

Fluting Jig



WARNING

To reduce the risk of injury, turn router off and disconnect it from power source before installing and removing accessories. An accidental start-up can cause injury.

WARNING

For your own safety, read and follow all safety procedures listed in the router instruction manual.

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of the tool.
- Wear safety shoes with non-slip soles.
- Wear protective hair covering to contain long hair.
- Wear eye and hearing protection. Always use safety glasses. Eye protection equipment should comply with ANSI Z87.1 standards. Hearing equipment should comply with ANSI S3.19 standards.
- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.
- Keep work area clean. Cluttered work areas and benches invite accidents.
- Keep children and visitors away. Your shop is a potentially dangerous environment. Children and visitors can be injured.
- Use the right tool for your job. Do not force your tool or attachment to do a job for which it was not designed.

CAUTION

Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

WARNING

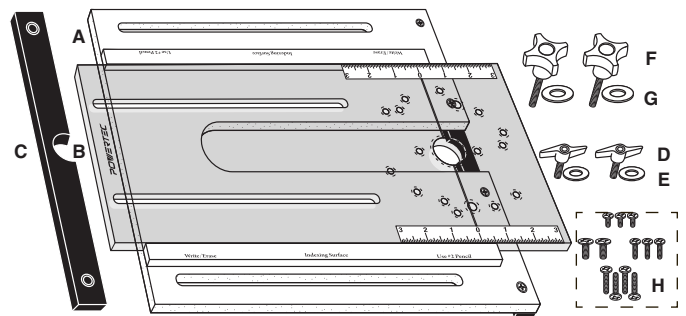
Do not attempt to operate tool until it is completely assembled according to the instructions.

SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

PACKAGING CONTENTS

ITEM	DESCRIPTION	QUANTITY
A	Dovetail Jig base	1
B	Acrylic router plate (shown over the dovetail jig base)	1
C	Adjustable fence	1
D	1/4-20 x 5/8" lock knobs	2
E	1/4" washers	2
F	5/16-18 x 1" lock knobs	2
G	5/16" washers	2
H	Fastener Package containing machine screws of different sizes (choose the correct screws to be used on your router)	12

Figure 1



TOOLS NEEDED

Phillips Head Screwdriver

INTENDED USE

To be used with a plunge router to cut flutes in columns, molding or furniture parts in stock up to 9-1/2" wide.

RECOMMENDED ROUTER BITS

Core Box Bits

V-Groove Bits

Classic Plunge and Pattern Bits

Straight Bits

Slot Wall Bits

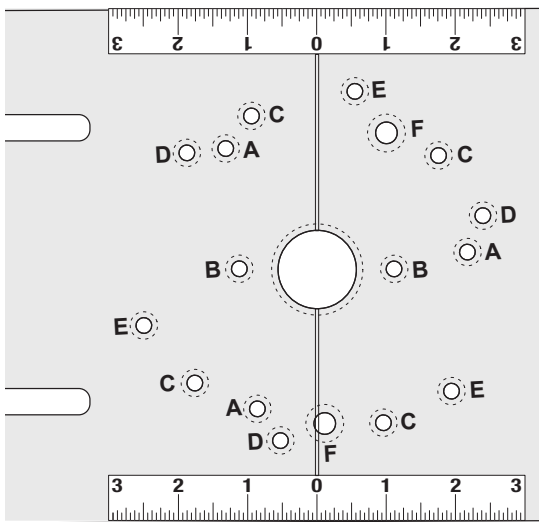
ASSEMBLE THE ROUTER PLATE

1. Remove the existing router plate and all related hardware from the router.
2. From the fastener package locate the machine screws for your router.
3. On the chart find the model and the corresponding letter for your router.

PORTER-CABLE*	A	690 Series	A	8529
	A	7529		
Bosch*	A	1617	A	1618
Craftsman*	C	315 275 000	E	315 175 060
	D	315 175 040	D	315 175 070
	D	315 175 050		
Fein*	F	FT 1800		
Milwaukee*	A	5615	A	5616
	A	5619		
Makita*	A	RF1101		
Hitachi*	B	M8V	A	M-12VC
	B	TR12		
Elu*	F	177		
DeWALT*	F	DW621	A	DW616 Series
	F	DW625	A	DW618 Series
Ryobi*	C	R1631K		

* PORTER-CABLE, DeWALT, Elu and Craftsman are trademarks of The Black & Decker Corporation/ Bosch is a trademark of the Robert Bosch Tool Corporation/ Milwaukee is a trademark of Milwaukee Electric Tool Corporation/ Makita is a trademark of Makita Corporation/ Fein is a trademark of C. & E. Fein GmbH/ Hitachi is a trademark of Hitachi, Ltd./ Ryobi is a trademark of RYOBI, LTD.

Figure 2



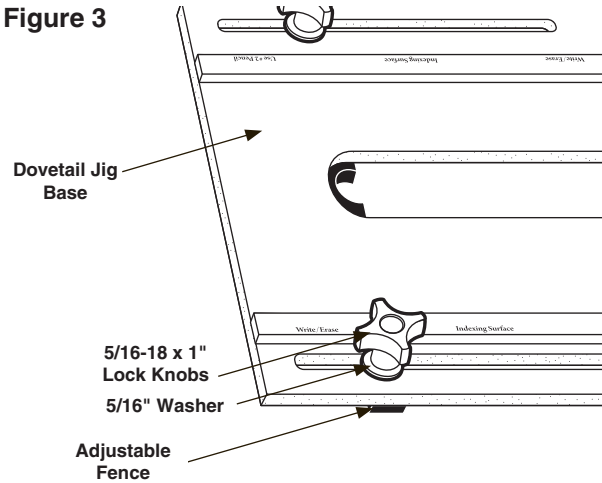
4. Find the corresponding letters for your router in Figure 2. These letters are not printed on the router plate.
NOTE: Some routers have more than one option.
5. Slide the dovetailed router plate from the jig base and remove. Place the router plate onto the router and line up the first letter with the appropriate hole and then rotate the plate until all holes for the pattern line up. Install the machine screws. Tighten the machine screws.

NOTE: If the machine screws (supplied) bottom out into the router mounting holes, they will need to be shortened to match the router.

ASSEMBLE THE ADJUSTABLE FENCE TO JIG BASE

1. Place the adjustable fence under the jig base. Align holes in adjustable fence with slots in jig base.
2. Secure in place using 5/16-18 lock knobs and 5/16" washers. **NOTE:** The washer should go between the knob and jig base.

Figure 3

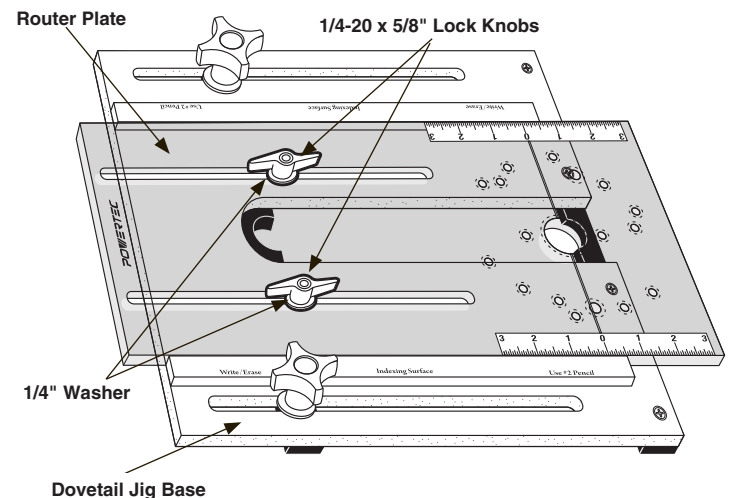


ASSEMBLE THE ROUTER PLATE TO JIG BASE

NOTE: For clarity the assembled router is not shown in the illustrations.

1. Slide the router plate into the dovetailed jig base. Align holes in jig base with slots in router plate.
2. Secure in place using the 1/4-20 lock knobs and 1/4" washers. **NOTE:** The washer should go between the knob and router plate.

Figure 4

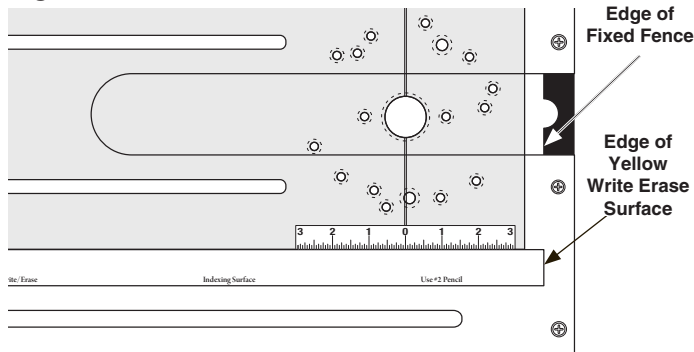


TO SET UP

NOTE: For clarity the assembled router is not shown in the illustrations.

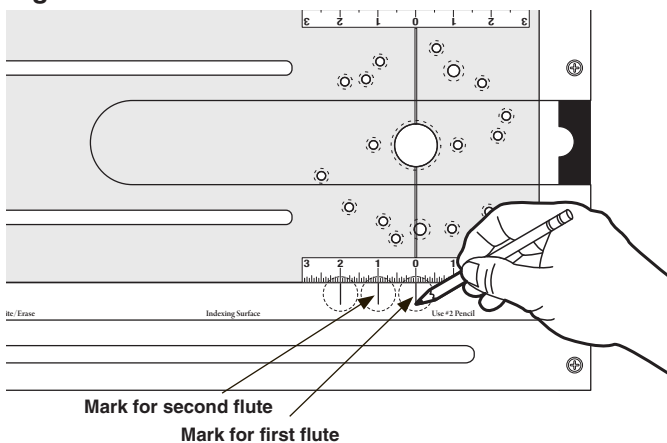
1. The end of the yellow plate guide with write/erase surface will line up with the inside edge of the fixed fence. The inside edge of the fixed fence will rest on the edge of the workpiece. **NOTE:** If the end of the yellow plate guide with write/erase surface DOES NOT line up with the inside edge of the fixed fence, make a mark on the write/erase surface to indicate the inside edge of the fixed fence.

Figure 5



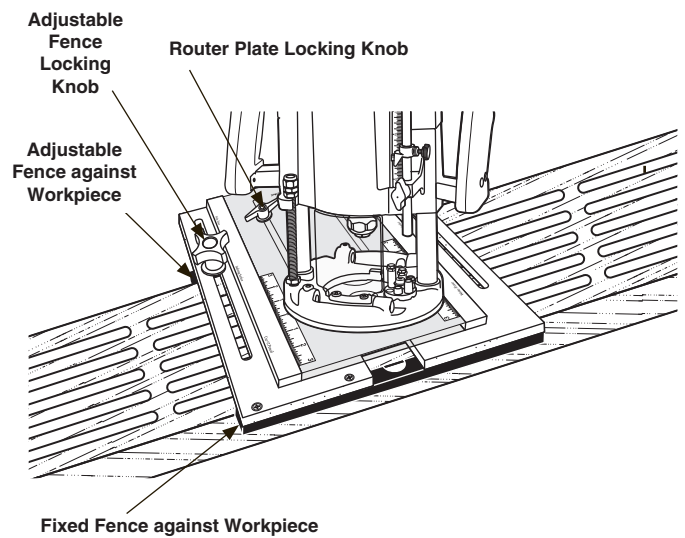
2. Identify the distance from the center of the first flute to the edge of the workpiece. Then adjust the acrylic router plate so this measurement lines up with the mark you made on the yellow plate guide with write/erase surface in Step 1.

Figure 6



3. Using a pencil, mark the yellow plate guide with write/erase surface at the "0" mark for the first flute.
4. To mark the second flute, measure to the left of "0" on the scale the distance equal to the spacing between flutes and make a mark.
5. Move the acrylic router plate so the "0" mark lines up with the second mark, and measure to the left of "0" on the scale the distance equal to the spacing between flutes and make a mark.
6. Repeat step 4 until all flutes are marked on the yellow plate guide with write/erase surface.
7. Place the jig over your workpiece with the fixed fence against one side of the workpiece. Slide the adjustable fence in or out to fit the width of your stock. Tighten the adjustable fence locking knobs, making sure the jig slides easily but is not loose or sloppy.

Figure 7



8. Before routing the flutes, set the router bit to the desired depth of cut. Move the acrylic router plate to align the "0" on the scale with the first mark on the write/erase surface, tighten the router plate locking knobs.
9. To route the remaining flutes, loosen the router locking knobs and move the router plate to align the "0" on the scale with the other marks on the write/erase surface, tighten the router plate locking knobs and proceed.

IMPORTANT: To prevent burning, move the router in and out of the cuts quickly.

MAINTENANCE

- Carnauba wax may be applied to the router plate to reduce scratching and make it slide easier. If scratching does occur, carefully polish with plastic polish until the scratches are removed.

Visit us on the web at powertecproducts.com



Put these instructions and the original sales invoice in a safe, dry place for future reference.

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