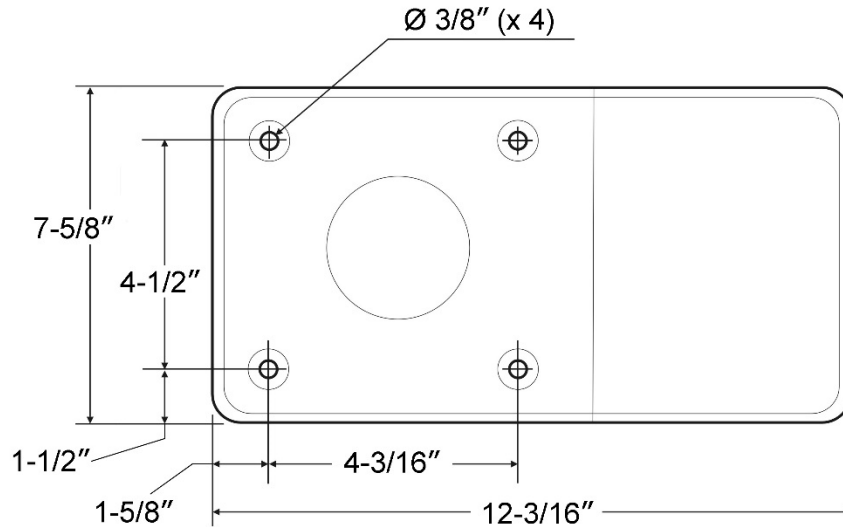


Figure 6-1

7.0 Unpacking

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Mortiser is assembled and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

7.1 Contents

- A. Mortising Machine
 - B. Hydraulic Cylinder
 - C. Handle
 - D. 3/4" Chisel Bushing
 - E. 5/8" Chisel Bushing
 - F. Spindle Extension Adapter
 - G. Chuck Key
 - H. Table
 - I. Hold Down
 - J. Fence Assembly
 - K. Flat Head Screws (2)
- Owner's Manual (not shown)
Product Registration Card (not shown)

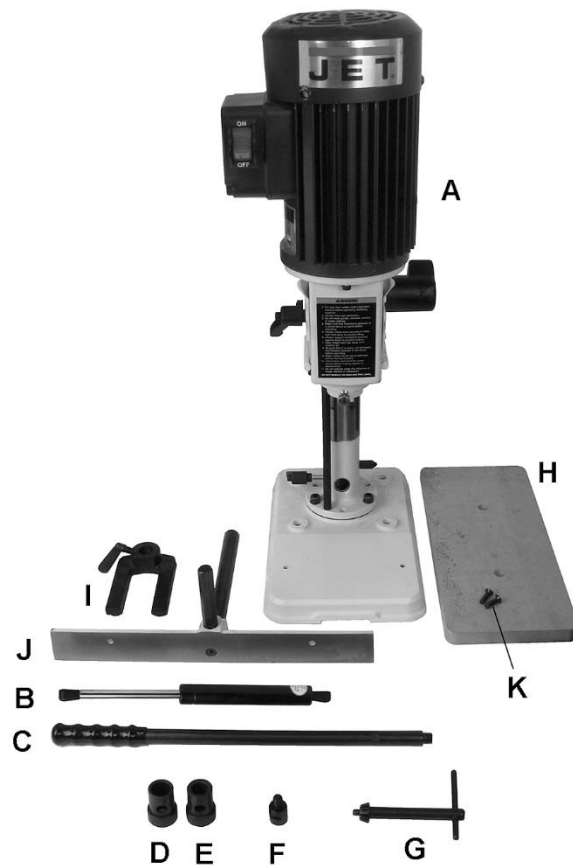


Figure 7-1

8.0 Assembly

⚠ WARNING Never connect the machine to the power source until assembly is completed. Failure to comply may result in serious injury!

1. Screw handle (A, Figure 8-1) into clutch block (B, Figure 8-1).

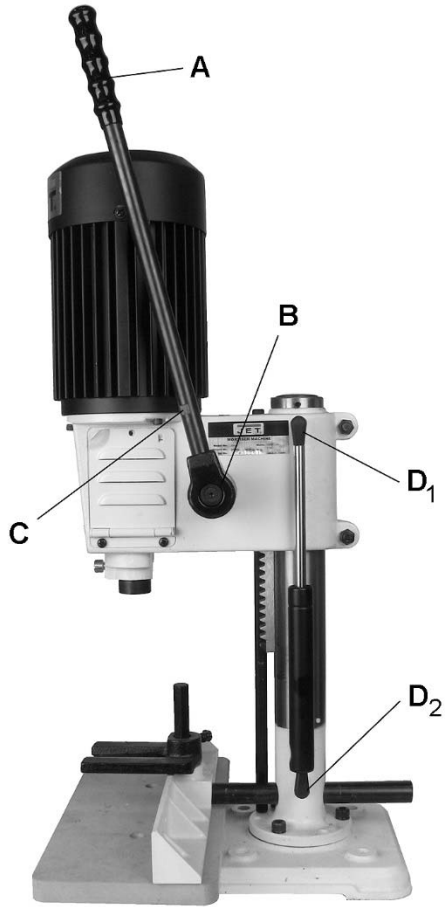


Figure 8-1

2. Tighten handle. The handle has a notch (C, Figure 8-1) to accommodate a wrench.
3. Use handle to raise machine head to its highest position. The handle is spring-loaded and can be repositioned by pulling handle and clutch block away from machine and repositioning it on shaft (See Figure 10-2).
4. With head in the up position, press the hydraulic cylinder onto the two fittings. The upper fitting (D₁, Figure 8-1) is located on the head. The lower fitting (D₂, Figure 8-1) is on the column.
5. Attach table to base using two flat head screws (K, Figure 8-2).

6. Insert bar of fence assembly (J, Figure 8-2) through hole in column. Use the fence-locking handle (J₁) to adjust fence assembly.
7. Attach the hold down (I, Figure 3) to the vertical post using wing screw (I₁, Figure 3).

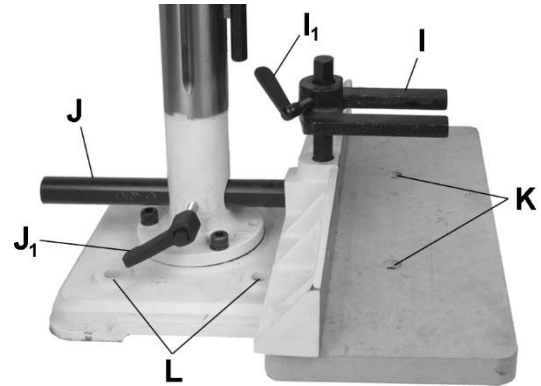


Figure 8-2

9.0 Installing

⚠ WARNING Make sure the Mortiser is attached to a firm and stable support surface.

This machine must be fastened to a supporting surface to prevent it from tipping during operation. The base has four 3/8" diameter holes (L, Figure 8-2) for this purpose. Mounting fasteners are not included.

10.0 Adjustments

10.1 On-Off switch

The switch (inset photo, Figure 10-1) has a safety key that, when pulled out, allows the switch to be locked in OFF position. The key must be reinserted to start machine.

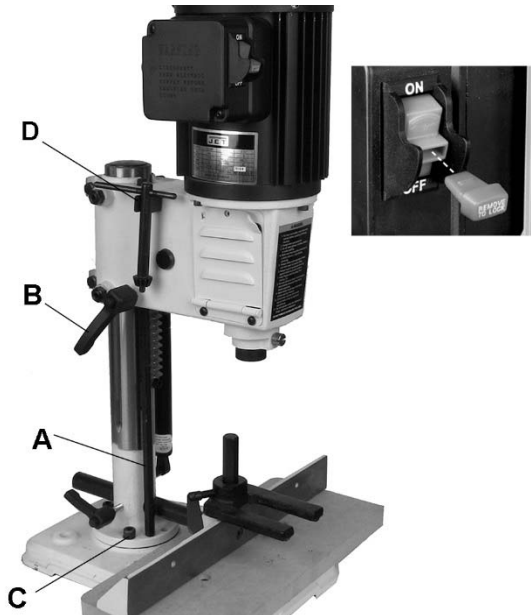


Figure 10-1

10.2 Handle adjustment

The spring-loaded handle can be adjusted for leverage and comfort. Pull handle away from head and reposition it on shaft. See Figure 10-2. Make sure handle re-engages clutch block.



Figure 10-2

10.3 Fence adjustment

The fence can be moved in and out by loosening locking handle (J₁, Figure 10-3) on the column. Always retighten handle before operating mortiser.

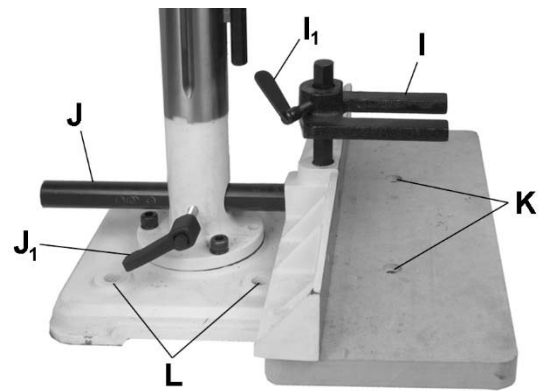


Figure 10-3

10.4 Hold down adjustment

The hold down (I, Figure 10-3) should be adjusted so it just touches top of workpiece and allows the workpiece to slide left or right. The hold down can also be taken off and turned over for a thicker workpiece. To adjust hold down, loosen wing screw (I₁, Figure 10-3).

10.5 Depth stop rod adjustment

The depth stop rod (A, Figure 10-1) is used to limit the depth of the chisel cut. Loosen handle (B, Figure 10-1) and lower head until bottom of chisel is at required depth. Lower depth stop rod until it is at rest against the base. Re-tighten handle (B).

10.6 180° Head rotation

The column can be rotated 180° to permit mortising large workpieces off the table.

⚠WARNING The base must be secured to the table or workbench when using head in rotated position.

1. Using a 4mm hex wrench, remove *four* screws, lock washers and flat washers (C, Figure 10-1)
Note: Only one screw is visible in Figure 10-1.
2. Rotate head and column to opposite direction.
3. Reinstall the four screws, lock washers and flat washers.

10.7 Chuck key holder

Store chuck key by pushing into holder (D, Figure 10-1).

10.8 Bit shank length

Chisel bits come with long or short shanks (Figure 10-4) depending on manufacturer. If using a bit with *short* shank, the spindle extension adaptor must be installed; see sect. 10.9. If using a bit with long shank, proceed to sect. 10.10.



Figure 10-4

10.9 Spindle adaptor

1. Open side door, and place a 10mm wrench on flat indents of motor spindle (A, Figure 10-5).
2. Insert chuck key into hole to use as leverage to unscrew chuck (B, Figure 10-5) while holding spindle stationary. Remove chuck from spindle.
3. Thread adaptor (C, Figure 10-5) onto motor spindle (A, Figure 10-5). Tighten using 10mm and 14mm wrenches respectively on flat sides of motor spindle and adaptor.
4. Thread chuck onto adaptor. Tighten using 14mm wrench on motor spindle flats and chuck key in chuck.

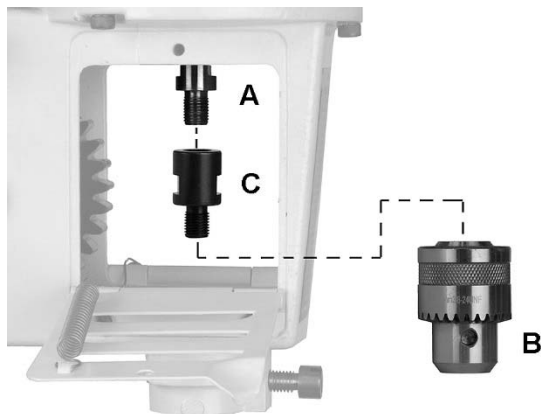


Figure 10-5

10.10 Chisel and bit adjustment

Note: Chisels and bits are available as optional accessories. See sect. 12.0.

⚠ WARNING Chisels are extremely sharp. Use great caution when handling to prevent personal injury.

1. Insert chisel bushing with hole facing forward (toward operator). See Figure 10-6. Tighten screw just enough to hold chisel bushing in place.
2. Insert bit into chisel, and use a block of wood to push chisel upward as far as possible into head. Then lower chisel approximately 1/16" to 3/16". This may vary depending upon type of wood. Table 2 shows general guidelines for distance between points of chisel and bit point.
3. Tighten screw to secure chisel in place.
4. Push bit upward through chisel as far as it will go into chuck. Lock bit in place using chuck key.
5. Loosen screw and push chisel up against bushing, then tighten screw. This should provide the proper distance between the points of chisel and bit.
6. **IMPORTANT:** Set the slot in side of chisel to the *left* or *right* if workpiece is to be moved laterally, and *front* or *back* if it is to be moved from front to back. The workpiece should be moved so that the chisel slot is releasing chips into the already-cut part of the workpiece (see Figure 11-1).

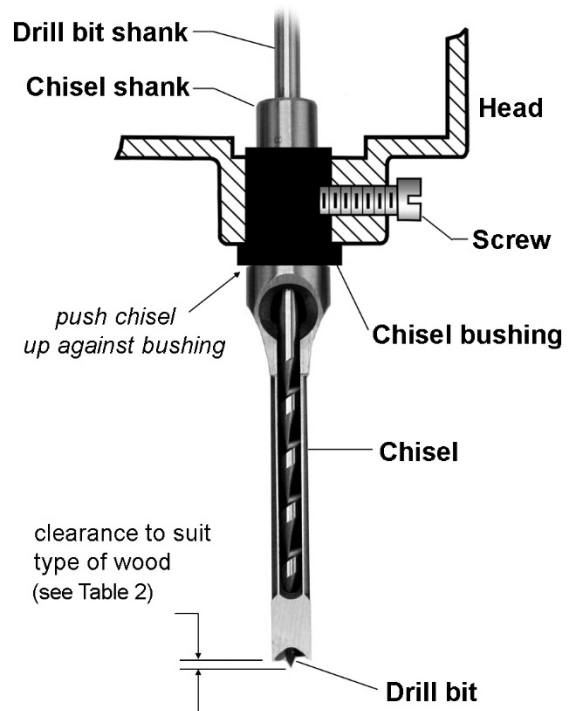


Figure 10-6

Type of wood	Chisel Size	Distance
Softwoods	1/4 to 3/8	1/32
	1/2	1/16 to 3/32
Hardwoods	1/4 to 3/8	1/16
	1/2	3/32 to 1/8

Table 2 (all dimensions inches)

10.11 Adjusting chisel parallel to workpiece

The chisel can be adjusted parallel to workpiece by loosening screw (A, Figure 10-7) and rotating chisel until back surface of chisel is flat against workpiece. Tighten screw to hold chisel in place.

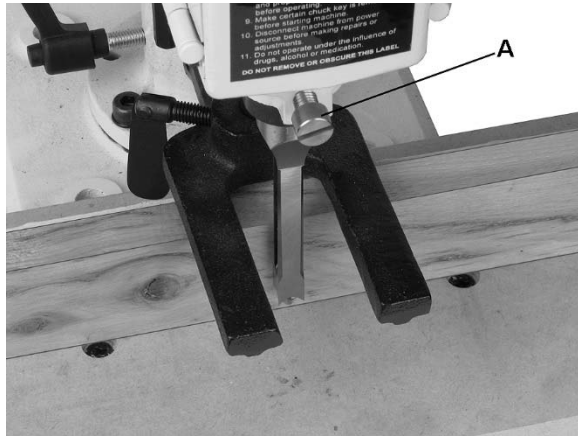


Figure 10-7

11.0 Operation

1. Set depth stop to required depth of cut (see sect. 10.5).
2. Place workpiece on table and against fence.
3. Adjust fence until workpiece is in correct position.
4. Clamp workpiece or set hold down to desired height (sect. 10.4).

⚠ WARNING Before turning on the machine, verify that chuck key is not in the chuck.

5. Turn on machine and feed chisel and bit steadily into workpiece by pulling down operating handle.
6. After the first cut, move workpiece along for each successive cut. The direction of movement must allow chips to clear freely. Move workpiece so that chisel slot is releasing chips into the already-cut part of the workpiece (Figure 11-1).

⚠ CAUTION Do not have chisel slot against the blind end of the mortise, as the chips will not be able to clear the chisel. This can cause overheating and possible breakage of chisel or bit.

7. When cutting deep mortises, make the cut in several stages of approximately 1" each, to allow chips to clear. To prevent breakout at the back of the workpiece when cutting through mortises, use a piece of scrap material under the workpiece as support.

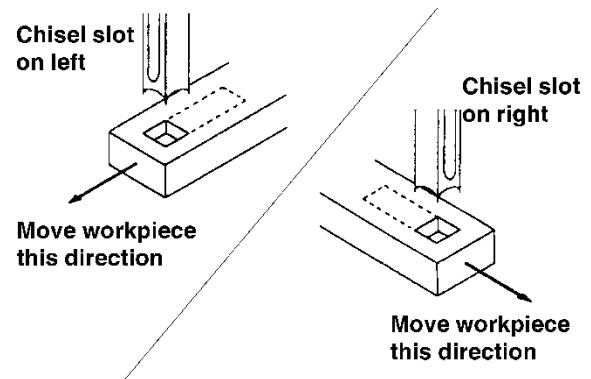


Figure 11-1

12.0 Storage

If the mortiser will be stored for an extended period, use the depth stop to help secure head in position; this will relieve stress upon the hydraulic cylinder.

13.0 Optional accessories

Premium Mortise Bit and Chisel Sets:

Stock no.	Chisel size
1791091	1/4"
1791092	5/16"
1791093	3/8"
1791094	1/2"

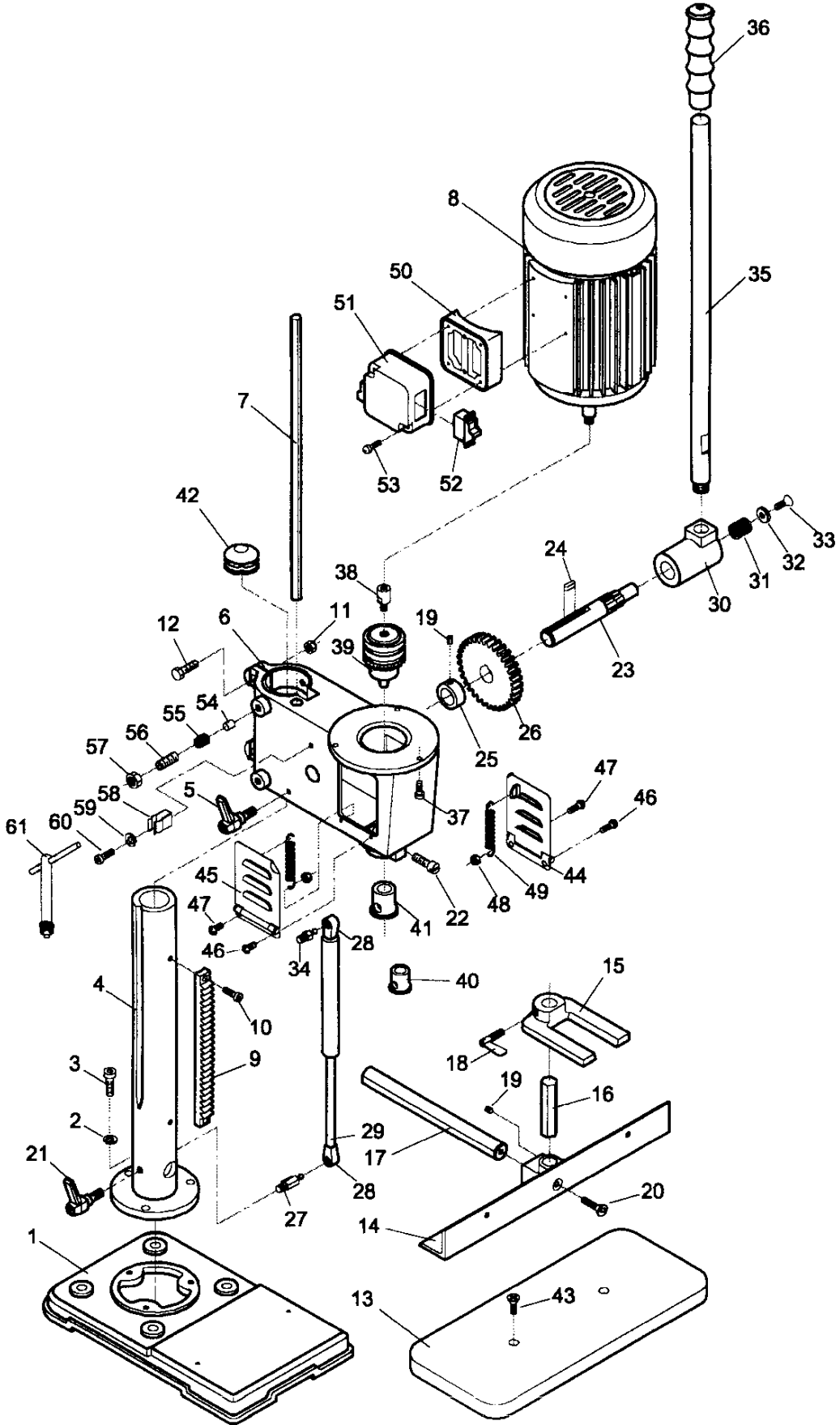
See sect. 15.0 for chisel specifications.

14.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

14.1 JBM-5 Benchtop Mortiser – Exploded View



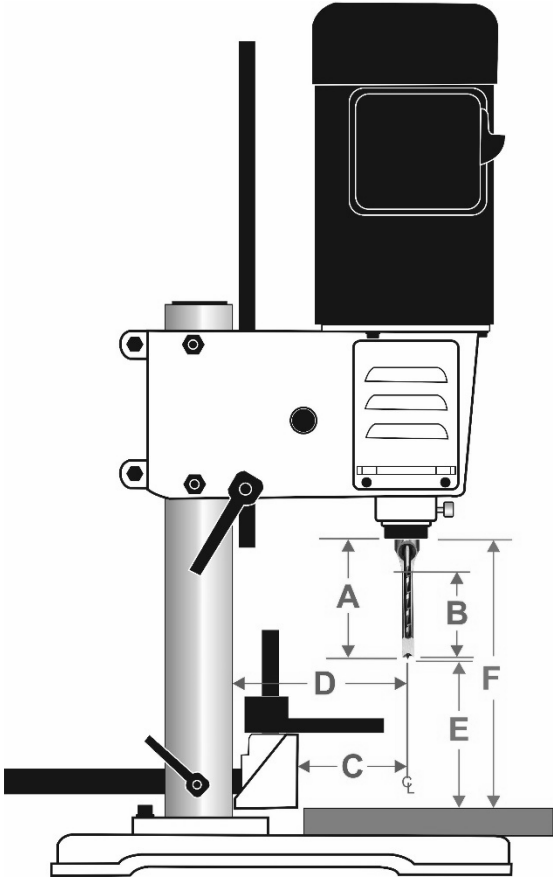
14.2 JBM-5 Benchtop Mortiser – Parts List

Index No.	Part No.	Description	Size	Qty
1	23011045W	Base		1
2	50302003	Lock Washer	5/16"	3
3	50102018	Hex Socket Cap Screw	M8-1.25x20	3
4	23011002W	Column		1
5	23011053	Lock Handle	M8-1.25x10	1
6	23011046W	Head		1
7	23011004	Depth Stop		1
8	23011054	Motor	1/2HP 1PH 115V	1
	23011054-01	Fan (not shown)		1
	23011054-02	Fan Cover (not shown)		1
	50154019	Fan Cover Screw (not shown)		1
	23011054-03	Capacitor	25uF, 250VAC	1
9	23011005	Rack		1
10	50102032	Hex Socket Cap Screw	M6-1.0x16	2
11	50201017	Nut	M8-1.25	2
12	50102021	Hex Cap Bolt	M8-1.25x30	2
13	23011055	Table		1
	23011056AW	Fence Assembly (includes #14,16,17,19,20)		1
14	23011056W	Fence		1
15	23011057	Hold Down		1
16	23011058	Hold Down Post		1
17	23011059	Fence Rod		1
18	50109001	Wing Screw	M8-1.25	1
19	TS-1523011	Set Screw	M6-1x6	2
20	50110005	Flat Head Screw	M6-1x22	1
21	23011009	Lock Handle	M8-1.25x30	1
22	23011010	Brass Screw	M8-1.25x25	1
23	23011061	Pinion Shaft		1
24	50605005	Key	5x5x14 mm	1
25	23011012	Collar		1
26	23011013	Gear		1
27	23011014	Lower Cylinder Fitting		1
28	23011030	Cylinder Head (re:23011031A)		1
29	23011031	Hydraulic Cylinder		1
	23011031A	Hydraulic Cylinder Assembly (includes #28,29)		1
30	23011062	Clutch Block		1
31	23011063	Spring		1
32	23011064	Washer		1
33	50110006	Flat Head Screw	M6-1.0x11	1
34	23011017	Upper Cylinder Fitting		1
35	23011065	Handle Rod		1
36	23011019	Handle Grip		1
37	50102042	Hex Socket Cap Screw	M5-0.8x16	3
38	23011020	Adapter		1
39	23011032	Chuck		1
40	23011033	Bushing	5/8"	1
41	23011034	Bushing	3/4"	1
42	23011021	Cap		1
43	50105006	Flat Head Screw	M6-1.0x20	2
44	23011066W	Right Side Cover Assembly		1
45	23011067W	Left Side Cover Assembly		1
46	50104010	Screw	M5-0.8x8	2
47	50104011	Screw	M5-0.8x12	2
48	50202006	Nut	M5-0.8	2
49	23011068	Spring		2
50	23011050	Switch Base		1
51	23011051	Switch Cover		1
52	23011029	Toggle Switch		1
53	50111002	Tap Screw	M10x2	2
54	23011026	Brass Pin		2

Index No.	Part No.	Description	Size	Qty
55	23011027	Spring		2
56	50103013	Set Screw	M10-1.5x20	2
57	50201014	Nut	M10-1.5	2
58	23011077	Key Clip		1
59	50322004	Spring Washer	M5	1
60	50102002	Hex Socket Cap Screw	M5-0.8x8	1
61	23011076	Chuck Key		1
	23010045	JET Label (not shown)		1

15.0 Chisel specifications

JET® JBM-5 Benchtop Mortiser (708580) Specifications in conjunction with our Premium Chisel and Bit Sets



JET JBM-5 Mortiser with Premium Chisels		1791091	1791092	1791093	1791094
		1/4" chisel ¹	5/16" chisel	3/8" chisel	1/2" chisel
A	Total Chisel Length (installed)	3-21/32"	3-7/8	3-7/8"	3-7/8"
B	Useful Chisel Plunge	1-13/16"	2-1/8"	2-3/4"	3-5/32"
C	Maximum Chisel Centerline to Fence	3-3/16"	3-3/16"	3-3/16"	3-3/16"
D	Maximum Chisel Centerline to Column	5"	5"	5"	5"
E	Maximum Working Clearance ^{2,3}	4-1/2"	4-5/16"	4-5/16"	4-5/16"
F	Maximum Total Clearance ²	8-1/4"	8-1/4"	8-1/4"	8-1/4"
	Bushing size used (inside diameter)	3/4"	3/4"	3/4"	3/4"

¹ Chisel size refers to dimension of square hole produced by the chisel.

² Measured with provided wood table installed; add 3/4" to each figure if wood table is removed.

³ Bit protrusion of 1/16" is assumed.

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