



Power House Pivoting Jig Install Guide

The Powerhouse jig was designed not only to be used as a new complete unit but also is can be used as an upgrade to most any existing milling machine.

Because of its low profile it can be added to most any milling machine with very few modifications.

We have found that in some cases it is necessary to change the drill bit holder arm and the arm for the control box.

If you need these items they have been included with your new Jig.

If you do not need these simply discard them?

Below we have listed the sequence for installing the jig.

NOTE: ALL THE FOLLOWING IS TO BE DONE WITH THE MACHINE UNPLUGGED.

1. Place the T-nuts in the slots on the Mill machine table.
2. Place the new Powerhouse jig on the mill table and align the T-nuts with the mounting holes in the new jig.
3. Start the round head allen screws thru the jig plate and into the t-nuts.
4. Align the jig with the front of the mill table and even on both sides, tighten the 4 allen screws.
5. Loosen the lug bolts on the right hand side of the machine, as you will need to raise the head of the machine. If your machine has the black cap that covers the top of the post you will need to remove this also.
6. To set the height of the head raise the head up so that it will enable you to remove a drill bit from the chuck with out removing the ball, the tip of the bit should be $\frac{3}{4}$ to 1" above the surface of the ball.
7. Once you have this set center the head and tighten the lug bolts, paying close attention to **NOT** tighten the nuts all at once, do them a little bit at a time till tight.

Setting the Table for Drilling:

1. Place a ball in the jig and clamp it down.
2. Place a 3" plug trimming blade in the chuck of the machine.
3. Pull it down so it is just touching the top of the ball and crank the tables forward and back and left to right until you are perfectly

aligned over the ball, note that if you are perfect you should be able to slip a dollar bill under each edge of the blade on each side, once you have equal space on both sides you can place the 6 inch rulers on the table, using a double sided tape.

4. Place one of the rulers on the bottom table for forward and reverse and the other ruler to the top table for left to right.