

# **MULTI-FENCE™**

## **ACCESSORIES**

### **Operators Manual**

**FOR MODELS:**

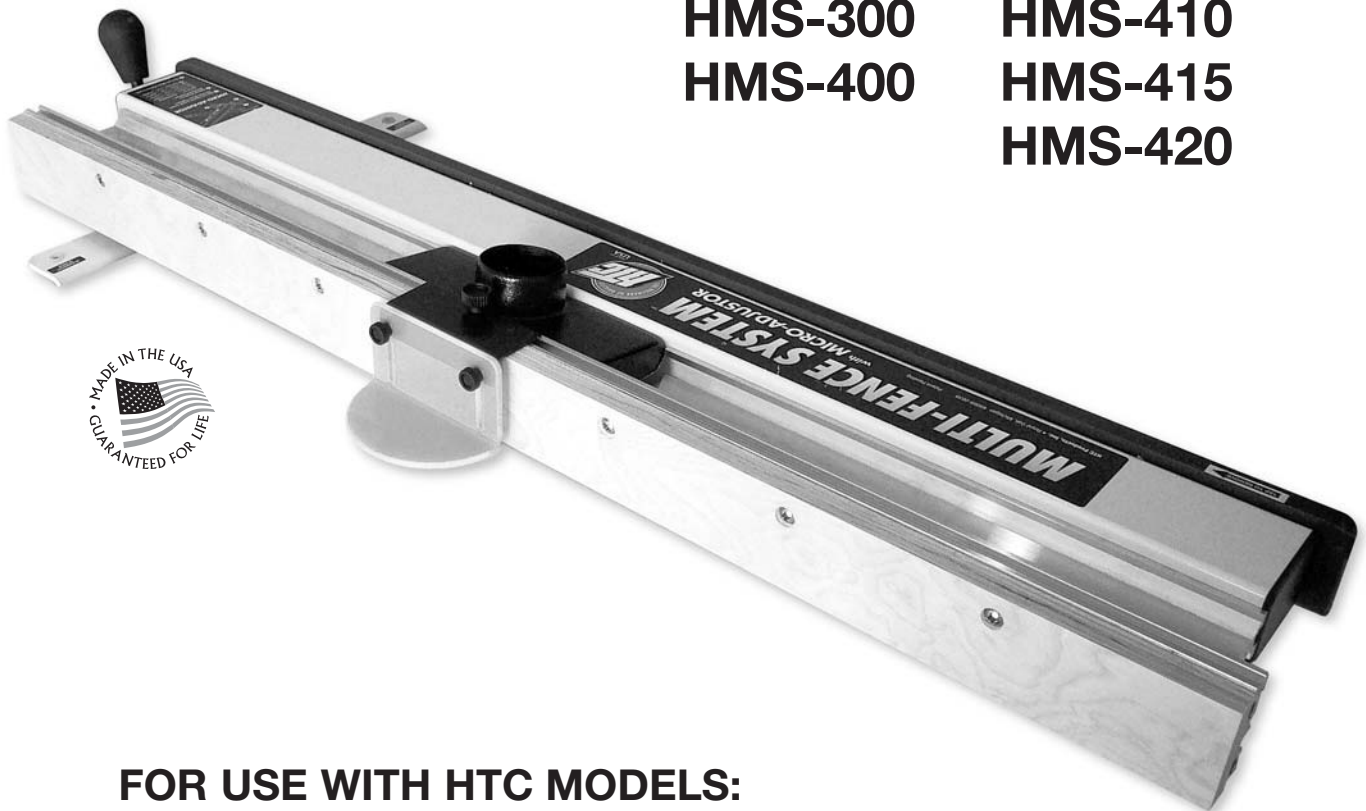
**HMS-300**

**HMS-410**

**HMS-400**

**HMS-415**

**HMS-420**



**FOR USE WITH HTC MODELS:  
HTC-800 AND HTC-900  
MULTI-FENCE SYSTEMS**



# MULTI-FENCE™

## ACCESSORIES

### Parts



#### HMS-400 Router Fence

Description	Part No.	Qty.
<b>A</b> Machined Extrusion	2926 (HTC-800) 2925 (HTC-900)	1
<b>B</b> Offset Extrusion R	2927A (HTC-800) 2618A (HTC-900)	1
<b>C</b> Offset Extrusion L	2927B (HTC-800) 2618B (HTC-900)	1
<b>D</b> Wood Face	—	2
<b>E</b> Dust Port	A115	1
<b>F</b> Acrylic Shield	A114	1
<b>G</b> Shield Mount	—	1
<b>H</b> Mounting Clip	F102	4
<b>J</b> 10-32 x 3/8" Machine Screw	D209	8
<b>K</b> 1/4 - 20 x 1/2" Flat Head	D127	4
<b>L</b> 1/4 - 20 x 3/4" Panhead	D101	6
<b>M</b> Slider Nut	J028A	7
<b>N</b> 10-32 Knob	G109	2
<b>O</b> 1/4 - 20 Knob	G110	1
<b>P</b> 1/4 x 3/8" Sheet Metal Screw	D136	2

#### HMS-415 Master Extrusion

Description	Part No.	Qty.
Machined Extrusion	2929 (HTC-800) 2928 (HTC-900)	1
Mounting Clip	F102	4
10-32 x 3/8" Machine Screw	D209	8

#### HMS-420 Cabinet Makers Fence

Description	Part No.	Qty.
Machined Extrusion	—	1
Mounting Clip	F102	8
10-32 x 3/8" Machine Screw	D209	16

# Thank You and Congratulations!

Thank you for your recent purchase of an HTC Multi-Fence Accessory. This product is manufactured by craftsmen dedicated to making high quality, reliable products. Each accessory has been designed to help you increase your shop's productivity and get the most out of your Multi-Fence System.

## General Product Safety Warning

As with all products there are certain hazards involved with their operation and use. Using any product with respect, caution, and common sense will considerably lessen the possibility of personal injury. Safety is a combination of staying alert, knowing how the product works, and knowing how to properly use the product. To use any product safely you should plan ahead and practice the proper steps prior to actually using the product. If safety rules and instructions are overlooked or ignored, personal injury to the operator or other people in the area may result. Safe operation of any product requires that you read and understand the product instructions and all labels affixed to the product.

**Always read and follow all instructions and safety rules carefully.**

This product is designed for certain uses only. This product or any of its parts shall NOT be altered, changed, or modified in any way and/or used for any other use than it's designed for. If you have any questions about its proper care or use DO NOT use the product until you have written HTC and we have advised you in writing.

HTC Products, Inc. – Technical Support  
P.O. Box 839  
Royal Oak, MI 48068-0839  
248-399-6185 • 800-624-2027  
8:00 AM to 5:00 PM EST/EDT Monday – Friday

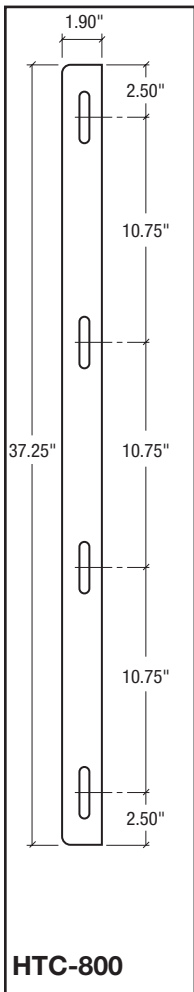
## General Safety Rules

Using power tools of any kind can be dangerous if safe operating procedures are not followed. Recognizing the hazards of each tool and using them with respect and caution will considerably limit the possibility of personal injury. However, if safety precautions are ignored, personal injury will likely result. Always use common sense – your personal safety is your responsibility.

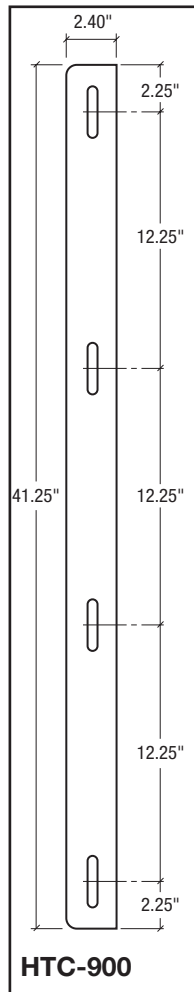
1. Know your power tool. Read and understand the Operator's Manual and observe the warnings and instruction labels affixed to the tool.
2. Properly ground all tools.
3. Keep guards in place.
4. Remove adjusting keys and wrenches.
5. Keep work area clean and dry.
6. Keep children away.

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HTC-800  
Figure 1



HTC-900  
Figure 2

7. Never leave running machines/tools unattended.
8. Disconnect tools from service.
9. Use correct tools for the job.
10. Never force a tool.
11. Wear safety apparel.
12. Wear safety glasses/goggles.
13. Never stand or sit on tools.
14. Replace damaged components immediately.
15. Make sure your work platform is sufficiently sturdy to do the specific job at hand.
16. Properly anchor power tools to work stands.
17. Use correct blade for job being done.
18. Think Safety. Safety is a combination of operator awareness, common sense and alertness at all times.

## Applications

When building jigs or fixtures for use with the HTC-800 or HTC-900 Multi-Fence Systems, it is extremely important to install the F-102 Mounting Clips at the correct depth and frequency to insure a tight lock to the fence head. In addition, the jig or fixture must lock onto the fence head in the same direction as material will be fed during a particular operation. This insures the jig or fixture will actually tighten under load.

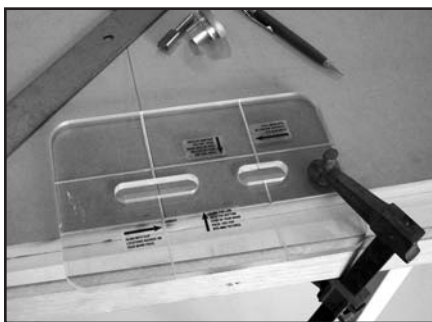


Figure 3



Figure 4

## HMS-300 Routing Template

The HMS-300 Routing Template is designed to assist in locating and machining F-102 clip positions in your own shop built jigs or fixtures. This template requires a 31/64" straight router bit, and a 5/8" O.D. x 17/32" I.D. guide bushing (short barrel).

1. To begin, determine the overall length you intend to build your fixture. We recommend building your fixture with 3/4" material and to the same length as your existing fence faces. All measurements regarding the frequency of mounting slots will reflect this recommendation.
2. Measure and mark the center lines (**CL**) of the slot locations on your work piece. Use the bottom edge of your material as the reference, and extend the lines completely across the face of your material with a square. Dimensions are shown in Figures 1 and 2.
3. Identify the horizontal line on the HTC-300 template that corresponds to your fence model. Align this line with the bottom edge of your work piece.
4. Starting with the long slot on the template, align the vertical center line with the line marked on your work piece. Horizontal line on template as per Step 3.
5. Clamp the template to the work piece and a solid work surface. Figure 3.

TIP: If you are using a large router, the clamp may become an obstruction during machining. Carefully drill 2 holes in each end of the template and hold in place on your material with brads.

6. Referencing the operating/safety instructions which accompanied your router, install a 31/64" straight router bit and 5/8" O.D. template guide bushing. Set the cutting depth at .230". Make a test cut in scrap material to verify dimension.
7. Using the long slot in the template as your guide, rout the first slot.
8. Repeat Steps 3 through 7 on the remaining 3 slot locations.
9. Reset the cutting depth on your router to .32". Verify dimension with a test cut in scrap material.
10. Align the template as in Steps 3, 4, and 5 using the small slot center line on the template.
11. Rout the small slot locations. This will complete the stepped slot required for mounting the F-102 clips. Figure 4.
12. You are now ready to install the F-102 clips into your fixture. Pre-drilling of holes for the screw locations is recommended. Pre-drill with 3/32" bit to a depth of 3/8". Secure each clip with the two screws provided. Figure 5.

NOTE: F-102 clips are installed with the stamped writing facing out. Also, the clips should lock onto the fence head, in the same direction as the material will be fed during a particular operation. This will ensure the fixture will remain tight and/or tighten under load.

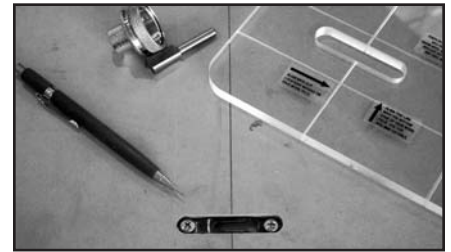


Figure 5

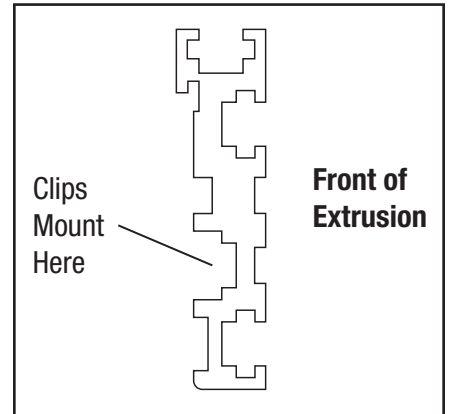


Figure 6

## HMS-410 Master Extrusion

The HMS-410 Master Extrusion is supplied without F-102 Mounting Clips and without machining of any kind. This allows the extrusion to be used in designing your own shop built jigs and fixtures. If the jig or fixture is intended for use with the HTC-800/900 Multi-Fence System, review the clip installation guidelines under the HMS-300 and HMS-415 instructions.



Figure 7

## HMS-415 Master Extrusion

The HMS-415 Master Extrusion includes (4) F-102 Mounting Clips with hardware, and is machined for use with the HTC-800 or HTC-900 Multi-Fence System.

1. Review Figure 6. Determine the correct side, and correct slot in the extrusion which is used to mount the F-102 clips.  
CAUTION: Clips must lock onto fence in the same direction as material feed.
2. Determine which side of the fence head you intend to mount the HMS-415 Extrusion to, and what the direction of feed will be.
3. Install the F-102 clips onto the HMS-415 Extrusion using the hardware provided. Use (2) 10-32 x 3/8" screws per clip, (4) clips per extrusion. Clips must be installed so the fixture attaches to the fence head in the same direction as the material will be fed.

NOTE: F-102 clips are installed with the stamped writing facing out.

4. The Master Fence Face Extrusion is now ready for attachment to the fence head. Align the key shaped holes in the F-102 clips with the studs found on the fence head. Tap with a rubber mallet to engage the clips and secure in place. Figure 7.



Figure 8



Figure 9

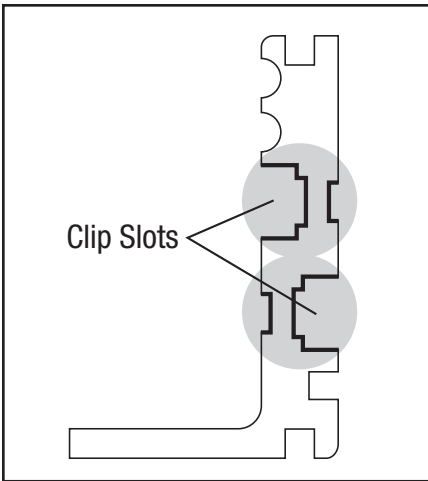


Figure 10

## HMS-420 Cabinet Makers Fence

The HMS-420 Cabinet Makers Fence is designed for use with the HTC-900 Multi-Fence System only. The F-102 Mounting Clips can be installed to use the Cabinet Makers Face on the right or left side of the fence head, and it can be oriented in two different positions. As with all accessories attached to the fence head, the direction of the material feed will dictate how the F-102 clips should be installed.

1. Determine which side of the fence head you intend to mount the Cabinet Makers Face and what direction of feed will be. Remove existing face from this side by tapping with a rubber mallet.
2. HMS-420 can be used in two different positions. Position 1 (Figure 9) is designed for laminate cutting. Position 2 (Figure 8) shows the HMS-420 in use as a standard fence face. Determine how you plan to use the HMS-420 and the direction(s) material will be fed for each position.
3. Install the F-102 clips onto the Cabinet Makers Face using the hardware provided. Clips must be installed so the fixture attaches to the fence head in the same direction as material will be fed. This insures that the fence face will actually tighten under load. Figure 10.

Note: F-102 clips are installed with the stamped writing facing out.

4. HMS-420 can now be attached to the fence head. Align the key shaped holes in the F-102 clips with the studs found on the fence head. Tap with a rubber mallet to engage the clips and secure in place.



Figure 11

## HMS-400 Router Fence

The HMS-400 is model specific for use with the HTC-800 or HTC-900 Multi-Fence System. The HMS-400 can be installed on the left or right side of the HTC-900 fence head and to the right side only on an HTC-800 fence head. As with all Multi-Fence jigs and fixtures, the direction material will be fed, dictates how the F-102 clips are installed.

1. Unpack and identify the various components which make-up the HMS-400.
2. Determine which side of the fence head you plan to attach the HMS-400. (Right side only on the HTC-800).
3. Align the various parts next to the fence head as shown in Figure 11 and Figure 12. Note changed position of the offset extrusion when used on the HTC-800 (Figure 11) versus the HTC-900 (Figure 12). The offsets are also right/left specific. See Parts List for additional reference.
4. Install the F-102 clips onto the offset extrusions. All clips installed in the offset extrusion must be oriented in the same direction. Use (2) 10-32 x 3/8" machine screws per clip, (2) clips per offset. Figure 13.

NOTE: Direction material will be fed dictates how the clips must be oriented. Clips must be installed so the fixture attaches to the fence head in the same direction as the material will be fed. This insures the fixture will actually tighten under load. F-102 clips are installed with stamped writing facing out.

5. Position the offset extrusions as per Figure 11 or Figure 12 for your fence model. Align the mounting holes in the router face with the threaded holes in the flat face of the offset extrusions. Cut-out in the center of the router face oriented down, counter-sunk mounting holes facing out. When the offsets are in their correct right and left positions, the space between the two offsets will measure 8" (for the dust port). Secure the face to the offsets using (4) 1/4" - 20 x 1/2" flat head screws. Figure 14 and Figure 15.



Figure 12



Figure 13

6. Position the dust port between the two offset extrusions. Be sure the lip on the dust port slips under the overhang on the back of the router face.
7. Align the key shaped slots in the Master Router Face with the studs on the fence head. Lock in place by tapping with a rubber mallet. Figure 16.
8. Insert 1/4" - 20 x 3/4" panhead screws through the front of the wood faces. Thread a slider nut onto each of the screws. 1-2 rotations only.
9. Slide the wood faces into position on the extrusion. Secure in place by tightening the screws installed in Step 8. Figure 17.
10. Install the small safety shield support angle as shown in Figure 18. Slider nut is used with a 1/4"-20 x 3/8" knob to secure the angle to the extrusion.
11. Secure the safety shield to the angle with (2) 10 - 32 x 1/2" knobs.
12. Refer to the operator instructions which accompanied your router for specific procedures regarding use and table mounted operations.

Note: The dust port can be easily secured to the offset extrusions using (2) 1/4" x 3/8" sheet metal screws. Drive screws through the sides of the dust port into the bosses (shown below) in the offsets.



Figure 14

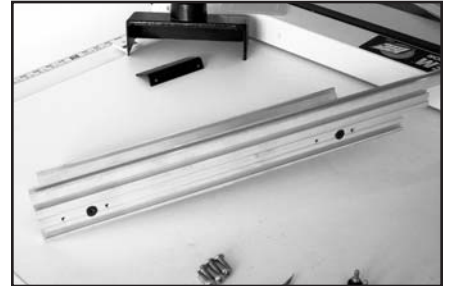


Figure 15

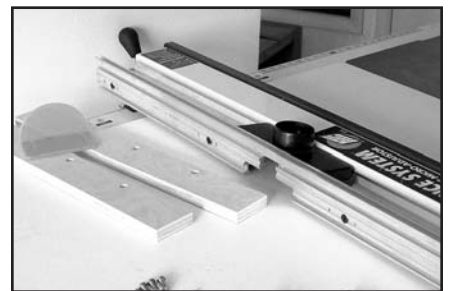


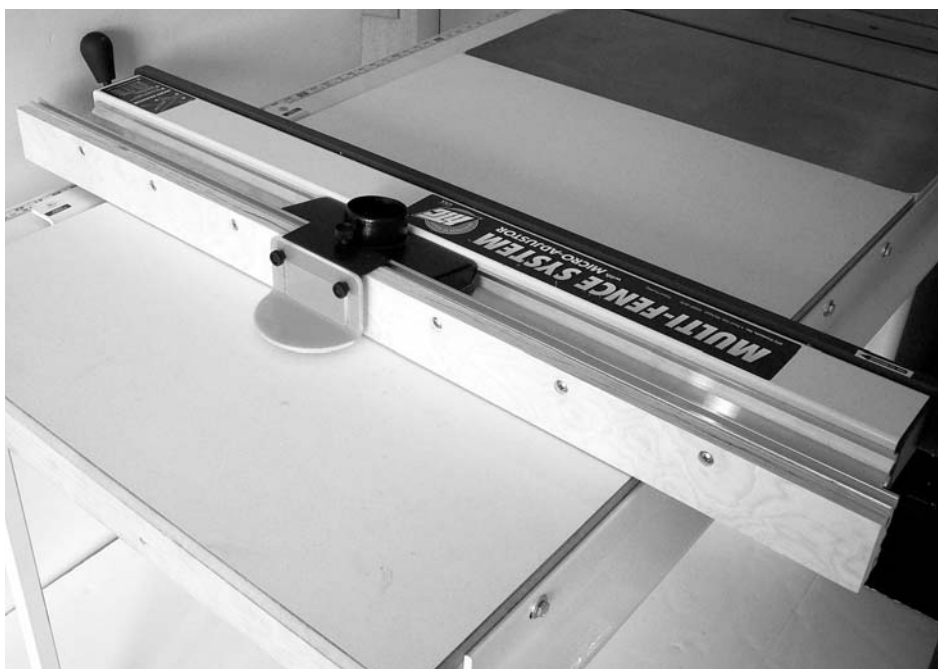
Figure 16



Figure 17



Figure 18



HMS-400 Router Fence Complete Unit

## LIMITED LIFETIME WARRANTY

Products manufactured by HTC Products, Inc. are guaranteed to be free from defects in material and workmanship under normal use and service. HTC's obligation under this warranty shall be limited to repairing or replacing for the original owner, at our option, any part of said equipment which HTC's examination shall disclose to its satisfaction to be thus defective.

Any product or component claimed to be defective is to be sent prepaid to: HTC Products, 332 E. Lincoln, Royal Oak, MI, 48067 Attn: Warranty Department, together with a copy of the original, dated sales receipt. Call for authorization number before shipping.

This warranty does not apply to damages resulting from shipping, accident, misuse, abuse or alteration.

Wear items (wheels, bearings, bushings, rubber feet, etc.) are warranted for a period of 1 year. Consumable items (fence faces, saw guard shields) are warranted for a period of 60 days.



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