

ROUTER INLAY AND REPAIR INSTRUCTIONS

Please read all instructions before using

BEFORE YOU CUT:

1. The bushings used in this kit will fit any router that accepts a standard $1\frac{3}{16}$ " two piece template guide bushing, such as Porter Cable and Black & Decker. Some routers come with adapter rings (Elu & Hitachi), while others offer this adapter as an accessory (Bosch, Freud, Makita, Ryobi). See your router owners manual for details. Alternative: Order our Universal Mounting Plate - see catalog.

2. Our kit is designed to work with $\frac{1}{8}$ " diameter bits only. We recommend a $\frac{1}{8}$ " down-cut carbide spiral bit to prevent chipping and unnecessary tear-out. Since most spirals are designed with a slight taper, it is suggested not to cut any deeper than $\frac{1}{16}$ " with each pass.

3. Cut your template pattern for the inlay or repair area out of $\frac{1}{4}$ " material. Lexan or Masonite are recommended. Do not use plywood as it will not hold or maintain a consistent pattern edge. Cut your pattern on a piece of material large enough to sufficiently support your router without "tipping". When designing the pattern, allow approximately $\frac{3}{16}$ " offset in pattern template design to allow for cutter and bushing offset. See drawings.

4. **IMPORTANT NOTE:** Remember that the router bit cuts a $\frac{1}{8}$ " diameter ($\frac{1}{16}$ " radius), therefore it is difficult to cut odd size inside corners and achieve sharp points. Adjust your patterns accordingly.

STEP 1: CUTTING THE WORKPIECE (NEGATIVE)

Firmly attach your template to the stock you wish to cut using double-faced tape, clamps, or small nails. With the brass sleeve pushed ON the bushing, proceed to cut inside your pattern following the pattern in a clockwise direction. After you have completed following the pattern in it's entirety, you can now cut the excess material out of the inside "free-handed" either with or without the aide of the pattern template. If your pattern was large, we recommend that you change bits and use an up-cut spiral, flat clean-bottom, or dado cutter for the remainder of this operation. See figure #1

STEP 2: CUTTING THE INLAY (POSITIVE)

Now put the same template pattern on the material you wish to cut out for the resulting inlay or repair piece. Again, secure with double-face tape, clamps or nails. With the brass sleeve now OFF proceed to follow the template again, this time cutting clockwise all the way through the stock. See figure #2

STEP 3: ASSEMBLY

Glue the inlay you cut in Step 2 into the workpiece you cut in Step 1. Slight sanding may be required. See figure #3

As always, a good suggestion is to practice on scrap to develop the technique before attempting your final masterpiece.

FIGURE #1: CUTTING THE WORKPIECE (NEGATIVE)



FIGURE #2: CUTTING THE INLAY (POSITIVE)

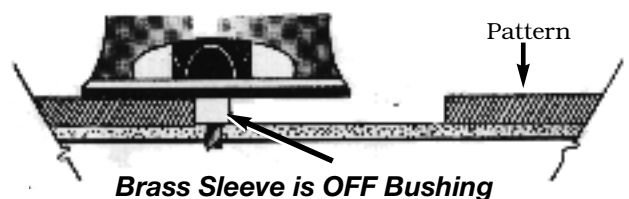


FIGURE #3: FINAL ASSEMBLY

