1-800-533-9298 ◆ mlcswoodworking.com

MLCS

Router Bits and Professional Woodworking Products

Instructions for FEED-SAFE HOLD DOWNS

(MLCS Item #9725, #9726)

Thank you for purchasing the MLCS Feed Safe Hold-downs. This item is constructed with sturdy, die-cast aluminum. The wheels are made from neoprene rubber to prevent marring of your workpiece. The YELLOW wheels (item #9725) turn only clockwise, hence serving as both anti-kickback and hold-down devices. The GREEN wheels (item #9726) will roll freely in both directions, allowing them to be used on a shaper as a hold-down device only. Your Hold-downs will mount to fences 1-1/2" to 3" high and 1" or wider.

WARNING! No safety device is a substitute for knowledge and safe practices. Thoroughly review the operating manual for your machine prior to use and always work safely!

ASSEMBLY AND INSTALLATION

Some final assembly and adjustment must be performed prior to using your new tool.

Your can install your Feed Safe brackets right on an auxiliary wood fence or the optional 24" sliding track (not included, MLCS Item #9727). If you use the Sliding Track option, the Track would mount to your auxiliary fence.

WARNING! To avoid serious injury, always unplug your machine and ensure that blades have completely stopped before performing any assembly or installation.

Assembly:

Step 1: Install the lock nut on each pivot arm.
Step 2: Roller should be installed onto each pivot arm at LEAST 1/2". Then tighten the lock nut against the roller nut to properly secure the roller. (*See* **Fig. 1**)
Step 3: Position the housing in the mounting bracket. Tighten the thumbscrews.

Fig 1. Roller Secured on Arm

WARNING! Roller nuts must be securely threaded on the pivot arm and lock nuts tightened securely. Failure to do so will render the hold-downs useless and could result in serious injury!

(If using MLCS Item #9727 Mounting Track, please refer to the separate instructions for the mounting track before, continuing to Step 5 below).

Installation:

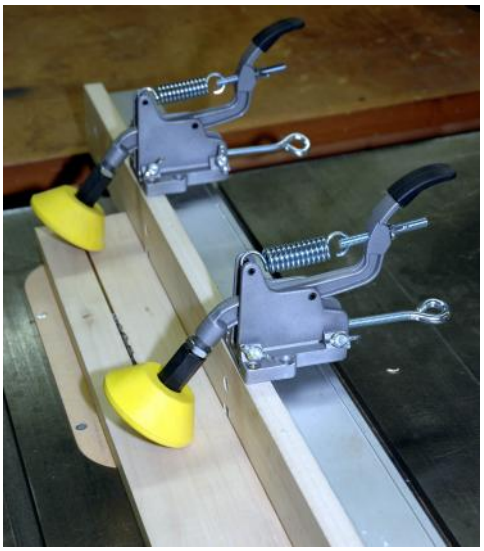


Fig 2. Feed Safe Installed with No Mounting Track

Step 1: An auxiliary wood fence 3" tall and 1" thick should be constructed at the same length as the machine's main fence.
Step 2: Use countersunk fasteners to secure the auxiliary fence to your machinery.
Step 3: Place the mounting bracket onto the auxiliary fence. Make sure it will not get in the way of your workpiece.
Step 4: Place the rollers onto the mounting bracket. Allow a minimum of 1/2" clearance in front of and behind your machine's blade.
Step 5: Adjust the mounting bracket's placement to ensure that the rollers will not be affected when you adjust your blade for increased cutting depth.
Step 6: Mark the locations of the FRONT screw holes then drill pilot holes for wood screws. (The REAR holes are provided for mounting to the optional sliding track).
Step 7: Use the wood screws to attach the mounting bracket securely to the auxiliary fence.

SAFETY AND OPERATION

This tool is designed to avoid kickback and maintain constant force against your stock.

Fig 3. Feed Safe Installation with Optional Mounting Track

Step 1: Position the main body so that the rollers line up between the line of cut and the fence. Secure with the positioning thumbscrews.
Step 2: Set the roller height to about 1/8" less than stock thickness by adjusting the roller nut, lock nut, and thumbscrew.
Step 3: Adjust the Roller pressure Adjustment Wing Nut to apply firm to firmly hold the stock in place. Do not allow the Feed Safe Hold-Down to tilt off the fence or track.

Step 4: The Feed Safe Hold-Down should never contact the blade while making any cut.
Step 5: NEVER make adjustments to your Feed Safe Hold-Downs with your machine turned on. All adjustments should be made after the machine has come to a complete stop.
Step 6: Feed your workpiece into the blade at a smooth, even pace properly using appropriate push sticks….never put hands near the machine's blades.

MAINTENANCE

Feed Safe Hold-Downs are designed for years of reliable use. Like all tools, though, periodic inspections and cleaning ensure optimal performance.

- **DO NOT** use lubricant or oil on Feed Safe parts. This could stain your workpiece or attract sawdust and other materials that may jam the tool.

- **DO ALWAYS** inspect the jam nuts and position locking thumbscrews for proper tightness. Also confirm that the Feed Safe Hold-Downs are properly adjusted.

TROUBLESHOOTING

Issue: Improper clamping pressure or roller tension, jamming of pivot arm.
Resolutions:

1) Make re-adjustments as described in the "Safety and Operation" section of this manual.
2) Adjusting screws and thumbscrews should be removed and cleaned. If any threads are stripped, replace the screws as needed.
3) Remove the Shoe by pushing down on the Pivot Arm. Remove and clean away any sawdust or other material that may prevent the shoe from moving properly in the housing. The shoe should also be replaced if broken or worn.

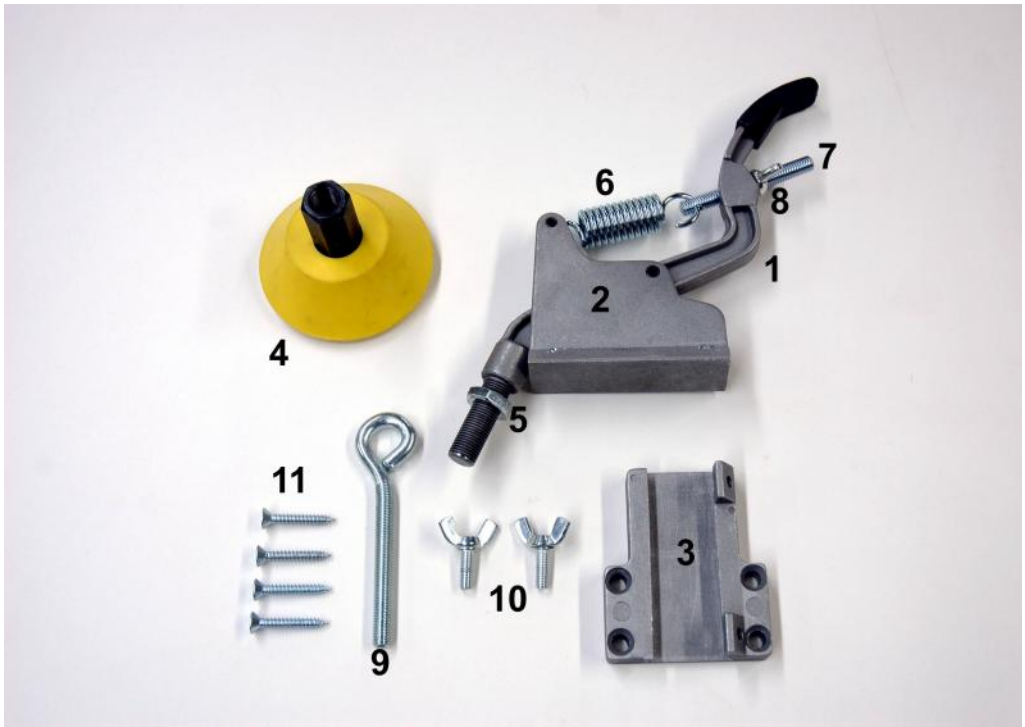
Issue: Feed Safe Hold-Down allows rolling in either direction.
Resolutions:

1) You may have the wrong roller. Replace with the appropriate YELLOW roller to allow only clockwise rotation. GREEN rollers are designed to roll freely in both directions.
2) The roller may be broken. It should be REPLACED with a new one. NEVER attempt to repair or reconstruct the roller.

PARTS LIST AND DIAGRAM

Please use this list and diagram to check your package upon receipt. Contact MLCS immediately in the rare event that a part is missing or damaged.

By e-mail: sawdust@mlcswoodworking.com
By toll-free phone: 1-800-533-9298



PART #	QUANTITY	DESCRIPTION
1	2	Pivoting Arm
2	2	Housing
3	2	Mounting Bracket
4	2	Roller Wheel
5	2	1/2" x 20 Lock Nut
6	2	Spring
7	2	5/16"-18 x 2-1/2" Tie Rod
8	2	5/16"-18 Wing Nut
9	2	5/16"-18 x 2" Adjusting Rod
10	4	1/4"-20 x 3/4" Thumbscrew
11	4	#10 x 1-1/2" Wood Screw