Kreg®

Precision Router Table Fence
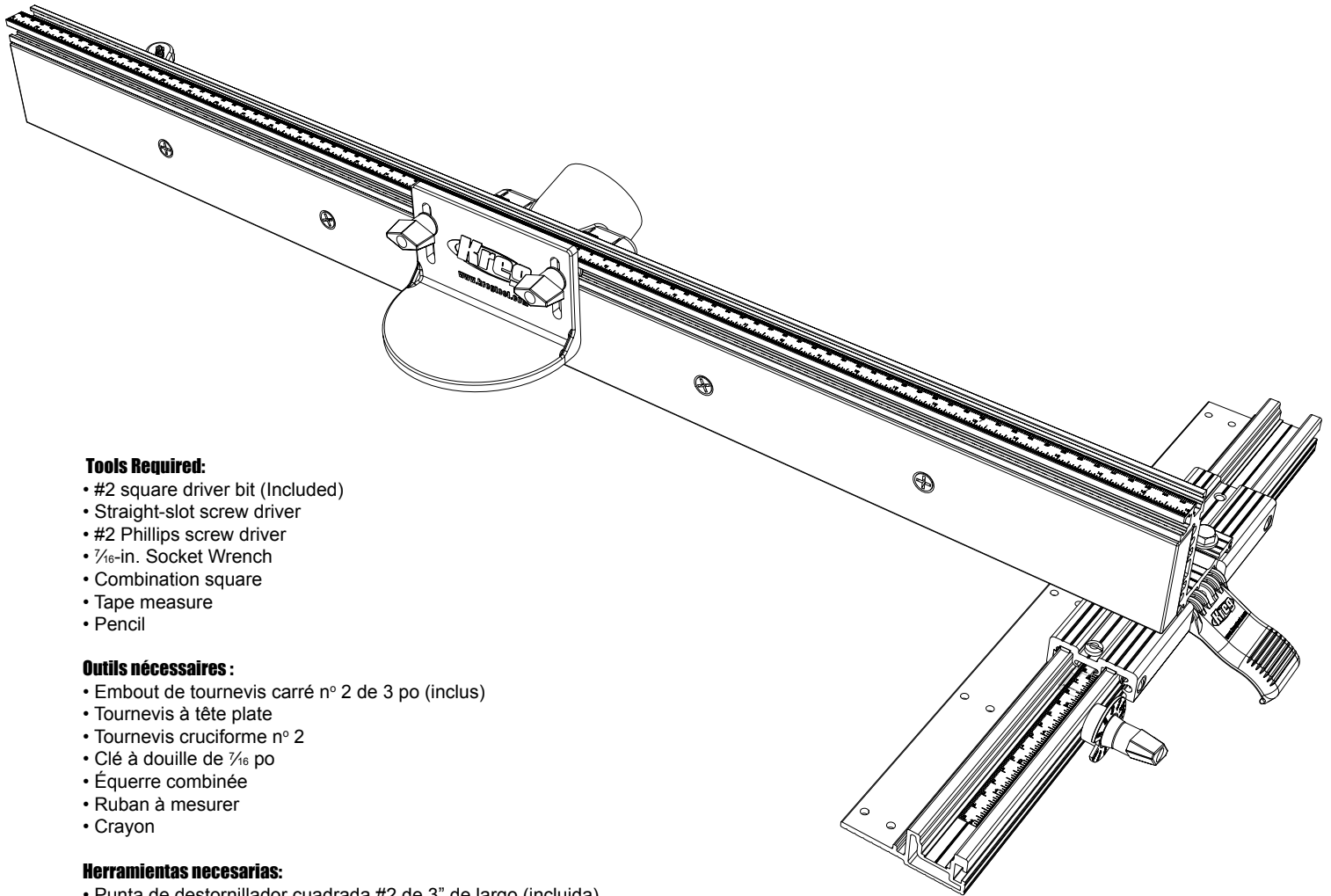
OWNER'S MANUAL

GUIDE D'UTILISATION • MANUAL DEL PROPIETARIO

Item# PRS1015
Article #PRS1015
Artículo No. PRS1015

Tools Required:
• #2 square driver bit (Included)
• Straight-slot screw driver
• #2 Phillips screw driver
• $7/16$-in. Socket Wrench
• Combination square
• Tape measure
• Pencil

Outils nécessaires :
• Embout de tournevis carré nº 2 de 3 po (inclus)
• Tournevis à tête plate
• Tournevis cruciforme nº 2
• Clé à douille de $7/16$ po
• Équerre combinée
• Ruban à mesurer
• Crayon

Herramientas necesarias:
• Punta de destornillador cuadrada #2 de 3" de largo (incluida)
• Destornillador de punta recta
• Destornillador Phillips #2
• Llave de tuercas de $7/16$ pulg
• Escuadra combinada
• Cinta métrica
• Lápiz

General Safety Instructions

> ⚠ **WARNING** When using electric tools, always follow the safety precautions *below* to reduce risk of fire, electric shock, and personal injury. Read all these instructions before attempting to operate this product. **<u>SAVE THESE INSTRUCTIONS</u>**.

1) Work area safety

a) **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.

b) **Don't use power tools in a dangerous environment.** Don't use power tools in damp or wet locations, or expose them to rain.

c) **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks that can ignite the fumes or dust.

d) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

e) **Make your workshop child proof.** Use padlocks, master switches, or remove starter keys.

2) Electrical safety

a) **Ground electric tools. If the tool is equipped with a three-prong plug, it must be plugged into a grounded three-hole electrical outlet.** If the proper outlet is not available, have one installed by a qualified electrician. Never remove the third prong or modify the provided plug in any way.

b) **Do not expose power tools to rain or wet conditions.** Water entering a power tool increases the risk of electric shock.

c) **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.

d) **Use a proper extension cord and make sure it is in good condition.** When using an extension cord, be sure to use one heavy enough to carry the current your power tool draws. An undersized cord causes a drop in line voltage resulting in loss of power and overheating. **Table 1** on the following page shows the correct cord gauge to use depending on cord length and tool nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gauge number, the heavier the cord.

e) **When operating electric tools, avoid body contact with grounded or earthed surfaces such as pipes, radiators, kitchen ranges, and refrigerators.** Contact with a grounded surface increases the risk of electric shock.

3) Personal safety

a) **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools can result in serious personal injury.

b) **Always wear safety glasses.** Everyday eyeglasses are not safety glasses. Safety glasses have specially constructed lenses, frames, and side shields.

c) **Use safety equipment.** Use a face or dust mask when the cutting operation is dusty. Safety equipment such as a dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions reduces personal injuries.

d) **Avoid accidental starting. Make sure the switch is in the off-position before plugging in.** Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.

e) **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool can result in personal injury.

f) **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.

g) **Secure workpieces.** Use clamps or a vise to hold work when practical. This is safer than using your hand and it frees both hands to operate the tool.

h) **Never stand on the machine.** Serious injury can occur if the tool tips or if the cutting tool is unintentionally contacted.

i) **Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewelry or long hair can be caught in moving parts. Roll up long sleeves to the elbow. Wear protective hair covering to contain long hair.

j) **If devices are provided for the connection of dust extraction and collection equipment, ensure these are connected and properly used.** Use of these devices reduces dust-related hazards.

4) Power tool use and care

a) **Keep guards in place and in working order.**

b) **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.

c) **Use the right tool.** Don't force a tool or attachment to do a job for which it was not designed.

d) **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.

e) **Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.

f) **Never leave a tool running unattended. Turn power off.** Don't leave the tool until it comes to a complete stop.

g) **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool and these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.

h) **Maintain power tools. Check for misalignment or binding of moving parts, broken parts, and any other condition that can affect power tool operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.

i) **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.

j) **Use the recommended speed for the cutting tool or accessory and workpiece material.**

k) **Only use parts and accessories recommended by the manufacturer.** Consult the owner's manual for recommended accessories. Using improper accessories can cause personal injury.

l) **Use the power tool, accessories, and tool bits in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended can result in a hazardous situation.

5) Service

a) **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This ensures that the safety of the power tool is maintained.

6) Safety instructions specific to using a router table fitted with the Precision Router Table Fence

a) **Read, understand, and follow your router manufacturer's safety warnings and instructions.**

b) **Disconnect the router from power before making adjustments.** Never adjust the fence, plate, reducing rings, or any part of the router or router table while the router is running.

c) **Place the router table on a flat surface to prevent tipping or sliding.** Never stand on the router table.

d) **Do not attempt to rout warped, twisted, or bowed workpieces.** All workpieces must have flat faces and square edges.

e) **Do not attempt to rout very large workpieces on a router table.** Very large workpieces can be difficult to control and can cause the router table to tip over.

f) **Only use router bits in your router.** Never use tools such as carving burrs, mounted abrasives, wire wheels, or drill pits, even if the shanks match the diameter of the router collet.

g) **Wear gloves when handling router bits.** Cutting edges are sharp.

h) **Never use dirty, dull, or damaged router bits.** Remove wood-resin build-up with a cleaner specifically formulated for cutting tools. Have dull bits sharpened by a qualified person. Discard damaged bits.

i) **Make sure at least 75% of the router-bit shank length is securely held in the router collet.** To ensure a secure hold, leave 1⁄16" to 1⁄8" (2mm-3mm) between the end of the bit shanks and the bottom of the collet.

j) **Use the insert-plate reducing ring with the smallest opening that allows the bit to pass through it.** A large gap around the bit can allow the workpiece to tip

into the bit and kick back.

k) **Position the fence faces as close as possible to the bit.** Turn the bit by hand to check for interference. Firmly tighten the fence-face T-knobs before routing.

l) **Adjust router speed to match the diameter of the bit.** Reduce router speed when using large-diameter bits. See **Table 2** for recommended router speeds.

m) **Make sure the router motor is securely clamped in the base before starting the router.**

n) **Always support the workpiece with the fence or start pin.** Only use the starter in with router bits that have a guide bearing.

o) **When using the fence, always position the bit guard over the router bit and as close to the workpiece surface as possible.**

p) **Never remove a large quantity of stock in one cut.** Make several progressively deeper cuts, adjusting the router bit or fence position between cuts.

q) **Keep hands away from the rotating bit and your body out of the path of the cut.** Always use the bit guard, Use push sticks, push blocks, and feather boards whenever possible, especially when routing narrow workpieces. Turn off the router before clearing parts of scrap.

r) **Avoid awkward hand positions, where a sudden slip could cause contact with the rotating bit.** Never overreach.

s) **Avoid routing small parts.** Rout the profile on a large workpiece and then cut the part to final size from the large workpiece. If you must rout a small part, build an appropriate jig or hold the part with a wood handscrew clamp.

t) **Make sure the workpiece is clear of the bit and the bit comes to a complete stop before adjusting the workpiece position.** Never start the router with the workpiece in contact with the bit.

u) **Avoid kickbacks. Kickbacks occur when the workpiece binds or lifts off the table while being routed, causing it to be thrown back toward the operator.** To avoid kickbacks and potential injury, use sharp bits, keep the machine aligned and maintained properly, and adequately support the workpiece. Do not attempt to rout workpieces that are twisted, warped, or bowed, or that have loose knots.

v) **Feed the workpiece against (not with) the bit rotation.** The bit can grab a workpiece fed with the rotation of the bit, violently eject it from the router table, and can cause your hand to contact the bit.

w) **Never trap a workpiece between the bit and the fence.** When forming a profile on the straight edge of a workpiece, always rout with the bit housed in the fence and the edge of the workpiece against the fence.

x) **Whenever routing a profile in which material is _not_ being removed below a protruding portion of the bit, or a part of the profile is trapped between cutters above and below, take extra precautions to prevent the workpiece from lifting off the table surface during routing.** A workpiece lifting off the table can kick back and cause serious personal injury. When routing these profiles, it is especially important to use straight, flat stock and avoid warped, bowed, or twisted stock.

y) **Periodically check the tightness of fasteners and adjustment and locking knobs and the alignment of the fence.** Loose fasteners and knobs and a misaligned fence can cause personal injury.

z) **This router table fence is designed for a specific application. Do not modify and or use it for any other application.** If you have questions relative to the application of the router table, DO NOT use it until you have contacted Kreg Tool Company and have been advised accordingly.

Guidelines for extension cord use
Extension cords are only to be used for temporary purposes. They do not replace the need for installation of outlets and proper wiring where necessary.

In the shop and on construction sites:
1. Extension cords with an equipment grounding conductor must be used at all times.
2. Extension cords must be protected from damage, and not run through doorways or windows where the doors or windows can close, causing damage to the cord.
3. Extension cords must be a minimum of 16 AWG and be rated for the equipment in use.
4. Extension cords must be periodically inspected to ensure that the insulation and conductivity of the wires are not compromised.
5. Extension cords should not be run through water or allowed to have connections that may be exposed to accumulated water.

TABLE 1

Nameplate Amperes @120 V	Extension Cord Length					
	25′	50′	75′	100′	150′	200′
	Recommended Wire Gauge					
0 -5	16	16	16	14	12	12
5.1 - 8	16	16	14	12	10	NR
8.1 -12	14	14	12	10	NR	NR
12.1 - 16	12	12	NR	NR	NR	NR

NR – Not Recommended

TABLE 2

Recommended Router Bit Speeds	
Bit Diameter	**Maximum Speed (RPM)**
Up to 1″ (25mm)	24,000
1¼″ to 2″ (32mm-51mm)	18,000
2¼″ to 2½″ (57mm-64mm)	16,000
3″ to 3½″ (76mm-89mm)	12,000

Always follow bit manufacturer's speed recommendations. Some bit designs require specific speeds for safety or performance.

⚠ **WARNING:** This product can expose you to chemicals including Acrylonitrile and other chemicals, which are known to the State of California to cause cancer and reproductive harm. For more information go to www.P65Warnings.ca.gov.

⚠ **WARNING:** Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to www.P65Warnings.ca.gov/wood.

Exploded View

![Kreg logo]
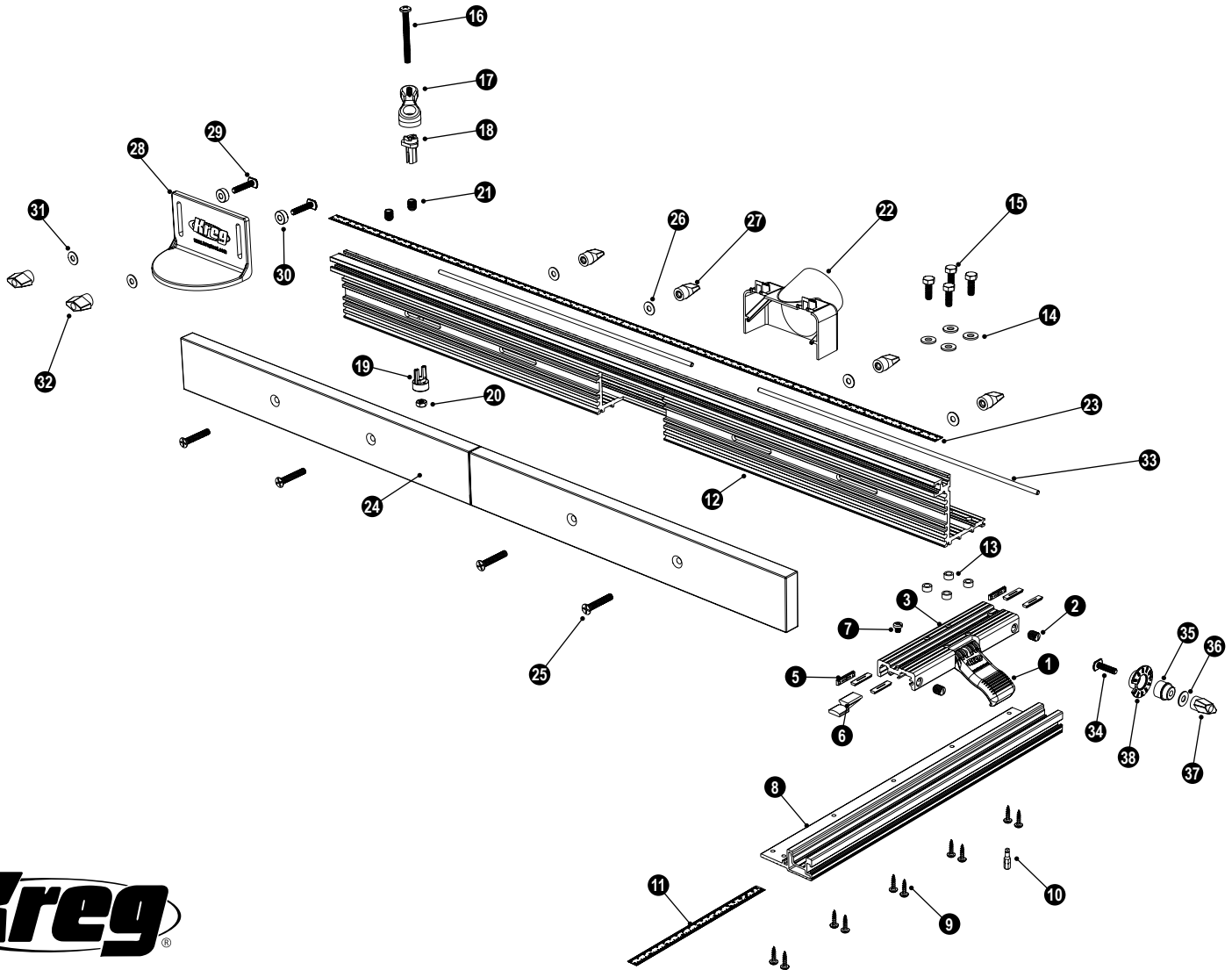
Parts

Item#	Description	Kreg Part#	Quantity	Item#	Description	Kreg Part#	Quantity
	CLAMP BLOCK ASSEMBLY	NK8300	1	㉑	Nylon set screws		2
❶	Handle		1	㉒	VACUUM PORT	NK8309	1
❷	Nylon set screws		2	㉓	48″ CENTER-READING TAPE	RT10140	1
❸	Clamp block		1	㉔	FENCE FACES	NK9206	2
❹	Pin (not shown)		1		**HARDWARE PACK #4**	NK8350	1
❺	Glides		6	㉕	¼-20 x 1 ½″ flathead bolts		4
❻	Lens cursor		1	㉖	¼″ brass flat washers		4
❼	Nylon machine screw		1	㉗	T-knobs		4
❽	MOUNTING RAIL	NK8320	1	㉘	BIT GUARD	RT10133	1
	HARDWARE PACK #1	NK8328	1		**HARDWARE PACK #5**	NK8353	1
❾	1″ Coarse-thread screws		10	㉙	¼-20 x 1 ¼″ T-bolts		2
❿	#2 square driver bit		1	㉚	Spacers		2
⓫	8″ SCALE	RT10139	1	㉛	¼″ brass flat washers		2
⓬	FENCE EXTRUSION	NK8313	1	㉜	T-knobs		2
	HARDWARE PACK #2	NK8342	1	㉝	JOINTING RODS	RT10131	2
⓭	¼″ x .210″-long spacers		4		**HARDWARE PACK #6**	NK8361	1
⓮	¼″ flat washers		4	㉞	¼-20 x 1¾″ T-slot bolt		1
⓯	¼-20 x ⅝″ hex-head machine screws		4	㉟	Micro-adjuster base		1
	HARDWARE PACK #3	NK8337	1	㊱	¼″ brass flat washer		1
⓰	¼-20 x 2 ½″ Phillips panhead machine screw		1	㊲	T-knob		1
⓱	Fence-lock handle		1	㊳	Micro-adjuster dial		1
⓲	Fence-lock base		1				
⓳	Fence-lock anchor		1				
⓴	Lock nut		1				

Attach the mounting rail

⚠️ ATTENTION To mount this fence to the Kreg Precision Router Table PRS1025, see **Step 1**. To mount the fence to other router tables, see **Steps 2** and **3**.

1 *Hardware for this section is in HARDWARE PACK #1.*
To mount the fence to the Kreg Precision Router Table PRS1025, raise the handle **(1)** to release the clamp-block assembly **(Parts 1-7)** from the mounting rail **(8)**. Position the rail on the bottom of the table top at the right rear corner, aligning the holes in the rail with the holes in the table top. Fasten the rail with the screws **(9)**.

2 This router-table fence is designed to be mounted on the Kreg Precision Router Table Top PRS1025, which is 1¹⁄₁₆″ thick. For thinner tops, insert a 1¼″-wide, 17″-long shim of the appropriate thickness between the mounting rail **(8)** and the router table top to make up the difference. For thicker table tops, create a 1¼″-wide, 17″-long recess to reduce the rail-mounting area to 1¹⁄₁₆″ thick. Apply the shim or rout the recess on the bottom of the router table top at the rear right corner. Raise the handle **(1)** to release the clamp-block assembly **(Parts 1-7)** from the mounting rail **(8)**. Position the rail on the bottom of the table top with the rear end of the rail and the rear edge of the table top flush. Using the holes in the rail as guides, drill pilot holes and fasten the rail to the top with the screws **(9)**.

3 For table tops other than the Kreg Precision Router Table Top PRS1025, drill and rout the keyhole slot for the ¼-turn fence lock. The length of the slot should allow the face of the fence to be positioned 2½″ in front of the center of the router-table insert plate.
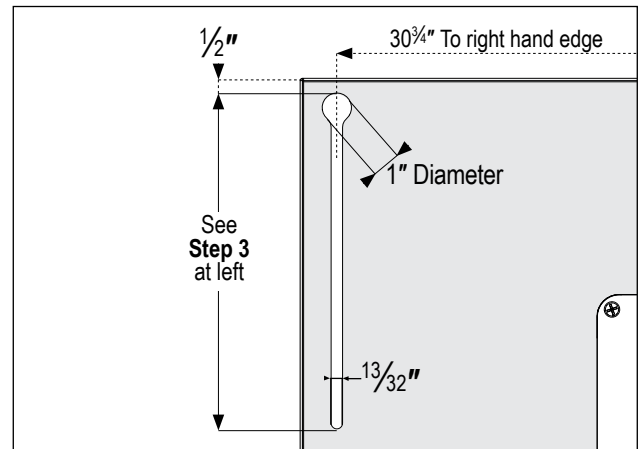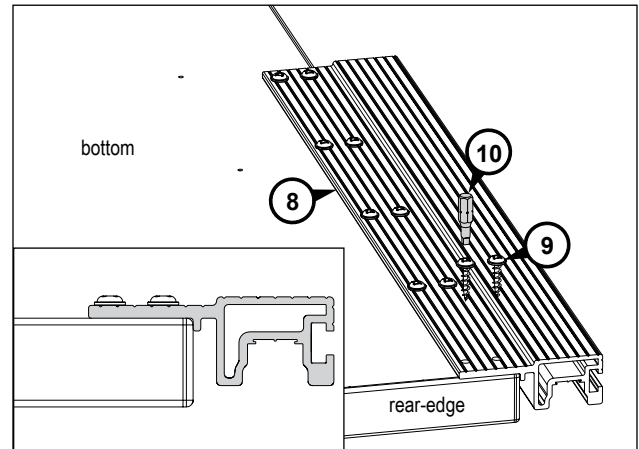
Install the clamp block

1 Position the clamp block assembly on the mounting rail. Adjust the nylon set screws **(2)** in the front of the clamp block **(3)** so they just graze the mounting rail. The clamp block should move easily but not wobble.
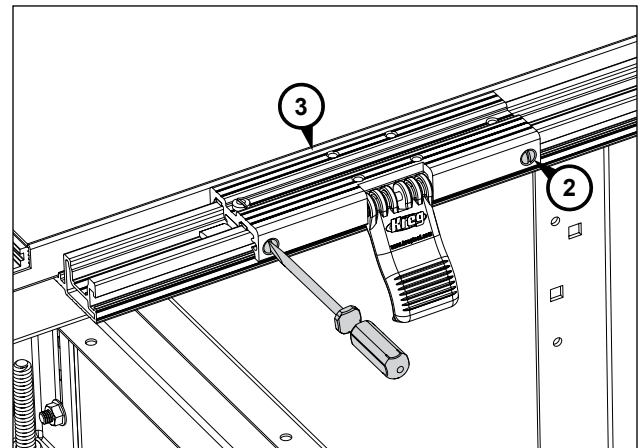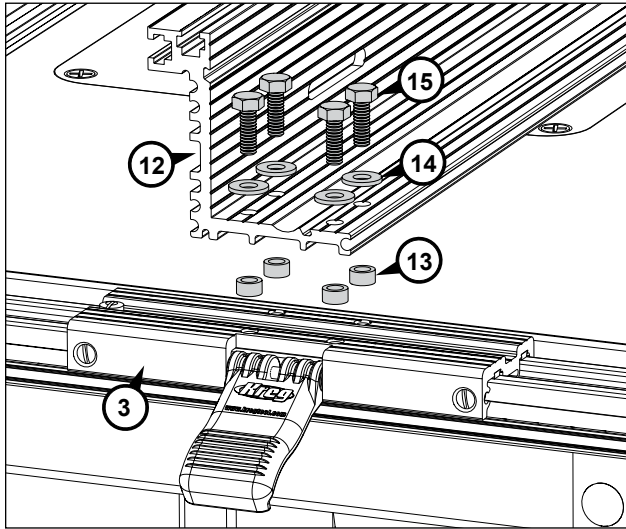

Installing the clamp block tape

2 Slide the 8″ scale **(11)** into the clamp block slot. The rib centered in the slot bows the scale, providing a friction fit that keeps it in position. (See **Indexing the fence** under the section **Using Your Router Table Fence**.)
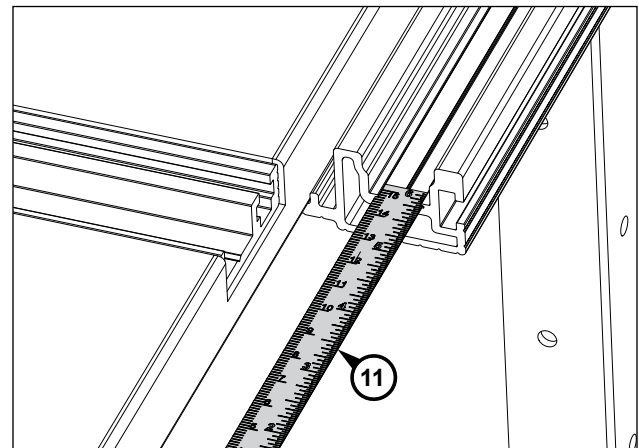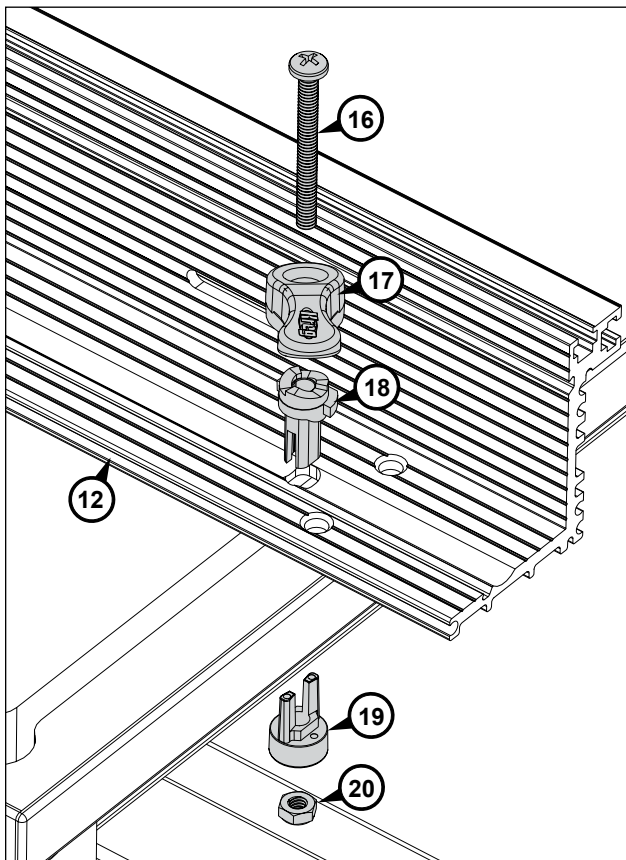
Add the fence extrusion

1 *Hardware for this section is in **HARDWARE PACK #2**.*
Place four spacers **(13)** over the mounting holes in the clamp block **(3)**. Fasten the extrusion **(12)** to the clamp block with washers **(14)** and machine screws **(15)**. Finger-tighten the screws.


2 *Hardware for this section is in **HARDWARE PACK #3**.*
Slip the machine screw **(16)** through the fence-lock handle **(17)** and fence-lock base **(18)**. Drop the handle/base/machine screw assembly through the hole in the base flange of the fence extrusion **(12)** and the keyhole slot in the router table top. The flat edge of the base stem faces the back of the fence and the handle points away from the back of the fence. Slide the fence-lock anchor **(19)** onto the machine screw from underneath the table with the anchor "fingers" in the table-top slot. Thread the lock nut **(20)** onto the machine screw. Make sure the nylon insert in the lock nut faces down. Lower the fence-lock anchor onto the lock nut, housing the nut in the tapered hexagonal recess in the anchor. Use a screw driver to draw the lock nut into the fence-lock anchor. Once the nut is fully seated in the anchor, it will not drop out.

⚠️ ATTENTION When using the fence with a table top thinner than $1\frac{1}{16}''$, carefully trim the ends of the anchor fingers so they don't bottom out in the fence-lock base.

3 Position the fence-lock handle **(17)** pointing away from the fence and angled 45 degrees to the left [viewed from the back of the fence]. This is the locked position for the handle. To adjust fence-lock tension, tighten the machine screw with a screw driver until the clamp is tight enough to hold the fence in place. Rotate the handle ¼-turn counterclockwise to release the fence.

⚠️ WARNING Periodically check the fence lock to make sure it has not loosened with use. Tighten the machine screw **(16)** as needed.
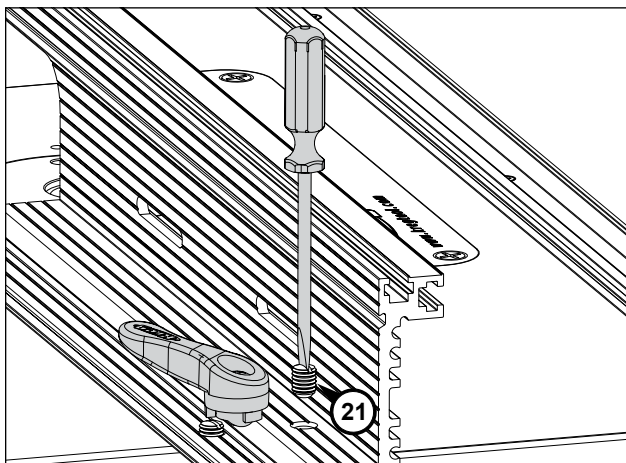

4 Thread two set screws **(21)** into the holes flanking the ¼-turn handle. You'll use these screws to square the fence. (See the section **Align and square the fence.**)

5 Insert the tabs at the bottom of the vacuum port **(22)** into the groove in the base of the fence extrusion. Align the two interior pegs on the dust port with the inside edges of the router-bit cutout. Push down on the spring-lock tabs at the top of the port and snap them into the groove in the back of the extrusion.
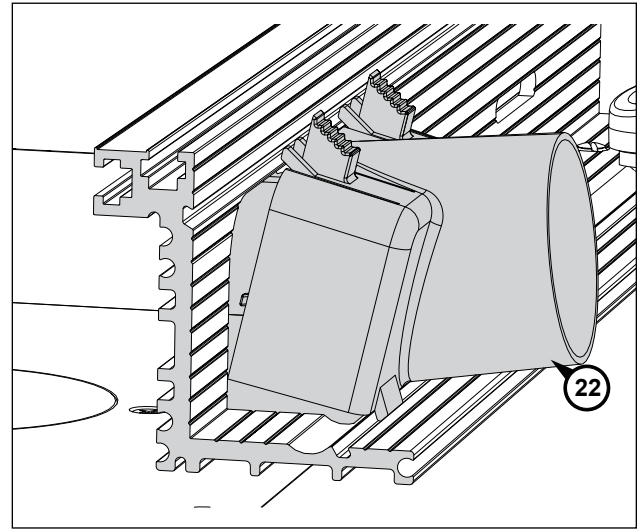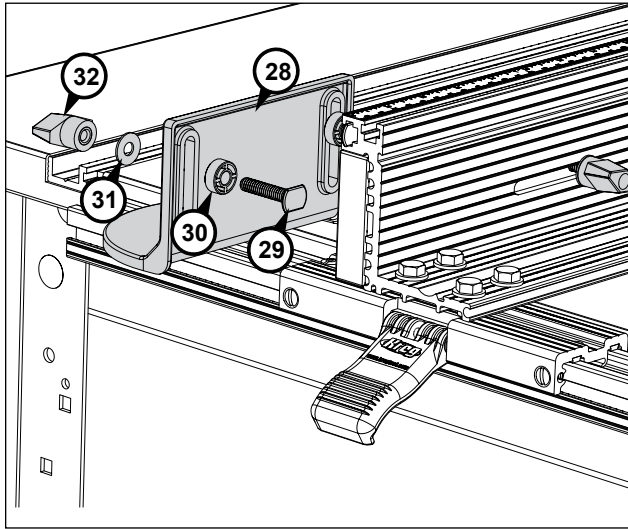

6 Mark the center of the top edge of the fence extrusion. Position the zero mark of the self-adhesive tape **(23)** at the mark and remove the protective backing as you adhere the tape to the extrusion. Trim the excess tape flush with each end of the extrusion.
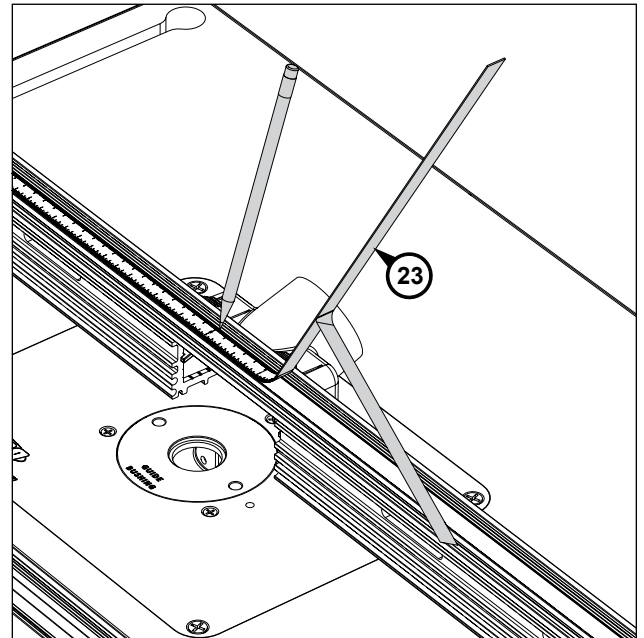
7 *Hardware for this section is in **HARDWARE PACK #4**.*
Install the fence faces **(24)** with flathead bolts **(25)** inserted through each fence face. Secure the machine screws at the back with brass flat washers **(26)** and T-knobs **(27)**.
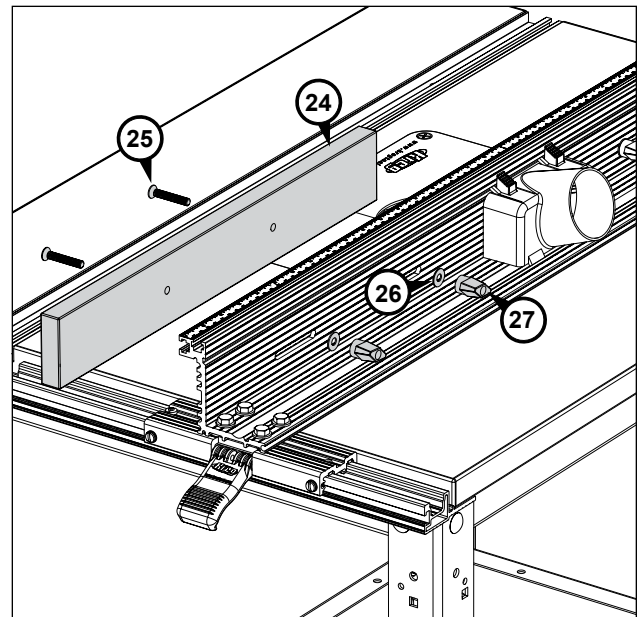
8 *Hardware for this section is in **HARDWARE PACK #5**.*
Assemble the bit guard **(28)** with T-bolts **(29)**, spacers **(30)**, brass flat washers **(31)**, and T-knobs **(32)**. Slide the T-bolt heads into the T-slot at the top front edge of the fence extrusion, center the guard on the router-bit cutout, and tighten the knobs.
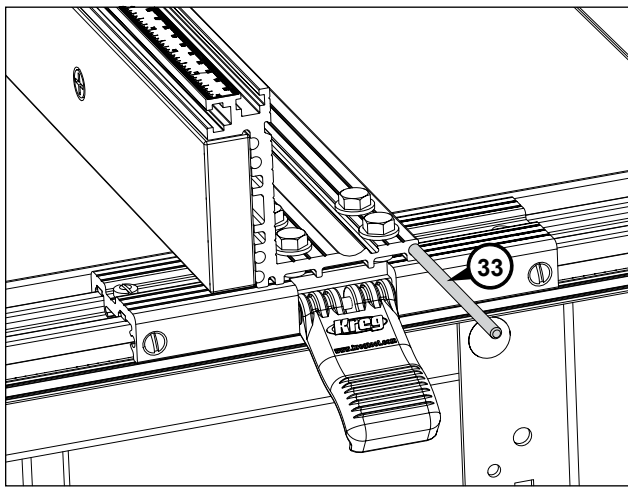
9 To store the jointing rods **(33)**, slide them into the round channel at the back edge of the fence extrusion base flange. (See **Jointing** under the section **Using Your Router Table Fence**.)
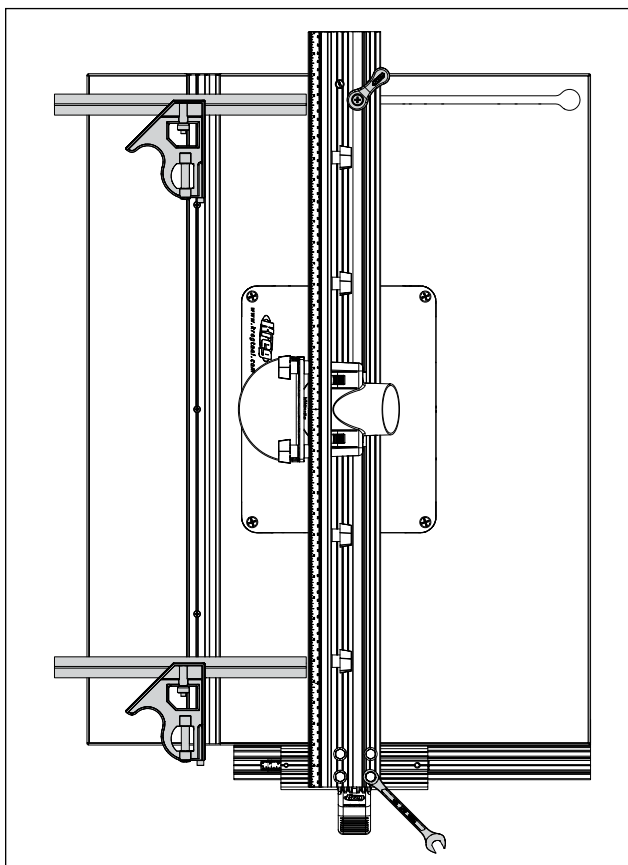
Align and square the fence

1 Using a combination square as a gauge, align the fence parallel to the miter-gauge slot. Lock the clamp block and tighten the ¼-turn fence lock. Re-check the parallel alignment and then tighten the hex-head machine screws that secure the fence extrusion to the clamp block assembly. Release the fence, slide it back and forth on the mounting rail, and lock it in place. Verify the parallel adjustment.
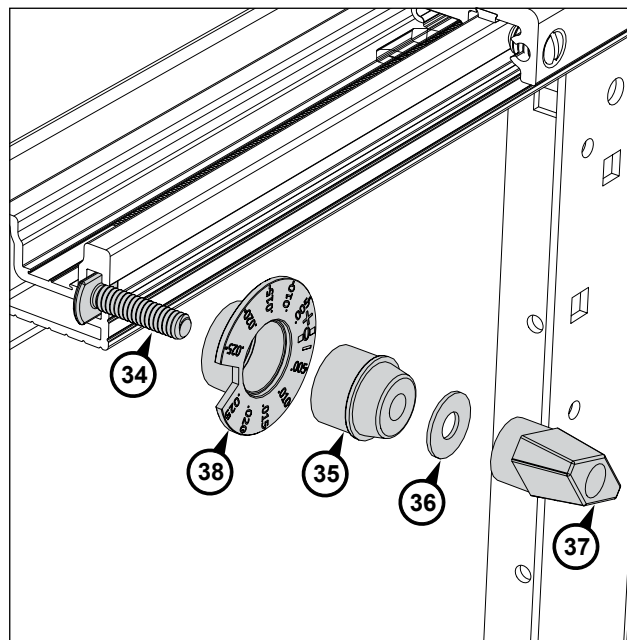
2 Industry standards allow a slight amount of end-to-end twist in aluminum extrusions. To eliminate any twist, secure the fence with the clamp block and ¼-turn fence lock. Place a square against the fence face at the left end of the fence. Use the set screws **(21)** flanking the ¼-turn handle to align the fence face with the square.
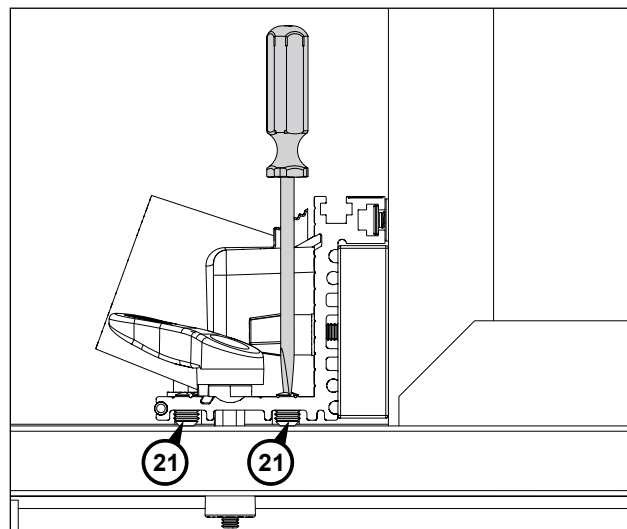
Install the micro-adjuster

1 *Hardware for this section is in HARDWARE PACK #6.* Slide the T-slot bolt **(34)** through the base **(35)** and the washer **(36)**. Thread on the T-knob **(37)**. Insert this assembly into the dial **(38)**.

2 Slide the head of the T-slot bolt into the mounting rail slot from the front end and tighten the knob. The micro-adjuster can be stored at the front of the mounting rail without interfering with router-table operation. (See **Micro-Adjustment** under the section **Using Your Router Table Fence**.)

Safety Instructions specific to using a Router Table fitted with the Precision Router Table Fence

a) **Read, understand, and follow your router manufacturer's safety warnings and instructions.**

b) **Disconnect the router from power before making adjustments.** Never adjust the fence, plate, reducing rings, or any part of the router or router table while the router is running.

c) **Place the router table on a flat surface to prevent tipping or sliding.** Never stand on the router table.

d) **Do not attempt to rout warped, twisted, or bowed workpieces.** All workpieces must have flat faces and square edges.

e) **Do not attempt to rout very large workpieces on a router table.** Very large workpieces can be difficult to control and can cause the router table to tip over.

f) **Only use router bits in your router.** Never use tools such as carving burrs, mounted abrasives, wire wheels, or drill pits, even if the shanks match the diameter of the router collet.

g) **Wear gloves when handling router bits.** Cutting edges are sharp.

h) **Never use dirty, dull, or damaged router bits.** Remove wood-resin build-up with a cleaner specifically formulated for cutting tools. Have dull bits sharpened by a qualified person. Discard damaged bits.

i) **Make sure at least 75% of the router-bit shank length is securely held in the router collet.** To ensure a secure hold, leave ¹⁄₁₆" to ⅛" (2mm-3mm) between the end of the bit shanks and the bottom of the collet.

j) **Use the insert-plate reducing ring with the smallest opening that allows the bit to pass through it.** A large gap around the bit can allow the workpiece to tip into the bit and kick back.

k) **Position the fence faces as close as possible to the bit.** Turn the bit by hand to check for interference. Firmly tighten the fence-face T-knobs before routing.

l) **Adjust router speed to match the diameter of the bit.** Reduce router speed when using large-diameter bits. See **Table 2** for recommended router speeds.

m) **Make sure the router motor is securely clamped in the base before starting the router.**

n) **Always support the workpiece with the fence or start pin.** Only use the starter in with router bits that have a guide bearing.

o) **When using the fence, always position the bit guard over the router bit and as close to the workpiece surface as possible.**

p) **Never remove a large quantity of stock in one cut.** Make several progressively deeper cuts, adjusting the router bit or fence position between cuts.

q) **Keep hands away from the rotating bit and your body out of the path of the cut.** Always use the bit guard, Use push sticks, push blocks, and feather boards whenever possible, especially when routing narrow workpieces. Turn off the router before clearing parts of scrap.

r) **Avoid awkward hand positions, where a sudden slip could cause contact with the rotating bit.** Never overreach.

s) **Avoid routing small parts.** Rout the profile on a large workpiece and then cut the part to final size from the large workpiece. If you must rout a small part, build an appropriate jig or hold the part with a wood handscrew clamp.

t) **Make sure the workpiece is clear of the bit and the bit comes to a complete stop before adjusting the workpiece position.** Never start the router with the workpiece in contact with the bit.

u) **Avoid kickbacks. Kickbacks occur when the workpiece binds or lifts off the table while being routed, causing it to be thrown back toward the operator.** To avoid kickbacks and potential injury, use sharp bits, keep the machine aligned and maintained properly, and adequately support the workpiece. Do not attempt to rout workpieces that are twisted, warped, or bowed, or that have loose knots.

v) **Feed the workpiece against (not with) the bit rotation.** The bit can grab a workpiece fed with the rotation of the bit, violently eject it from the router table, and can cause your hand to contact the bit.

w) **Never trap a workpiece between the bit and the fence.** When forming a profile on the straight edge of a workpiece, always rout with the bit housed in the fence and the edge of the workpiece against the fence.

x) **Whenever routing a profile in which material is <u>not</u> being removed below a protruding portion of the bit, or a part of the profile is trapped between cutters above and below, take extra precautions to prevent the workpiece from lifting off the table surface during routing.** A workpiece lifting off the table can kick back and cause serious personal injury. When routing these profiles, it is especially important to use straight, flat stock and avoid warped, bowed, or twisted stock.

y) **Periodically check the tightness of fasteners and adjustment and locking knobs and the alignment of the fence.** Loose fasteners and knobs and a misaligned fence can cause personal injury.

z) **This router table fence is designed for a specific application. Do not modify and or use it for any other application.** If you have questions relative to the application of the router table, DO NOT use it until you have contacted Kreg Tool Company and have been advised accordingly.

Guidelines for extension cord use

Extension cords are only to be used for temporary purposes. They do not replace the need for installation of outlets and proper wiring where necessary.

In the shop and on construction sites:

1. Extension cords with an equipment grounding conductor must be used at all times.
2. Extension cords must be protected from damage, and not run through doorways or windows where the doors or windows can close, causing damage to the cord.
3. Extension cords must be a minimum of 16 AWG and be rated for the equipment in use.
4. Extension cords must be periodically inspected to ensure that the insulation and conductivity of the wires are not compromised.
5. Extension cords should not be run through water or allowed to have connections that may be exposed to accumulated water.

TABLE 1

Nameplate Amperes @120 V	Extension Cord Length					
	25'	50'	75'	100'	150'	200'
	Recommended Wire Gauge					
0 -5	16	16	16	14	12	12
5.1 - 8	16	16	14	12	10	NR
8.1 -12	14	14	12	10	NR	NR
12.1 - 16	12	12	NR	NR	NR	NR

NR – Not Recommended

TABLE 2

Recommended Router Bit Speeds	
Bit Diameter	**Maximum Speed (RPM)**
Up to 1" (25mm)	24,000
1¼" to 2" (32mm-51mm)	18,000
2¼" to 2½" (57mm-64mm)	16,000
3" to 3½" (76mm-89mm)	12,000

Always follow bit manufacturer's speed recommendations. Some bit designs require speeds for safety or performance.

General Routing
(A) Use the insert-plate reducing ring with the smallest opening that allows the bit to pass through it. **(B)** Position the fence faces as close as possible to the bit. Turn the bit by hand to check for interference. Firmly tighten the fence-face T-knobs before routing. **(C)** Position the bit guard over the router bit and as close to the workpiece surface as possible. **(D)** Feed the workpiece against (not with) the **(E)** the bit rotation.

Indexing the fence
The 8″ tape rule **(A)** and clamp block lens cursor **(B)** provide an easy way to index the fence to a router bit, allowing you to accurately rout a groove in two passes, rout a large profile in progressive passes, or perform a two-step routing task and return the fence to the initial position.
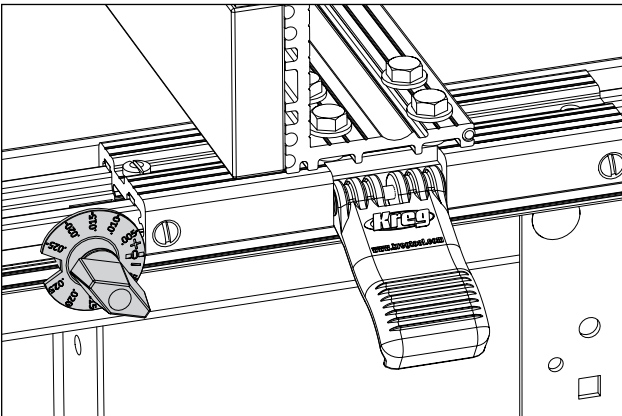
Micro-Adjustment
The micro-adjuster will move the fence up to .025″ in .005″ increments. Start with the fence locked in position. Slide the adjuster against the end of the clamp block, turning the dial so the zero mark aligns with the bottom edge of the clamp block. Tighten the knob. When adjusting the fence away from the micro-adjuster, release the fence and turn the dial to the desired increment. The dial pushes the fence to the new position. Lock the fence. When adjusting the fence toward the micro-adjuster, turn the dial to the desired increment and tighten the knob. Unlock the fence, push it against the micro-adjuster, and re-lock the fence.
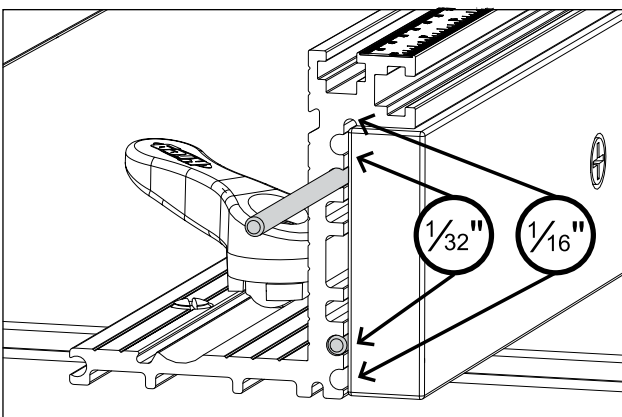
Jointing
Remove the jointing rods **(33)** stored in the fence extrusion. Loosen the outfeed fence face knobs. There are two shallow and two deep round channels in the fence extrusion behind the fence faces. For a $\frac{1}{16}$″ offset, slide the rods into the shallow recesses. For a $\frac{1}{32}$″ offset, slide the rods into the deep recesses. With the rods in place, tighten the outfeed fence-face knobs.

Install a straight bit in the router. Place a steel ruler against the outfeed fence face and position the fence so the bit just grazes the ruler.
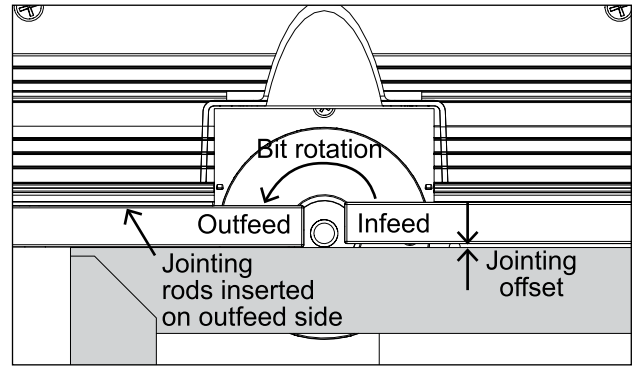
Use a scrap piece of wood to test the setup. If you feed the scrap past the bit and it runs into the leading end of the outfeed fence face, the fence is too far forward and you're not removing enough material. Use the micro-adjuster to move the fence back.
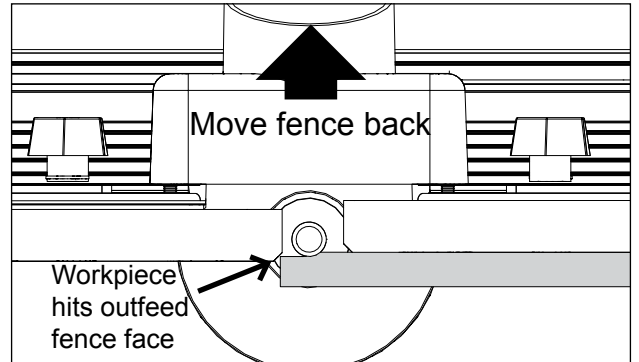
If the bit gouges the scrap at the trailing edge, the fence is too far back, and you're removing too much material. Use the micro-adjuster to move the fence forward.
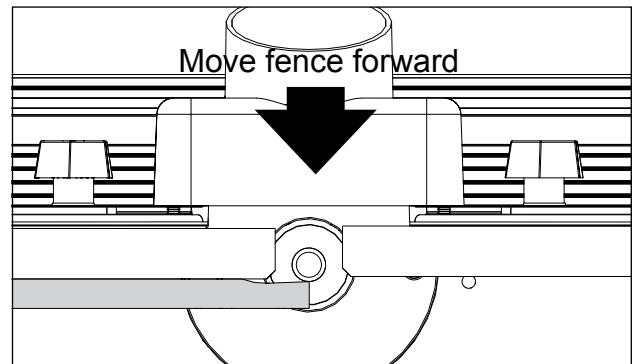
Starting Pin
To use the starting pin, begin with your workpiece touching the pin, but not in contact with the router bit. Slowly pivot the workpiece into the bit until the workpiece makes contact with the bit guide bearing. Always feed the workpiece so the router bit rotates against (not with) the feed direction. With the workpiece in solid contact with the guide bearing, ease the workpiece off of the starting pin and feed the workpice along the guide bearing.

⚠ WARNING Use the starting pin when routing along curved edges and only with router bits that have a guide bearing. When routing along straight edges, always use the fence.
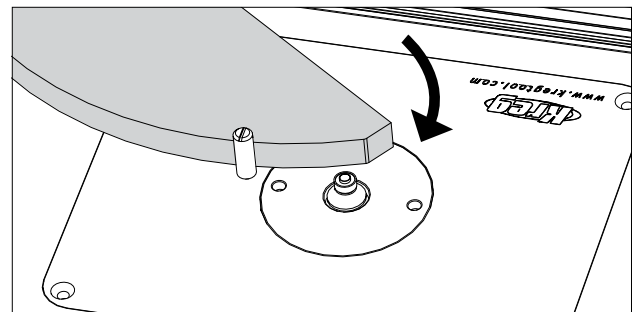
T-Slots
The fence extrusion features two T-slots, one on the top and one on the front face. Use T-bolts to attach feather boards and stops.

Center-Reading Tape Rule
Center the fence on the router bit and use the tape rule to position stops for routing stopped cuts.