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**HOCK #KF150** includes:

- 2 Sides
- 1 Front Block
- 1 Rear Block
- 1 Wedge, maple
- 1 Cross-pin, 1/2" diameter
- 8 Dowels, 1/4" diameter
- 1 HOCK Plane Iron Assembly (part #PI150)

### Assembling HOCK Plane Kit (#KF150)

video at [www.hocktools.com](http://www.hocktools.com)

here: [www.hocktools.com/sharpen.htm](http://www.hocktools.com/sharpen.htm).

1. Familiarize yourself with the parts by dry-assembling the front and rear blocks, the sides and the cross-pin into something resembling a plane. Notice that the top rear corners of the sides and the rear block have alignment chamfers. Match the chamfers and align the sides with the rear of the rear block. Space the front block from the rear by 3/16" (4.8mm); you can use the blade as a spacer.

2. Clamp the sides to the blocks and check that the blocks and sides are flush on the bottom and that the front block is 3/16" (4.8mm) from the rear block. If you slide the blade down the ramp, the cutting edge (bevel-down!) should hit the front block about 1/16" (1.5mm) up from the bottom. This will allow you to adjust the mouth precisely later. Drill 1/4" holes for the dowels that will align the parts during glue-up (see drawing). Before removing the clamps, mark the inside of the sides along the blocks so you'll know where *not* to apply glue. Unclamp, apply glue, use the quarter-inch dowels to locate everything and clamp it securely.

3. While waiting for the glue to dry, sharpen the blade. Instructions are

4. When the glue has dried, remove the clamps, trim the dowels, and take some time to clean any glue that squeezed out into the mouth or throat. The whole area must be clean and tidy. Glue in the cross-pin.

5. To flatten the sole install the blade, *backed up out of the way*, with the wedge fully tightened. Use a plane or 100-grit sandpaper on a flat surface – go slowly and carefully – it's easy to take off too much. When the sole is flat, if the blade still isn't protruding, you can use a file or knife to carefully open the mouth just enough to allow the blade to cut.

6. Adjusting this type of plane calls for a small hammer and some practice. Tapping the blade increases the depth of cut while striking the rear of the plane will retract the blade for a finer cut – a thinner shaving. Lateral adjustments are done by simply tapping the blade on one side or the other.

7. Shape the plane to suit. Some like them simple, trimmed down a bit but rough, right off the bandsaw while others like a little style in the shop and do some fancy shaping and detail work.

**Congratulations!**