Drill Press Fence Operation and Instruction Manual

Features and Benefits

- Powerful magnets allow quick positioning and fine adjustment of the fence and make it easy to remove and store when a fence is not needed.
- Magnets can be positioned at different points on the fence for optimal placement on drill press tables.
- The sturdy large vertical plate that will not interfere with the drill chuck, even when drilling holes close to the fence, and can be used as a bandsaw resaw fence.
- Stop block that can be quickly be positioned flush with the drill press table or sacrificial material under the workpiece and can be stored out of the way when it is not needed.
- The Fence Plate Spec:
    - Drill Press Fence Pro (81101371): the fence plate is 21 inches long by 4 5/16 inches high.
    - Drill Press Fence (81101375): the fence plate is 13 inches long by 2 1/2 inches high.

WARNING!
Read all instructions! Failure to follow all instructions listed below may result in an unsafe or dangerous condition.

General Precautions

- All magnets must be kept a safe distance from all magnetic storage devices, electronics, credit cards, etc.
- ***Ensure that Magswitch tools are stored in the OFF position when not in contact with ferromagnetic materials***. Magswitch tools can be left ON or OFF indefinitely without harm.
- When Magswitch tools are turned ON and brought near ferromagnetic materials there will be a sudden and powerful attraction which can result in pinching and impact hazards.
- ***Never use a Magswitch tool to lift or transport materials unless specifically prescribed in the user manual.*** All Magswitch tools can be used to clean up small debris such as nuts and bolts, metal shavings, etc.
- ***DO NOT attempt to disassemble or alter Magswitch tools***; there are no user-serviceable parts inside.
- All Magswitch products are ***designed for normal work/jobsite conditions***. DO NOT use underwater or in hazardous environments without first consulting Magswitch engineering.
- ***DO NOT use a Magswitch tool if it is damaged or not working properly***. Severe injury can occur if the device is not used properly and safely.
- ***DO NOT expose standard Magswitch tools to temperatures above 176 degrees Fahrenheit (80 degrees Celsius)***. Higher temperatures will permanently degrade the magnet's effectiveness and may result in product failure or unsafe conditions.
- Painted or coated surfaces will reduce holding force and the finish may be damaged by the magnet.
- ***Always keep the bottom of the magnet clean and free of debris and rust***. If needed, wipe with WD-40 or light oil.
- This product contains PTFE lubricant. For MSDS information contact Magswitch.

⚠ **WARNING:** This product can expose you to chemicals including nickel and tetrafluoroethylene, which are known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov

⚠ **WARNING:** This product can expose you to chemicals including toluene, which are known to the State of California to cause birth defects or other reproductive harm. For more information, go to www.P65Warnings.ca.gov

Drill Press Fence Precautions

- Always consider the orientation of load and center of gravity to avoid unnecessary "moments" or torques which can peel the magnet away from the part.
- Always test the connection before relying on the Drill Press Fence to ensure it is capable of holding the material securely.
- Numerous factors can negatively affect the strength of the magnetic bond. Dirt, debris, oils and grease, painted surfaces and any gap between the magnet and the metal surface will decrease the holding force. Ensure that the attachment/connection point is clean and free of these factors for best performance.
- Thicker metals will be held more strongly than thinner metals. For instance, ¼" (6mm) steel will be held more strongly than 12 gauge (0.10") (2.7mm) and other thin material.
- Avoid sudden jerking or shock forces as this can cause the Drill Press Fence to lose its hold or slip.
- This Drill Press Fence is NOT designed to be used as a welding ground clamp or as part of an electrical circuit.
- For safe operation, the bottom surface of the magnet must always be flat and smooth. If necessary, it is possible to sand the contact face smooth with 400 grit paper and a flat surface. Always file any burrs that interfere with full contact.

Drill Press Fence Setup

- Use 3mm Allen key (included) to attach magnets to the fence (2 screws per magnet).
    - For large tables the ideal magnet position is 2 to 3 inches from the sides of the table with the fence centered. This allows from an off-center positioning of the fence for operations that benefit from the taller fence section directly behind the bit.
    - For smaller tables the ideal magnet position is close to the edges of the table to maximize the holding power of the magnets.
- The stop block can be stored out of the way on any ferrous metal surface. The user may find that the back side of the fence provides a convenient and out of way place to store the stop block

Drill Press Fence Operation

- Ensure that the bottom of the fence and drill press table is not coated with excess sawdust, as this can weaken hold of the magnets.
- Position the fence close to the desired distance from the bit and turn one magnet ON, taking care not to let the fence tip over before the first magnet is turned ON.
- With one magnet OFF and one ON, fine tune the position of the fence by moving the end with the magnet OFF (pivoting around the magnet that is on). When the desired location obtained turn the second magnet ON.
- If the drilling operation will penetrate through the workpiece it is recommended that a piece of sacrificial material is used above the drill press table, put this in place now.

- If the stop block is needed for the operation position it and turn on the magnet now, the stop block can be positioned on top of the drill press table or sacrificial material.
- Complete all drilling operations using the established fence and stop block setup and reposition by repeating these use steps for the next operation.

Drill Press Fence Service

- Gasket replacement
    - The Magswitch Drill Press Fences are intended to be lifetime tools; however, they employ rubber gasket material to increase the shear holding force provided by the magnets, and this gasket material may require replacement, and sufficient material for several replacements is provided.
    - Carefully remove and scrape out old gasket material from the recess in the base of the magnet. Plastic implements are recommended to reduce risk of damage to the aluminum metal housing, if metal tools are used please exercise extra caution.
    - Cut a length of replacement gasket material slightly longer than what is needed to replace the magnet gasket.
    - With the magnet upside down, apply a small amount (squeeze-out should be avoided) of CA glue to the bottom of the gasket recess. Epoxy is also a viable glue option.
    - Press replacement gasket strip into the recess with a small amount of excess length on each end, making sure that it is fully seated, and give the glue sufficient time to set.
    - Cut off the excess ends of the gasket so that it is flush with the ends of the magnet, taking care not to scratch the magnet top cap.

Drill Press Fence Storage

- When the drill press fence is not needed for a drilling operation it can be placed at the back of the drill press table with mounting magnets ON. Occasionally a drilling operation will require the full surface of the drill press table to be occupied by the workpiece, in such cases the drill press fence can be taken off the table and stored out of the way. If the drill press fence is placed upright on a non-magnetic surface, keep in mind that the gaskets in the base of the mounting magnets create some instability so take care not to knock the fence over. A more favorable option is placing the fence on a magnetic surface. If that surface is horizontal a single mounting magnet can be turned ON, but if it is vertical both mounting magnets should be turned ON.

Warranty

Magswitch Limited Warranty

Magswitch products are covered by a one year limited warranty on material and workmanship. Warranty is non-transferable. Magswitch reserves the right to inspect all product claims under warranty. Any alteration of the device voids this warranty. User assumes all risk for the proper use of this device and for ensuring product suitability for intended application. This warranty shall not cover any incidental or consequential damages due to the improper use or failure of this device.

Many Magswitch products are covered under international patents or patents pending. Please consult Magswitch for questions about a specific product.