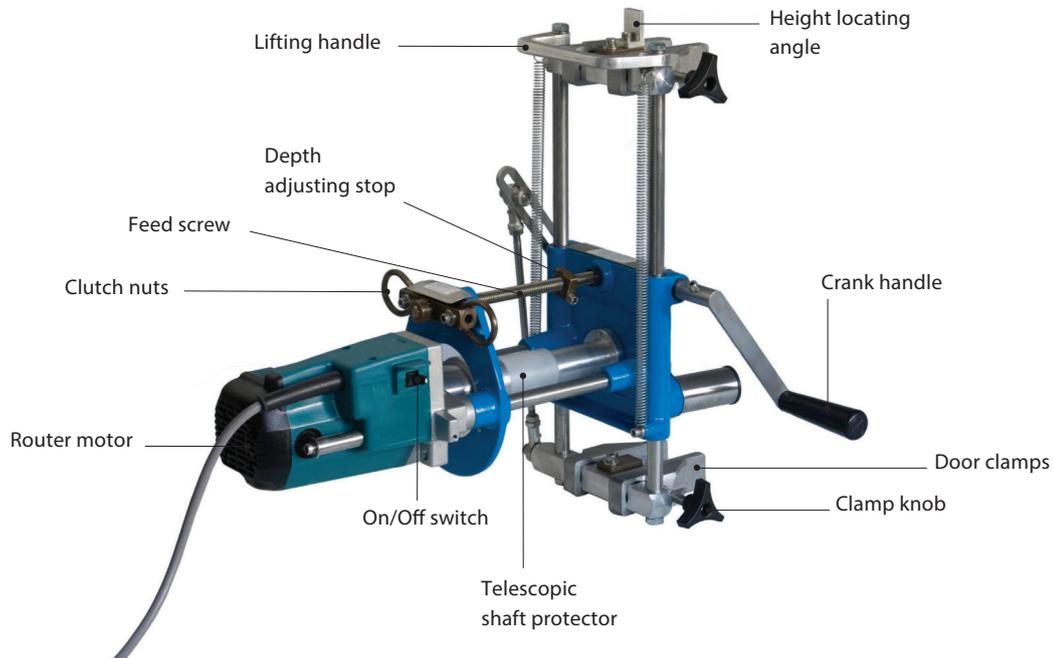


# Chant Lock Mortising Machine

6005 \* See note below

6006 \* See note below



## Mortising Machine

\* 6005 Machine fitted with a router shaft for router cutters with a 1/4" UNF male threaded shank. Metric sizes, refer to page 9.

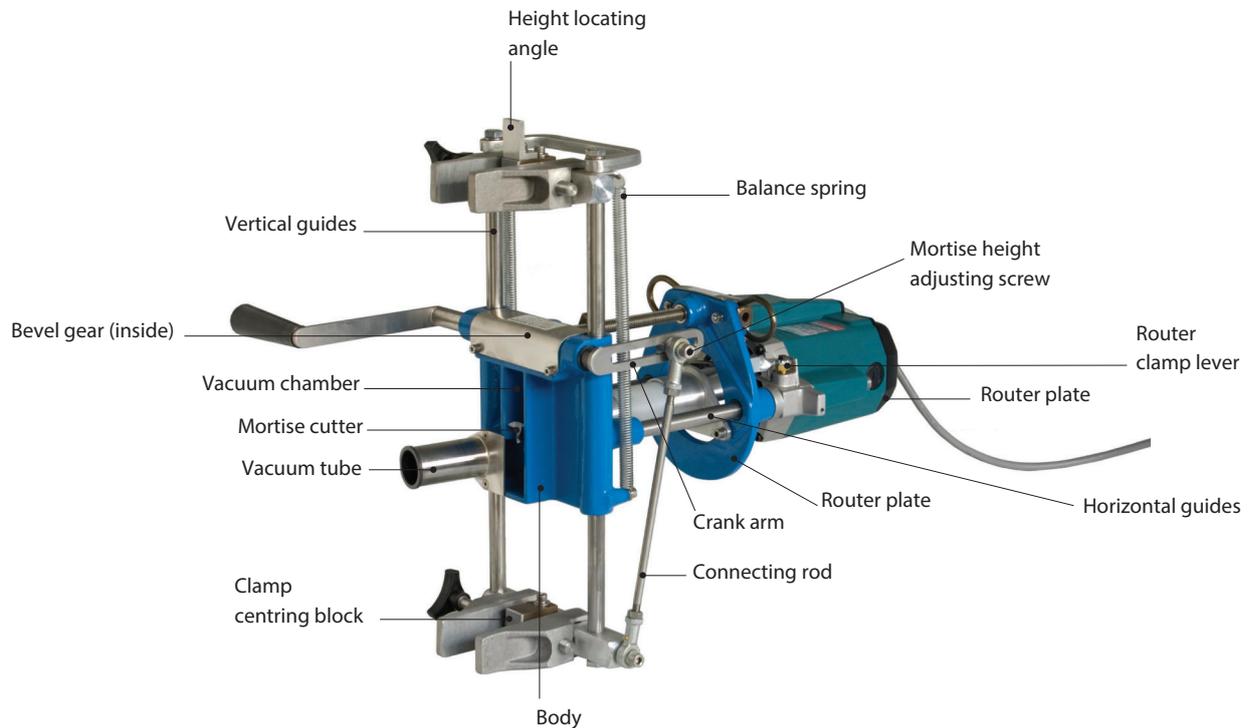
\* 6006 Machine fitted with a router shaft for router cutters with a 1/4" UNF female threaded bore. Imperial sizes, refer to page 9.

- Designed for quick, accurate and dust free mortising of doors from 30mm - 80mm thick. 1 1/4" to 3 1/8"
- The Makita 3612C electronic speed controlled motor allows for low speed operations and is capable of cutting through metal clad fire doors with special cutters at the lowest speed of 9,000 rpm. Seek advice from Chant.
- Variable speed reduces the noise level while still maintaining optimum cutting efficiency.
- The machine is designed to be lifted by the lifting handle with the left hand, positioned on the door, and the clamp screws tightened with the right hand. Then operating the machine with the right hand on the crank handle.
- Self-centering door clamps with protective face pads. These are a generous length to avoid marking the door surface, and are machined with "toe-in" so that they grip at the tips first, then over their full length as the clamps tighten.

- Clamp adjustment left to right on the clamp centring block allows for the perfect parallel alignment of the machined recess with the door faces.
- Router shaft enclosed with telescopic sleeves for safety.
- Mortise cutter enclosed when on the door by the vacuum chamber.
- Shaving extraction system for operator safety, clean machine operation and work area.
- Mortise height adjustment: 40mm to 200mm (1 5/16" to 7 7/8")
- Mortise depth adjustment: 125mm (5")
- Clamps designed for door thickness: 30mm to 80mm (1 1/4" to 3 1/8").
- Cutter diameters available:  
16mm, 17mm, 18mm, 19mm, 20mm, 22mm, 25mm with 1/4" UNF threaded shaft to screw into the end of the router shaft.  
5/8", 3/4", 7/8", 1" with 1/4" UNF threaded bore for the USA and some countries where this style of cutter is available. It requires the router shaft to have a 1/4" UNF threaded stud protruding for the cutter to screw into. Refer to Mortise Shafts, Cutters and Accessories, page 8 for additional details.
- Weight: 13.4kg (30 lbs.)

The lock mortising machine can be purchased as a separate item from the trolley.

# Chant Lock Mortising Machine



## Settings - Adjustment

1. Select and install the correct diameter mortise cutter to the machine for the lock being installed.
2. Calculate the correct MSH (Machine Setting Height) for the machine to be positioned on the door (see Positioning the Mortising Machine and Faceplate Jig on the Door for Various Locks).
3. Fasten the vertical locating clamp 6040 to the door with the bottom of the clamp flush with this mark.
4. Clamp the mortising machine to the door with the height locating angle against the underside of the vertical locating clamp.
5. Pull the clutch nuts apart to disengage the router motor from the feed screw and push the motor forward so that the cutter touches the door.
6. Lay the lock case being installed between the router plate and the depth adjusting stop. Release the clamp screw on the depth adjusting stop and rotate the stop along the feed shaft to provide a gap approximately 3mm or  $\frac{1}{8}$ " between it and the lock case. Tighten the screw.
7. Return the router to the safety/start position.
8. Adjust the mortise height by releasing the mortise height adjusting screw and sliding the ball joint along the slot in the crank arm. It is graduated in mm for the clear rectangle that is machined, not including the radius at each end created by the cutter. Tighten the screw. Refer to Mortise Height Setting Dimension "X" on page 10.
9. Insert the vacuum hose.
10. Switch on the router motor and vacuum, or if the lock mortising machine is used in conjunction with the trolley, the vacuum will start automatically.
11. Crank the handle making the machine go up and down, while it self feeds into the door until the router head is close to the depth adjusting stop, approximately 1mm. There is no need to run into it. It is intended as an indicating stop only.
12. Stop the router motor.
13. Pull on the clutch nuts to release them from the feed screw and return the router head to the safety/start position.
14. Remove the vacuum hose and remove the machine from the door placing it back on the trolley for safe keeping.