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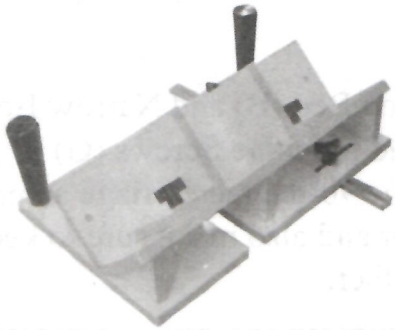
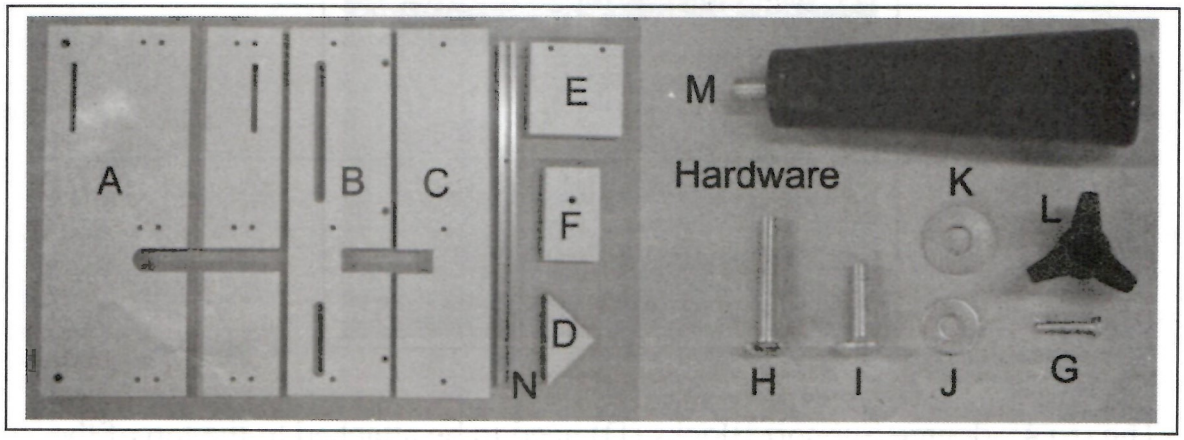
MLCS
Router Bits and Professional Woodworking Products

MLCS Instructions for #9537
Router Table Spline Cutting Jig



Parts :

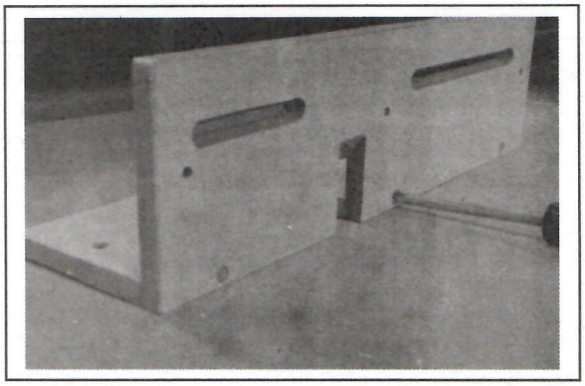


A Base (1)
B Wide Bed (1)
C Narrow Bed (1)
D 45-Degree Support Blocks (6)
E Support Fence Upright (2)
F Support Fence Base (2)
G M4 x 3/4" Cross Head Machine Screws (25)
H M6 x 1-1/2" Sliding T-Head Bolts (2)
I M6 x 1" Sliding T-Head Bolts (2)
J 6mm Flat Washer (4)
K 8mm Flat Washer
L M6 x 1.0 Triangle Locking Knob (4)
M M8 Tall Handle
N 14-1/2" T-Track (1)

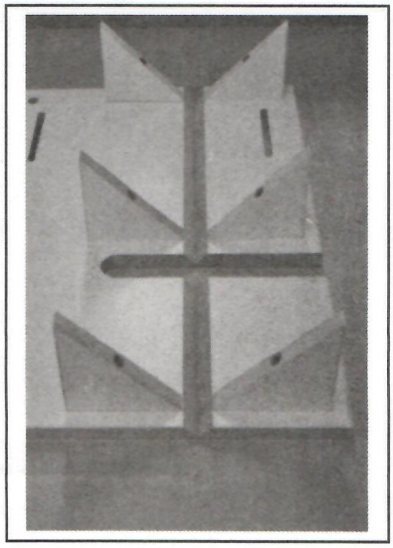
Assembly of the Jig:

Please use a handheld screwdriver to assemble this jig. A power driver may over torque the screws, resulting in pulling the threaded inserts from the MDF parts.

Start by assembling the Wide Bed (B) and Narrow Bed (C) together. Use (3) of the M4 x 3/4" Cross Head Machine Screws (G) to assemble these two sections together to make the 90-degree carriage assembly. The counterbore on the slot faces the exterior and also make sure to keep the two router bit cutouts aligned with each other.

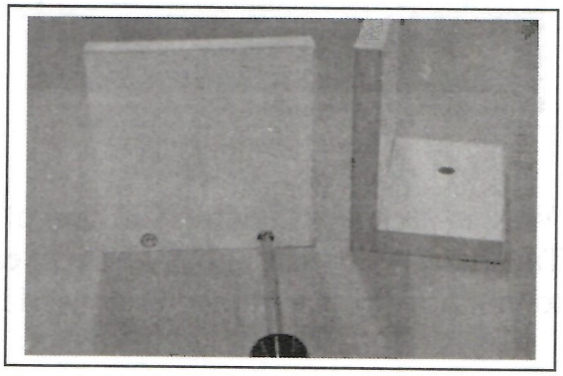


The (6) 45-degree Support Blocks (D) need to be attached to the top of the Base (A) using (12) M4 x 3/4" Cross Head Machine Screws (G). Do not fully tighten the screws at this time.

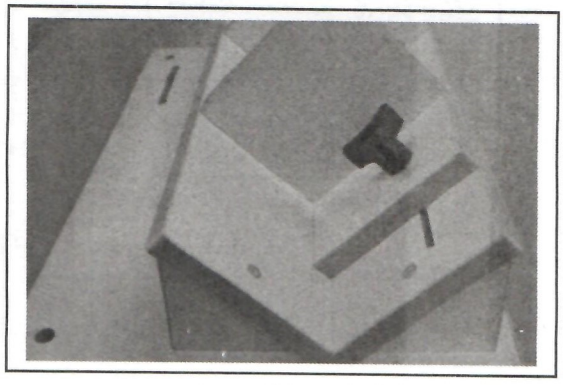


Place the carriage assembly onto the 45-degree Support Blocks (D) with the router bit cutout aligned with the bit cutout on the Base (A). Attach the carriage assembly to the 45-degree Support Blocks (D) using (6) M4 x 3/4" Cross Head Machine Screws (G). Once all of the screws have been inserted, you can fully tighten the screws to secure the 45-degree Support Blocks (D) to the carriage assembly and Base (A).

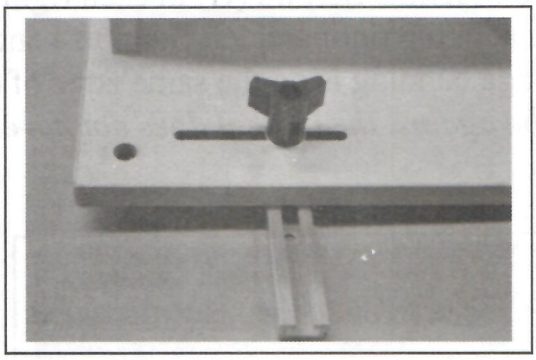
The support fences used to hold the box in place on the jig need to be assembled next. Assemble both left and right support fences by using two M4 x 3/4" Cross Head Machine Screws (G) in each right and left support fence. Make sure to match the right and left Support Fence (E) and Support Base (F) so that the edge banding is on the same edge of each piece. *(There is one edge that will be against the jig that does not have any edge banding on it.)*



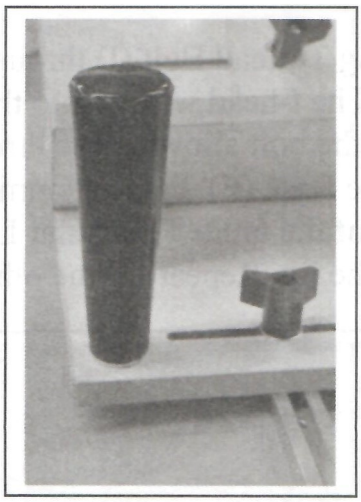
Place (1) M6 x 1-1/2" Sliding T-Head Bolt (I) through the slot in the Wide Bed (B) from the backside. The t-head will fit into the counter bore. Place the right support fence over the bolt allowing the threads to protrude through the hole in the Support Fence Base (F). Place a 6mm Flat Washer (J) over the exposed thread. Use (1) of the 6mm Triangular Locking Knobs (K) to secure the support fence to the jig. Repeat for the other support fence.



Slide the (2) M6 x 1" Sliding T-Head Bolts (I) into the 14-1/2" long T-Track (N). Adjust the position of the Sliding T-Head Bolts (I) so they align with the slots in the Base (A). Place the Base (A) over the Sliding T-Head Bolts (I) allowing the threads to protrude through the hole in the Base (A). Place a 6mm Flat Washer (J) over each exposed thread and finally use the (2) remaining 6mm Triangular Locking Knobs (K) to secure the 14-1/2" T-Track (N) to the bottom of the Base (A).



Place (1) 8mm Flat Washer (K) over the threaded stud of the Tall Handle (M) and thread the Tall Handle (M) through the hole in each back corner of the Base (A) and into the threaded insert that is screwed into the underside of the Base (A).



The position of the T-Track (N) is determined by placing the T-Track (N) into the miter slot on your router table. With the Locking Knobs (K) loosened, center the router bit cutout over the center of the router collet. Use a square to make sure the jig is perpendicular to your miter slot and secure the jig position by tightening the two Locking Knobs (K).

Using the Jig:

Place the box you are planning to cut the spline into in position over the bit cutout in the carriage assembly and the Base (A). Loosen the Locking Knobs (K) that secure the left and right support fences to the carriage assembly. Slide each support fence up to the box and tighten the Locking Knobs (K) to hold the box firmly in position between the support fences. You can use a straight bit, spiral bit or dovetail bit to cut the spline slot across the corner of the box. Once all four corners have had the spline slot cut through them, remove the box. Glue and trim the spline material flush to the box once the glue has dried to complete the spline joint.