

SIP Industrial Products Limited
Gelders Hall Road
Shepshed
Loughborough
Leicestershire
LE12 9NH
United Kingdom

Bench Mortcer with Sliding Table

01944



For help or advice please
contact your distributor, or sip
directly on: Tel.: 01509 500400
Email: sales@sip-group.com or
technical@sip-group.com
www.sip-group.com

sip
SIP INDUSTRIAL

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SAFETY INSTRUCTIONS



Danger / Caution: This picture indicates risk of personal injury and/or the possibility of damage.



Warning: This picture indicates risk of electrical injury or damage!



Note: This picture indicates supplementary information.



Important: Please read the following instructions carefully, failure to do so could lead to serious personal injury and / or damage to the item.

Woodworking can be dangerous. If safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, feather boards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, do not try. Figure out an alternative procedure that feels safer. **REMEMBER:** Your personal safety is your responsibility.

This machine was designed for certain applications only. We strongly recommend that this machine is not modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, **DO NOT** use the machine until you have first contacted your local dealer to determine if it can or should be performed on the product.

General Safety Instructions

- FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE

SAFETY INSTRUCTIONS

TOOL. Learn the tool's application and limitations as well as the specific hazards peculiar to it.

- KEEP GUARDS IN PLACE and in working order.
- ALWAYS WEAR EYE PROTECTION. Wear safety glasses. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty.
- REMOVE ADJUSTING KEYS AND WRENCHES. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
- KEEP WORK AREA CLEAN. Cluttered areas and benches Invite accidents.
- DO NOT USE IN DANGEROUS ENVIRONMENT. Do not use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- KEEP CHILDREN AND VISITORS AWAY. Children and visitors should be kept a safe distance from work area.
- MAKE WORKSHOP CHILDPROOF - with padlocks, master switches, or by removing starter keys.
- DO NOT FORCE TOOL. It will do the job better and be safer at the rate for which it was designed.
- USE RIGHT TOOL. Do not force tool or attachment to do a job for which it was not designed.
- WEAR PROPER APPAREL. No loose clothing, gloves, rings, bracelets, or other jewellery to get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- SECURE WORK. Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
- DO NOT OVERREACH. Keep proper footing and balance at all times.
- MAINTAIN TOOLS IN GOOD CONDITION. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- DISCONNECT TOOLS before servicing and when changing accessories such as blades, bits, cutters, etc.
- USE RECOMMENDED ACCESSORIES. The use of accessories and attachments not recommended by the manufacturer may cause hazards or risk of Injury to persons.
- REDUCE THE RISK OF UNINTENTIONAL STARTING. Make sure switch is in 'OFF' position before plugging in power cord. In the event of a power failure, move switch to the 'OFF' position.
- NEVER STAND ON TOOL. Serious Injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
- CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure 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

SAFETY INSTRUCTIONS

conditions that may affect its operation. A guard or other part that is damaged should be properly replaced.

- **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.
- **STAY ALERT; WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE WHEN OPERATING A POWER TOOL. DO NOT USE TOOL WHILE DRIVEN OR UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR MEDICATION.** A moment of inattention while operating power tools may result in serious personal injury.
- **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
- **THE DUST GENERATED** by certain woods and wood products can be injurious to your health. Always operate machinery in well-ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.
- **WARNING: SOME DUST CREATED BY POWER SANDING, SAWING, GRINDING, DRILLING, AND OTHER CONSTRUCTION ACTIVITIES** contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are: Lead from lead-based paints, crystalline silica from bricks and cement and other masonry products, and arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Specific Safety Instructions

- **DO NOT OPERATE THE MACHINE** until it is assembled and sited according to the instructions.
- **TAKE ADVICE FROM YOUR SUPERVISOR, instructor, or another qualified person** if you are not familiar with the operation of this machine.
- **FOLLOW ALL WIRING CODES** and recommended electrical connections.
- **MAKE CERTAIN** the machine is fastened to a supporting surface to prevent it from tipping over during operation.
- **NEVER** turn the morticer "ON" before clearing the table of all object (scrap pieces, etc.).
- **ALWAYS** keep hands, fingers and hair away from the rotating bit.
- **DO NOT** attempt to machine material that does not have a flat surface, unless a

SAFETY INSTRUCTIONS

suitable support is used.

- ALWAYS position hold-down directly over work-piece to prevent work-piece from lifting during operation.
- ALWAYS support work-piece securely against fence to prevent rotation.
- BE SURE drill bit is sharp, not damaged, and properly secured in the chuck before operation.
- MAKE SURE chuck key is removed before starting machine.
- NEVER turn on the power with the drill bit or chisel contacting the work-piece.
- NEVER perform layout, assembly, or set-up work on the table while the mortiser is operating.
- ADJUST the depth stop to avoid drilling into the table.
- ALWAYS turn off the power before removing scrap pieces from the table
- SHUT-OFF The power, remove the drill bit and chisel, and clean the table before leaving the machine.
- FOR YOUR OWN SAFETY - Don't wear gloves when operating the machine.
- SHOULD any part of your tool be missing, damaged, or fail in any way, or any electrical component fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged, or failed parts before resuming operation.
- THE USE of attachments and accessories not recommended by SIP may result in the risk of injuries.
- TURN THE MACHINE "OFF" AND DISCONNECT THE MACHINE from the power source before installing or refitting accessories, before adjusting or changing setups, or when making repairs.
- TURN THE MACHINE "OFF" , disconnect the machine from the power source, and clean the table/work area before leaving the machine.
- LOCK THE SWITCH IN THE "OFF" POSITION to prevent unauthorized use.

ELECTRICAL CONNECTIONS



WARNING: Read these electrical safety instructions thoroughly before connecting the product to the mains supply.


Connect the mains lead to a standard, 230 Volt (50Hz) electrical supply through an approved 13 amp plug, or a suitably fused isolator switch.

If the plug has to be changed because it is not suitable for your socket, or because of damage, it must be removed and a replacement fitted, following the wiring instructions shown below. The old plug must be discarded safely, as insertion into a power socket could cause an electrical hazard.



WARNING: The wires in the power cable of this product are coloured in accordance with the following code:
Blue = neutral / Brown = live / Yellow and Green = earth

If the colours of the wires in the power cable do not agree with the markings on the plug:

- The BLUE wire must be connected to the terminal which is marked N or coloured black.
- The BROWN wire must be connected to the terminal which is marked L or coloured red.
- The YELLOW and GREEN wire must be connected to the terminal which is marked E or  or coloured green.



We strongly recommend that this machine is connected to the mains supply through a Residual Current Device (RCD).

If you are not sure, consult a qualified electrician. DO NOT try to do any repairs.

ELECTRICAL CONNECTIONS



NOTE: Always make sure the mains supply is of the correct voltage and the correct fuse protection is used. In the event of replacing the fuse always replace the fuse with the same value as the original.



WARNING: Improper use of extension leads may cause inefficient operation of the item which can result in overheating and motor damage.

GUARANTEE

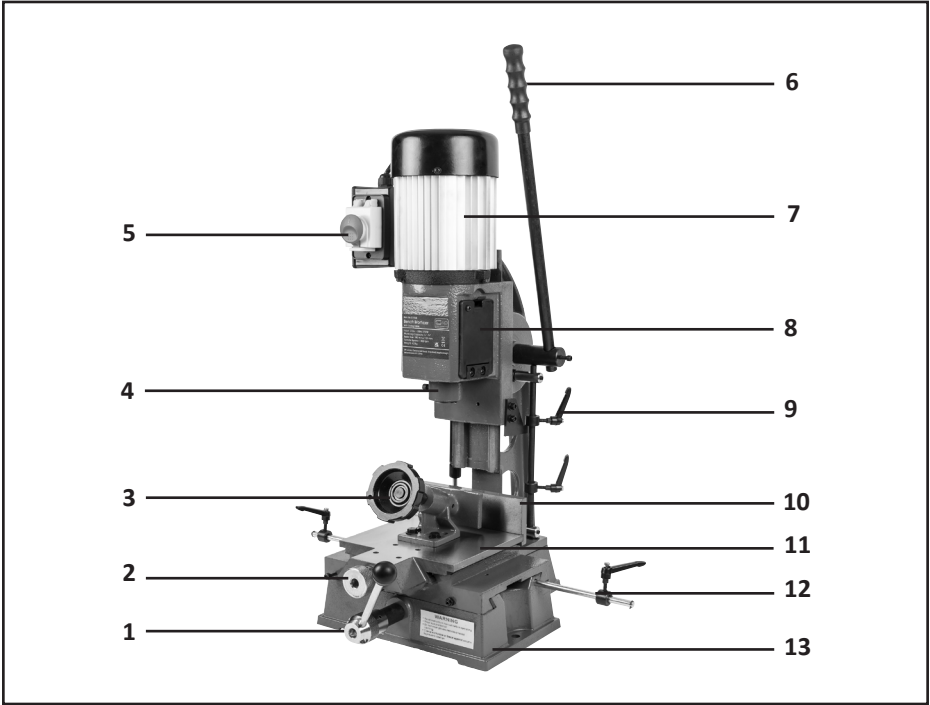
This item is covered by a 24 month parts and labour warranty covering failure due to manufacturers defects. This does not cover failure due to misuse or operating the item outside the scope of this manual - any claims deemed to be outside the scope of the warranty may be subject to charges Including, but not limited to parts, labour and carriage costs, failure to regularly clean your item will shorten its working life and reduce performance.

Consumable items such as the chisels, drill bits are not covered by the warranty.



NOTE: Proof of purchase will be required before any warranty can be honoured.

YOUR ITEM



Ref.	Description	Ref.	Description
1.	L - R Table adjustment handle	8.	Chuck access cover
2.	Front - Back Table adjustment knob	9.	Depth stop guide
3.	Fence clamp knob	10.	Fixed fence
4.	Chisel housing	11.	Table
5.	NVR Switch	12.	Table stop
6.	Operating handle	13.	Base
7.	Motor	14.	NA.

TECHNICAL SPECIFICATION

Model No.	01944
Power	230 V - 50 Hz / 370 W
Morticing Capacity	1/4" - 5/8" (6 - 16 mm)
Table Size	180 mm x 157 mm
Spindle Speed	1400 rpm
Chisel Stroke	130 mm
Table Movement	100 mm L to R / 40 mm Back to Front
Max. Distance - Spindle to fence	50 mm
Chisel to Table	100 mm max.
Max Clamping Width	80 mm
Weight	42 Kg

ASSEMBLY INSTRUCTIONS



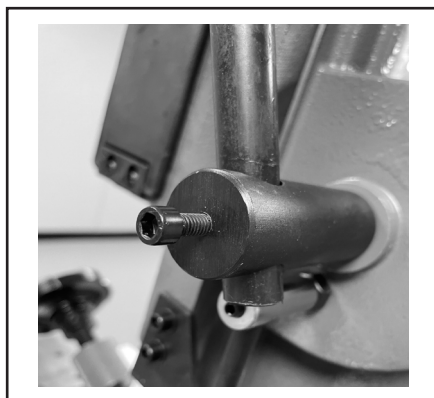
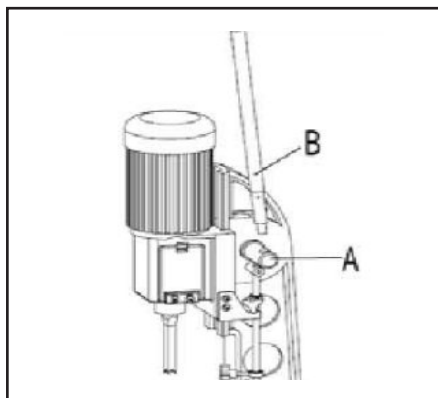
Danger / Caution: Do not connect the machine to the power supply until the machine is completely assembled and you have read and understood the entire instruction manual.



NOTE: If any parts are missing, please contact customer service.

HANDLE

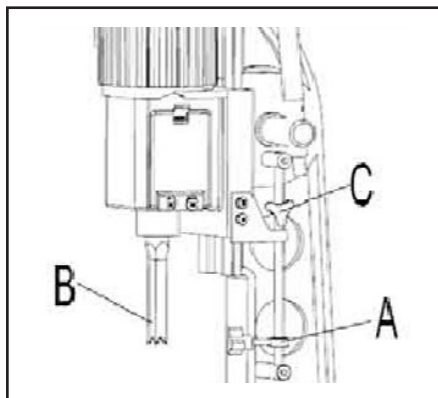
1. Insert the handle (B) through the hole (A).
2. Make sure it shows at least 5 mm through the bottom end and screw the retaining bolt.



DEPTH STOPS - RAISING AND LOWERING THE HEAD

Tighten the depth stop guides (A & C) in the positions desired. The chisel (B) will stop at the desired positions in depth and height.

ASSEMBLY INSTRUCTIONS

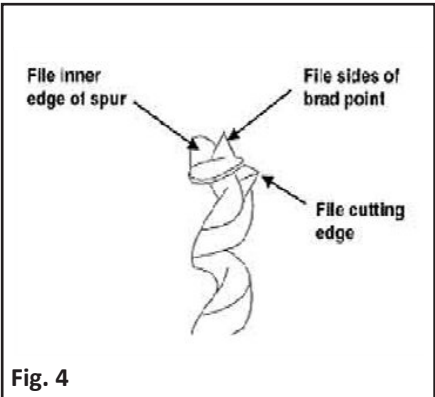
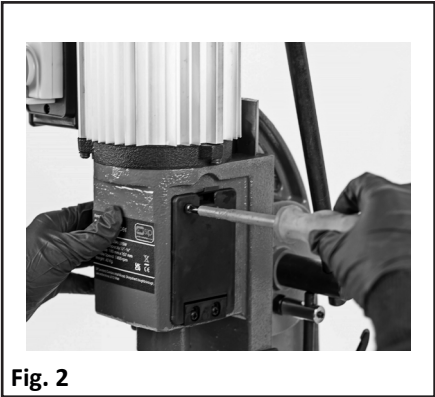
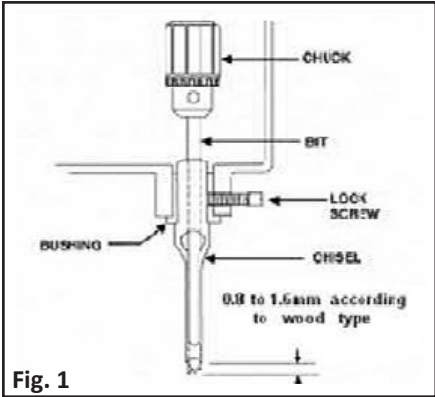


INSTALLING CHISEL & DRILL BIT

1. Loosen the lock screw shown in Fig.1.
2. In order to access the chuck, undo the lock screw of the plastic cover and pull the release tab Fig.2.
3. Loosen the chuck with the chuck key provided with the machine.
4. Place the drill bit inside the chisel. Note: These items are sharp, wear safety gloves when assembling.
5. Insert the chisel into the bush and the drill bit into the chuck together. Push the chisel up as far as possible into the head. Tighten the lock screw just enough to hold the chisel in place. Make sure you set the slot in the side of the chisel to the left or right, NOT to the front or back. This will allow chips to escape when cutting mortises. Push the drill bit up through the chisel as far as it will go. Tighten the drill bit with the chuck key enough to hold it in place. Then lower the chisel head using the handle. Set the "drill to chisel height" approximately 0.8mm to 1.6mm, depending on the type of wood being worked. See Fig.1. Re-tighten the screw to hold the chisel in place.
6. Lock the drill bit in place with the chuck key. See Fig. 3.
7. Close the plastic cover of the chuck access and screw the lock screw.

Next set the chisel square to the back fence of the table. Use the operating handle to lower the chisel down to the table. Adjust the table forward until the back fence touches the chisel. Check the back face of the chisel is square to the table fence and adjust as necessary.

ASSEMBLY INSTRUCTIONS



FENCE

The fence can be moved in or out by loosening the hand-wheel, sliding the fence to the desired position and tightening the hand-wheel. Fig. 5.

Different thicknesses of material can be accommodated by positioning the moving fence in the threaded holes provided. Use the slots in the fence base for fine adjustments. Fig. 6.

ASSEMBLY INSTRUCTIONS

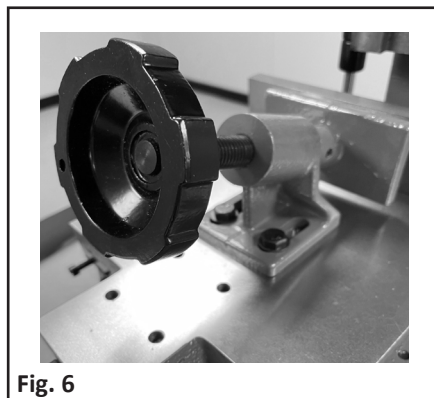
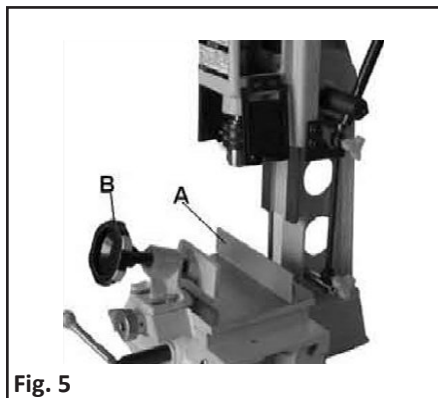


TABLE STOPS - LEFT TO RIGHT MOVEMENT

1. Slide the stop lever assembly on to the bar.
2. Place the bar into the hole and make sure the threaded hole aligns with the hole of the bar. Fig.7.8. & 9.
3. Tighten the grub screw with the hex key provided. Fig.10.

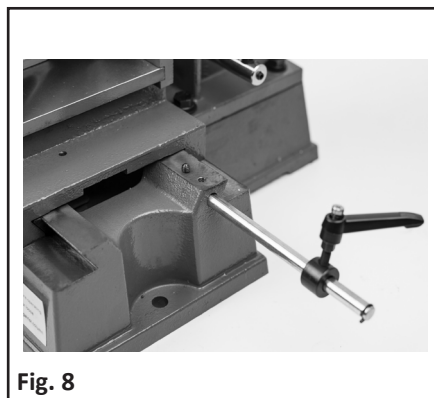
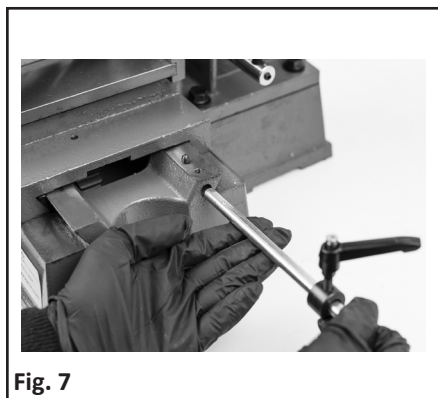




Fig. 9



Fig. 10

OPERATING INSTRUCTIONS



NOTE: Before connecting the machine to the mains supply, make sure all the screws and connections have been tightened.

RAISING AND LOWERING THE HEAD

1. Pull the handle to lower the machine head. Fig.11.
2. Lift the handle to raise the machine head.
3. Changing the position of the depth stop guides will allow you to restrict the depth and height of the operation. Fig.12.

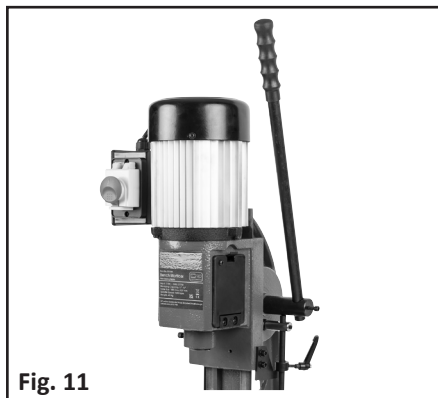


Fig. 11

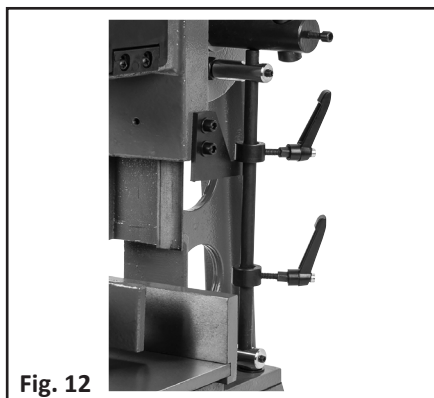
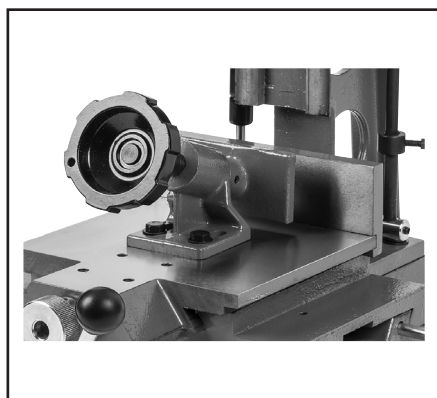
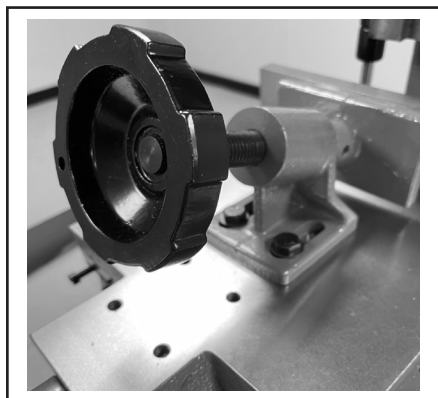


Fig. 12

FENCE

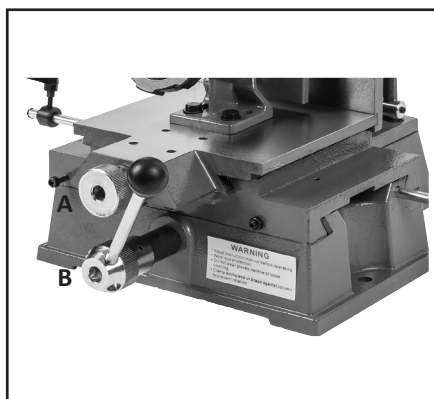
1. Place the fence in the position desired. It can be done loosening the screws and placing them in a closer or further position, depending on the thickness of your piece.
2. Once it is allocated in the desired position. Turn the knob clockwise to tight the piece and have a safe operation.

OPERATING INSTRUCTIONS



SIDEWAYS TABLE

1. Turn the knob A for forward and backwards movement of the table.
2. Attach the lever B and turn it for Left & Right movement of the table.



OPERATING INSTRUCTIONS

CUTTING A MORTICE

When cutting a slot mortice it is important to start from the correct end of the work piece. With the open side of the chisel set to the right - start the cut from the right hand edge - or the same if cutting from the left. As the cut progresses the open side of the chisel will remain open into the hole already cut to aid chip clearance.

If dust extraction is to be used the dust throat should be positioned just above the timber and close to the chisel for best results.

To begin the cut, press the green start button and pull down on the operating handle.

For the initial cut, withdraw the chisel at 20mm depth. Now move the table to the right by the width of the chisel and make a second cut to 20mm. Continue making a series of shallow cuts until the whole outline has been completed. Now go back to the starting position and make a second series of cuts deepening the mortice by a further 20mm. Continue in this fashion until the mortice is to the depth required.

If the mortice now needs enlarging in width, use the handwheel to adjust the table forwards or backwards and continue cutting.

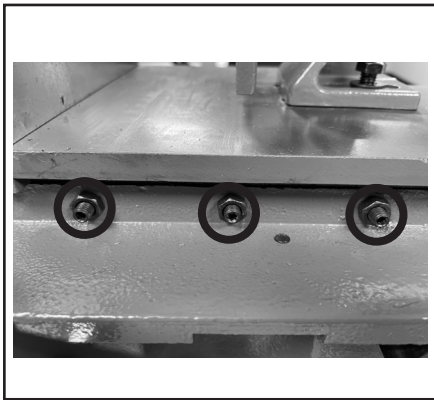


MAINTENANCE

The Morticer requires only minor maintenance, such as dealing and lubrication and routine adjustment and sharpening of the chisel and bit.

Dust the machine down after each use and, as necessary, use light applications of oil or grease to lubricate linkages, moving parts, etc.

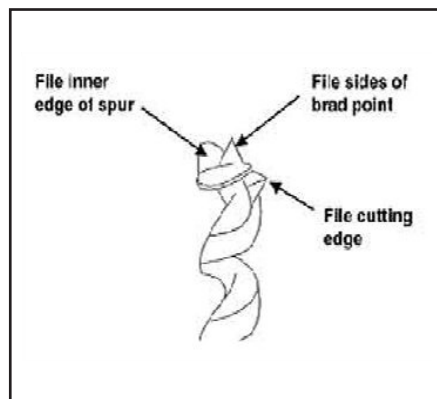
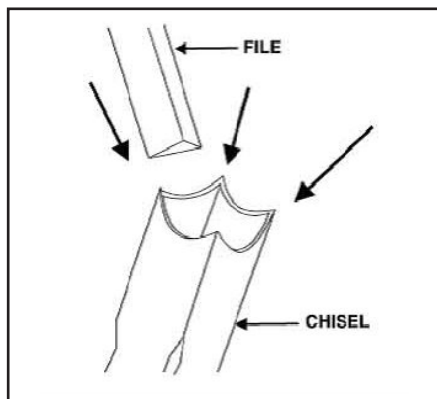
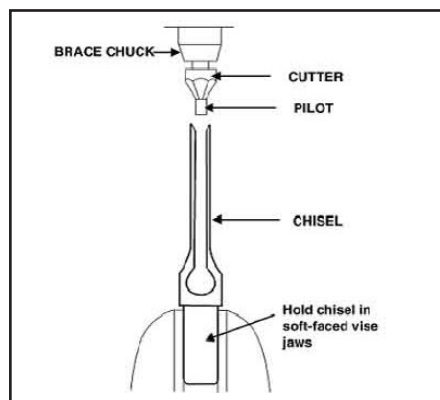
There are two adjustable dovetails on the machine. They should be kept clean and lightly oiled. If either of the dovetail slides become too tight or loose they can be adjusted. Along each slide there are a series of Grub screws with a Hex locking nut. These secure the gib strip which sits between the two moving dovetails.



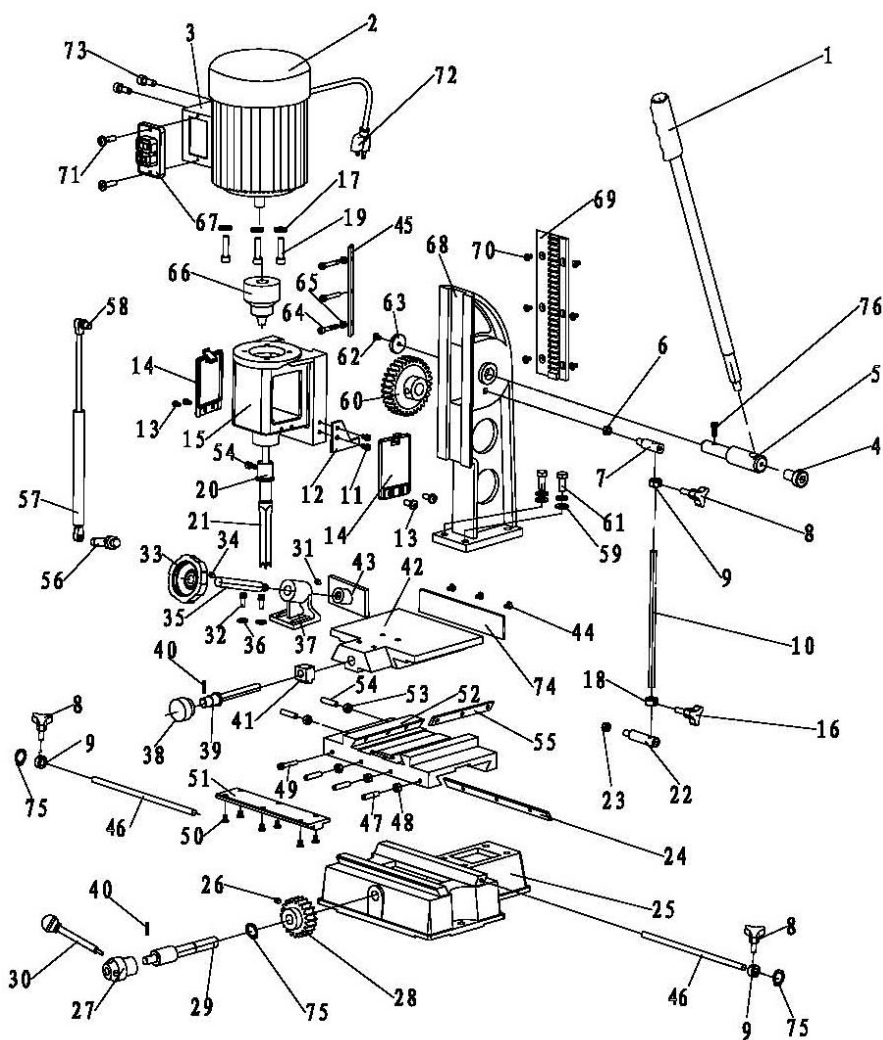
SHARPENING CHISEL & BIT

The chisel and bit should be kept sharp for best performance. Blunt edges will give inaccurate mortises and can lead to overheating and breakage to chisel or bit. If chisel and bit are badly worn and become difficult to sharpen, they should be replaced.

1. Sharpen the bit by using a small, smooth file, following the original shape of the bit. File the inside edge of the spur, the sides of the brad point, and the cutting edge Inwards toward the flute of the bit. Do not file the outside edge of the spur as this will affect the diameter of the bit.
2. Sharpen the chisel with a mortise chisel cutter with the correct size pilot. (Pilot size will differ depending on the size of your chisel). Two or three turns of the cutter in a carpenter's brace chuck should be enough to sharpen the chisel.
3. Use a small, triangular, smooth file to relieve the inner corners of the chisel. Remove any burrs from the outside of the chisel.



EXPLODED DRAWING



PART LIST

Part No.	Description	Q.	Part No.	Description	Q.
1	Handle	1	39	Lead Screw	1
2	Motor	1	40	Pin	2
3	Switch Box	1	41	Lead Nut	1
4	Screw	1	42	Table	1
5	Gear Shaft	1	43	Clamp Plate	1
6	Screw	1	44	Screw	2
7	Screw	1	45	Drift	1
8	Handle	3	46	Shaft	2
9	Setting Collar	3	47	Screw	1
10	Guide Column	1	48	Nut	2
11	Screw	2	49	Screw	1
12	Localizer	1	50	Screw	3
13	Screw	2	51	Rack	1
14	Cover	2	52	Sliding Plate	1
15	Gear Casing	1	53	Washer	3
16	Handle	1	54	Screw	3
17	Washer	4	55	Drift	4
18	Setting Collar	1	56	Screw	4
19	Bolt	4	57	Gas Spring	1
20	Chisel Bushing	1	58	Screw	1
21	Chisel	1	59	Washer	4
22	Screw	1	60	Gear	1
23	Nut	1	61	Bolt	4
24	Drift	1	62	Screw	1
25	Base	1	63	Drift	1
26	Screw	2	64	Screw	3
27	Knob	1	65	Washer	3
28	Gear	1	66	Chuck	1
29	Gear Shaft	1	67	Switch	1
30	Handle	1	68	Column	1

PART LIST

31	Screw	1	69	Rack	1
32	Screw	2	70	Screw	6
33	Knob	1	71	Screw	2
34	Screw	1	72	Power Cord	1
35	Lead Screw	1	73	Screw	4
36	Washer	2	74	Angle block	1
37	Connecting Bend	1	75	Closing ring	3
38	Knob	1	76	Screw	1

Declaration of Conformity

We

SIP (Industrial Products) Ltd
Gelders Hall Road
Shepshed
Loughborough
Leicestershire
LE12 9NH
England

As the manufacturer within the UK, England, Scotland & Wales,
declare that the

Bench Morticer with Sliding Table - Part No.01944

Conforms to the requirements of the following directive(s), as indicated.

2006/42/EC - Machinery Directive
2014/30/EU - EMC Directive
2011/65/EU - RoHS Directive

And the relevant harmonised standard(s), including

BS EN 61029-1:2009+A11:2010
BS EN 55014-1:2006+A1:2009+A2:2011
BS EN 55014-2:1997+A1:2001+A2:2008
BS EN 61000-3-2:2006+A1:2009+A2:2009
BS EN 61000-3-3:2008

Signed:



Mr P. Ippaso - Managing Director - SIP (Industrial Products) Ltd
Date: 04/10/2021



Declaration of Conformity

We

SIP (Machinery Europe) Ltd
ASM Chartered Accountants
First Floor Block One
Quayside Business Park
Dundalk
County Louth
Republic of Ireland

As the manufacturer's authorised representative within the EC
declare that the

Bench Morticer with Sliding Table - Part No.01944

Conforms to the requirements of the following directive(s), as indicated.

2006/42/EC - Machinery Directive
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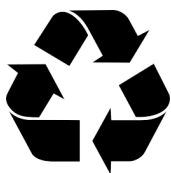
EN 61029-1:2009+A11:2010
EN 55014-1:2006+A1:2009+A2:2011
EN 55014-2:1997+A1:2001+A2:2008
EN 61000-3-2:2006+A1:2009+A2:2009
EN 61000-3-3:2008

Signed:



Mr P. Ippaso - Managing Director - SIP (Industrial Products) Ltd
Date: 04/10/2021





Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local amenity tip and place into the appropriate recycling bin.

Never dispose of electrical equipment or batteries in with your domestic waste. If your supplier offers a disposal facility please use it or alternatively use a recognised recycling agent. This will allow the recycling of raw materials and help protect the environment.

**FOR HELP OR ADVICE ON THIS
PRODUCT PLEASE CONTACT
YOUR DISTRIBUTOR, OR SIP
DIRECTLY ON:**

TEL: 01509 500400

**EMAIL: sales@sip-group.com or
technical@sip-group.com
www.sip-group.com**