

PORTER-CABLE SERVICE CENTERS (CENTROS DE SERVICIO DE PORTER-CABLE)

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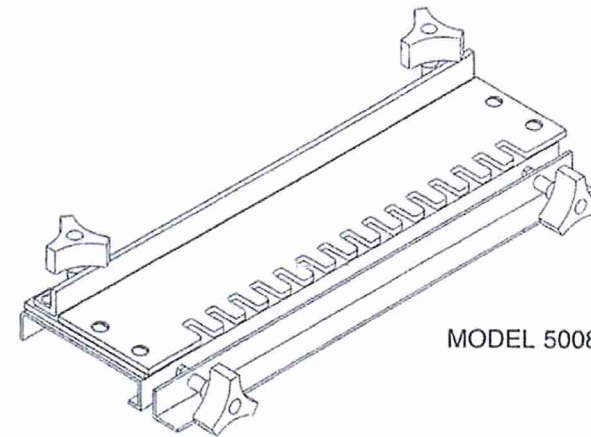
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Dovetail Templet

IMPORTANT

Please make certain that the person who is to use this equipment carefully reads and understands these instructions before starting operations.



MODEL 5008

INTRODUCTION

Your new Porter-Cable tool is simple to operate and is built to give long, trouble-free performance. However, you will achieve the best results if you will take a few minutes to read through this manual. In the following pages, basic operating instructions are given. Please be sure to learn the basic operating techniques so you can get the longest life and most productive use from your tool.

IMPORTANT SAFETY INSTRUCTIONS

WARNING: When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following:

READ AND FOLLOW ALL INSTRUCTIONS.

There are certain applications for which this tool was designed. Porter-Cable strongly recommends that this tool NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application DO NOT use the tool until you have written Porter-Cable and we have advised you.

Technical Service Manager
Porter-Cable Corporation
4825 Highway 45 North
P. O. Box 2468
Jackson, TN 38302-2468

1. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite injuries.
2. **AVOID DANGEROUS ENVIRONMENT.** Don't expose power tools to rain. Don't use power tools in damp or wet locations. Keep area well lit. Avoid chemical or corrosive environment. Do not use tool in presence of flammable liquids or gases.
3. **GUARD AGAINST ELECTRIC SHOCK.** Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges, refrigerator enclosures.
4. **KEEP CHILDREN AWAY.** Do not let visitors contact tool or extension cord. All visitors should be kept away from work area.
5. **STORE IDLE TOOLS.** When not in use, tools should be stored in dry, and high or locked-up place – out of reach of children.
6. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was intended.
7. **USE RIGHT TOOL.** Don't force small tool or attachment to do the job of a heavy duty tool. Don't use tool for purpose not intended – for example – do not use a circular saw for cutting tree limbs or logs.
8. **DRESS PROPERLY.** Do not wear loose clothing or jewelry. Loose clothing, draw strings and jewelry can be caught in moving parts. Rubber gloves and non-skid footwear are recommended when working outdoors. Wear protective hair covering to contain long hair.
9. **USE SAFETY GLASSES.** Wear safety glasses or goggles while operating power tools. Also face or dust mask if operation creates dust. All persons in the area where power tools are being operated should also wear safety glasses and face or dust mask.
10. **DON'T ABUSE CORD.** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil, and sharp edges. Have damaged or worn power cord and strain reliever replaced immediately. **DO NOT ATTEMPT TO REPAIR POWER CORD.**
11. **SECURE WORK.** Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
12. **DON'T OVERREACH.** Keep proper footing and balance at all times.
13. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and if damaged, have repaired by authorized service facility. Inspect extension cords periodically and replace if damaged. Have all worn, broken or lost parts replaced immediately. Keep handles dry, clean and free from oil and grease.
14. **DISCONNECT TOOLS** when not in use, before servicing, and when changing accessories such as blades, bits, cutters, etc.
15. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
16. **AVOID UNINTENTIONAL STARTING.** Do not carry a plugged-in tool with finger on switch. Be sure switch is off when plugging in. Keep hands, body and clothing clear of blades, bits, cutters, etc. when plugging in the tool.
17. **OUTDOOR USE EXTENSION CORDS.** When tool is used outdoors, use only extension cords marked "Suitable for use with outdoor appliances – store indoors when not in use."

18. **STAY ALERT.** Watch what you are doing. Use common sense. Do not operate tool when you are tired or while under the influence of medication, alcohol or drugs.

19. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in this instruction manual. Have defective switches replaced by authorized service center. Do not use tool if switch does not turn it on and off.

20. **WEAR EAR PROTECTION** to safeguard against possible hearing loss.

SAVE THESE INSTRUCTIONS

ADDITIONAL SAFETY RULES

1. **SECURE WORK.** Be sure dovetail templet and work are anchored securely to prevent movement.
2. **BE SURE CORD SET IS FREE** and will not hang up during routing operations.
3. **KEEP HANDS CLEAR** of cutter when motor is running to prevent personal injury.
4. **MAINTAIN FIRM GRIP** on router when starting to resist starting torque.
5. **STAY ALERT** and keep cutter free, clear of all foreign objects while motor is running.
6. **BE SURE MOTOR HAS COMPLETELY STOPPED** before removing router from templet and setting machine down between operations.
7. **NEVER REMOVE ROUTER MOTOR** from router base while templet guide and dovetail bit are installed. Dovetail bit will not fit through hole in templet guide.
8. **TIGHTEN** templet guide locknut securely.
9. **READ AND FOLLOW ALL SAFETY INSTRUCTIONS** in the instruction manual supplied with your router.
10. **SOME WOOD CONTAINS PRESERVATIVES WHICH CAN BE TOXIC.** Take extra care to prevent inhalation and skin contact when working with these materials. Request, and follow, any safety information available from your material supplier.

REPLACEMENT PARTS

When servicing use only identical replacement parts.

FOREWORD

One of the strongest and most widely used joints in the professional woodworking industry is the dovetail joint. Large commercial furniture houses use this method of construction on all of their better furniture. You can duplicate such joint construction by using your Porter-Cable Dovetail Templet in conjunction with your Porter-Cable portable electric router. Once set up, this templet may be used to rout any number of dovetail joints.

CAPACITY

Your Porter-Cable Dovetail Templet will handle stock up to 12" wide and from $\frac{5}{16}$ " to 1" in thickness.

TYPE OF DOVETAILES

FLUSH DOVETAILES – When the front of the drawer is flush with the sides of the drawer, it is known as a Flush Dovetail. See Fig. 1.

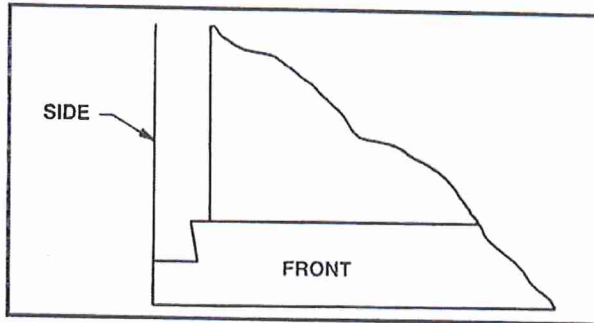


Fig. 1

RABBETED DOVETAILES – When the front of the drawer overlaps the sides of a drawer, it is known as a Rabbeted Dovetail. See Fig. 2.

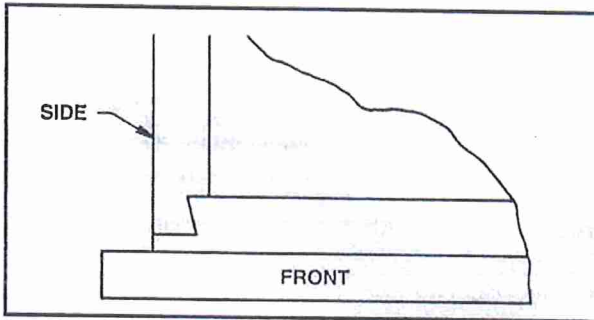


Fig. 2

SELECTING THE SIZE FOR DOVETAILES

$\frac{1}{2}$ " Flush or Rabbeted Dovetails are recommended for drawers having the front and side pieces $\frac{1}{2}$ " min. thick.

$\frac{1}{4}$ " Flush Dovetails are recommended for drawers having the front piece $\frac{3}{8}$ " min. thick and side pieces $\frac{5}{16}$ " min. thick.

Most common size drawers require $\frac{3}{4}$ " thick front piece, $\frac{1}{2}$ " thick side and back pieces, and $\frac{3}{16}$ " or $\frac{1}{4}$ " thick bottoms.

MOUNTING THE TEMPLAT

It is recommended that the dovetail templet be permanently mounted on a work bench or a piece of $\frac{5}{8}$ " (or thicker) plywood of such size that it can be clamped or otherwise firmly attached to a rigid support.

1. Remove the wing nuts and spacers (A) Fig. 3, from the top clamp bar.
2. Lift off the finger templet-bracket-top clamp bar assembly (B) Fig. 3.

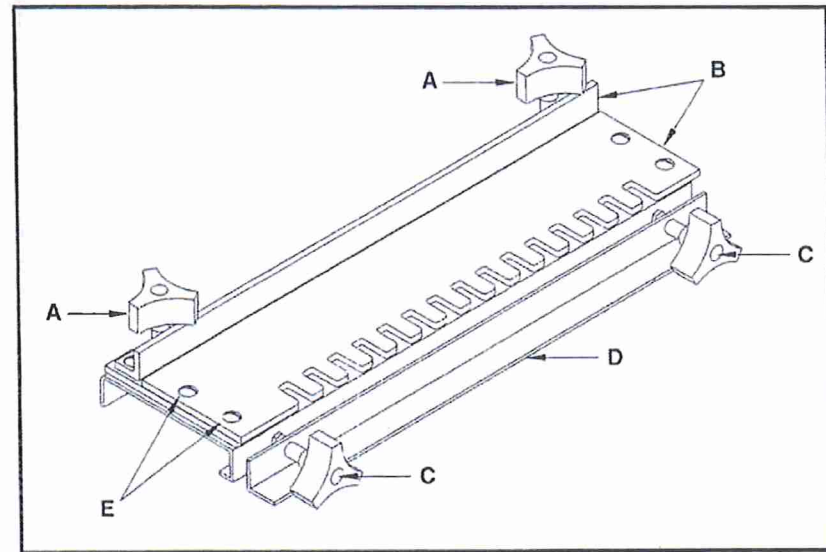


Fig. 3

3. Remove springs from clamp bar screws (E) Fig. 4.
4. Snugly butt templet apron (A) Fig. 4, against front of bench top or plywood (B) Fig. 4.
5. Insert round head wood screws (C) Fig. 4, in holes (D) Fig. 4, at rear edge of templet base and screw into bench top or plywood to firmly attach templet base.
6. Check the two clamp bar screws to make sure they are square to the base. If any are found to be tilted in any direction, loosen locknut, straighten the screw and tighten the nut.

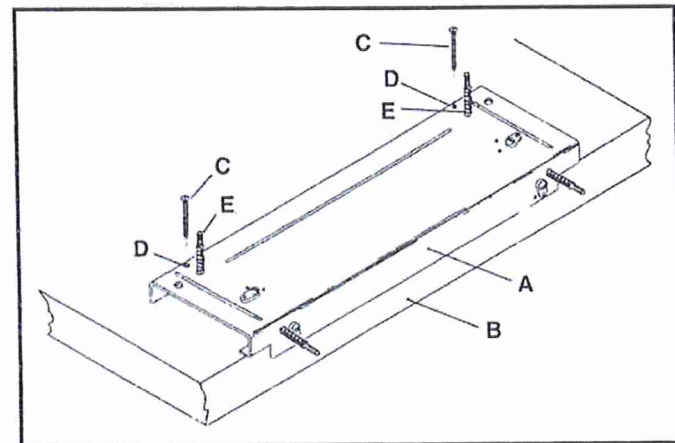


Fig. 4

PREPARING TEMPLT FOR 1/2" FLUSH DOVETAIL JOINTS

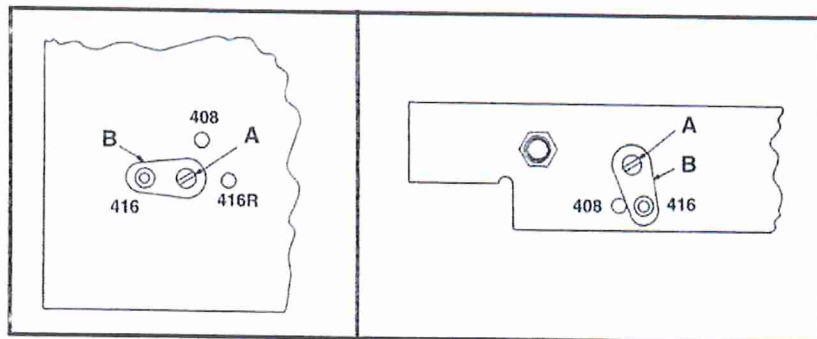


Fig. 5

Fig. 6

1. Loosen the locating cam screw (A) Fig. 5, on the left top surface of the templet base, and rotate the locating cam (B), until the pimple on the cam nests in the hole marked 416.
2. Now, position the locating cam on the right top surface in the same way.
3. Install springs, finger templet-bracket-top clamp assembly, spacers and wing nuts.
4. Remove the wing nuts and spacers (C) Fig. 3, from the front clamp bar (D) Fig. 3.
5. Remove front clamp bar.
6. Loosen the locating cam screw (A) Fig. 6, on the left front end of the templet apron, and rotate the locating cam until the pimple on the cam nests in the hole marked 416.
7. Now, position the locating cam on the right front end of the apron in the same way.
8. Install front clamp bar, spacers and wing nuts.
9. Check the 3/8" space, Fig. 7, between the back edge (B) Fig. 7, of the finger templet and the front side (C) Fig. 7, of the top clamping bar. This space should be the same at both ends of the finger templet. If necessary, adjustment may be made as follows:
 - (a) Loosen the two screws (A) Fig. 7, just enough so brackets (E) can be moved.
 - (b) While holding finger templet and brackets forward, turn set screws in back edge of brackets at point (F) until the 3/8" dimension is the same at both ends.

NOTE: A wrench is furnished with the dovetail templet for adjusting the set screws.

PREPARING ROUTER FOR 1/2" FLUSH AND RABBETED DOVETAILS

To make 1/2" Flush or Rabbeted Dovetails, #42183 Dovetail Kit, available as an accessory, is required. This kit consists of one each of #42027 Templet Guide, #42237 Lock Nut, and #43640 1/2" Dovetail Bit.

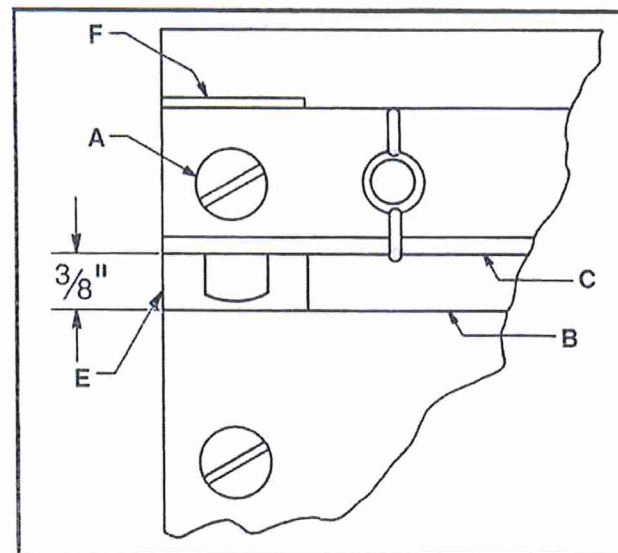


Fig. 7

1. **CAUTION: DISCONNECT ROUTER FROM POWER SOURCE.**
2. Insert templet guide (A) Fig. 8, in hole (B), in router sub-base (C).
3. Install templet guide locknut (D) on templet guide and firmly tighten to lock templet guide in sub-base.
4. Insert #43640 dovetail bit (A) Fig. 9, thru templet guide into router collet.
5. Adjust router so dovetail bit projection (B) from bottom of router sub-base (C), is exactly 19/32".

The router is now ready to cut 1/2" dovetail joints.

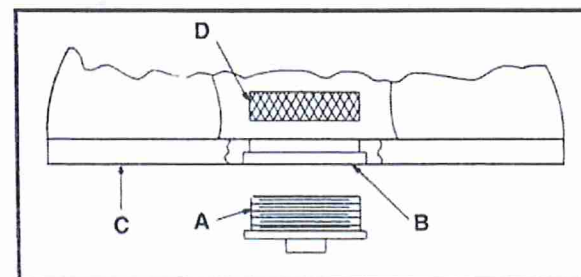


Fig. 8

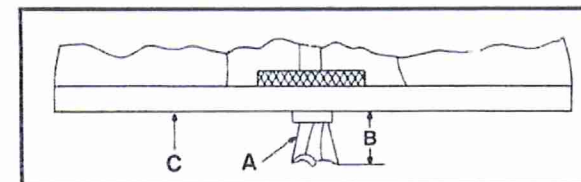


Fig. 9

SETTING UP DRAWER PARTS FOR ROUTING

It is recommended that scrap lumber be used when making your first dovetail cut so all adjustments and fits can be checked to insure a satisfactory joint. Once the templet and router have been set up to rout a satisfactory dovetail joint, any number of joints can be made.

1. Arrange the drawer front and side pieces as shown in Fig. 10.

NOTE: Ends of front and side pieces must be cut square with the length of the pieces to produce good dovetail joints.

2. Mark the "outside", "inside" and ends of each piece as shown in Fig. 10.
3. Always be sure to clamp the "outside" surfaces of the pieces toward the templet. The pieces are routed in the position of being "inside out", and, when joined together, are reversed.

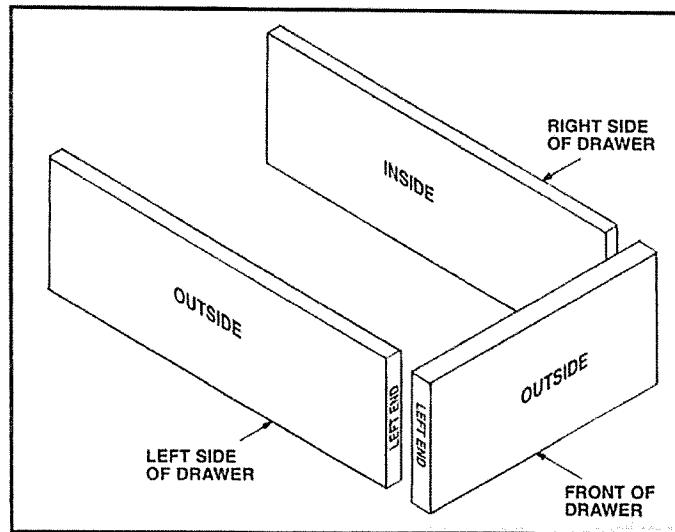


Fig. 10

4. Temporarily clamp the left side of the drawer against the front apron. The piece ("inside out") as in Fig. 11, should be firmly butted against the locating cam on the left end of the apron with about $\frac{1}{2}$ " of stock showing above the top surface of the base as shown in Fig. 11.

5. Now, place the drawer front ("inside up") as in Fig. 12, under the finger templet and firmly butt it against the side piece and the locating cam on the left top surface of the templet base as shown in Fig. 12. Firmly tighten top clamp bar wing nuts to lock drawer front in place.

6. Next, loosen front clamp bar wing nuts just enough so you can move the side piece up, butting it against the underside of the finger templet and against the left locating cam. Firmly tighten front clamp bar wing nuts. You are now ready to rout.

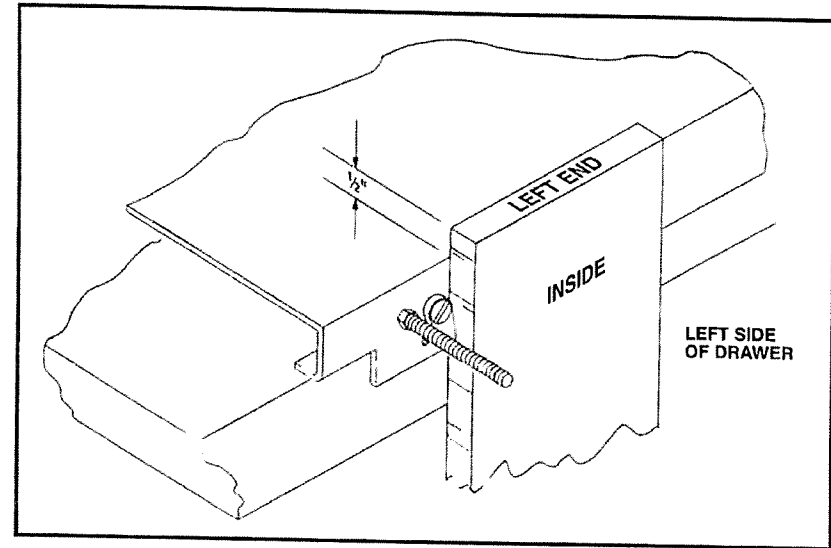


Fig. 11

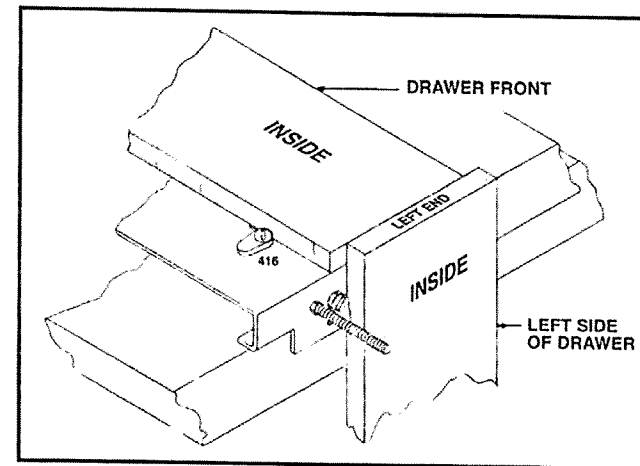


Fig. 12

ROUTING $\frac{1}{2}$ " FLUSH DOVETAIL JOINT

NOTE: When making the dovetail cut, never move the router on or off the finger templet while the motor is running. The spinning router bit might hit and damage the finger templet.

1. As you stand facing the templet, set the router squarely on the finger templet to the right of the drawer pieces. Make sure bit is clear of work and motor is "OFF".
2. Start the motor and make the first cut along the entire outside edge of the finger templet, from right to left, in the direction of the arrow (A) Fig. 13. This will prevent chipping of the edge of the drawer piece when the router is moved in and out of the templet.

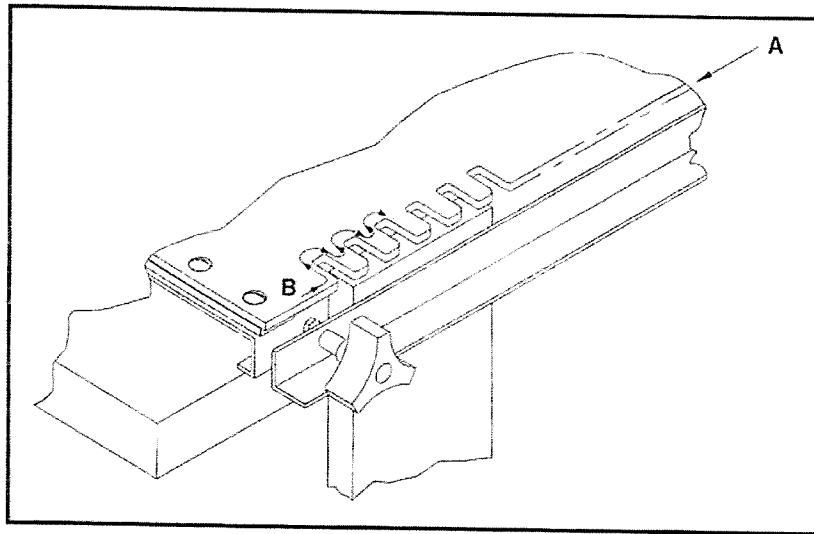


Fig. 13

3. Now, carefully move the router from left to right around the templet outline, in and out of the slots as shown by arrow (B) Fig. 13.
4. Next, examine the drawer pieces to make sure they have been cleanly routed. See Fig. 14.
5. Remove drawer pieces and fit together, matching dovetail (A) with slot (B), Fig. 14.
6. Try the dovetail joint for snugness of fit.

CAUTION: DISCONNECT ROUTER FROM POWER SOURCE BEFORE MAKING ADJUSTMENTS TO ROUTER.

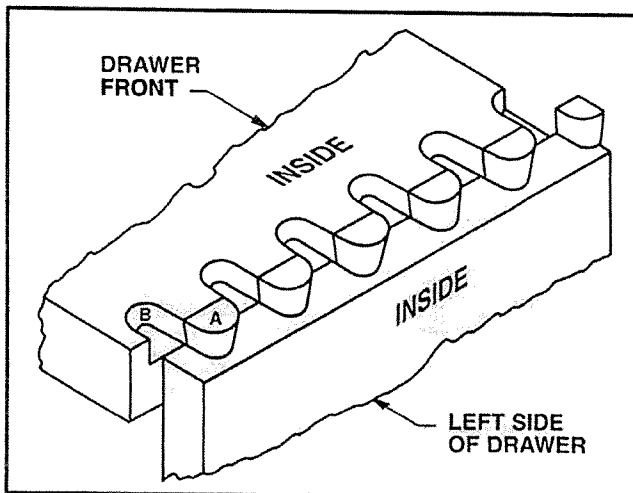


Fig. 14

If joint is loose, slightly increase dimension (B) Fig. 9. If joint is tight, slightly decrease dimension (B) Fig. 9. The bit is raised or lowered by adjusting the router motor in the router base with the motor "OFF".

7. After obtaining a snug dovetail fit as outlined in step 6 assemble parts and check the relation of the end of the drawer front with the side of the left side of the drawer. If they are not flush, increase or decrease the $\frac{3}{8}$ " space, Fig. 7, until the desired fit is obtained. REMEMBER, this space must be the same at both ends at the templet after tightening screws (A) Fig. 7.

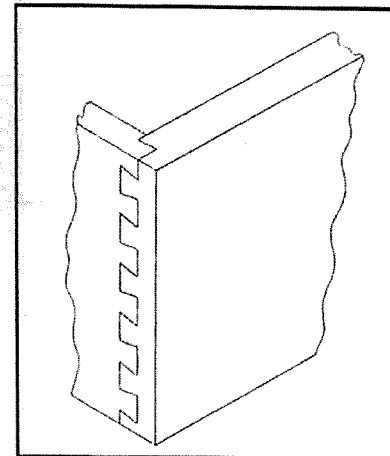


Fig. 15

Fig. 15 shows the left corner fitted together.

8. When you have completed the left dovetail joint, temporarily clamp the right side of the drawer ("inside out") under the front clamp bar making certain it firmly butts against the locating cam at the right end of the templet apron and with about $\frac{1}{2}$ " of stock showing above the top surface of the templet base.

9. Now, install the drawer front ("inside up") with unrouted end under the right end of the finger templet, making sure it is firmly butted against the locating cam and side piece.

10. Readjust the side piece and follow the same procedure used to cut the left corner.

Most drawers are dovetailed only at the front joints since there is no pulling strain on the back of the drawer. After dovetailing, the front and side pieces of the drawer are slotted to receive the bottom section. This may be done with your Porter-Cable portable electric router equipped with a straight cutter and edge guide.

After the front and side pieces have been slotted, the dovetail joints may be fitted and glued, the bottom piece slipped into place and the back piece nailed or screwed to the two side pieces with the bottom edge resting on the drawer bottom piece.

HOW TO CUT RABBETED DOVETAIL JOINTS

If you prefer a rabbeted or overlapping drawer front, add $\frac{3}{4}$ " to the length and $\frac{3}{4}$ " to the width of the drawer front. Before routing the dovetails, cut a $\frac{3}{8}$ " x $\frac{3}{8}$ " rabbet completely around the inside of the drawer front. See Fig. 16.

For the following, the same equipment that was specified for $\frac{1}{2}$ " flush dovetail joints, is used.

1. Loosen the locating cam screws on the top of the templet base and position the locating cams so the pimples nest in the holes marked 416R. See Fig. 5. Firmly tighten screws.
2. Now, clamp and adjust the left side and front pieces in the templet in the same manner as outlined for $\frac{1}{2}$ " flush dovetail joints.

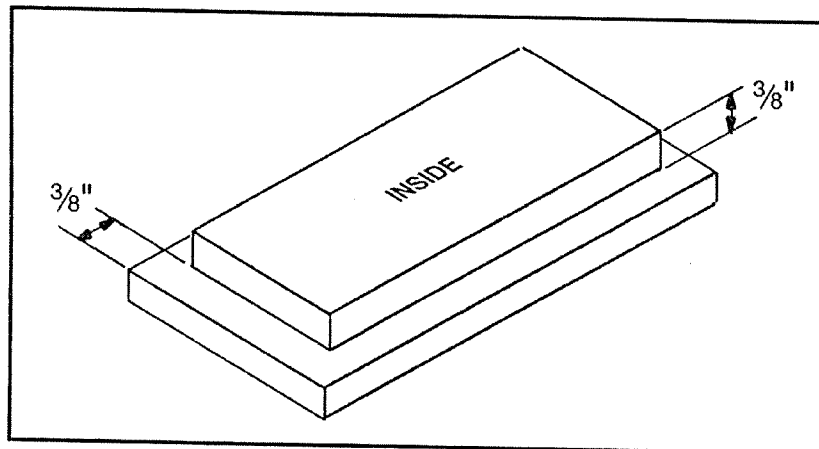


Fig. 16

3. Rout joint same as for 1/2" flush dovetail joints. During this operation, the left side piece will be completely cut but the front piece will be only slightly notched.
 4. Loosen front clamp bar wing nuts and remove side piece.
 5. Loosen templet adjusting screws (A) Fig. 7, at each end of the top clamp bar only enough to allow the finger templet-bracket assembly to be moved. **DO NOT LOOSEN THE TOP CLAMP BAR WING NUTS** because the drawer front is not to be disturbed.
 6. Move finger templet-bracket assembly back until the back edge (B) Fig. 7, of the finger templet butts against the top clamp bar (C) Fig. 7, along its entire length. Firmly tighten templet adjusting screws (A) Fig. 7, to lock finger templet-bracket assembly in this position.
 7. Recut the drawer front to the depth permitted by the new setting of the finger templet.
 8. Loosen templet adjusting screws (A) Fig. 7, and move finger templet-bracket assembly forward as far as it will go and firmly tighten screws. Check the 3/8" dimension Fig. 7, to make sure it is the same at each end of the templet.
 9. Remove drawer front.
 10. Now, clamp and adjust the drawer front and right side pieces against the locating cams at the right end of the templet and make the right dovetail corner in a manner similar to that used to make the left dovetail corner.
 11. Slot the front and side pieces and assemble the drawer in the same manner that was outlined for 1/2" flush dovetail joints.
- A special Rabbet Dovetail Finger Templet, No. 48029, available as an accessory, is designed for cutting 1/2" rabbeted dovetails in one cut without adjusting the finger templet-bracket assembly after cutting the side.

ROUTING 1/4" FLUSH DOVETAIL JOINTS

To cut 1/4" flush dovetails the following equipment, available as accessories, is required.

- 48021 Finger Templet
- 42054 Templet Guide
- 42237 Lock Nut
- 43639 1/4" Dovetail Bit

NOTE: 1/4" RABBETED DOVETAILS CANNOT BE CUT.

1. Remove four screws (E) Fig. 3, and Finger Templet furnished with your dovetail templet.
2. Set locating cams (B) Fig. 5 and 6, on top and front of templet base, in the holes marked 408.
3. Assemble #48021 Finger Templet with four screws removed in Step 1.
4. Assemble #42054 Templet Guide and Locknut as shown in Fig. 8.
5. Insert #43639 Dovetail Bit through Templet Guide and into collet, Fig. 9. Firmly tighten collet.
6. Adjust router so Dovetail Bit Projection (B) Fig. 9, is 7/16".
7. Set up drawer parts and rout dovetail joint in the same manner as outlined for 1/2" flush dovetails.

ACCESSORIES

The testing of this tool has been accomplished with the following accessories. For safest operation, it is recommended that only these accessories be used with this product.

WARNING: Since accessories other than those listed have not been tested with this product, use of such accessories could be hazardous.

- No. 42183** Dovetail Accessory Kit includes 43640 1/2" Dovetail Bit, 42027 Router Templet Guide and 42237 Nut.
- No. 42027** Router Templet Guide for 1/2" dovetails.
- No. 42054** Router Templet Guide for 1/4" dovetails.
- No. 42237** Lock Nut for attaching templet guides to router.
- No. 48016** Finger Templet for 1/2" dovetails.
- No. 48021** Finger Templet for 1/4" dovetails.
- No. 48029** Finger Templet for 1/2" rabbet dovetails only.

HIGH SPEED STEEL

Dovetail (DT). For dovetailing joints.
Use with dovetail template.

Model No.	Cutting		Shank	
	Dia. In.	Length In.	Dia. In.	Length
43639	1/4	7/16	1/4	1 1/2
43640	1/2	1/2	1/4	1 1/4

PORTER-CABLE LIMITED ONE YEAR WARRANTY

Porter-Cable warrants its Professional Power Tools for a period of one year from the date of original purchase. We will repair or replace at our option, any part or parts of the product and accessories covered under this warranty which, after examination, proves to be defective in workmanship or material during the warranty period. For repair or replacement return the complete tool or accessory, transportation prepaid, to your nearest Porter-Cable Service Center or Authorized Service Station. Proof of purchase may be required. This warranty does not apply to repair or replacement required due to misuse, abuse, normal wear and tear or repairs attempted or made by other than our Service Centers or Authorized Service Stations.

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