

Circle Cutting 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.

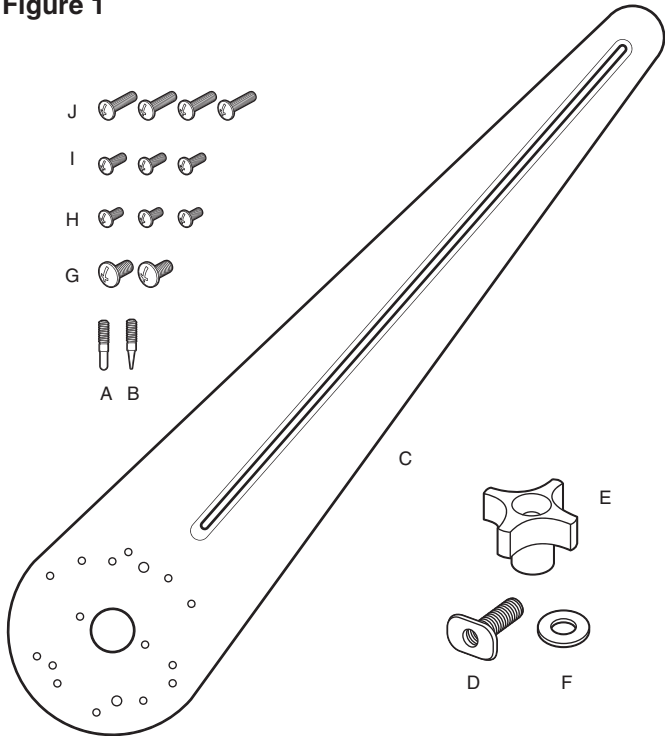
⚠ WARNING

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

PACKAGING CONTENTS

ITEM	DESCRIPTION	QTY
A	Insert Pin A	1
B	Insert Pin B	1
C	Big Router Compass Circle Jig	1
D	5/16"-18 x 1" T-Bolt Pivot Pin	1
E	5/16"-18 4 Star Knob	1
F	5/16" Washer	1
This Fastener Package contains machine screws of different sizes (choose the correct screws to be used on your router)		
G	M6 x 1/2" Screws	2
H	#10-24 x 1/2" Screws	3
I	#8-32 x 3/8" Screws	3
J	#10-32 x 3/4" Screws	4

Figure 1



TOOLS NEEDED

Phillips Head Screwdriver

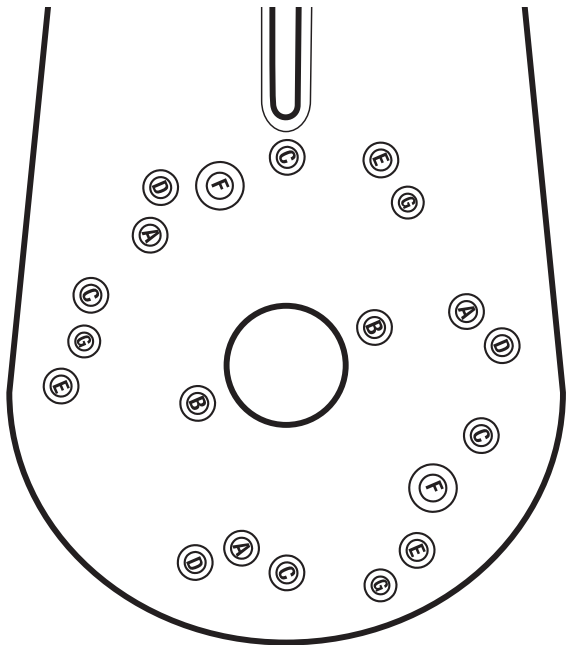
ASSEMBLY

- Place the circle cutting jig on a flat surface with the countersink holes facing down.
- Remove the existing router plate and all related hardware from the router.
- From the fastener package locate the machine screws for your router or use the fasteners removed from your router base.
- 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 (fixed base)	A	1618
	G	1617 (plunge base)	A	MR23 Series
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		

- Find the corresponding letters for your router in Figure 2. Use the circle cutting jig as a template and mark the hole pattern on the router base plate with a wax crayon or felt tip marker.

Figure 2



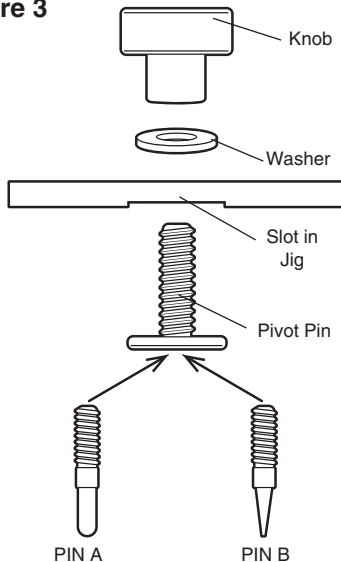
- Place the circle cutting jig onto the router and line up the marked holes, install the machine screws (selected earlier). Tighten the machine screws.

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

- Install knob, washer and T-bolt pivot pin through the slot on the circle cutting jig (Figure 3). Choose the correct pin, PIN A for cutting from the bottom surface or predrilled 1/8" hole or PIN B for cutting from the top surface.

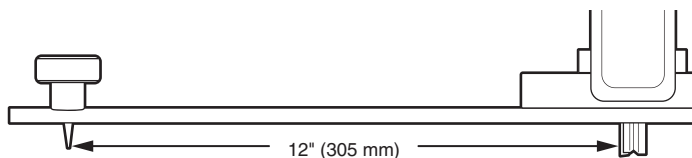
NOTE: PIN A and B have left handed threads, they must be turned counterclockwise to tighten into the pivot pin and clockwise to loosen.

Figure 3



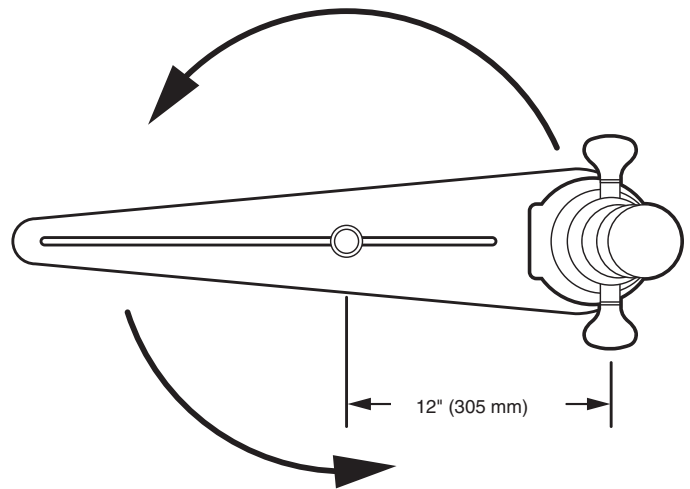
- The radius of the circle will be the distance from the inside edge of the router bit to the center of the pin. Figure 4 shows the side view of the circle cutting jig setup to make a 24" (610 mm) circle with a 1/2" bit.

Figure 4



- Set the router depth of cut and route in a counterclockwise direction as shown in Figure 5.

Figure 5



MAINTENANCE

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

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

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