



ON/OFF MAGNETIC JIG

OPERATION MANUAL

JP095R, JP155R, JF095R, JF155R

INTRODUCTION

READ AND UNDERSTAND THIS MANUAL BEFORE INSTALLATION AND OPERATION OF YOUR PRODUCT.

Read all instructions prior to use! Failure to follow all instructions listed below may result in an unsafe or dangerous condition.

This magnet is designed to hold a jig, fixture or similar device to any Ferromagnetic Surface. This device has tremendous holding power as well as a great amount of Shear Force Holding Strength to prevent sideways movement.

GENERAL INFORMATION

- » All magnets need to be **kept at a safe distance** from all magnetic storage devices, electronics and credit cards etc...
- » Ensure that the magnet is **stored in the "OFF" position** when not in contact with Ferromagnetic metals. The magnet can be left "ON" or "OFF" indefinitely without harm. When "ON" and near Ferromagnetic metals there will be a sudden and powerful attraction.
- » **Never use this magnet to lift or transport any materials**, although it is ideal for debris cleanup, nuts and bolts, metal shavings, etc...
- » **DO NOT attempt to disassemble or alter** the magnet; there are no user serviceable parts inside the device.
- » All On/Off magnetic products are **designed for normal work/jobsite conditions**, do not use underwater or in a hazardous environment.
- » **DO NOT use the magnet if it is damaged or is not working properly**. Severe injury can occur if this device is not used properly and safely.
- » **DO NOT expose the magnet to temperatures above 180 degrees Fahrenheit (82 Celsius)**. High temperatures will permanently degrade the magnet's effectiveness and may result in an unsafe condition.
- » **Not recommended for painted or finish coated surfaces** as these will reduce the magnetic bond and the finish may be damaged.
- » **This product contains PTFE lubricant**. For MSDS information contact Industrial magnetics, Inc.
- » **Flanged magnets are designed to be installed into 3/4" thick non-Ferromagnetic materials**. If installing into thinner materials it is possible to stack or shim the material to achieve 3/4" thickness. **The magnet base will protrude very slightly**, this is critical to ensure metal to metal contact!
- » JP095R and JF095R require a 30mm Forstner bit for installation. JP155R and JF155R require a 40mm Forstner Bit to install.
- » **Always keep the bottom of the magnet clean and free of debris and rust**. If needed wipe with WD40 or light oil

TO USE THE MAGNETIC JIG

- » **Never exceed the rated capacity** of the magnet. JP095R and JF095R are rated up to 95 lbs. of holding force and 15 lbs. of shear force each under ideal conditions. JP155R and JF155R are rated up to 155 lbs. of holding force and 30 lbs. of shear force under ideal conditions.
- » Always **test the connection** before attempting to use the magnet to ensure that it is capable of holding the material securely.
- » **Numerous factors can negatively affect the strength** of the magnetic bond. Dirt, debris, oils and grease, painted surfaces and any gap between the magnet and the metal surface will decrease the bond. **Ensure that the connection point is clean** and free of these factors.
- » **Thicker metals will be held more strongly than thinner metals**. E.g.: 1/4" steel will be held more strongly than thin gauge metals.
- » **Industrial Magnetics, Inc. recommends that only non-Ferromagnetic materials** be used as a holder for your Jig or Fixture. **Wood, Plastics and Aluminum** are all non-Ferromagnetic materials that make for excellent attachments.
- » **Avoid sudden jerking or Shock force** as this will cause the magnet to lose its hold or to move.
- » **This magnet is not designed to be used as a welding ground clamp** or as part of an electrical circuit.
- » For safe operation, the **bottom surface of the magnet must always be Flat and Smooth**. If necessary, it is possible to sand the magnet face smooth using 400 grit sandpaper and a flat surface. **Always file any burrs** that would interfere with full contact.



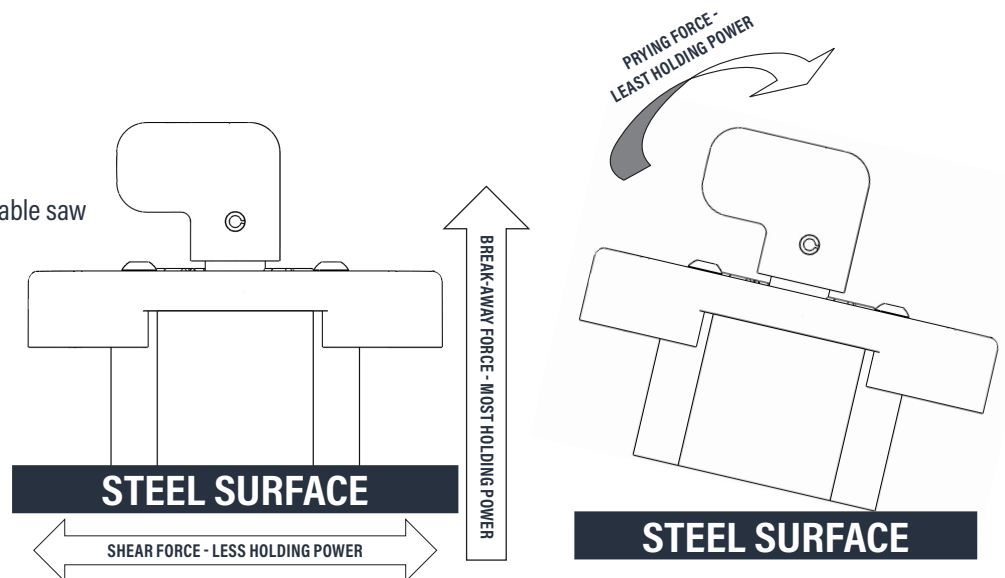
MAGNETIC JIG OPERATION

- » *The knob on this device must be turned clockwise 200 degrees until it stops* in order to be turned "ON". It is not possible to hold the magnet in place unless fully turned "ON".
- » ***DO NOT turn "ON" unless in contact with Ferromagnetic Metal!***
- » *To release the magnet, turn the knob counter clockwise until it stops.* The magnet will **turn "OFF" and release Immediately** upon turning the knob, Use Caution to ensure that it is safe to release the magnet and that nothing will fall or become dangerous.
- » ***Always turn off power tools before turning the magnet "ON" or "OFF" to avoid injury.***
- » This magnet is capable of **exceptional Break-Away Force** holding power; magnets are exceptionally strong in **Shear Force** as well. **Prying Force is the least powerful** of the holding capabilities and great care must be used when attempting to use this device with Pry force. **See Illustration.**

USAGE & APPLICATION INFORMATION

TYPICAL MAGNET APPLICATIONS INCLUDE:

- » Holding a cove molding jig in place
- » Creating your own Featherboard
- » Holding a repetitive stop in place
- » Holding down thin stock
- » Create a fence for your power tools
- » Hold a bench top tool in place on your table saw



SECURING THE MAGNET
Secure the magnets use the mounting holes provided.

Use #6 or #8 screws, 8-32 or M4 machine screws.

JF095R hole spread:
1.81" or 46mm

JF155R hole spread:
2.20" or 56mm

USING MULTIPLE MAGNETS
To avoid unwanted rotation, use in pairs at ends of material. When using multiple magnets very close to each other, align the ON/OFF in the same direction for maximum magnetic holding power as shown.

LIMITED WARRANTY

These products are covered by a One Year Limited Warranty on Material and Workmanship. Warranty is Non-Transferable. Industrial magnetics, Inc. reserves the right to inspect all product claims under warranty. Any alteration of the device voids this warranty. User assumes all risk for the proper use of this device and for ensuring product suitability for intended application. This warranty shall not cover any incidental or consequential damages due to the improper use or failure of this device.