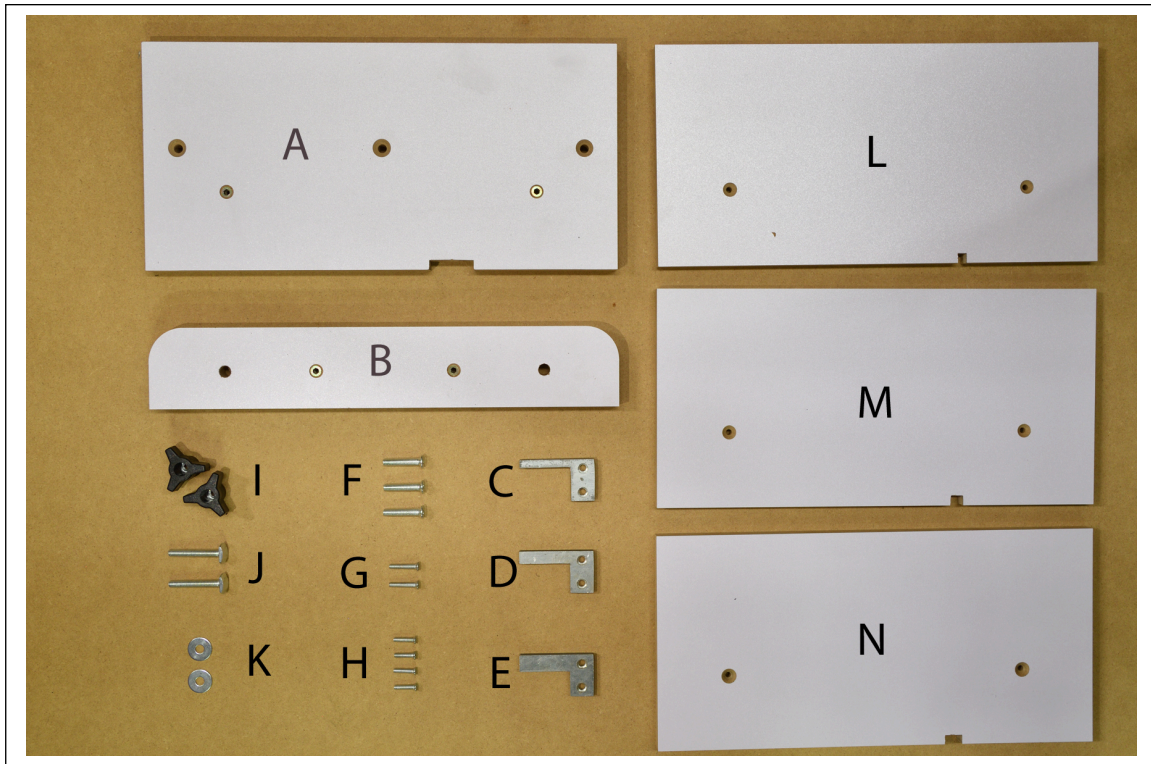


## Box Joint Fixture (#9799) for the Multiform Crosscut Sled

### Parts Layout:



- A. Vertical Fence (Qty. 1)**
- B. Mounting Cleat (Qty. 1)**
- C. 1/4" Guide Pin (Qty. 1)**
- D. 3/8" Guide Pin (Qty. 1)**
- E. 1/2" Guide Pin (Qty. 1)**
- F. M6 Machine Screw (Qty. 3)**
- G. M5 Machine Screw (Qty. 2)**
- H. M4 Machine Screw (Qty. 4)**
- I. Threaded Star Knob (Qty. 2)**
- J. M6 T-Head Bolt (Qty. 2)**
- K. M6 Flat Washer (Qty. 2)**
- L. 1/4" Sacrificial Fence (Qty. 1)**
- M. 3/8" Sacrificial Fence (Qty. 1)**
- N. 1/2" Sacrificial Fence (Qty. 1)**

## Assembly:

1. Start by securing the mounting cleat (B) to the vertical fence (A) using the three M6 machine screws (F). The side of the mounting cleat with the small MDF strip exposed faces downward toward the notch at the bottom of the vertical fence (see fig 1).
2. Choose the guide pin (C, D, or E) for the width of box joints that you will be making and secure it to the bottom edge of the vertical face (A) using two of the M4 machine screws (H). The pin should be placed with the extension toward the short edge of the vertical fence and protruding outward from the vertical fence (A) (see fig. 2).

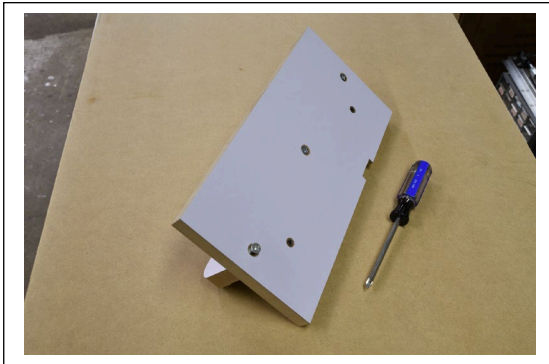


fig. 1

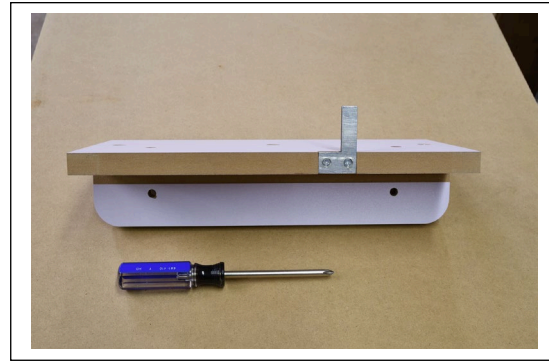


fig. 2

3. Secure the remaining two unused guide pins (C, D, or E) to the top of the mounting cleat (B) using the two remaining M4 machine screws (H) (see fig. 3).
4. Select the corresponding sacrificial fence (L, M, or N) to match the box joint width you are going to make. Secure the sacrificial fence (L, M, or N) to the vertical fence (A) using the two M5 machine screws (G) (see fig 4).

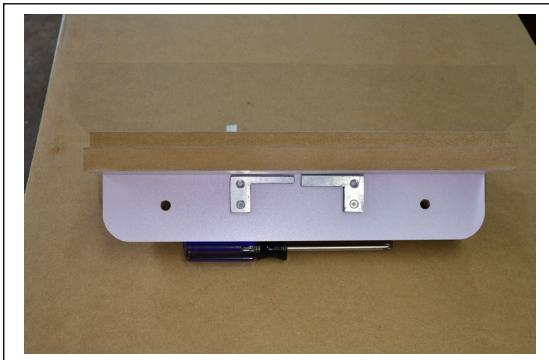


fig. 3

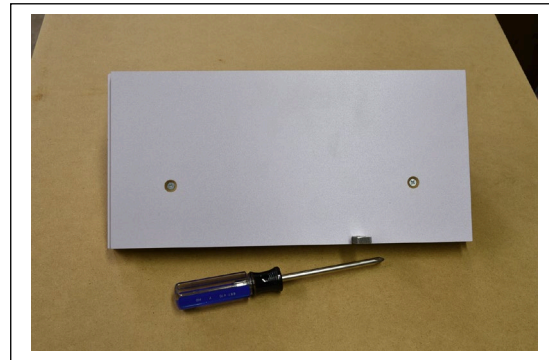


fig. 4

## Using the Box Joint Fixture on the Multiform Crosscut Sled;

5. Slide the two M6 T-head bolts (J) into the t-track slot in top of the Multiform Crosscut Sled fence (see fig. 5).
6. Place the assembled Box Joint Fixture onto the Multiform Crosscut Sled fence and slide the M6 t-head bolt threads through the mounting holes in the mounting cleat (B). Use a M6 flat washer (K) and M6 triangle locking knob (I) to secure the Box Joint Fixture to the Multiform Crosscut Sled fence (see fig. 6).

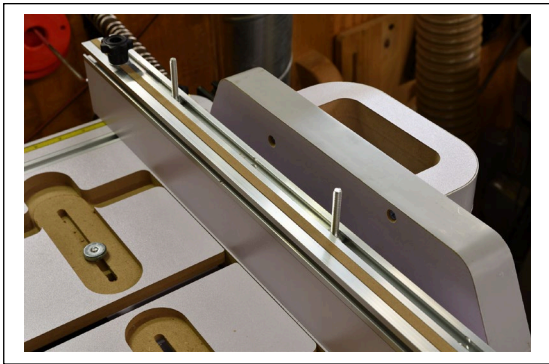


fig. 5



fig. 6

7. In your router collet, mount a straight or spiral router bit the appropriate diameter for the width box joint you will be making. Adjust the cutting height to thickness of wood that you will be joining together (See fig. 7).
8. Use a set up bar of the same diameter as your box joint / router bit to adjust the final position of the Box Joint Fixture on the Multiform Crosscut Sled fence (see fig 8). The set up bar should fit snugly between the bit and the guide pin. Make sure the carbide cutting blade is at the widest point perpendicular to the vertical fence to be sure you have the gap between the router bit and guide pin the exact width as your box joint size.

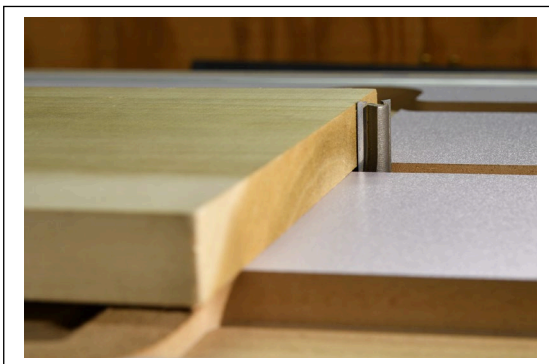


fig. 7

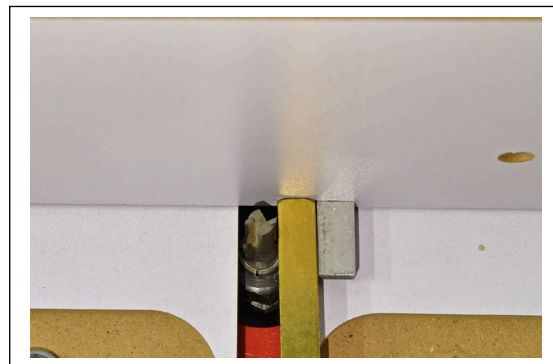


fig. 8



9. When making the cut on the first board, sit the edge of the board directly against the guide pin. Use clamps to secure the board to the sacrificial and vertical fences (see fig 9). Move the Multiform Crosscut Sled so that the bit cuts completely through your stock and into the sacrificial fence. Pull the Multiform Crosscut Sled back and remove the clamps. Place the newly cut notch over the pin and repeat cutting all the way across your board placing the newly created notch over the guide pin each time (see fig. 10).



fig. 9

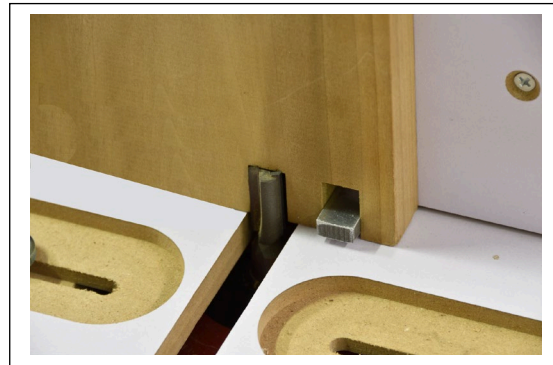


fig. 10

10. When making the cut on the second board, place the set up bar directly next to the guide pin. Sit the edge of the board directly against the setup bar. Use clamps to secure the board to the sacrificial and vertical fences (see fig. 11). Make sure to remember to remove the set up before starting the router. Move the Multiform Crosscut Sled so that the bit cuts completely through your stock and into the sacrificial fence. Pull the Multiform Crosscut Sled back and remove the clamps. Place the newly cut notch over the pin and repeat cutting all the way across your board placing the newly created notch over the guide pin each time (see fig. 12).



fig. 11



fig. 12

11. You should have boards that now have offset fingers on them and they should look as follows (see fig. 13 & fig. 14).

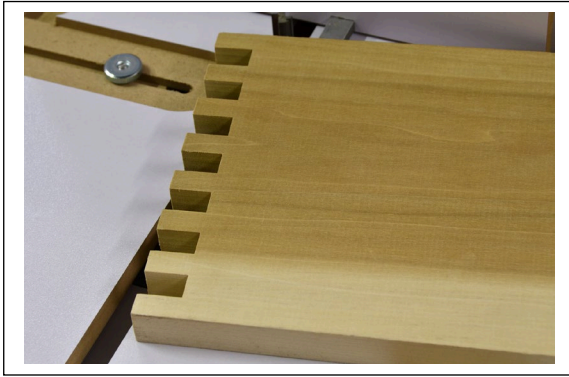


fig. 13



fig. 14

When the box is assembled, your completed joint should look like this (see fig. 15).

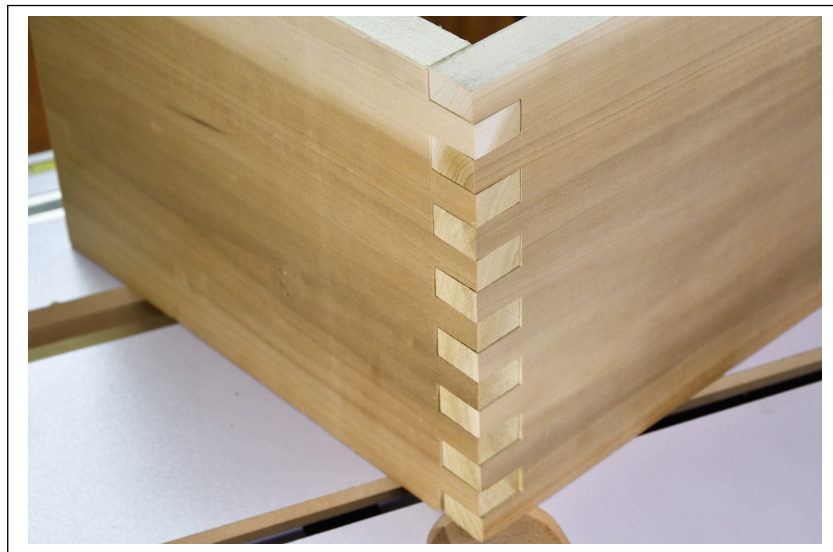


fig. 15