Instructions for
Combination Arched Fluting Jig #9539/#400-1297

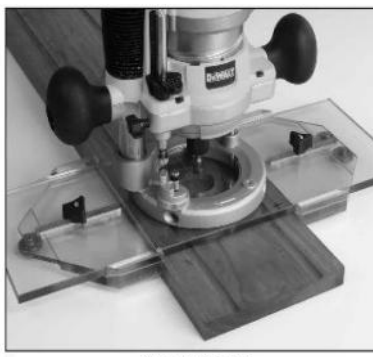
Parts List:

Base Plate (1)
Guide Wings (2)
M6 3 Point Through Knobs (2)
M6 x 1.0 x 25mm Carriage Bolts (2)
M6 Flat Washer (Installed on Guide Wing (3)
M6 x 1.0 x 13mm Tapered Head Machine Screw (3)
6mm I.D. x 25.4mm (1”) O.D. Ball Bearing (Installed on Guide Wing) (3)

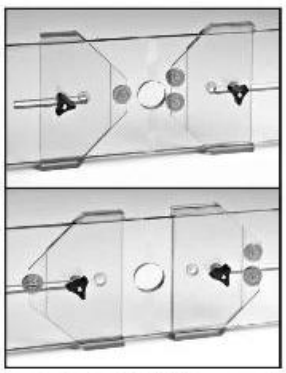
Assembly:

A plunge router is preferred when using this jig, but a fixed base router can also be used. Remove the existing sub base from your router. Center the router bit opening in the sub base over the router bit opening in the fluting jig. Use that sub base as a template to mark the mounting screw hole locations that you will need to drill and countersink to attach your router to the jig. Using the existing screws from your router, attach the router to the fluting jig. Insert a M6 x 25mm carriage bolt through a hole in each guide wing. There are two holes in each guide wing that can be used. The hole you choose will depend on your stock width or distance you will be cutting in from the edge of the stock. The end of the guide wing you use will depend on if you are cutting a straight or curved surface. Use the plain straight end of the guide wing if you are making a straight cut and the ball bearing guided end if you are following a curved edge. Secure the guide wing to the jig base using the M6 3-Point knobs. If you are using this as an edge guide when working on very wide stock, you will most likely need to remove one of the guide wings and only use one guide wing to control your cutting path.

Cut curved or arched stock



Cut straight stock



By rotating the Guide Wings on each

Using the Jig:

Install the type of bit you plan to use in the router. Make a layout line or lines if you are making multiple cuts across the face of your stock. Align the center of the router bit directly over your layout line. If you are using a fixed base router, adjust the router bit to your desired cutting depth. If you are using a plunge router, set the depth stop to the desired cutting depth. If you are making a curved cut, keep the guide wing with the single bearing on the inside, or smaller radius of the edge and the guide wing with the two bearings on the outside or large radius of the curve.

Making stopped cuts:

Start the router and plunge the bit into the stock, quickly starting the movement of the jig to prevent burn marks at the start of the cut. Use the same caution as you end the cut so you do not end up with burn marks, as they are very difficult to remove. If you are using a fixed base router, you will need to tilt the jig up, start the router and carefully lower the jig back down flat on your stock.

Making through cuts:

Start the router and follow the entire length of your stock working the jig along the full length of the cut in a steady consistent motion and avoid stopping mid cut to reduce the chances of creating burn marks.