



06

**Boring**

# 6.6 Slot Mortiser

## 6.6.1 Mortise to Location and Depth

Candidate Name: \_\_\_\_\_ Date/Time: \_\_\_\_\_

Evaluator Name: \_\_\_\_\_ Location: \_\_\_\_\_

Completed test successfully:  Yes  No (If no, reason:) \_\_\_\_\_

### Pre-Operation Checklist

#### Level 1

**PERFORMANCE STANDARD:**

- ▶ Verifies tool is properly guarded.
- ▶ Demonstrates knowledge of and proper use of all machine specific controls.
- ▶ Verifies jigs and/or fixtures are secure and operating effectively.
- ▶ Verifies hold-downs are positioned correctly and function properly.
- ▶ Verifies dust collection is positioned for effective chip removal.

#### Level 2

**PERFORMANCE STANDARD:**

- ▶ Verifies cutting tools are secure and free of defects.
- ▶ Verifies table is free of defects and clean.
- ▶ Verifies arbor height and table angle are set to specified dimension(s).
- ▶ Installs cutting tools and verifies cutter rotation.
- ▶ Installs and properly adjusts required jigs, fixtures and/or stops.
- ▶ Verifies fences are set with appropriate clearance to cutter head.
- ▶ Meets Level 1 performance standard.

### Considerations:

- ▶ Pre-Operation Checklist is a prerequisite for ANY operation.
  - ▶ Stock is supported as necessary
  - ▶ Proper stance and hand position are demonstrated.
  - ▶ Demonstrate appropriate feed rate to control cutter movement and waste removal relative to the size and type of material being shaped.
  - ▶ Stock is held securely against the fence or fixture as appropriate.
  - ▶ Clears machine and cleans work area after operation.
  - ▶ Required OSHA approved personal protective equipment is worn.
  - ▶ Lock-out/Tag-out procedure is in place and followed.
  - ▶ Process is completed in a timely manner.
- Please use back side for additional notes

### Operation Checklist

Level 1:	Performance standard:	
Given stock marked for single mortise, machine set up to work with cutter installed, fence, location, and depth stops set, create a slot mortise at the proper location to specified depth.	<input type="checkbox"/> Material is mortised to proper depth, width and length $\pm 0.4$ mm (1/64") [0.0156"].	<input type="checkbox"/> Sides of mortise are smooth and free of burn marks.
	<input type="checkbox"/> Material is mortised in proper position $\pm 0.4$ mm (1/64") [0.0156"].	
	<input type="checkbox"/> Mortise is free of tear-out at entry point.	

Level 2:	Performance standard:	
Given a layout and stock ready to be mortised, set up and adjust machine to mortise in the proper position to specified depth.	<input type="checkbox"/> Examines spindle for wear and lubricates machine as necessary.	<input type="checkbox"/> Meets Level 1 performance standard.
	<input type="checkbox"/> Diagnoses and corrects table misalignment.	
	<input type="checkbox"/> Fabricates a jig for angled mortises or a production fence with stops for multiple mortises.	