



# 1827 & 1827XL Drill Press Fence

*Please Read Carefully!*

## BEFORE BEGINNING

Identify and verify that you have all the parts listed. Read the instructions at least once, familiarizing yourself with the parts and assembly steps, before beginning. You'll need a #3 Phillips screwdriver for assembly.

## ASSEMBLY

Assemble the fence clamps (**1827SC** or **1827VC**) that came with your fence according to the instructions that came with them, then proceed to the rest of the assembly process below.

Insert the 3/4" flat head screws (**MF010**) in the countersunk holes of each clamp bracket (**1827A1**) and start an oval nut (**5760B**) on the end of each screw. Slide the 2" double track (**4002**) on to the oval nuts. Position the double track even with the long edge and flush with the end of the clamp bracket, then tighten the screws. *See fig. 1.*

Insert the 3/4" flat head screws (**MF010**) in the countersunk holes of each fence bracket (**1827A2**) and start an oval nut (**5760B**) on the end of each screw. Slide the fence bracket on to the 2" double track, position the end without the holes flush with the end of the double track, then tighten the screws. *See fig. 1.*

Insert a 3/4" screw (**5771B**) thru the lower hole in each fence bracket (*there is an upper hole in case you want to stack tracks horizontally on top of each other*) and start an oval nut (**5760B**) on the end of each screw. Slide a completed clamp on to each end of the 32" double track (**4032**) by inserting the oval nuts of the fence bracket into the back T-slot of the track. *See fig. 4.*

Note that the double track can be positioned vertically (**1-1/2" tall**) or horizontally (**3/4" tall**). Determine the best configuration for your needs and install the clamps on the track accordingly. *See fig. 2 & 3.*

You can center the clamps on the track, or you can offset the clamps to favor one side. Adjust the spacing between the clamps so the fence has a limited amount of side-to-side movement when placed on the drill press table, then tighten the screws. *See fig. 2 thru 6.*

## ACCESSORIES

Flip Stops (**4512** or **4514**) are available to help position work pieces on the fence. Longer double tracks (**4048 - 48"**, **4072 - 72"** & **4096 - 96"**) are available if you need a longer fence.

## Parts List:

Part	Description	Quantity
1827A1	Clamp Bracket.....	2
1827A2	Fence Bracket.....	2
4032	32" Double Track.....	1
4002	2" Double Track.....	2
5760B	Oval Nut.....	10
MF010	3/4" Screw.....	8
5771B	3/4" Screw.....	2

*In addition to the above parts, you will also have one of the fence clamp hardware packages below:*

1827SC	Standard Fence Clamps.....	1
1827VC	Vise Grip Fence Clamps.....	1

