Precision Router Table Top *(24" x 32")*

OWNER'S MANUAL

GUIDE D'UTILISATION • MANUAL DEL PROPIETARIO

Item# PRS1025
Article #PRS1025
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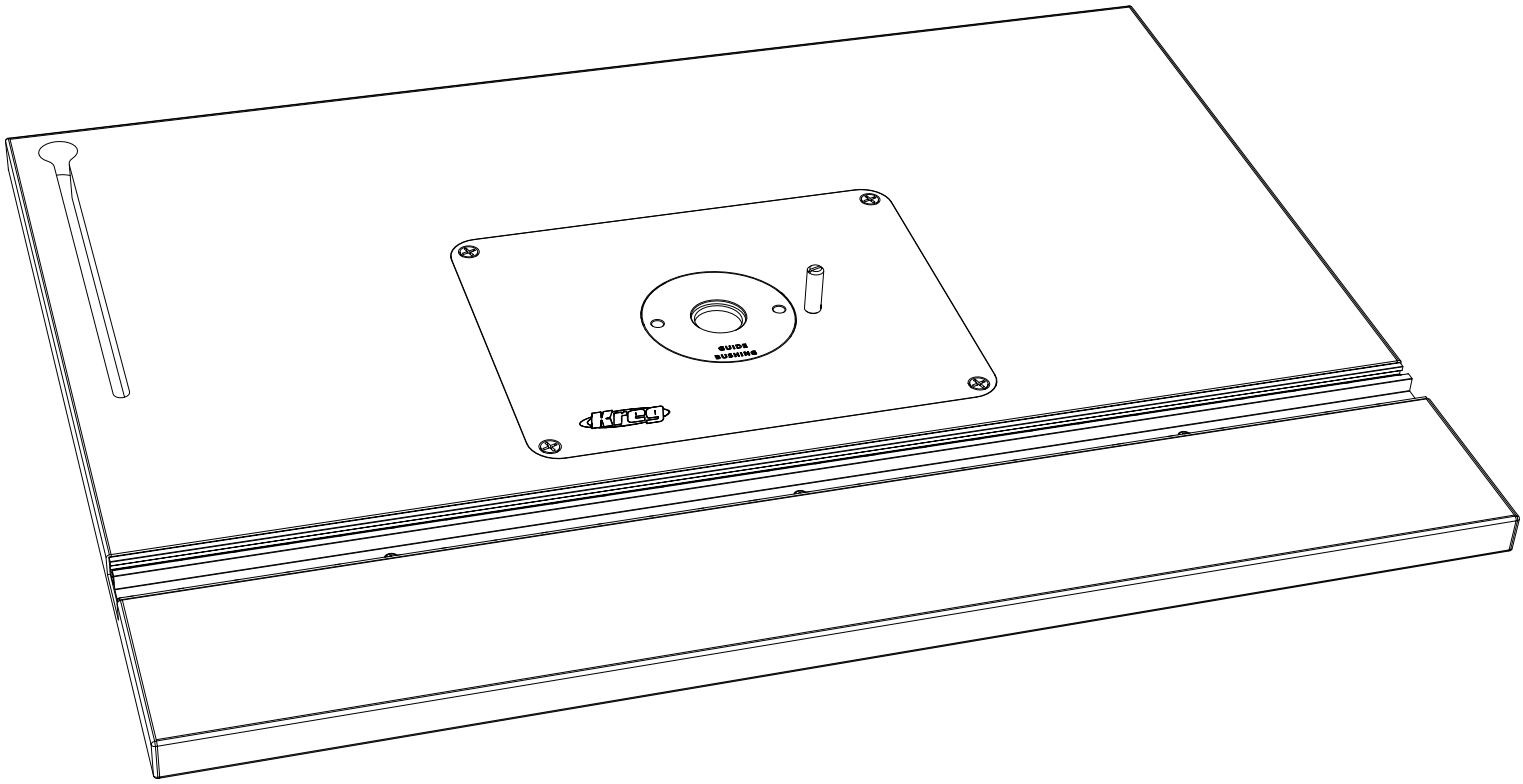


Tools Required:

- Phillips-head screwdriver
- Straight-slot screwdriver
- ⅛" hex wrench (included)
- #2 square driver (included)
- Double-faced tape
- Electric drill or drill press
- Drill bits
- Countersink bit

Outils nécessaires :

- Tournevis cruciforme
- Tournevis à tête plate
- Clé hexagonale de ⅛ po (incluse)
- Tournevis carré nº 2 (inclus)
- Ruban adhésif à double face
- Perceuse électrique ou à colonne
- Forets
- Fraise

Herramientas necesarias:

- Destornillador Phillips
- Destornilladores de punta recta
- Llave hexagonal de ⅛ pulg (incluida)
- Punta de destornillador cuadrada #2 (incluida)
- Cinta doble faz
- Taladro eléctrico o prensa de taladrar
- Brocas para taladro
- Broca para avellanar

NK8854
Version 6 - 05/2018

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. **SAVE THESE INSTRUCTIONS**.

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 should only 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 will increase 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 gage 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 may 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 may 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 could 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 can reduce 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 may 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 may 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 could 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 the Precision Router Table Top fitted with a 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 pin 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 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

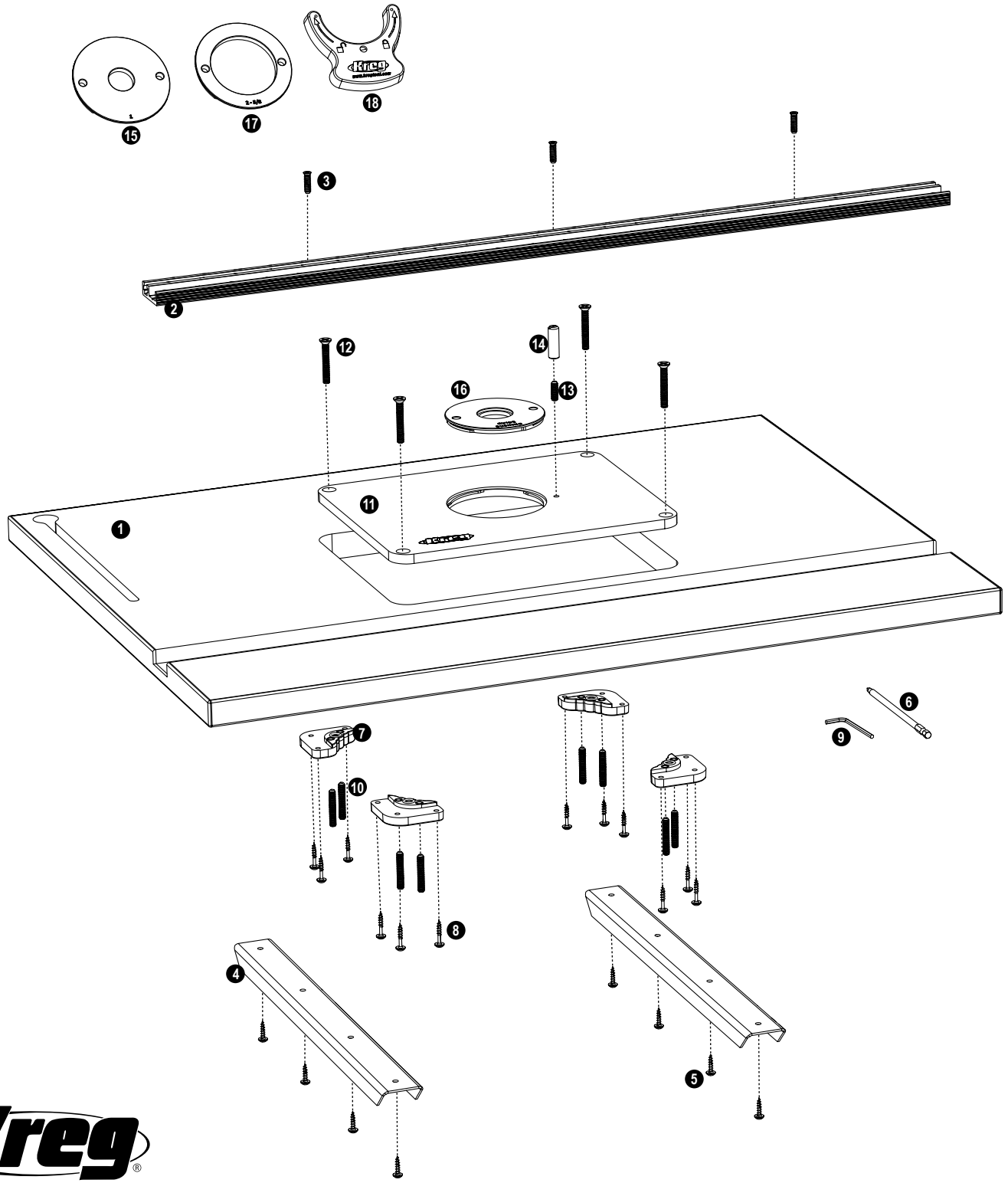
Recommended Router Bit Speeds	
Bit Diameter	**Maximum Speed (RPM)**
Up to 1″ (25mm)	24,000
1¼″ to 2″ (32mm-51mm)	18,000
2¼″ to 2½″ (57mm-64mm)	16,000
3″ to 3½″ (76mm-89mm)	12,000

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

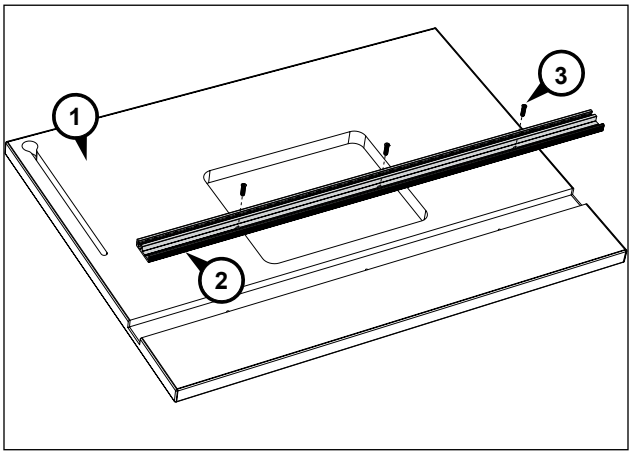


Parts

Item#	Description	Kreg Part#	Quantity	Item#	Description	Kreg Part#	Quantity
1	Table top	NK8324	1	10	¼-20 x 1½″ set screws	RT10111	8
2	Combo-Trak	NK8151	1	11	Insert plate	NK8840	1
3	5mm system screws 20mm long	NK8025	3	12	¼-20 x 1¾″ flathead machine screws	RT10112	4
4	Struts	RT10171	2	13	¼-20 x ¾″ set screw	DK1522	1
5	¾″ coarse-thread screws, 8-pack	RT10199	1	14	Starting pin	RT10108	1
6	#2 square driver bit	D6	1	15	1″ reducing ring	NK7773	1
7	Insert-plate levelers	RT10100	4	16	Guide-bushing reducing ring	NK7775	1
8	1¼″ coarse-thread screws	SML-C125	12	17	2⅝″ reducing ring	NK7774	1
9	⅛″ hex wrench	AW18	1	18	Ring wrench	NK8003PP	1

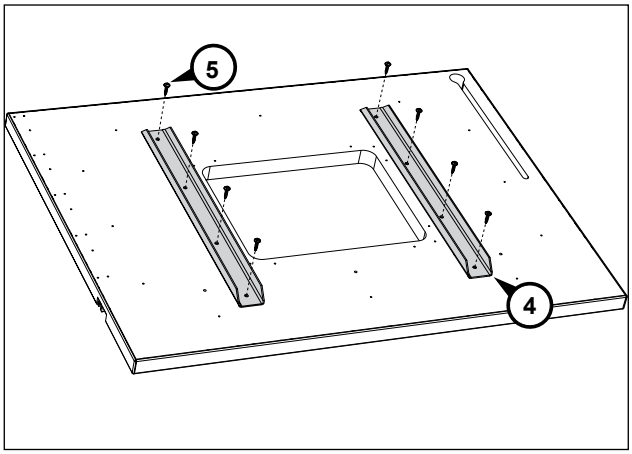
Assemble the top

1 The table top **(1)** is shipped with the combination miter-gauge track/ T-track **(2)** in place, but fastened only with a plastic rivet. Remove the rivet and secure the track with the system screws **(3)**, driving them into the holes in the table top.

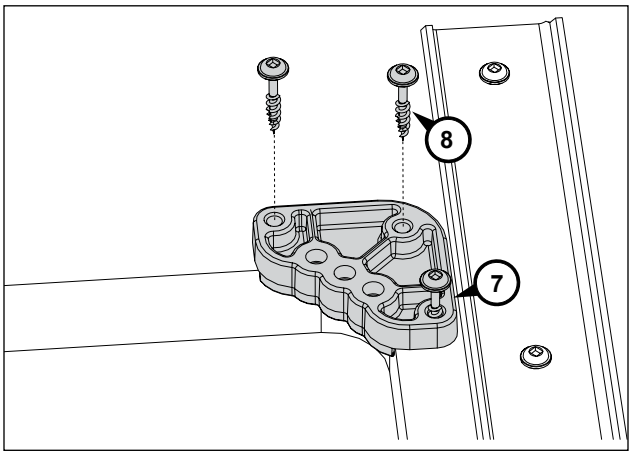


2 Turn the table top upside down. Align the two support struts **(4)** with holes in the bottom of the table top. Drive ¾″ coarse-thread screws **(5)** with the driver bit **(6)**.

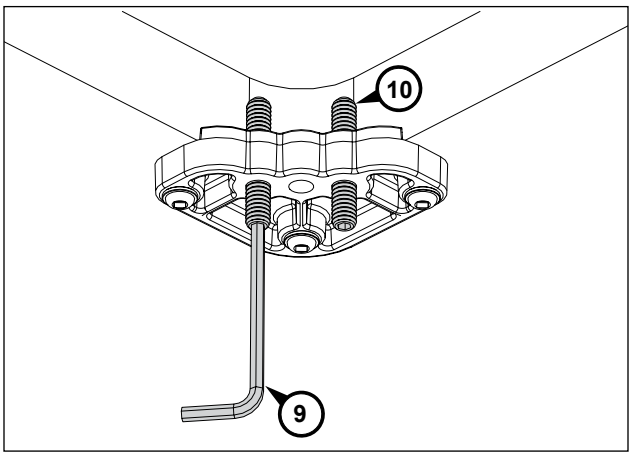
ATTENTION In this step, use the ¾″ screws **(5)**, NOT the 1¼″ screws **(8)**.

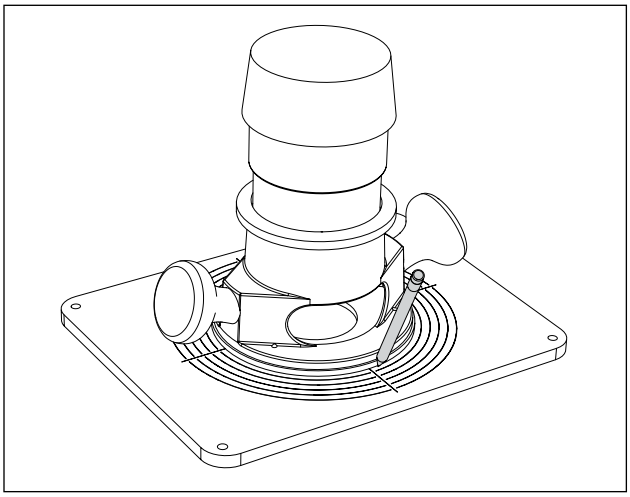


3 Position an insert-plate leveler **(7)** in each corner of the table-top opening. The holes in the levelers align with holes in the table-top. Fasten the levelers to the tabletop with 1¼″ coarse-thread screws **(8)**.



4 Using the hex wrench **(9)**, drive a set screw **(10)** into the outside holes in each leveler, threading them in from the bottom until the tips are ⅜″ below the table surface.

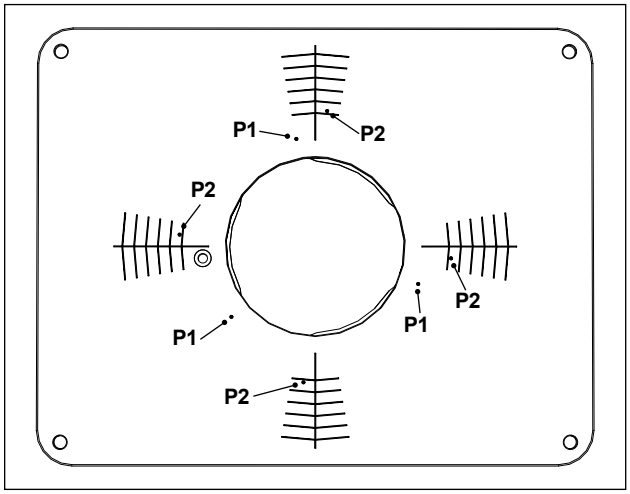




Mount your router to the insert plate

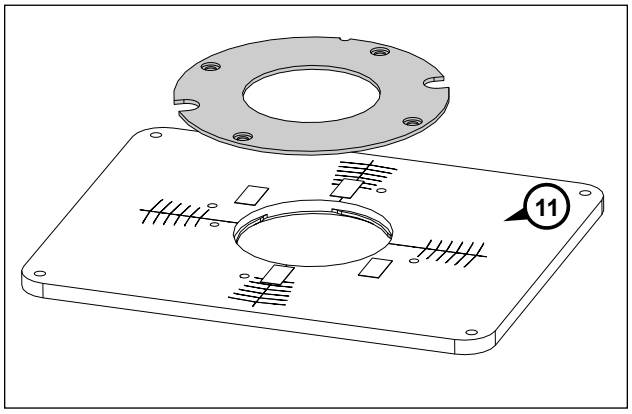
1 Place the insert plate **(11)** on your workbench with the front edge facing you and the target pattern facing up. Center your router base on the insert-plate target pattern. Adjust the router orientation to provide easy access to the controls when the router and plate are installed in your router table. Make an index mark on the router sub-base and the insert plate.

ATTENTION To view a free video that shows you how to drill your insert plate, go to www.kregtool.com. You also can have Kreg do the drilling for a fee. For complete information, go to www.kregtool.com/plateprogram.

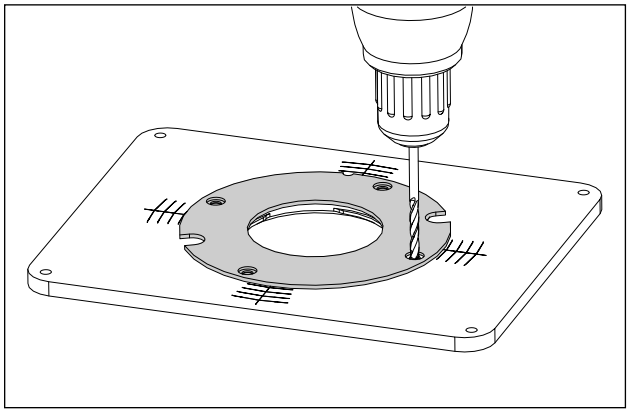


ATTENTION The included insert plate has center points molded into the bottom face for drilling mounting holes for the following routers: **Pattern 1** (three holes): Bosch 1617 and 1618; DeWalt 616 and 618; Hitachi M12VC; Makita 1100; Milwaukee 5616 and 5624; Porter-Cable 690, 890, 7529, 97529, and 8529; and Ridgid 2930 Combo Kit. **Pattern 2** (four holes): Milwaukee 5625-20; Porter-Cable 7518, 7519, 7538, and 7539; and Triton TRA001 and MOF001. Drill holes and counterbores or countersinks to accommodate the mounting screws supplied with the router. For routers equipped with a built-in lift system, use the router sub-base as a guide for the location and size of the access hole and as a drilling guide.

For routers not covered by **Pattern 1** or **Pattern 2** follow the instructions below.



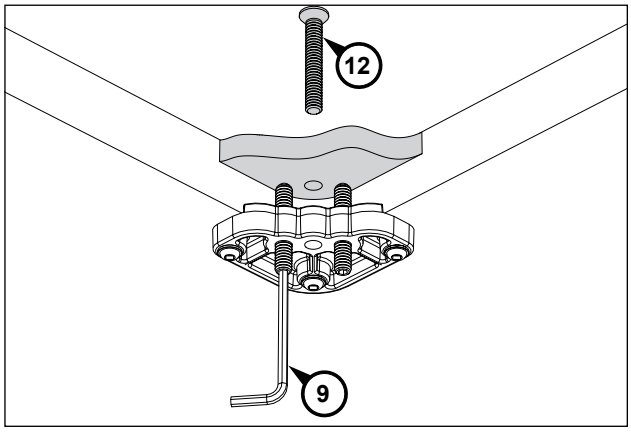
2 Remove the sub-base from your router and select a drill bit that fits the mounting holes. For routers equipped with a built-in lift system, also select a bit that fits the lift-access hole. Apply several small pieces of double-faced tape to the insert plate. Center the sub-base on the plate, using the target pattern as a guide and aligning the index marks. Make sure that none of the sub-base holes interfere with the threaded hole for the start pin. Press the sub-base firmly onto the insert plate.



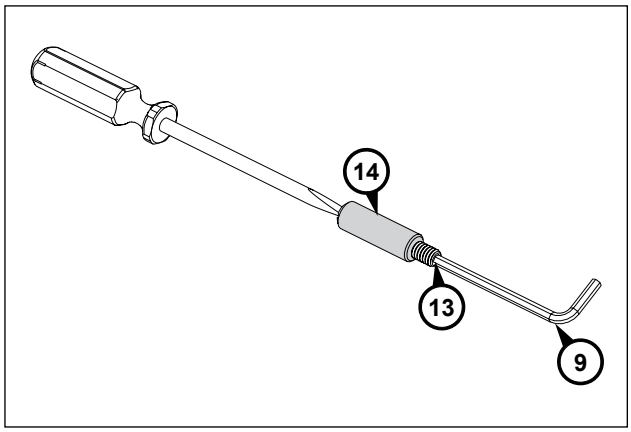
3 Using the holes in the sub-base as guides, drill the holes in the insert plate. For best results, use a drill press. Remove the sub-base from the insert plate. Flip the plate over and countersink the mounting holes.

4 Attach the router base to the insert plate, using the screws that were used to attach the sub-base to the router base. Make certain that the screws are long enough to fully thread into the router base. Depending on the thickness of your router sub-base and the type of screw head, it may be necessary to purchase different screws. For fixed-base routers, install the motor unit in the router base.

Install the insert plate



1 Place the insert plate with attached router in the table-top opening, resting it on the plate leveler set screws. Using the hex wrench **(9)**, adjust the set screws from under the table to align the plate and the table surfaces. Make sure all eight set screws are in equal contact with the insert plate. Fasten the insert plate to the levelers with the machine screws **(12)**. Some adjustment of the machine screws and set screws may be necessary to fine-tune the plate alignment.



2 Thread the set screw **(13)** into the bottom of the starting pin **(14)** and tighten the assembly with a screwdriver and the hex wrench **(9)**. When ready for use, thread the starting pin assembly into the threaded hole in the insert plate.

ATTENTION When using the Kreg Precision Router Table Fence PRS1015 on your router table, store the starting pin in the threaded hole at the rear of the clamp block.

Safety Instructions specific to using the Precision Router Table Top fitted with a 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 pin 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.

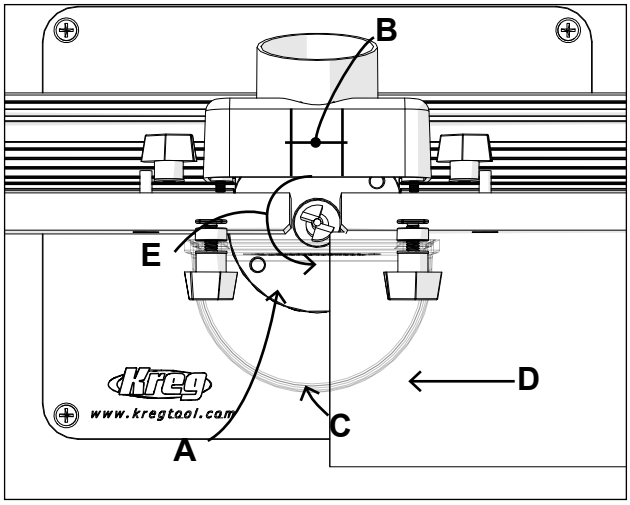
Safety Instructions specific to using the Precision Router Table Top fitted with a fence

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.

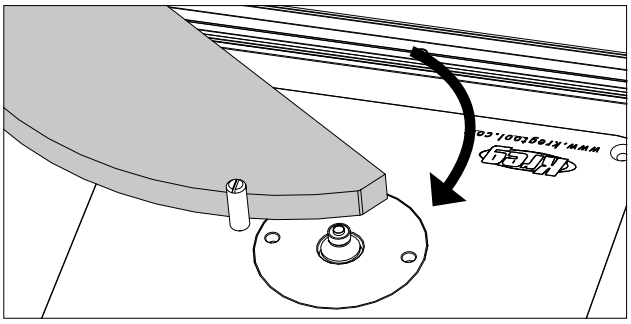
z) **This router table is designed for a specific application. Do not modify and or use it for any other application.** If you have questions relative to the application of the router table, DO NOT use it until you have contacted Kreg Tool Company and have been advised accordingly.

Using your Precision Router Table Top



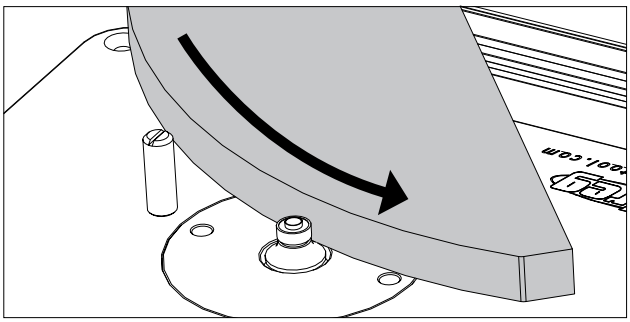
General Routing

(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.

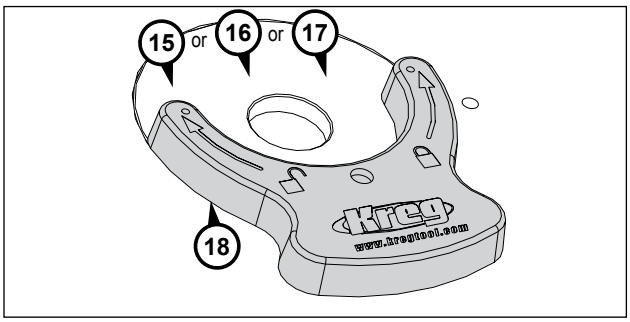


Starting Pin

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.



Reducing Rings

The reducing rings (15, 16, 17) provide flexibility in matching the size of the insert-plate opening to the diameter of the router bit in use. The ring with the rabbeted opening accepts universal-style guide bushings for use in pattern routing. To install a reducing ring, place it in the insert-plate opening and turn it by hand until it drops flush with the plate surface. Rotate the ring counterclockwise with the ring wrench (18) to lock the ring in place.

⚠ WARNING Always use the reducing ring with the smallest possible opening.