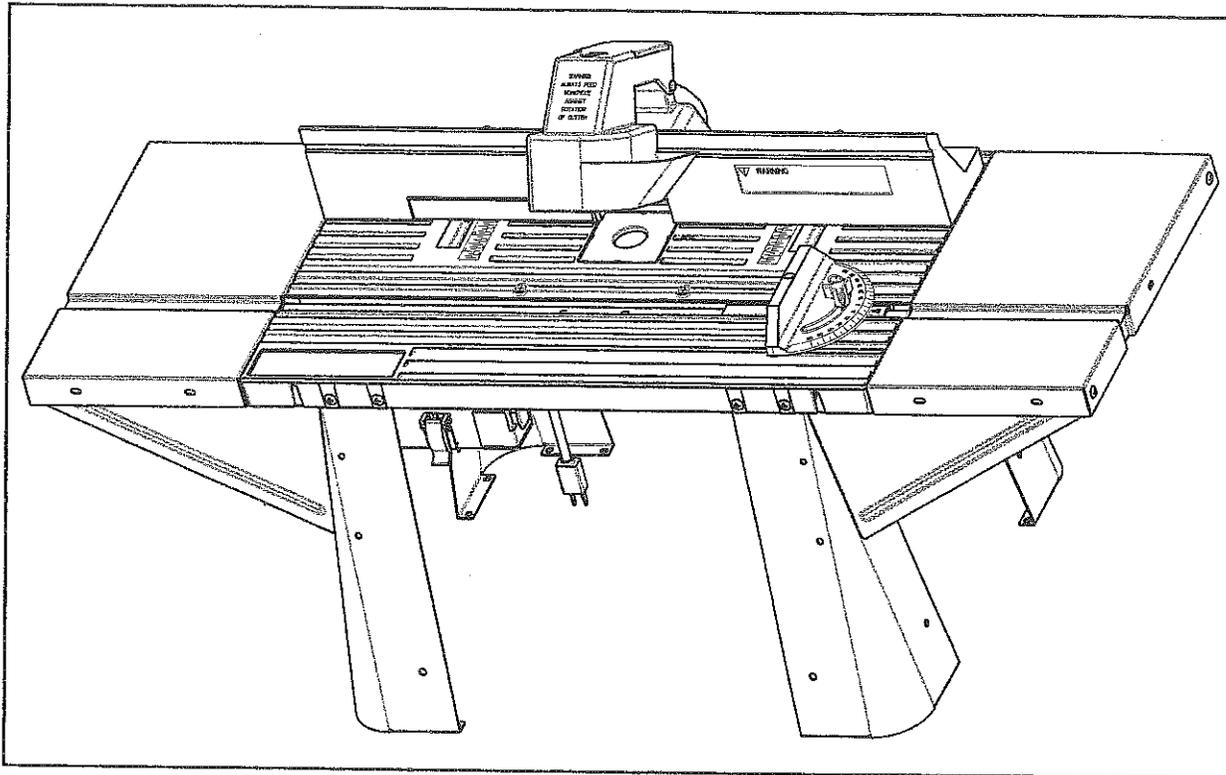


Mastercraft.
MAXIMUM
ROUTER TABLE



MODEL #54-6800-2

WARNING

Before operating product,
read this manual and follow
all its safety and operating
instructions.

SAFETY

ASSEMBLY

INSTALLATION

**SWITCH
INSTRUCTIONS**

OPERATION

PARTS LIST

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SAFETY GUIDELINES – DEFINITIONS		
<p>This manual contains information that is important for you to know and understand. This information relates to protecting YOUR SAFETY and PREVENTING EQUIPMENT PROBLEMS. To help you recognize this information, we use the symbols to the right. Please read the manual and pay attention to these sections.</p>	 URGENT SAFETY INFORMATION - A HAZARD THAT <i>WILL</i> CAUSE SERIOUS INJURY OR LOSS OF LIFE	 INFORMATION FOR PREVENTING DAMAGE TO EQUIPMENT
	 IMPORTANT SAFETY INFORMATION - A HAZARD THAT <i>MIGHT</i> CAUSE SERIOUS INJURY OR LOSS OF LIFE	 INFORMATION THAT YOU SHOULD PAY SPECIAL ATTENTION TO

GENERAL SAFETY INSTRUCTIONS FOR POWER TOOLS

 Failure to obey all safety instructions and warnings may result in injury or death.

- Know your power tool**
Read the owner's manual carefully. Learn its application and limitations as well as the specific potential hazards peculiar to this tool.
- Ground all tools (unless double insulated)**
If tool is equipped with an approved three-conductor cord and a three-prong grounding type plug, it should be plugged into a three hole electrical receptacle. Never remove the third prong. Never connect the green ground wire to a terminal.
- Keep guards in place**
Maintain in working order, and in proper adjustment and alignment.
- Remove adjusting keys and wrenches**
Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning it ON.
- Keep work area clean**
Cluttered areas and benches invite accidents. Floor must not be slippery due to wax or sawdust.
- Avoid dangerous environment**
Do not use power tools in damp or wet locations or expose them to rain. Keep work area well lighted. Provide adequate surrounding work space.
- Keep children away**
All visitors should be kept a **safe** distance from work area.
- Make workshop child-proof**
Use padlocks, master switches, or remove starter keys.

- Do not force tools**
They will do the job better and safer at the rate for which they were designed.
- Use the right tool**
Do not force tool or attachment to do a job it was not designed to perform.
- Wear correct apparel**
Do not wear loose clothing, gloves, neckties or jewellery (rings, wristwatches) that may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Roll long sleeves above the elbow.
- Use safety goggles (head protection)**
Wear safety goggles (must comply with CSA-Z94-3-M88) at all times. Also, use face or dust mask, if cutting operation is dusty, and ear protectors (plugs or muffs) during extended periods of operation.
- Secure work**
Use clamps or a vise to hold work. It's safer than using your hands, and both hands are free to operate tool.
- Do not overreach**
Keep proper footing and balance at all times.
- Maintain tools with care**
Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- Disconnect tools**
Before servicing, when changing accessories such as blades, bits, cutters, etc.

Avoid accidental starting

Make sure switch is in OFF position before plugging in.

Use recommended accessories

Consult the owner's manual for recommended accessories and follow the instructions. The use of improper accessories may cause hazards.

Never stand on tool

Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted. DO NOT store materials above or near the tool making it necessary to stand on the tool to reach them.

Check damaged parts

Before further use of the tool, any guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or any other part that is damaged should be properly repaired or replaced.

Direction of feed

Feed work into a blade or cutter AGAINST the direction of rotation of the blade or cutter only.

Never leave tool running unattended

Turn power OFF. DO NOT leave tool until it comes to a complete stop.

Keep hands away from cutting area**Store idle tools**

When not in use, tools should be stored in dry, high or locked-up place – out of reach of children.

Do not abuse cord

Keep cord away from heat, oil and sharp edges.

Outdoor extension cords

When tool is used outdoors, use only extension cords suitable for use outdoors and so marked.

Never use in an explosive atmosphere

Normal sparking of the motor could ignite fumes, flammable liquids, or combustible items.

Drugs, alcohol, medication

DO NOT operate tool while under the influence of drugs, alcohol, or any medication.

Read and understand this instruction book completely **BEFORE** using this product.

ADDITIONAL WARNINGS FOR ROUTER TABLE

Read and understand table and router manual and accessory warnings. Failure to follow all instructions and warnings may result in serious personal injury.

Fully assemble and tighten all fasteners required for this table and for mounting the router to the plate. Do not use the router table until all assembly and installation steps have been completed. Check the stand and the router to make sure fasteners are still tight before each use. A loose stand is unstable and may shift in use.

Make certain the router is not plugged into a power outlet when installing into the table, making adjustments or changing accessories. Router could accidentally start.

Do not plug router motor power cord into standard wall outlet. It must be plugged into the router table switch. Power tool switches and controls need to be within your reach in emergency situations.

Before operating make sure the entire unit (table with router installed) is placed on and secured to a solid, flat, level surface and will not tip. Use of auxiliary in-feed and out-feed supports is necessary for long or wide workpieces. Long workpieces without adequate support can flip off the table or cause the table to tip over.

Be certain router motor is fully and securely clamped in the router base. Periodically check the base fastener clamping tightness. Router motor can vibrate loose from the base during use and fall from table.

Do not use the router table without the overhead guard or auxiliary bit guard. Remove all dust, chips, and any other foreign particles that can affect its function. Adjust the guard height so that it clears the router bit and the workpiece. The guard will aid in keeping hands from unintended contact with rotating bit.

Never place your fingers near a spinning bit or under the guard when router is plugged in. Never hold the workpiece on the out-feed side of bit. Pressing the workpiece against the out-feed side of the fence may cause material binding and possible kick-back pulling hand back into bit.

Routers are intended for working with wood, wood-like products and plastic or laminates, not for cutting or shaping metals. Be sure workpiece does not contain nails, etc. Cutting nails may cause loss of control.

Do not use bits that have a cutting diameter that exceeds clearance hole in table top insert. Bit could contact insert ring throwing fragments.

Install bit in accordance with instructions in router manual and securely clamp the router bit in the collet chuck before making any cuts to avoid bit becoming loose during operation.

Never use dull or damaged bits. Sharp bits must be handled with care. Damaged bits can snap during use. Dull bits require more force to push the workpiece, possibly causing the bit to break or the material to kickback.

The router table is designed to cut flat, straight and squared materials. Do not cut material that is warped, wobbly or otherwise unstable. If the material is slightly curved but otherwise stable, cut the material with the concave side against the table or fence. Cutting the material with the concave side up or away from table may cause the warped or wobbly material to roll and kick back and cause user to lose control.

Never start the tool when the bit is engaged in the material. The bit cutting edge may grab the material causing loss of control of the workpiece.

Feed the workpiece against the rotation of the bit. The bit rotates counter-clockwise as viewed from the top of table. Feeding the work in the wrong direction will cause the workpiece to "climb" up on the bit pulling the workpiece and possibly your hands into the rotating bit.

Use push sticks, vertical and horizontally-mounted feather boards (spring sticks) and other jigs to hold down the workpiece. Push sticks, featherboards and jigs eliminate the need to hold the workpiece near the spinning bit.

Do not use the table as workbench or worksurface. Using it for purposes other than routing may cause damage and make it unsafe to use in routing.

Never stand on the table or use as ladder or scaffolding. Table could tip or the cutting tool could be accidentally contacted.

Use only approved replacement parts. Any others may create a hazard.

INTRODUCTION

Your **Mastercraft® Maximum™** Router Table comes with the following:

- Multi-function guide fence with V-groove alignment for precise setup. For straight cuts, crosscuts, and ripping cuts.
- Scales provided for fast and accurate fence adjustment for making the following items:
 - tenons
 - sliding dovetail joints
 - tongue and groove joints
 - edge and end grain cuts
 - face cuts
- The unique fence also allows you to perform these additional routing operations:
 - veining
 - fluting
 - making crown moulding
 - making cuts up to 2 1/2" from the edge of the workpiece toward the centre of the workpiece

- A jointer pocket fence. Pull-out fence is adjustable to 1/2".
- A 2 1/2" dust port for use with a wet/dry vacuum.
- Heavy-duty steel extensions provide extra stability for extra-long workpieces.
- A switch box, with overload protection, to control turning the router ON and OFF. An additional accessory, such as a wet/dry vac, can also be plugged into the second receptacle.
- Two scales are provided to aid in aligning and adjusting workpieces:
 - A right side scale and a left side scale.
 - Each scale has both metric and inch markings.

UNPACKING AND CHECKING CONTENTS

Refer to Parts List on page 29.

- **WARNING** If **ANY** of the parts are missing, **DO NOT** attempt to assemble, install, or use your router table until the missing parts have been found or replaced and your router table has been properly and correctly assembled per this manual.
- Contact the place of purchase for missing or replacement parts.

- In order to simplify handling and to minimize any damage that may occur during shipping, your router table comes unassembled.
- Separate all parts from the packaging materials and check each part against the illustrations and the parts list at the end of this manual, to make sure that all parts have been included. Do this before discarding any of the packaging material.

ASSEMBLY

TOOLS REQUIRED

- Slotted and Phillips® screwdriver.
- Small or medium-sized adjustable wrench (or a set of nutdrivers, open-end wrenches, or box wrenches).
- Electric drill.
- One or more of the following drill bit sizes: 1/8", 3/16", 1/4", 9/32", or 11/32". (Refer to CHART 1 in the Section **MOUNTING THE ROUTER TO ADAPTOR PLATE**).
- 3/4" diameter x 81° steel countersinking tool.

FASTENERS REQUIRED

One or more of the following sets of fasteners will be required: (Refer to CHART 1 in the Section **MOUNTING ROUTER TO ADAPTOR PLATE**).

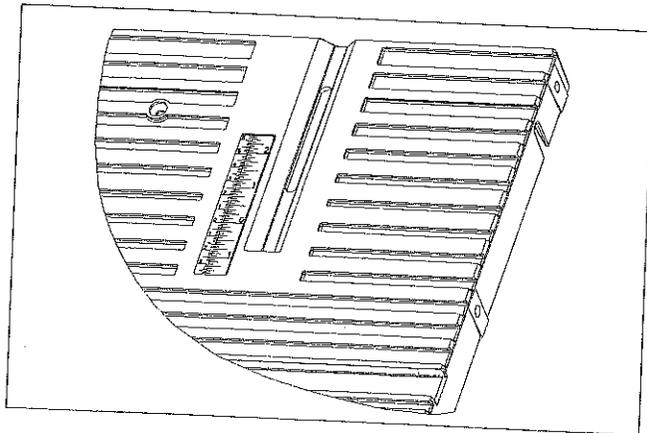
- Two 5/16-18 x 5/8" long flat countersunk head machine screws.
- Three 5/16-18 x 5/8" long flat countersunk head machine screws.
- Four 5/16-18 x 7/8" long flat countersunk head machine screws.
- Three #10-24 x 3/4" long flat countersunk head machine screws.
- Three #10-32 x 1/2" long flat countersunk head machine screws.
- Three 1/4-20 x 1-1/4" long flat countersunk head machine screws and three 1/4-20 hex machine screw nuts.
- Three #8-32 x 3/4" long flat countersunk head machine screws and three #8-32 hex machine screw nuts.
- Three #8-32 x 3/8" long flat countersunk head machine screws.
- Five M6 x 1 x 15mm long metric flat countersunk head machine screws.
- Four M4 x .7 x 10mm long metric flat countersunk head machine screws.

Other – depends upon the router, screws must be of the flat countersunk head type.

ASSEMBLE SCALES TO THE ROUTER TABLE

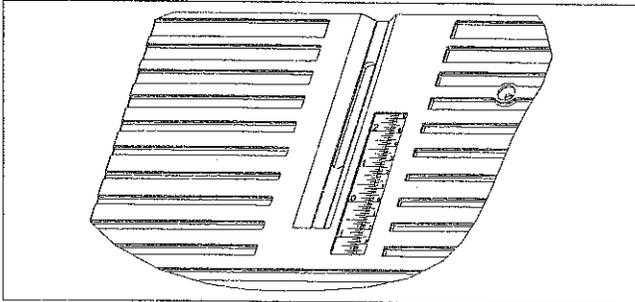
1. Take the right hand scale and remove the protective backing from the back of the scale to expose the adhesive. Be careful not to bend the scale when doing this.
2. Line up the bottom of the scale with the front of the rectangular recess on the right side of the router table as shown in Figure 1.
3. While holding the scale in this position, firmly press it down into the recess.

FIGURE 1



4. Take the left hand scale and remove the protective backing from the back of the scale to expose the adhesive. Be careful not to bend the scale when doing this.
5. Line up the bottom of the scale with the front of the rectangular recess on the left side of the router table as shown in Figure 2.
6. While holding the scale in this position, firmly press it down into the recess.

FIGURE 2



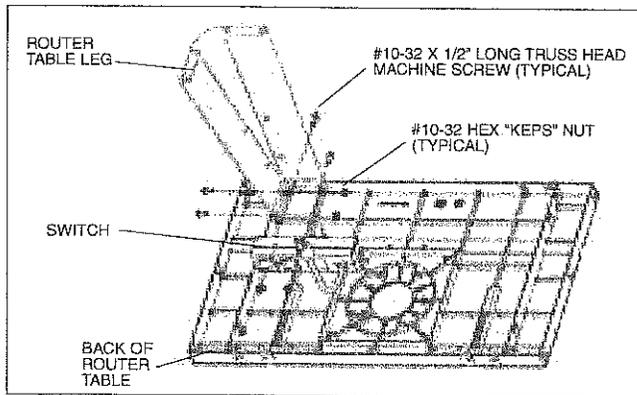
NOTE

Certain figures showing the underneath side of the router table may not agree with the actual appearance of your table. THIS IS NOT A CAUSE FOR CONCERN.

ROUTER TABLE

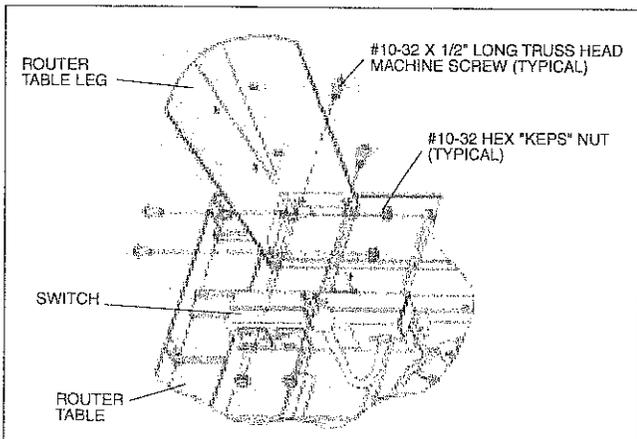
1. Lay the router table, top down, on a flat surface so that the orientation of the table is as shown in Figure 3. (The BACK of the table is facing toward you.)

FIGURE 3



2. Assemble a table leg to the table top using four #10-32 x 1/2" long truss head machine screws and four #10-32 hex "KEPS" nuts, as shown in Figure 3 and the Figure 3, Assembly Detail. (Leg is shown in the UPPER LEFT corner of router table.) DO NOT TIGHTEN at this time.

FIGURE 3, ASSEMBLY DETAIL



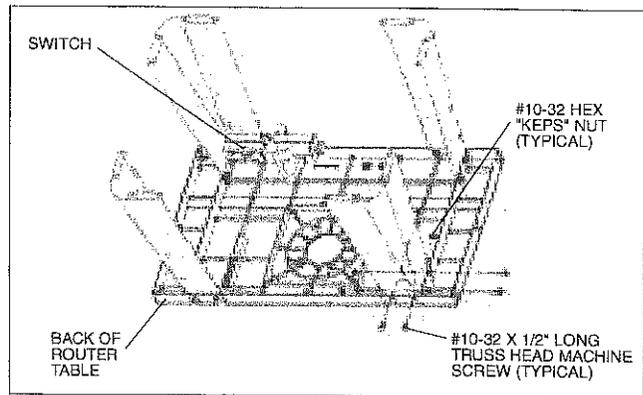
3. Position the switch against the leg, as shown in Figure 3, Assembly Detail.
4. Secure the switch to the leg and tabletop using two #10-32 x 1/2" long truss head machine screws, and two #10-32 hex "KEPS" nuts.

NOTE

There are two hex shaped recesses in the switch case into which the hex "KEPS" nuts are placed, with the toothed washer side of the nuts facing out of the recesses.

5. SECURELY TIGHTEN all fasteners.
6. Assemble the remaining three table legs to the table top using four #10-32 x 1/2" long truss head machine screws and four #10-32 hex "KEPS" nuts for each leg, as shown in Figure 4. (The BACK of the table is facing toward you.)
7. SECURELY TIGHTEN all fasteners.

FIGURE 4



EXTENSIONS TO THE ROUTER TABLE

1. Position the router table so that the orientation is as shown in Figure 5 and Figure 5, Assembly Detail. (The FRONT of the table is facing toward you.)
2. Position one of the extensions alongside the right side of the tabletop so that the mitre slot in the extension lines up with the mitre slot in table top.
3. Assemble a #10-32 x 1/2" long truss head machine screw and a #10-32 hex "KEPS" nut at each of the holes in the extension, as shown in Figure 5 and Figure 5, Assembly Detail. DO NOT tighten fasteners at this time.

NOTE

The extension braces are identified with either an "R" for the RIGHT SIDE extension brace or an "L" for the LEFT SIDE extension brace. The "R" or the "L" will be found on one of the bent down or bent up ends of the extension braces.
4. Assemble one of the RIGHT SIDE extension braces to the table leg and the extension using #10-32 x 1/2" long truss head machine screws and #10-32 hex "KEPS" nuts, as shown in Figure 5 and Figure 5, Assembly Detail.

FIGURE 5

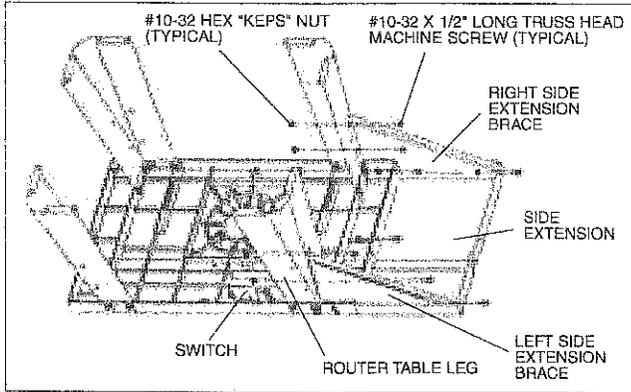
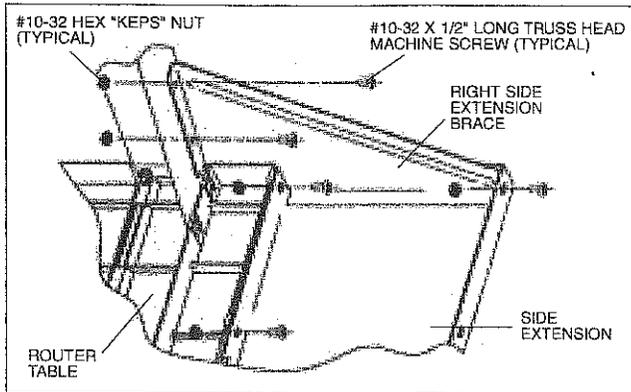
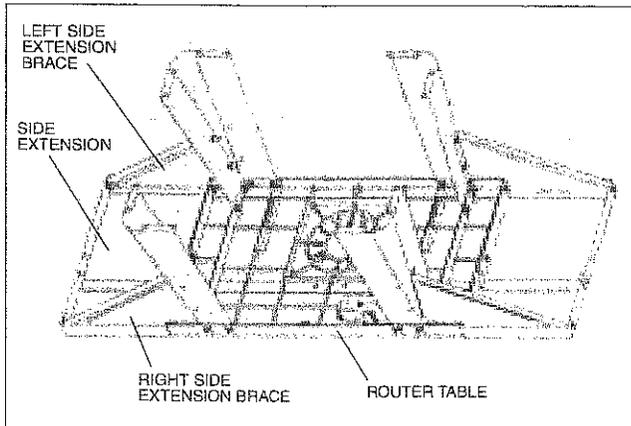


FIGURE 5, ASSEMBLY DETAIL



5. Assemble one of the LEFT SIDE extension braces to the table leg and the extension using #10-32 x 1/2" long truss head machine screws and #10-32 hex "KEPS" nuts, as shown in Figure 5.
6. While pressing down on the extension, tighten all of the fasteners using the following sequence:
 - a. Those holding the extension to the tabletop.
 - b. Those holding the extension braces to the legs.
 - c. Those holding the extension braces to extension.
7. Position the other extension alongside the left side of the table top so that the mitre slot in the extension lines up with the mitre slot in tabletop, as shown in Figure 6.

FIGURE 6



8. Assemble a #10-32 x 1/2" long truss head machine screw and #10-32 hex "KEPS" nut at each of the holes in the extension, as shown in Figure 5. **DO NOT TIGHTEN** fasteners at this time.
9. Assemble the other LEFT SIDE extension brace to the table leg and the extension using #10-32 x 1/2" long truss head machine screws and #10-32 hex "KEPS" nuts, as shown in Figure 5.
10. Assemble one of the RIGHT SIDE extension braces to the table leg and the extension using #10-32 x 1/2" long truss head machine screws and #10-32 hex "KEPS" nuts, as shown in the Figure 5.
11. While pressing down on the extension, tighten all of the fasteners using the following sequence:
 - a. Those holding the extension to the tabletop.
 - b. Those holding the extension braces to the legs.
 - c. Those holding the extension braces to the extension.
12. Set the router table right-side-up on the floor and check that the extensions are parallel and even with, or slightly below, the top of the table.

WARNING

In no case are the extensions to be higher than or above the surface of the tabletop. They may interfere with the workpiece during routing, and could cause a condition that can result in possible serious injury.

13. If the extensions are higher and/or not parallel, then loosen the fasteners holding the extensions to the braces and the tabletop, and reposition the extensions so that they are parallel.
14. **SECURELY TIGHTEN** all fasteners again.
15. To double check, slide a flat piece of wood along top of the table in all directions. Make sure that the edge of the wood moves freely without contacting the edges of the extensions.

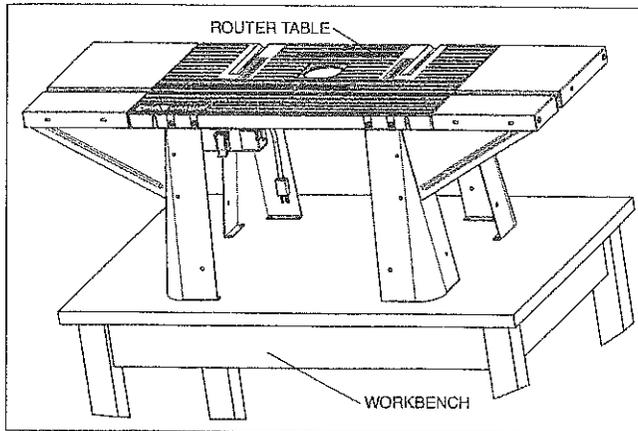
MOUNTING ROUTER TABLE TO A WORK SURFACE OR WORKBENCH

WARNING

The router table must always be **FIRMLY** and **SECURELY** mounted to a work surface before use. Failure to do so could cause the router table to tip over or slide, resulting in property damage and/or serious personal injury.

1. Set the router table on a workbench or other stable and sturdy surface, so that the FRONT of the router table faces toward you, as shown in Figure 7. It may be necessary to loosen the fasteners holding the legs to the table in order to make the table legs lie flat on the workbench. When the legs are lying flat

FIGURE 7

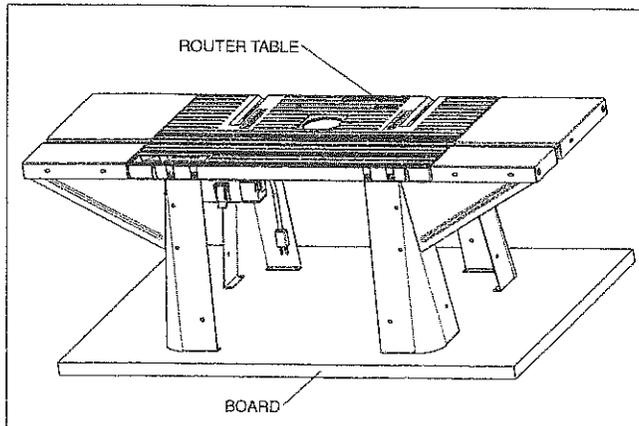


- on the workbench, **SECURELY TIGHTEN** all fasteners holding the legs to the router table.
2. While holding the router table in place, spot the location of the four mounting holes in each of the legs onto the workbench. (Total number of holes is sixteen.)
 3. Remove the router table from the workbench and set it aside.
 4. Drill a 1/8" diameter hole at each of the spotted locations.
 5. Position the router table on the workbench so that the holes in the legs line up with the drilled holes in the workbench.
 6. Secure the router table to the workbench using sixteen #10-16 x 3/4" long round head wood screws (not provided). Applying a little soap to the screw threads will make it easier to thread the screws into the holes.
 7. **TIGHTEN** the screws **SECURELY**.

ALTERNATE METHOD

1. Cut a board 18-1/4" wide by 23" long from a piece of 3/4" thick wood.
2. Place the router table on the board so the spacing from the edge of the board to the router table legs is equal on all four sides of the board, as shown in Figure 8. It may be necessary to loosen the fasteners

FIGURE 8



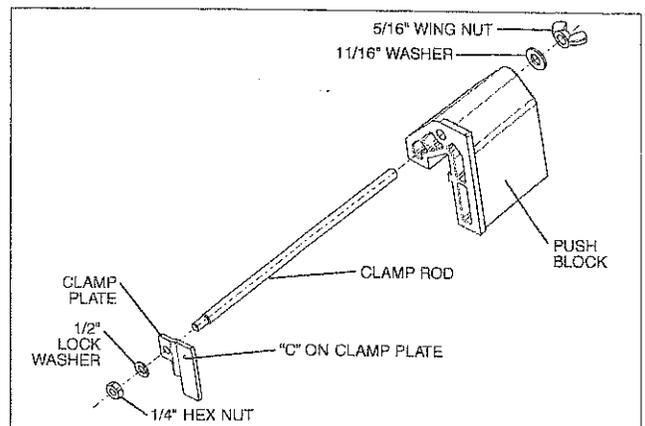
holding the legs to the table in order to make the table legs lie flat on the board. When the legs are lying flat on the board, **SECURELY TIGHTEN** all fasteners holding the legs to the router table.

3. While holding the router table in place, spot the location of the four mounting holes in each of the legs onto the board. (Total number of holes is sixteen.)
4. Remove the router table from the board and set it aside.
5. Drill a 1/8" diameter hole at each of the spotted locations.
6. Position the router table on the board so that the holes in the legs line up with the drilled holes in the board.
7. Secure the router table to the board using sixteen #10-16 x 3/4" long round head wood screws (not provided). Applying a little soap to the screw threads will make it easier to thread the screws into the holes.
8. **TIGHTEN** the screws **SECURELY**.
9. Place the router table on a workbench or other stable and sturdy surface
10. Firmly secure the board(s) to a workbench or other stable and sturdy surface with screws or other suitable means.

PUSH BLOCK

1. Thread the small end of the clamp rod into the threaded hole of the clamp plate, until the rod bottoms out securely against the clamp plate, as shown in Figure 9.
2. Make sure that the clamp plate is oriented so that the "C" on the clamp plate **FACES OUTWARD** as shown in the figure.
3. Assemble the 1/2" lock washer and 1/4" hex nut to the clamp rod.
4. Securely **TIGHTEN** the nut on the clamp rod.
5. Insert the other end of the clamp rod through the hole in the push block. Make sure the orientation of the push block is as shown in Figure 9.

FIGURE 9



- Assemble the 11/16" washer and the 5/16" wing nut to the clamp rod.
- It is not necessary to tighten the wing nut. The clamp rod should rotate freely in the push block.

WARNING

The vibrations from operating the router can, from time to time, cause the hex nut and the clamp plate to become loose on the clamp rod. **PERIODICALLY CHECK THESE FASTENERS AND ALL FASTENERS** to ensure that they are tight and secure.

FENCE

- Assemble the adjustable jointing fence to the router table fence using a 1/4-20 x 1" long hex cap screw, a 9/32" I.D. x 3/4" O.D. x 1/16" thick washer, and the adjustable fence clamping knob, as shown in Figures 10 and 11.

The V-guide on the adjustable jointing fence will mate with and slide on the V-guide in the router table fence.

FIGURE 10

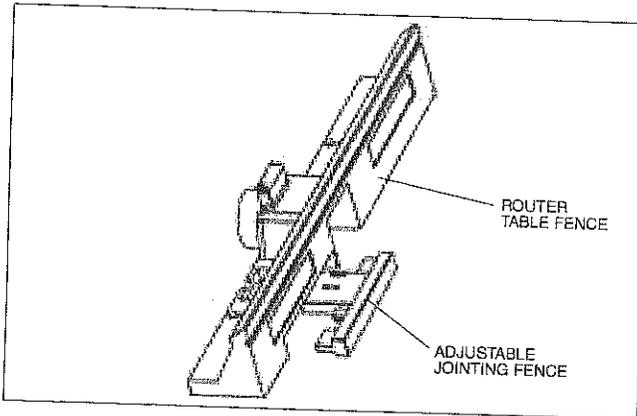
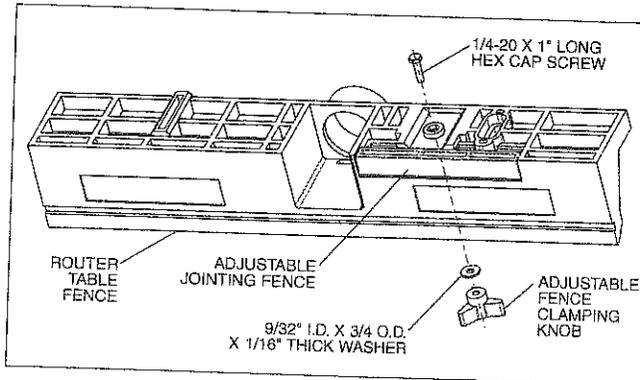


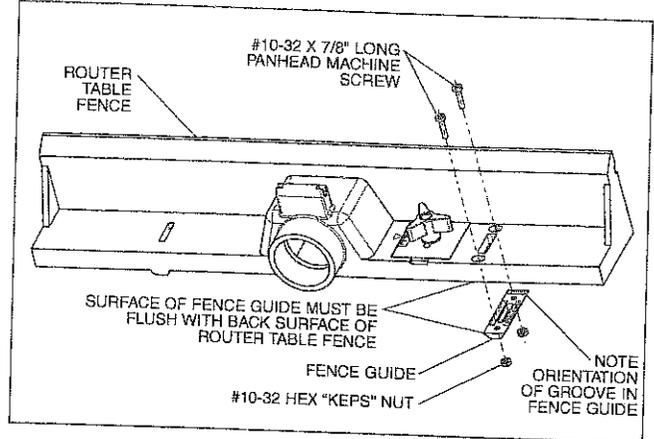
FIGURE 11



- Push the adjustable jointing fence into the router table fence as far as it will go and tighten the clamping knob.
- Assemble the fence guide to the bottom of the fence using #10-32 x 7/8" long panhead machine screws and #10-32 hex "KEPS" nuts, as shown in

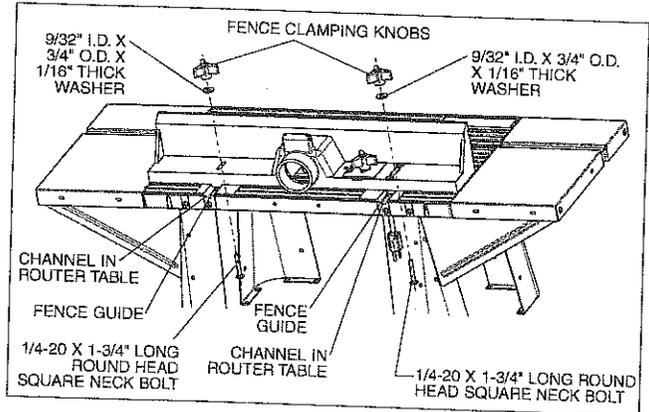
Figure 12. (The nut portion of the hex "KEPS" nut fits into the recess, with the washer portion out of the recess.) **DO NOT TIGHTEN** the fasteners at this time.

FIGURE 12



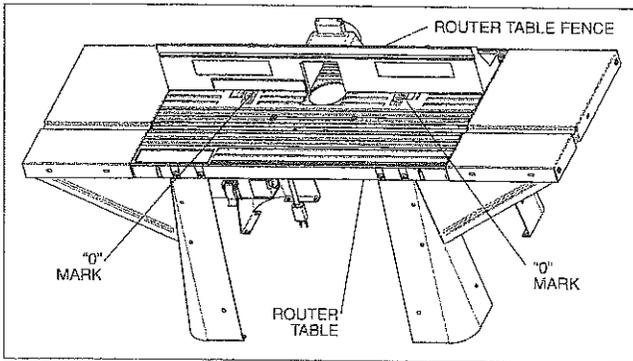
- To align the fence, position the fence on the router table so that the fence guide fits in the channels in the top of the table, as shown in Figure 13A.
- Insert a 1/4-20 x 1-3/4" long round head square neck bolt, from the underside of the table, through the slot in the fence, as shown in Figure 13A.
- Place a 9/32" I.D. x 3/4" O.D. x 1/16" thick washer over the bolt, as shown in Figure 13A.

FIGURE 13A



- Lightly thread a fence clamping knob onto the bolt. **DO NOT TIGHTEN** clamping knob at this time – fence must be able to **MOVE FREELY** from front to back on the table.
- Repeat Steps 5 through 7 for the other side of the fence.
- Make sure that the adjustable jointing fence is inside the router table fence as far as it will go and that the clamping knob has been securely tightened.
- Line up the front of the fence with the "0" marks on the top of the router table, as shown in Figure 13B.
- TIGHTEN** the fence clamping knobs **MAKING SURE THAT THE FENCE DOES NOT MOVE.**
- TIGHTEN** the two #10-32 x 7/8" long panhead

FIGURE 13B



screws to secure the fence guide to the fence, as shown in Figure 12.

13. Remove the fence from the table by unthreading the fence clamping knobs from the 1/4-20 x 1-3/4" long round head square neck bolts while holding the bolts in place from the underside of the table.

14. Remove the 9/32" I.D. x 3/4" O.D. x 1/16" thick washers from the bolts and then remove the bolts.

15. Store fasteners in a convenient place so they can be used at a later time.

16. Assemble the overhead guard to the router table fence using the clevis pin and the 1/4" pushnut, as shown in Figure 14:

a. Position the overhead guard on the fence so the holes in the overhead guard line up with the through-hole in the router table fence.

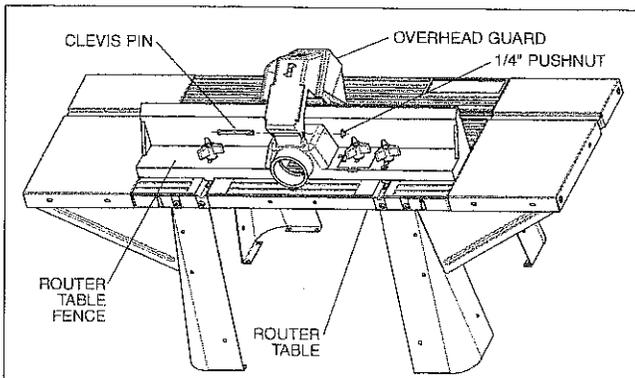
MAKE SURE THE ORIENTATION OF THE OVERHEAD GUARD IS AS SHOWN IN FIGURE 14.

b. Insert the clevis pin through the aligning holes.

c. Press the pushnut onto the end of the clevis pin.

d. Move the overhead guard up and down a few times to ensure that the overhead guard moves freely.

FIGURE 14



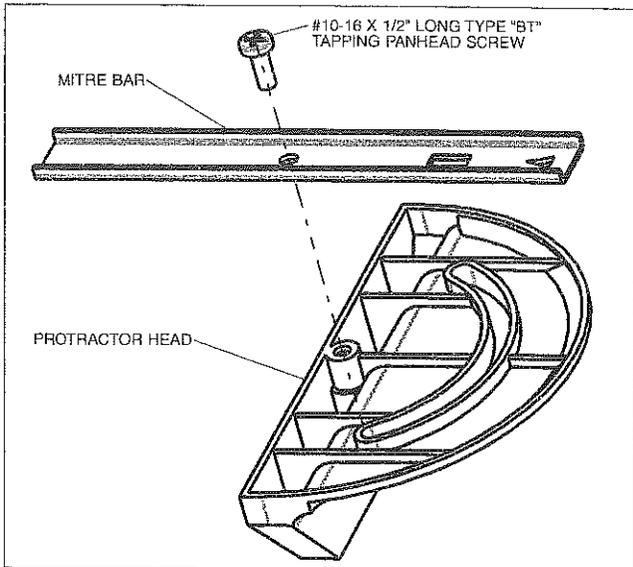
WARNING

Once the overhead guard has been assembled to the fence, **DO NOT** remove it for any reason. Its removal can result in an unsafe operating condition that can result in possible bodily injury.

MITRE GAUGE

1. Assemble the protractor head to the mitre bar, as shown in Figure 15, using a #10-16 x 1/2" long Type "BT" tapping panhead screw.

FIGURE 15



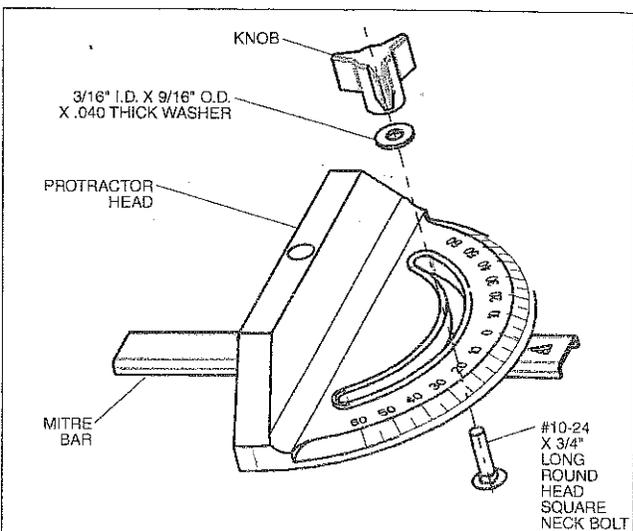
2. Tighten the truss head screw into the protractor head so that the screw head touches the mitre bar but still provides a resistance when the protractor head is rotated.

3. The screw will resist turning when being threaded into the hole. The screw is cutting and forming its own thread in the protractor head.

4. Assemble the knob, the 3/16" I.D. x 9/16" O.D. x .040" thick washer and the #10-24 x 7/8" long round head square neck bolt to the mitre bar and protractor head, as shown in Figure 16.

5. **TIGHTEN** the knob **SECURELY**.

FIGURE 16



INSTALLATION

MOUNTING ROUTER TO ADAPTOR PLATE

Remove the fence assembly from the router table before proceeding any further, if it is currently installed on there.

Determination of the correct template to use:

Six templates have been provided with this manual. They are used to help locate appropriate places to drill and countersink holes in the adaptor plate that will match your brand and model of router.

After drilling and countersinking the correct holes, screws (and also nuts on some router models) will be used to attach the router to the adaptor plate. The adaptor plate/router assembly will then be assembled to the underside of the router table.

In order to determine which template to be used to mark where to drill and countersink the holes in the adaptor plate, you will need to look at CHART 1, below.

1. Find your make and model of router in the chart. The first column lists the makes and model numbers

for some popular models. If your make and model is not shown, use the last row, marked **Other**.

2. After finding your router's row on the chart, look under the column titled **Template Type**. This will direct you to use the correct template for your router. The templates are printed at the back of this Manual.

3. The third column in your router's row, titled **Pattern No.**, will show you which pattern to use on the template.

4. The fourth column in your router's row, titled **Number of Holes**, will tell you how many holes you will need to drill and countersink in the adaptor plate.

5. The fifth column, titled **Hole Size Dia.**, will tell you which size drill bit is to be used in drilling the holes in the adaptor plate.

6. The sixth column, titled **Fasteners**, will tell you the size and quantity of fasteners required to assemble the router to the adaptor plate.

7. The seventh column, titled **Assembly Type**, will tell you whether or not to remove the router's base plate before assembling the adaptor plate to the router.

CHART 1

ROUTER MODEL #	TEMPLATE TYPE	PATTERN No.	NUMBER OF HOLES	HOLE SIZE DIA.	** FASTENERS	ASSEMBLY TYPE
Mastercraft	F	12	4	7/32"	Three #10-32 x 3/8" long flat countersunk head screws	a
Porter Cable #7539	A	1	4	11/32"	Four 5/16"-18 x 7/8" long flat countersunk head screws ***	a
Porter Cable #690 & 6931 Router Base	A	2	3	7/32"	Three #10-24 x 3/4" long flat countersunk head screws	a
Skil #1823	A	3	3	7/32"	Three #10-32 x 1/2" long flat countersunk head screws	b
Skil #1835	A	3	3	7/32"	Three #10-32 x 1/2" long flat countersunk head screws	b
Skil #1845-02	A	3	3	7/32"	Three #10-32 x 1/2" long flat countersunk head screws	b
Sears #17504	A	3	3	7/32"	Three #10-32 x 3/8" long flat countersunk head screws	a
Sears #17505	A	3	3	7/32"	Three #10-32 x 3/8" long flat countersunk head screws	a
Sears #17506	A	3	3	7/32"	Three #10-32 x 3/8" long flat countersunk head screws	a
Bosch #1613 EVS	C	4	3	9/32"	Three #1/4-20 x 1 1/4" long flat countersunk head screws, Three 1/4-20 hex nuts, and three 1/4" steel washers	c
Dewalt #DW621	C	5	2	1/4"	Two M6x1 x 15mm long metric flat countersunk head screws	a
Ryobi #R175	C	6	2	11/32"	Two 5/16-18 x 5/8" long flat countersunk head screws ***	b
Ryobi #RE175	C	6	2	11/32"	Two 5/16-18 x 5/8" long flat countersunk head screws ***	b
Ryobi #R160K	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Ryobi #R160U	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Ryobi #R165	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Ryobi #R180	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Sears #27500	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Sears #27510	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Sears #27511	D	7	3	11/32"	Three 5/16-18 x 5/8" long flat countersunk head screws ***	a
Black and Decker #7604	B	8	3	3/16"	Three #8-32 x 3/4" long flat countersunk head screws and Three #8-32 hex nuts	c
Dewalt #DW610	B	9	3	3/16"	Three #8-32 x 3/8" long flat countersunk head screws	a
Makita #3612C	B	10	4	3/16"	Four M4x.7 x 10 mm long flat countersunk head screws	a
Dewalt #DW625	D	11	3	1/4"	Three M6x1 x 15 mm long flat countersunk head screws	a
Other	E	*	*	*	* If screws with 5/16" threads are required, spacers must be used. If screws with 1/4" threads are required, 1/4" steel washers must be used	a, b, c or d

Assembly Type:
a) Base plate removed; screws only
b) Base plate not removed; screws only
c) Base plate not removed; screws and nuts
d) Base plate removed; screws and nuts

* Determined by user per instruction manual
** Fasteners are not supplied. Obtain these from your local hardware/do-it-yourself retail store.
*** Spacers required. Supplied with this product.

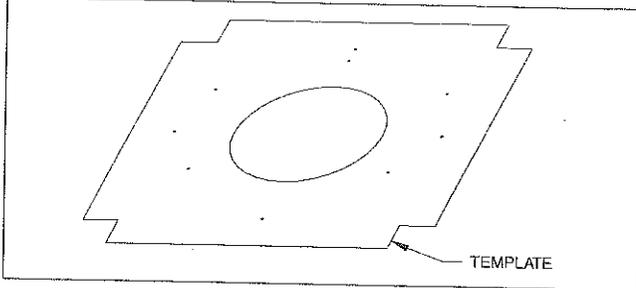
PREPARING ADAPTOR PLATES REQUIRING TEMPLATE TYPES A, B, C, D, AND F

NOTE

THE TEMPLATES CAN BE FOUND AT THE BACK OF THIS MANUAL.

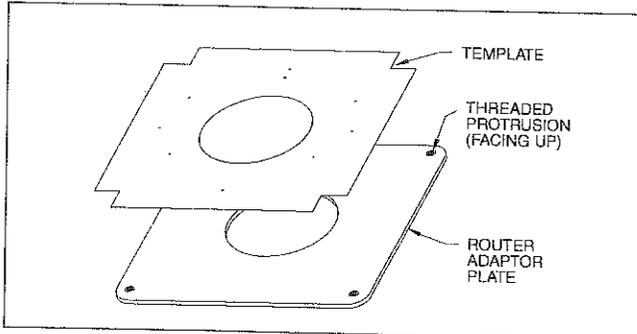
1. Cut out your template along the outer edges so that it looks like the template shown in Figure 17.
OPTIONAL: Cut out the inside of the template along the innermost circle.

FIGURE 17



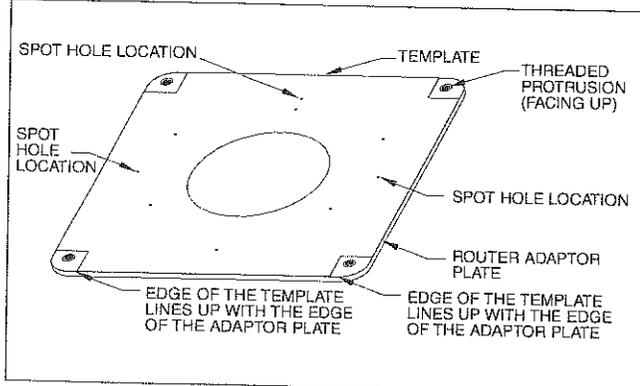
2. Place the template on the same side of the adaptor plate as the threaded protrusions are located, as shown in Figure 18. (The word UP is stamped on the opposite side of the adaptor plate).

FIGURE 18



3. Position the template on the adaptor plate so that the edges of the template line up with the edges of the adaptor plate, as shown in Figure 19. The hole in the centre of the template should also line up with the hole in the adaptor plate.

FIGURE 19

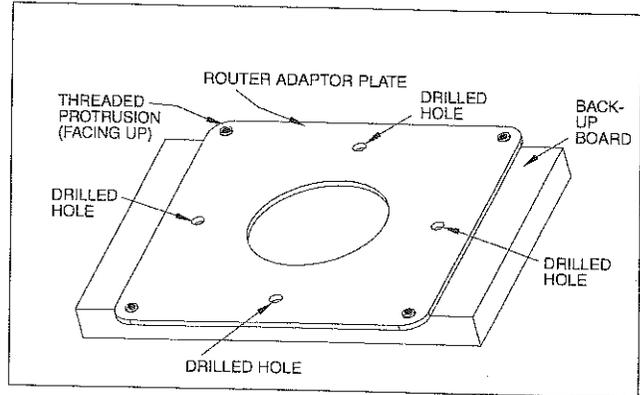


NOTE

USE CARE WHEN DOING THIS – THE ROUTING ACCURACY WILL BE AFFECTED WHEN USING THE ROUTER TABLE IF THIS IS NOT DONE ACCURATELY.

4. Tape the template to the adaptor plate using clear or masking tape.
5. Choose the appropriate **Pattern Number**, as shown on the chart.
6. Spot the location of the hole pattern on the adaptor plate using a steel centre punch.
7. Remove the template from the adaptor plate and store in a convenient location for possible future use.
8. Select a drill bit with a diameter that is the same size as listed in the **Hole Size** column on the chart.
9. Drill holes through the adaptor plate at the locations previously spotted. The use of a wooden backup board is recommended to minimize drill breakout.
10. Remove the backup board from the adaptor plate and **place on the other side of the adaptor**; that is, the side of the adaptor plate on which there are no threaded protrusions. Refer to Figure 20.

FIGURE 20



11. Using a 3/4" diameter steel countersink, countersink the previously drilled hole to a depth so that the **top of the flat countersunk screw, as determined from CHART 1, is flush with the top of the adaptor plate**, as shown in Figure 21. The wooden backup board should still be on the adaptor plate as shown.

FIGURE 21

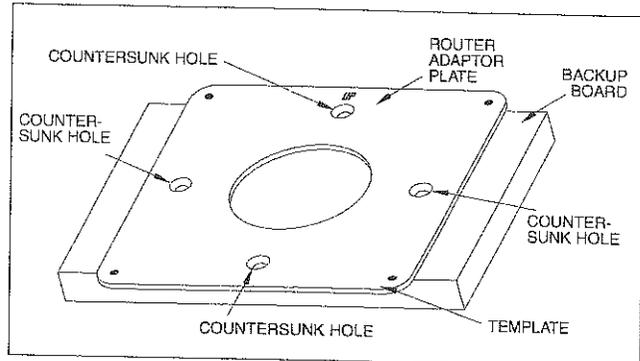
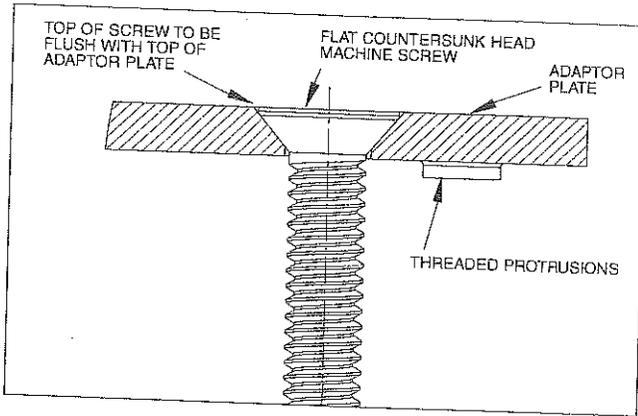


FIGURE 21A



IT IS EXTREMELY IMPORTANT THAT THE HEAD OF THE SCREW BE FLUSH WITH, OR BE SLIGHTLY BELOW, THE TOP OF THE ADAPTOR PLATE. OTHERWISE, THE HEAD OF THE SCREW CAN COME IN CONTACT WITH THE UNDERNEATH SIDE OF THE ROUTER TABLE WHEN IT IS ASSEMBLED TO THE ROUTER TABLE AS DESCRIBED IN THE SUBSEQUENT SECTION, **ADAPTOR PLATE TO THE ROUTER TABLE.** REFER TO FIGURE 21A.

THIS WILL RESULT IN THE ADAPTOR PLATE NOT BEING SEATED PROPERLY AGAINST THE UNDERNEATH SIDE OF THE ROUTER TABLE.

COUNTERSINKING TOO DEEPLY WILL CAUSE THE SCREW TO BOTTOM OUT AGAINST THE ROUTER INSTEAD OF AGAINST THE ADAPTOR PLATE – THE ROUTER WILL BE LOOSE ON THE ADAPTOR PLATE.

WARNING THIS CAN RESULT IN AN UNSATISFACTORY OPERATING CONDITION AND POSSIBLY IN AN UNSAFE OPERATING CONDITION WHICH CAN RESULT IN POSSIBLE BODILY INJURY.

PREPARING ADAPTOR PLATES REQUIRING TEMPLATE TYPE E

NOTE THE TEMPLATES CAN BE FOUND AT THE BACK OF THIS MANUAL.

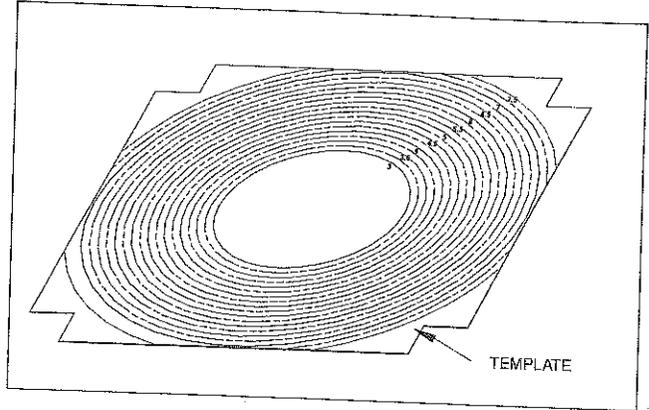
- The template has concentric circles of various sizes printed on it. These are aids in aligning the router to the adaptor plate.
- The bold circles are in inch size circles, with the sizes identified in large bold type.
- The light circles are in half-inch size circles, with the sizes identified in small regular type.

- The broken light circles, located between the inch and the half-inch circles, are quarter-inch circles, but are not otherwise identified with text.
- The smallest circle is also an alignment aid. Use it to align the template to the adaptor plate.

1. Cut your template along the outer edges so that it looks like the template shown in Figure 22.

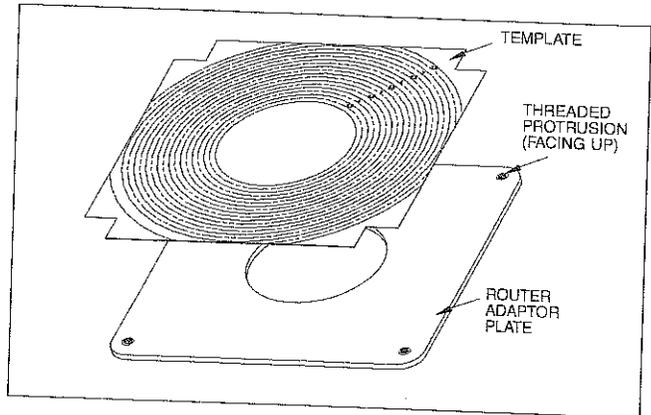
OPTIONAL: Cut out the inside of the template along the innermost circle.

FIGURE 22



2. Place the template on the same side of the adaptor plate as the threaded protrusions are located, as shown in Figure 23. (The word UP is stamped on the opposite side of the adaptor plate).

FIGURE 23

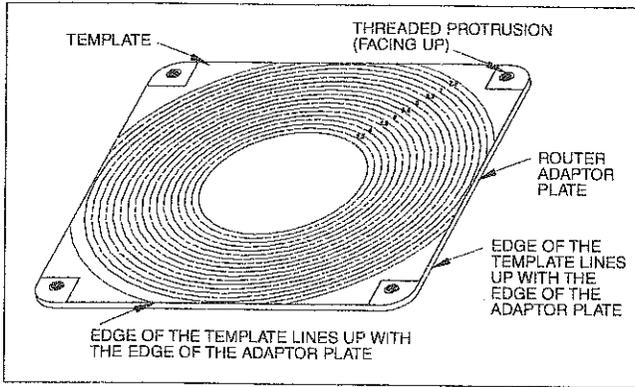


3. Position the template on the adaptor plate so that the edges of the template line up with the edges of the adaptor plate, as shown in Figure 24. The hole in the centre of the template should also line up with the hole in the adaptor plate.

NOTE USE CARE WHEN DOING THIS – THE ROUTING ACCURACY WILL BE AFFECTED WHEN USING THE ROUTER TABLE IF THIS IS NOT DONE ACCURATELY.

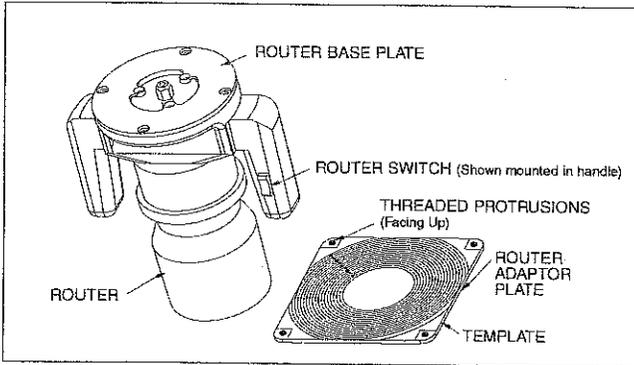
4. Tape the template to the adaptor plate using clear or masking tape.

FIGURE 24



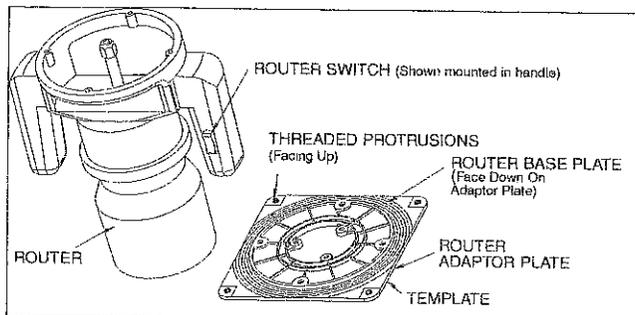
5. Place the adaptor plate on a flat surface with the template facing upwards, as shown in Figure 25.
6. Place the router upside down next to the adaptor plate, as shown in Figure 25.
7. Orient the router so that the switch will be facing one of the edges of the adaptor plate. This will make it easier to turn the router ON and OFF in those applications where the switch box assembly is not used.
8. Remove the base plate from the router and set aside the screws.

FIGURE 25



9. Flip the base plate over and place it on the template so that it is face down on the adaptor plate. Use care so that the base plate does not rotate when doing this.
10. Position the base plate on the template so that it is concentric with one of the circles on the template, as shown in Figure 26.

FIGURE 26

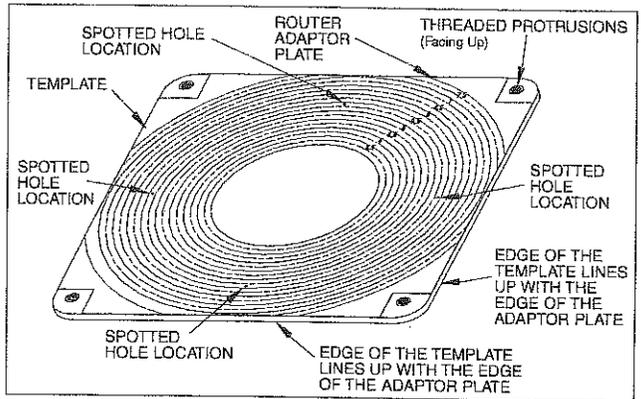


11. Mark the location of the base plate mounting holes on the template using a pencil or felt tipped marker.

(The base plate is being used as a template for locating the router mounting holes onto the adaptor plate. If the base plate is not removable, use the router to mark the location of the mounting holes).

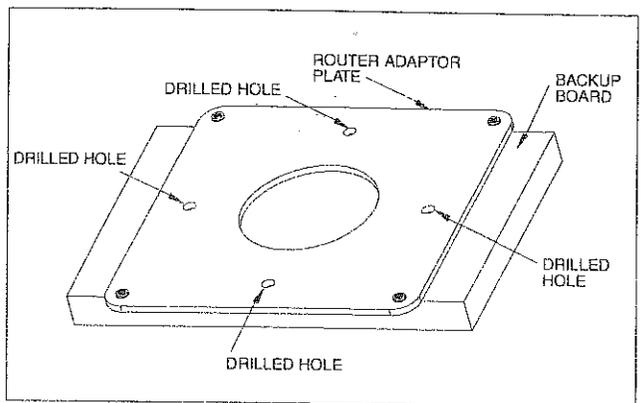
12. Remove the base plate (or router) from the adaptor plate and place in a convenient place for storage.
13. Spot the location of the holes on the adaptor plate using a steel centre punch. Refer to Figure 27.

FIGURE 27



14. Remove the template from the adaptor plate and store in a convenient location for possible future use.
15. Select a drill bit with a diameter that is the same size as the through holes in the base plate (or router mounting holes).
16. Drill holes through the adaptor plate at the locations previously spotted. The use of a wooden backup board is recommended to minimize drill breakout.
17. Remove the backup board from the adaptor plate and **place on the other side of the adaptor**; that is, the side of the adaptor plate on which there are no threaded protrusions. Refer to Figure 28.

FIGURE 28



18. Using a 3/4" diameter steel countersink, countersink the previously drilled holes to a depth such that the top of the flat countersunk screw is flush with the top of the adaptor plate, as shown in Figure 29A. Refer to "DETERMINATION OF SCREW LENGTH – FOR ADAPTOR PLATES; STYLE E" in the next section entitled "ASSEMBLY OF THE ROUTER TO THE ROUTER ADAPTOR PLATE". The wooden backup board should still be in place on the adaptor plate as shown.

FIGURE 29A

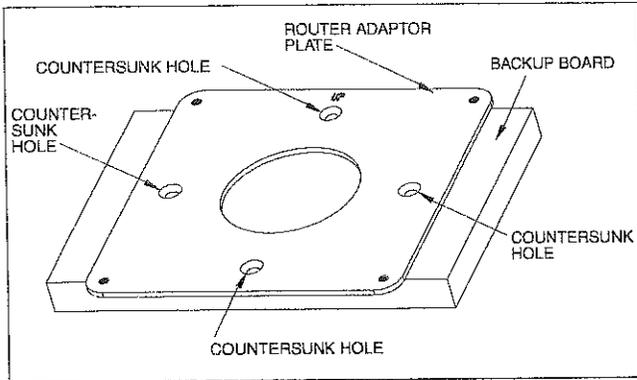
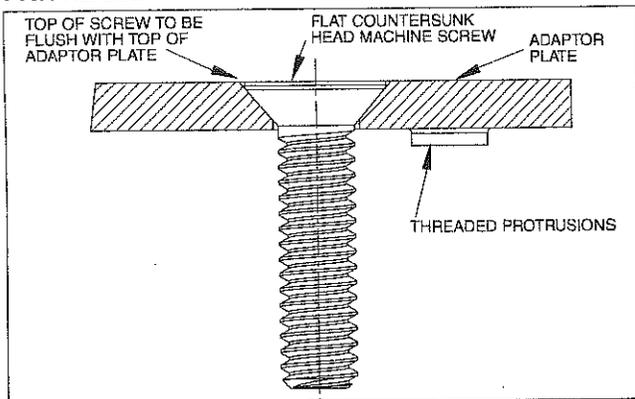


FIGURE 29B



IT IS EXTREMELY IMPORTANT THAT THE HEAD OF THE SCREW BE FLUSH WITH, OR BE SLIGHTLY BELOW, THE TOP OF THE ADAPTOR PLATE. OTHERWISE, THE HEAD OF THE SCREW CAN COME IN CONTACT WITH THE UNDERNEATH SIDE OF THE ROUTER TABLE WHEN IT IS ASSEMBLED TO THE ROUTER TABLE AS DESCRIBED IN THE SUBSEQUENT SECTION, ADAPTOR PLATE TO THE ROUTER TABLE. REFER TO FIGURE 29B.

THIS WILL RESULT IN THE ADAPTOR PLATE NOT BEING SEATED PROPERLY AGAINST THE UNDERNEATH SIDE OF THE ROUTER TABLE. COUNTERSINKING TOO DEEPLY WILL CAUSE THE SCREW TO BOTTOM OUT AGAINST THE ROUTER INSTEAD OF AGAINST THE ADAPTOR

PLATE – THE ROUTER WILL BE LOOSE ON THE ADAPTOR PLATE.

WARNING THIS CAN RESULT IN AN UNSATISFACTORY OPERATING CONDITION AND POSSIBLY IN AN UNSAFE OPERATING CONDITION WHICH CAN RESULT IN POSSIBLE BODILY INJURY.

ASSEMBLY OF THE ROUTER TO THE ROUTER ADAPTOR PLATE

DETERMINATION OF SCREW LENGTHS

- FOR ADAPTOR PLATES; TEMPLATE STYLES A, B, C, D, AND F use fasteners listed in CHART 1.
- FOR ADAPTOR PLATES; STYLE E.

Because of the large variety of routers with which the adaptor plate can be used, the screws required for assembling the router to the adaptor plate are not shown in CHART 1.

Therefore, it becomes necessary for you to determine the lengths of the screws required.

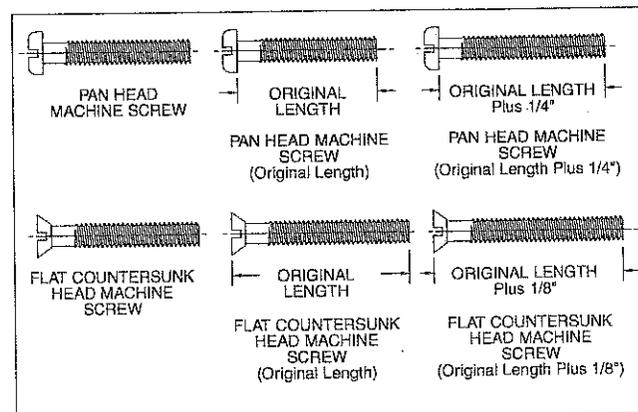
To do this, proceed as follows:

Remove one, and only one, of the screws holding the base plate to the router base. The screw will generally be one of the two types shown in Figure 30. (Although slotted screws are shown in the illustrations, the actual screws may be Phillips recessed).

For routers using pan head machine screws:

1. Measure the length of the screw, as shown in Figure 30.
2. Add 1/4" to this length. (For screws with 5/16" threads, add an additional 1/8" to provide for the thickness of the spacer).
3. Obtain the required quantity of FLAT COUNTERSUNK HEAD MACHINE SCREWS with this length, and the proper thread size, from your local hardware, or do-it-yourself store. Screws with a slotted or a Phillips recess may be used.

FIGURE 30



For routers using flat countersunk head machine screws:

1. Measure the length of the screw, as shown in Figure 30.
2. Add 1/4" to this length. (For screws with 5/16" threads, add an additional 1/8" to provide for the thickness of the spacer).
3. Obtain the required quantity of FLAT COUNTERSUNK HEAD MACHINE SCREWS with this length, and the proper thread size, from your local hardware, or do-it-yourself store. Screws with a slotted or a Phillips recess may be used.

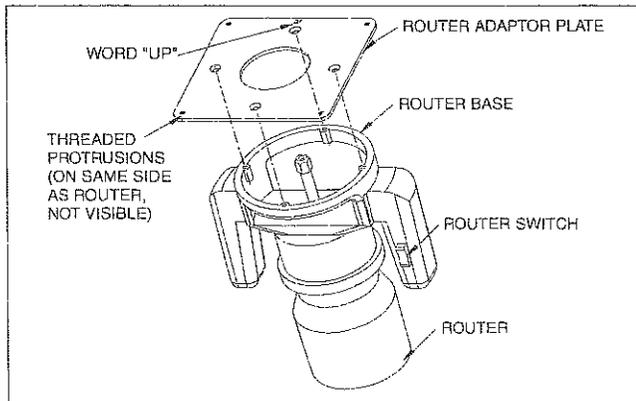
NOTE

- For some routers, the threaded holes in the router may not be threaded through holes. In those situations, the screw length established above may not be exactly correct. (Refer to ASSEMBLY TYPES "a" and "b").
 - Check the length of the screws before purchasing.
 - For some routers, the holes in the router may not be threaded. In addition to the screws, nuts will also be required to assemble the adaptor plate to the router.
- (Refer to ASSEMBLY TYPES "c" and "d").

ASSEMBLY TYPE "a" (BASE PLATE REMOVED; SCREWS ONLY):

1. Place the router upside down on a flat surface as shown in Figure 31. For some routers, it will be necessary for the router to be supported.
2. Remove the base plate from the router, if this has not already been done.
3. Place the adaptor plate on the router base so that the threaded protrusions are facing DOWNWARD. THE ROUTER MUST BE ON THE SAME SIDE OF THE ADAPTOR AS THE THREADED HOLES. THE WORD "UP" ON THE ADAPTOR PLATE SHOULD BE VISIBLE. REFER TO FIGURE 31.

FIGURE 31



4. Line up the holes in the adaptor plate with the threaded holes in the router base, as shown in the figure.
5. Insert the screws obtained as a result of the Section, "DETERMINATION OF SCREW LENGTHS", through the holes in the adaptor plate, as shown in Figure 32.

FIGURE 32

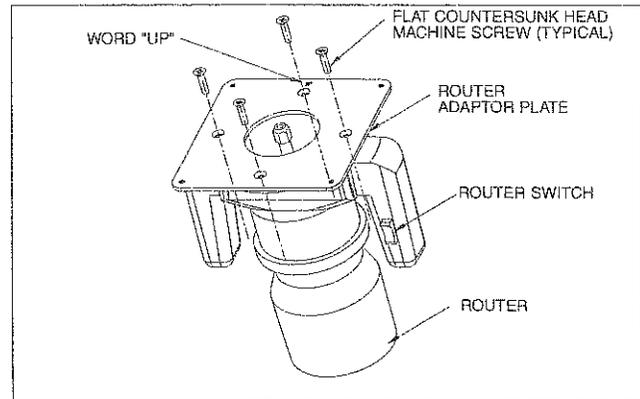
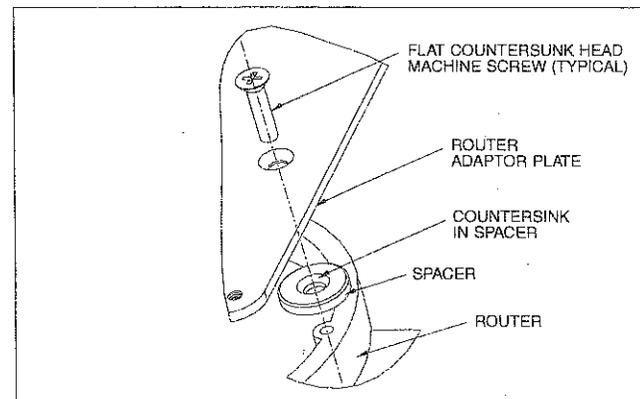


FIGURE 33A



NOTE

a) WHEN 5/16" DIAMETER SCREWS ARE BEING USED, THE PROVIDED SPACERS MUST BE USED. THEY ARE POSITIONED BETWEEN THE ADAPTOR PLATE AND ROUTER, WITH THE COUNTERSINK IN THE SPACER FACING THE ADAPTOR PLATE, AS SHOWN IN FIGURE 33A.

NOTE

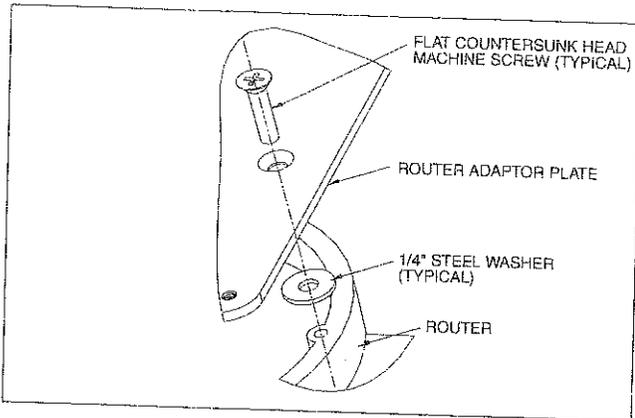
b) WHEN 1/4" DIAMETER SCREWS ARE BEING USED, 1/4" STEEL WASHERS MUST BE USED. (SUGGESTED SIZE: 9/32" I.D. X 5/8" O.D. X 1/16" THICK OR 9/32" I.D. X 3/4" O.D. X 1/16" THICK).

THEY ARE POSITIONED BETWEEN THE ADAPTOR PLATE AND ROUTER, AS SHOWN IN FIGURE 33B.

6. Thread the screws into the threaded holes in the router base.

7. SECURELY TIGHTEN ALL OF THE SCREWS.

FIGURE 33B



ASSEMBLY TYPE "b" (BASE PLATE NOT REMOVED; SCREWS ONLY):

1. Place the router upside down on a flat surface as shown in Figure 34. For some routers, it will be necessary for the router to be supported.

2. Place the adaptor plate on the router base so that the threaded protrusions are facing DOWNWARD.

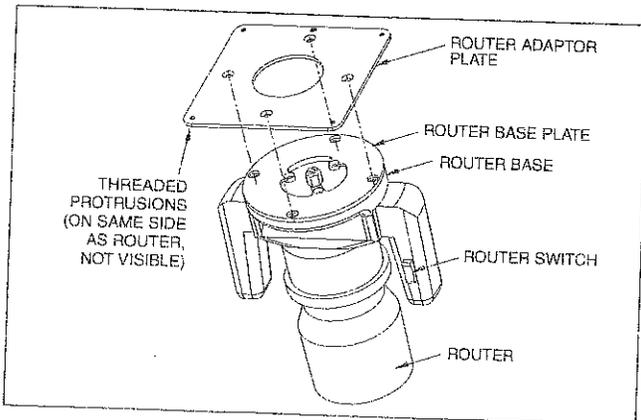
3. THE ROUTER MUST BE ON THE SAME SIDE OF THE ADAPTOR PLATE AS THE THREADED HOLES. THE WORD "UP" ON THE ADAPTOR PLATE SHOULD BE VISIBLE.

REFER TO FIGURE 34.

4. Line up the holes in the adaptor plate with the threaded holes in the router base, as shown in the figure.

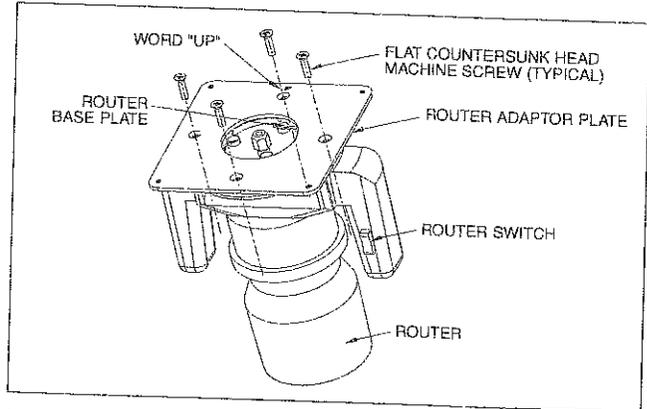
5. Insert the screws obtained as a result of the Section, DETERMINATION OF SCREW LENGTHS, through the holes in the adaptor plate, as shown in Figure 35.

FIGURE 34



6. NOTE: WHEN 5/16" DIAMETER SCREWS ARE BEING USED, THE PROVIDED SPACERS MUST BE USED.

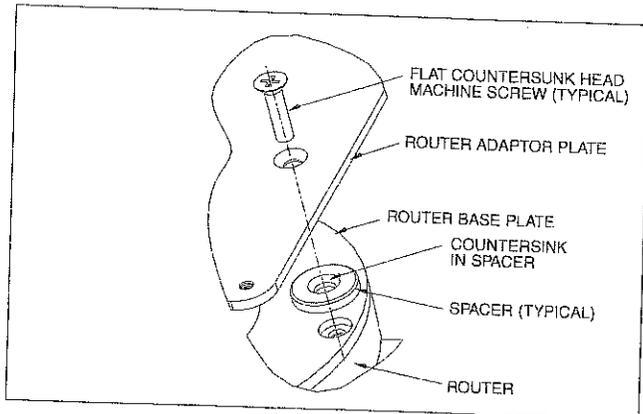
FIGURE 35



7. THEY ARE POSITIONED BETWEEN THE ADAPTOR PLATE AND ROUTER, WITH THE COUNTERSINK IN THE SPACER FACING THE ADAPTOR PLATE, AS SHOWN IN FIGURE 36A.

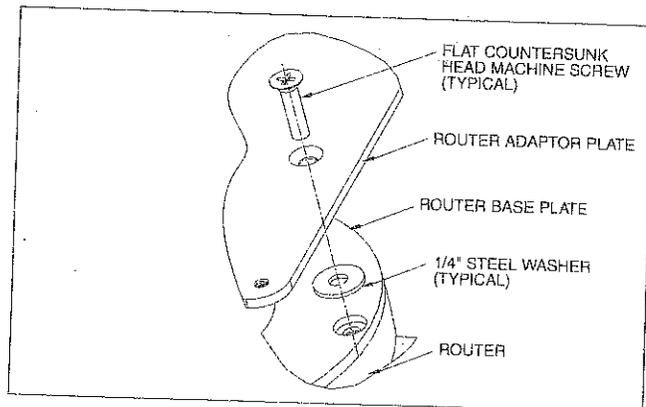
8. NOTE: WHEN 1/4" DIAMETER SCREWS ARE BEING USED, 1/4" STEEL WASHERS MUST BE USED. (SUGGESTED SIZE: 9/32" I.D. X 5/8" O.D. X 1/16" THICK OR 9/32" I.D. X 3/4" O.D. X 1/16" THICK).

FIGURE 36A



9. THEY ARE POSITIONED BETWEEN THE ADAPTOR PLATE AND ROUTER, AS SHOWN IN FIGURE 36B.

FIGURE 36B

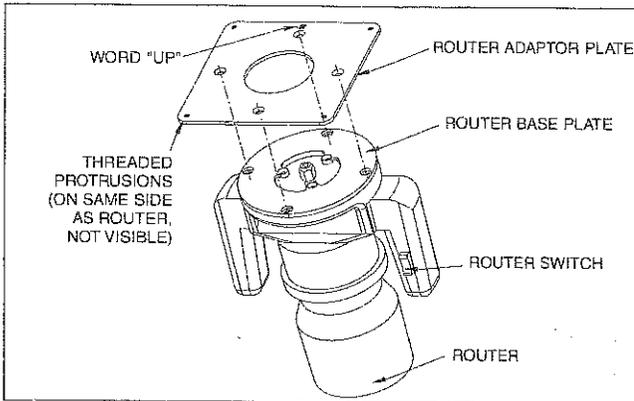


10. Thread the screws into the threaded holes in the router base.
11. SECURELY TIGHTEN ALL OF THE SCREWS.

ASSEMBLY TYPE "c" (BASE PLATE NOT REMOVED; SCREWS AND NUTS):

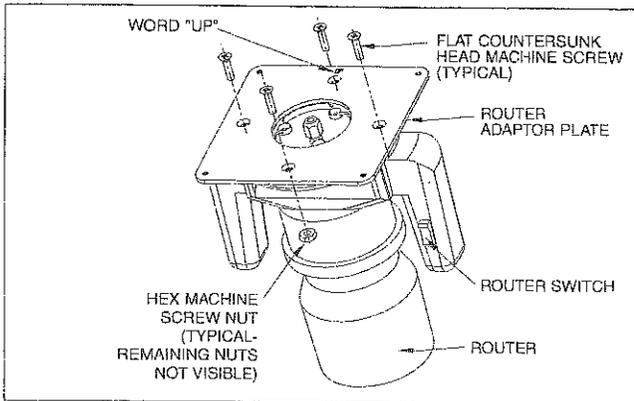
1. Place the router upside down on a flat surface as shown in Figure 37. For some routers, it will be necessary for the router to be supported.
2. Place the adaptor plate on the router base so that the threaded protrusions are facing DOWNWARD.
3. THE ROUTER MUST BE ON THE SAME SIDE OF THE ADAPTOR PLATE AS THE THREADED HOLES. THE WORD "UP" ON THE ADAPTOR PLATE SHOULD BE VISIBLE.
4. REFER TO FIGURE 37.
5. Line up the holes in the adaptor plate with the threaded holes in the router base, as shown in Figure 37.

FIGURE 37



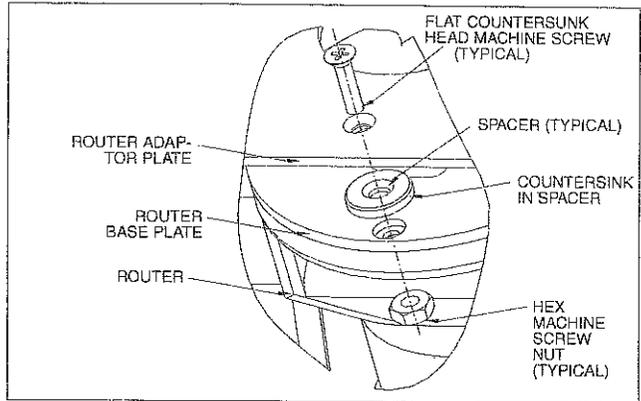
6. Insert the screws obtained as a result of the Section, DETERMINATION OF SCREW LENGTHS, through the holes in the adaptor plate, as shown in Figure 38.
7. Line up the nuts with the holes in the router base as shown in the figure.

FIGURE 38



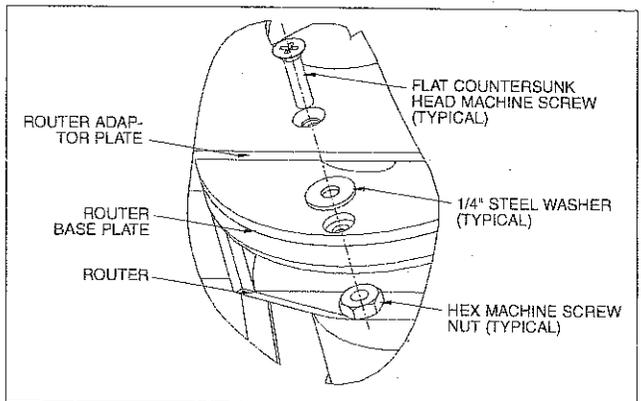
8. NOTE: WHEN 5/16" DIAMETER SCREWS ARE BEING USED, THE PROVIDED SPACERS MUST BE USED.
9. THEY ARE POSITIONED BETWEEN THE ADAPTOR PLATE AND ROUTER, WITH THE COUNTERSINK IN THE SPACER FACING THE ADAPTOR PLATE, AS SHOWN IN FIGURE 39A.

FIGURE 39A



10. NOTE: WHEN 1/4" DIAMETER SCREWS ARE BEING USED, 1/4" DIAMETER STEEL WASHERS MUST BE USED. (SUGGESTED SIZE: 9/32" I.D. X 5/8" O.D. X 1/16" THICK OR 9/32" I.D. X 3/4" O.D. X 1/16" THICK).
11. THEY ARE POSITIONED BETWEEN THE ADAPTOR PLATE AND ROUTER, AS SHOWN IN FIGURE 39B.

FIGURE 39B



12. Thread the screws into the nuts.
13. SECURELY TIGHTEN ALL OF THE SCREWS.

ASSEMBLY TYPE "d" (BASE PLATE REMOVED; SCREWS AND NUTS):

Same as ASSEMBLY TYPE "c", except that the router base plate is removed; as in Step 2, in the above section ASSEMBLY TYPE "a".

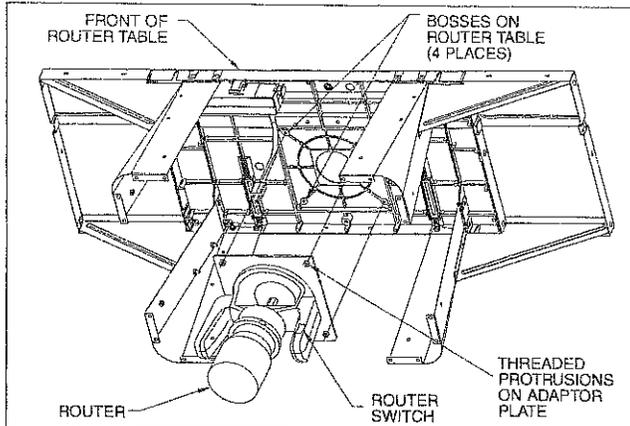
ADAPTOR PLATE TO THE ROUTER TABLE

The adaptor plate should be assembled to the router table ONLY AFTER the router has been assembled to the adaptor plate.

Conversely, the router can ONLY be removed from the adaptor plate AFTER the adaptor plate has been removed from the router table. The router MUST be supported while being removed.

1. While holding the router upside down, position the adaptor plate against the four bosses on the underside of the router table, as shown in Figure 40.

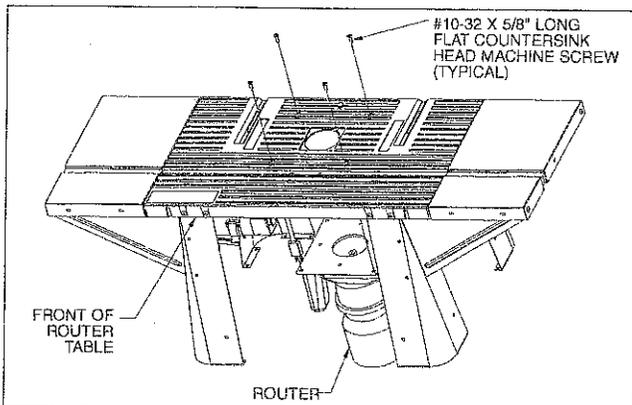
FIGURE 40



NOTE

- The word UP has been stamped on the surface of the adaptor plate that MUST join with the underside of the router table.
- Position the router so that the switch on the router faces the front of the router table.
 - Line up the four threaded holes in the threaded protrusions on the adaptor plate with the four corresponding holes in the bosses.
 - Insert the four #10-32 x 5/8" long flat countersunk head machine screws provided, through the four holes in the top of the table, as shown in Figure 41.
 - Thread the screw into the threaded holes in the adaptor plate.
 - TIGHTEN THE SCREWS SECURELY.

FIGURE 41

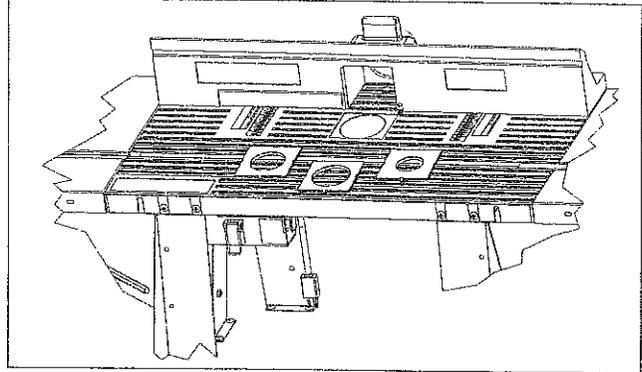


TABLETOP INSERTS TO THE ROUTER TABLE

This router table comes with three tabletop inserts in the following hole sizes:

- 1-1/4" diameter, for use with router bits with diameters up to 1-1/8"
- 1-7/8" diameter, for use with router bits with diameters up to 1-3/4"
- 2-1/8" diameter, for use with router bits with diameters up to 2"
- For router bits with diameters between 2" and 2-3/4" the tabletop inserts are not used. See Figure 42.

FIGURE 42

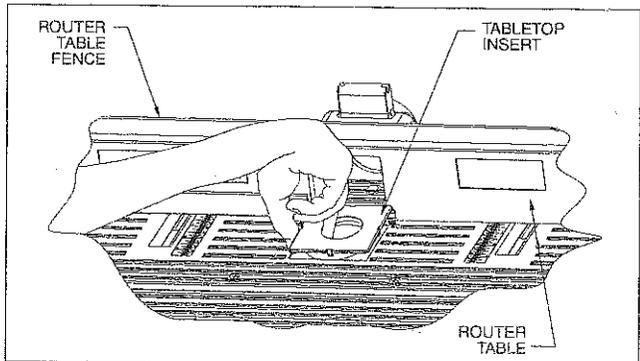


WARNING

A 2-3/4" diameter router bit is the LARGEST router bit that can be SAFELY used on this router table.

- Select the tabletop insert that accommodates the router bit to be used.
- Assemble the insert to the tabletop by pressing it into the large hole in the top of the router table, as shown in Figure 43.

FIGURE 43



- Press down equally over the tabs on the insert so that the tabs snap into place.
- To remove, insert a finger in the insert hole and gently pull up until the tabs disengage the hole. When not in use, store the inserts in a convenient place.

WARNING

DO NOT attempt to remove tabletop insert from the tabletop unless router bit has been removed from the router.

SWITCH INSTRUCTIONS

ELECTRICAL REQUIREMENTS

A 14-gauge (or heavier) three-wire extension cord with a three-hole grounding receptacle and three-hole grounding plug is to be used for connecting the switch to an electrical outlet.

A double insulated 14-gauge (or heavier) two-wire extension cord having a two-hole receptacle and a two-prong grounding plug may also be used for connecting the switch to an electrical outlet.

DAMAGED OR WORN EXTENSION CORDS ARE NOT TO BE USED AND ARE TO BE REPLACED IMMEDIATELY.

The electrical cord at the back of the switch will accept either three-hole or two-hole double-insulated extension cords.

The electrical receptacles at the back of the switch will accept either three-prong or two-prong plugs from a router or accessory.

In the event of a malfunction or breakdown, grounding provides the path of least resistance for electric current in order to reduce the risk of electric shock. This switch box is equipped with an electric cord that has an equipment grounding connector and a grounding plug.

The extension cord must be plugged into a matching outlet **that has been installed by a licensed electrician and grounded in accordance with all local codes and ordinances.**

DO NOT modify the plug from the switch if it does not plug into the extension cord. Obtain an extension with the proper outlet.

Improper connection of the equipment-grounding conductor can result in risk of an electric shock.

The conductor with insulation that has a green outer surface, with or without yellow stripes, is the equipment-grounding conductor. **DO NOT CONNECT THE EQUIPMENT GROUNDING CONDUCTOR TO A LIVE TERMINAL.**

Check with a licensed electrician if the grounding instructions are not completely understood, or if there is a doubt as to whether the electrical outlet or extension cord is properly grounded.

WARNING DO NOT PERMIT FINGERS TO TOUCH THE TERMINALS OF THE PLUG WHEN PLUGGING IT INTO OR REMOVING IT FROM AN ELECTRICAL OUTLET.

WARNING IF NOT PROPERLY GROUNDED, A POWER TOOL CAN PRESENT POTENTIAL HAZARDS OF ELECTRICAL SHOCK, WHICH CAN POSSIBLY RESULT IN SERIOUS BODILY INJURY OR DEATH, particularly when used in a damp location, in proximity to plumbing, or outdoors.

If an electrical shock occurs, there is always the potential of a secondary hazard, such as your hands contacting the router bit, or falling down or against an object.

WARNING USE THE SWITCH BOX ONLY WHEN PROPERLY ASSEMBLED TO THE ROUTER TABLE. USE ONLY WITH A ROUTER WHICH HAS ALSO BEEN PROPERLY INSTALLED ON A PROPERLY ASSEMBLED ROUTER TABLE.

CONNECTING THE ROUTER POWER CORD TO THE SWITCH

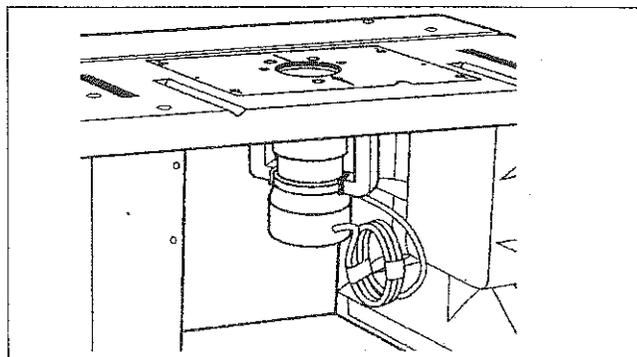
WARNING

• MAKE SURE THAT THE POWER CORD FROM THE SWITCH IS NOT PLUGGED INTO ANY ELECTRICAL OUTLET AT THIS TIME. IF IT IS, UNPLUG IT.

• MAKE SURE THAT THE ROUTER SWITCH IS IN THE "OFF" POSITION.

1. Plug the router power cord into one of the electrical outlets on the back of the switch case.
2. Form the excess power cord into a coil.
3. Wrap two pieces of friction tape or strong cord around the coiled cord at opposite sides of the coil, as shown in Figure 44.
4. Allow some slack, so that the cord does not become stretched when it is plugged into the switch box outlets.

FIGURE 44



5. If desired, at this time plug the power cord from an accessory, such as a wet/dry vac or light, into the other outlet.

WARNING MAKE SURE THAT POWER CORDS FROM THE ROUTER, ACCESSORIES, THE SWITCH CASE, AND THE EXTENSION CORD DO NOT AND CANNOT COME IN CONTACT WITH THE ROUTER OR ANY MOVING PARTS OF THE ROUTER.

GENERAL INFORMATION

The power switch is designed for use with most Router Tables. It provides the convenience of an ON (RESET)--OFF switch at the front of the router table, thus eliminating the need to reach under the table to turn the router ON and OFF.

The power switch also provides optional simultaneous ON/OFF control of an additional accessory, such as a light, wet/dry vac, etc. The switch has an internal resettable circuit breaker to provide overload protection.

SWITCH OPERATION

This section explains the operation and features of the switch prior to plugging the power cord into an extension cord. The intent is to familiarize the user with the switch operation without actually turning the router ON.

The switch incorporates two positive features to prevent inadvertent switching ON of the router and the unauthorized, and possibly hazardous, use by others:

- A switch cover prevents the accidental switching ON of the router.
- The clear opening in the cover allows you to see a small red light on the switch toggle when the switch is turned ON.
 - The light is ON when the switch is ON.
 - The light is OFF when the switch is OFF.
- The safety key must be **completely** inserted into the side of the switch case before the switch can be turned ON.

FIGURE 45A

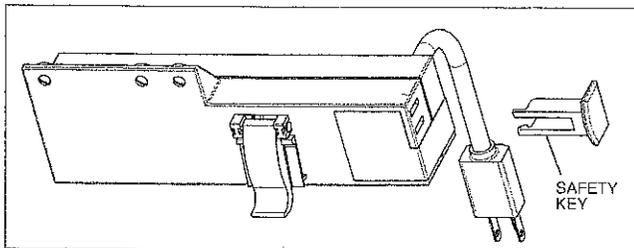
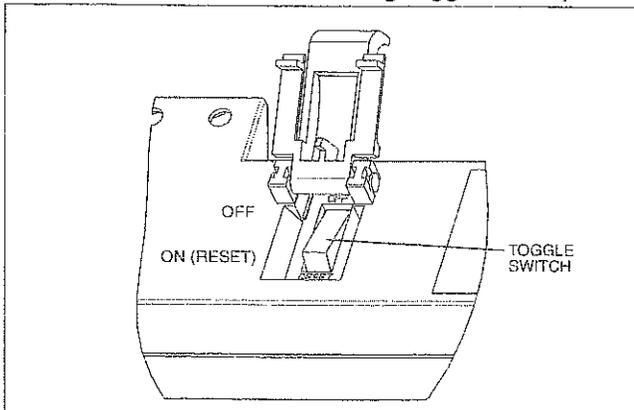


FIGURE 45B (Detail View Showing Toggle Switch)



To operate the switch, proceed as follows:

MAKE SURE THAT THE EXTENSION CORD IS NOT PLUGGED INTO AN ELECTRICAL OUTLET BEFORE PROCEEDING ANY FURTHER.

1. Insert the safety key into side of the switch case. See Figure 45A.

2. To turn the router ON, lift the switch cover and toggle the switch to the ON (RESET) position. See Figure 46A.

Gently lower the switch cover. Letting the switch cover drop closed may cause the switch to turn OFF by activating the EMERGENCY OFF feature.

3. To turn the router OFF, lift the switch cover and toggle the switch to the OFF position. See Figure 46B.



NEVER LEAVE THE ROUTER UNATTENDED WHILE IT IS RUNNING OR BEFORE IT COMES TO A COMPLETE STOP.

4. To lock switch in the OFF position, toggle the switch to OFF and remove key completely from the side of the switch case. See Figure 46C.

5. Make sure the red slide panel covers the top half of the toggle switch once the safety key is removed, as shown in Figure 46C.

FIGURE 46A

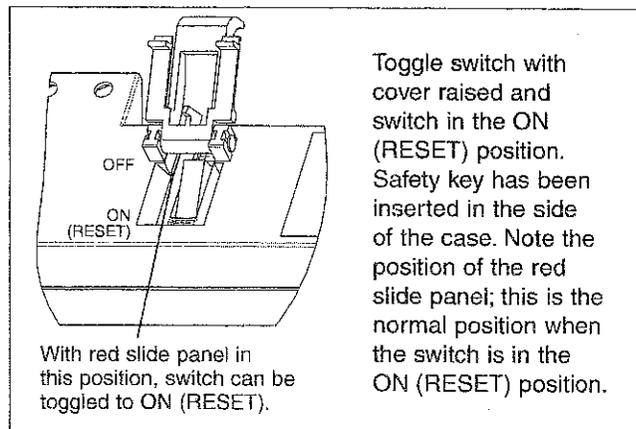


FIGURE 46B

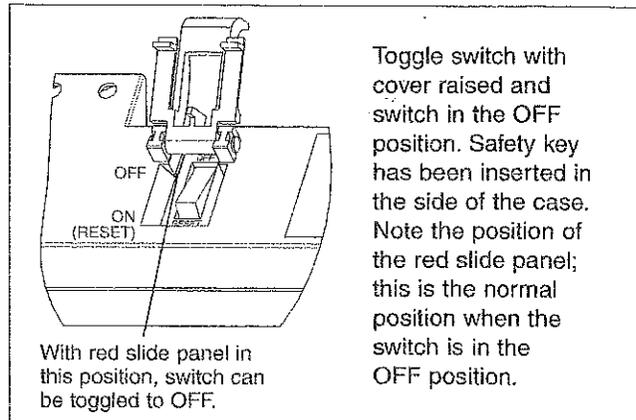
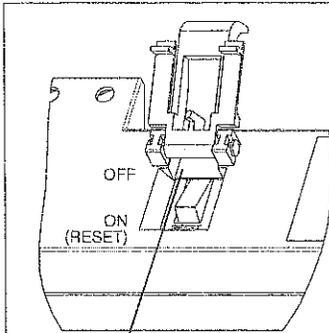


FIGURE 46C



With red slide panel in this position, switch can NOT be toggled to ON (RESET).

Toggle switch with cover raised and switch in the OFF position. Safety key has been removed from the side of the case. Note the position of the red slide panel; this is the normal position when the switch is in the OFF position and the key is removed.

If the red slide panel does not cover the top half of the toggle switch once the safety key is removed, press down on the switch toggle under the word OFF.

If the slide panel still does not cover the top half of the switch:

- Unplug ALL electrical connections.
- Remove the switch from the router table and obtain a replacement switch from your local hardware outlet/store/centre.

The router table can still be used by plugging the router into a suitable outlet and using the ON/OFF switch on the router.

With the safety key removed and the red slide panel covering the top half of the switch toggle, the switch CANNOT be toggled to the ON position.

WARNING BEFORE PROCEEDING ANY FURTHER, MAKE SURE THE SWITCH ON THE ROUTER IS IN THE OFF POSITION AND SWITCH IS IN THE OFF POSITION.

The power cord from the switch can now be plugged into the extension cord.

WARNING MAKE SURE THAT POWER CORDS FROM THE ROUTER, ACCESSORIES, THE SWITCH CASE, AND THE EXTENSION CORD DO NOT AND CANNOT COME IN CONTACT WITH THE ROUTER OR ANY MOVING PARTS OF THE ROUTER.

ROUTER AND SWITCH OPERATION

This section explains operation of the switch with the power cord plugged into an extension cord.

The router will turn ON when the toggle switch is toggled to the ON (RESET) position.

1. Position the ON-OFF switch on the router in the ON position. On certain routers this will require the use of the switch trigger and the "LOCK-ON" button. (Consult router owner's manual.) Make sure the

switch on the switch case is in the OFF position when doing this.

2. To turn the router ON, lift the switch cover and toggle the switch to the ON position. See Figure 46A.
3. To turn the router OFF, lift the switch cover and toggle the switch to the OFF position. See Figure 46B on page 22.

WARNING NEVER LEAVE THE ROUTER UNATTENDED WHEN IT IS RUNNING OR BEFORE IT COMES TO A COMPLETE STOP.

NOTE In the event of an overload, the internal switch circuit breaker will trip the toggle switch to the OFF position. This will interrupt the power to the router and any accessory plugged into the switch itself. If this should occur, proceed as follows:

1. Unplug the switch cord from the extension cord.
2. Remove the workpiece from the router table.
3. Correct the cause of the overload situation (i.e. the removal of too much stock or use of too high a feed rate).
4. Plug the switch power cord into the extension cord.
5. Restart the router as described in the section ROUTER AND SWITCH OPERATION.

SPECIAL NOTE TO OWNERS OF ROUTERS WITH "LOCK ON" FEATURE

Because these routers come with a special "LOCK-ON" feature, they cannot be turned on by the switch mounted on the router table, but can be turned off by the switch.

To operate routers with this feature:

1. Position the toggle switch to the ON (RESET) position as described in ROUTER AND SWITCH OPERATION. The router should NOT start, even though the trigger lock on the router is in the "LOCK-ON" position. (Consult your router owner's manual.)
2. To start the router, depress the trigger and engage the "LOCK-ON" button on the side of the handle. THE ROUTER SHOULD START IMMEDIATELY.

If it does not:

- a. If the router switch is already in the "LOCK-ON" position (the "soft" and "1/4 inch" indicator lights should be flashing – consult your router owner's manual), unlock the trigger.
 - b. Then depress the trigger, THE ROUTER SHOULD START IMMEDIATELY.
 - c. Engage the "LOCK-ON" button on the side of the handle.
3. To turn the router off, lift the switch cover and toggle the switch to the OFF position, or press the switch cover.

4. To restart the router, repeat steps 1 and 2.

WHEN THE ROUTER TABLE IS NOT IN USE

1. Toggle the switch to the OFF position.
2. Remove the safety key.
3. **Store the safety key in safe location where it is not available to children and other unauthorized persons.**
4. Unplug the switch power cord from the extension cord.

5. Remove the router bit from the router.
6. Position the router collet assembly below the top of the router table.

NOTE

If the key should become lost or misplaced, replacement keys are available. Please contact your place of purchase.

OPERATION

ALIGNING THE FENCE TO THE ROUTER TABLE

1. Refer to Steps 4 through 8 and Figure 13A on Page 10.
2. Adjust fence to desired location to obtain required cut.

NOTE

There are two scales, with 1/16" increments, in the top of the router table to aid you in adjusting the location of the fence.

3. **TIGHTEN** the knobs when the fence assembly is aligned at the desired location.

CONNECTING A WET/DRY VAC TO THE FENCE

The router table fence assembly has a port at the back where a wet/dry vac hose can be connected. The port will accommodate a 2-1/2" diameter hose nozzle.

To attach, push the nozzle into the port while holding the router table fence assembly in place.

CAUTION

Operating the router table without a wet/dry vac can result in an excessive collection or build-up of sawdust and chips under the fence assembly and the overhead guard. This can hinder the performance of the router table and the fence assembly.

RECOMMENDATION: Regardless of whether a wet/dry vac is being used, remove the sawdust and wood chips from under the fence assembly and the overhead guard as needed. This removal should be done so that the performance of either is not hindered.

RECOMMENDATION: It is always a good practice to keep the work area clean. As necessary, remove the sawdust and wood chips from the top of the router table, as well as any that has accumulated on the floor around the router table.

WARNING

When doing the above, keep the following in mind:

- The **ROUTER** and **THE SWITCH** must be turned **OFF**.
- The router bit must **NOT** be turning.
- The router power cord must be **UNPLUGGED** from the switch.
- The power cord from the switch must be **UNPLUGGED** from the extension cord.

INSTALLING THE ROUTER BIT (CUTTER)

Because of the large variation of routers and router bits, certain router bits may not always operate in the desired manner with this router table.

To ensure that the majority of the most popular bits will perform satisfactorily, install the bit so that the router collet engages 3/4" of the router bit shank. If the shank of the router bit bottoms out in the collet, back out the router bit approximately 1/16" to allow for proper tightening.

NEVER INSTALL ROUTER BITS WITH LESS THAN 3/4" OF SHANK ENGAGEMENT IN THE COLLET.

USING THE ROUTER TABLE

WARNING

BEFORE each and every use, make sure that the floor stand is **STABLE** on the floor and **DOES NOT** rock back and forth. If it does, level the floor stand as described in a prior section. The adjustable fence on your table is provided as a guide against which the workpiece should be held for accuracy in routing. **FREE HAND ROUTING** (not holding work against the fence) is **HAZARDOUS** and should be **STRICTLY AVOIDED** without piloted router bits.

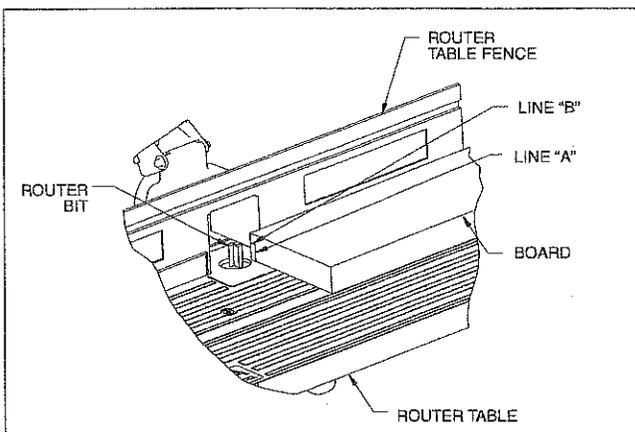
ADJUSTING DEPTH AND HEIGHT OF THE CUT

UNPLUG the router for these adjustments. Rotate the overhead guard upward in order to have full access to the router bit for making adjustments.

Select a board that is smooth, with edges square to each other and its surfaces. Other recommendations are the following:

1. Mark Lines "A" and "B" on the end of this board. Line "A" indicates the desired depth-of-cut (amount of material you want to remove) and Line "B" indicates the desired cutting height.
2. Position this board against the face of the router table fence with the edge resting on the tabletop and end marked with Lines "A" and "B" close to the bit. See Figure 47. (Make sure router is UNPLUGGED when making adjustments.)

FIGURE 47



3. Loosen both large knobs to allow movement of fence and move forward and backward until outermost cutting edge of router bit is aligned with Line "A". Tighten both knobs.
4. Raise or lower the router until the top of the bit cutting edge is aligned with Line "B". (Refer to your Router Owner's Manual for adjusting your router properly.) After making this adjustment, be sure router is SECURELY TIGHTENED in the router based, the bit is SECURELY TIGHTENED in the router chuck and the router base is SECURELY TIGHTENED to the router tabletop.
5. Remove the board from the fence and LOWER THE OVERHEAD GUARD to OPERATING POSITION.

WARNING DO NOT operate the router if any part of the bit contacts the overhead guard.

NOTE You should substitute a scrap board for the actual workpiece when making adjustments.

ROUTING USING THE FENCE WITHOUT THE PUSH BLOCK

Full edge cutting:

For maximum strength and accuracy, boards to be joined together should be smooth and true. The edges should be true to the workpiece surface. You can true the edges on your router table using a straight bit.

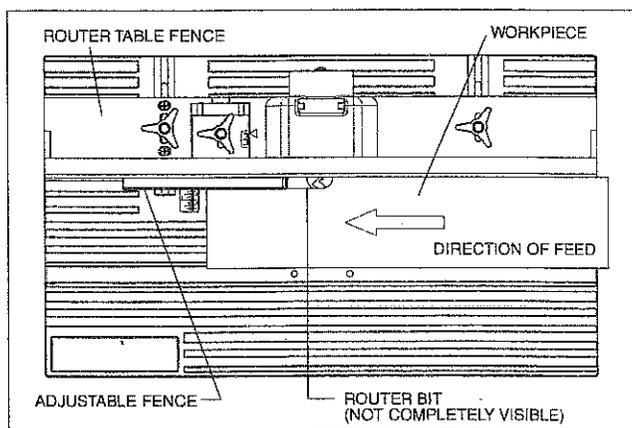
1. Check to see if face of adjustable jointing fence is flush with the face of the router table fence. If not, loosen adjustable fence clamping knob on jointing fence and adjust. Tighten the fence clamping knob on the adjustable fence.

NOTE The adjustable jointing fence provides a continuous support for the workpiece as it is fed beyond the router bit. The adjustable jointing fence compensates for the gap created after the removal of material by the router bit.

2. Adjust depth of cut (the material you want to remove) and router bit height as described in Steps 1 – 4, **ADJUSTING DEPTH AND HEIGHT OF THE CUT** on Page 24. Tightly secure the fence and the router as described before. (Make sure router is UNPLUGGED when making adjustments.)
3. LOWER THE OVERHEAD GUARD to the operating position. (Overhead guard shown raised for reasons of clarity.)
4. Check your adjustments by turning the router ON, using the switch, and feeding a piece of scrap wood a few inches beyond router bit. Then stop and turn router OFF, using the switch.

NOTE Feed work AGAINST the rotation of the cutter (in the direction shown by arrow in Figure 48).

FIGURE 48



Guard not shown for reasons of clarity.

5. Loosen the fence clamping knob on the adjustable jointing fence and move it out, flush against the finished edge of scrap wood. Re-tighten the knob. See Figure 48.
6. Repeat the test cut on the scrap wood with overhead guard DOWN.
7. The router table is now ready for use.

NOTE For best results when jointing, take very shallow cuts, 1/32" or less.

Edge cutting with non-piloted router bits:

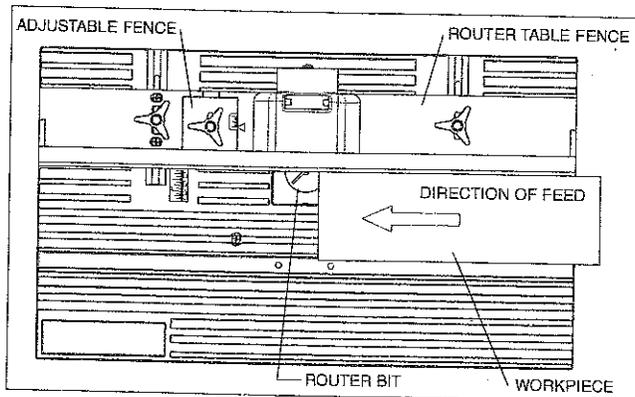
1. Position the adjustable jointing fence so that its face is flush with the face of the table fence. Tighten adjustable fence clamping knob on jointing fence. See Figure 49.
2. Adjust depth of cut (material you want to remove) and router bit height, as described previously in **ADJUSTING DEPTH AND HEIGHT OF THE CUT**, Steps 1 – 4 on Page 24. Tighten both fence clamping knobs to lock fence on table. Tighten secure the router. (Make sure router is **UNPLUGGED** when making adjustments.)
3. **LOWER THE OVERHEAD GUARD** to the **OPERATING POSITION**. Overhead guard shown raised for reasons of clarity.
4. Test cut a piece of scrap wood to make sure adjustments are satisfactory.

NOTE

Feed work **AGAINST** the rotation of the cutter (in the direction shown by the arrow in Figure 49).

5. The router table is now ready for use.

FIGURE 49



Guard not shown for reasons of clarity.

Edge cutting with piloted router bits:

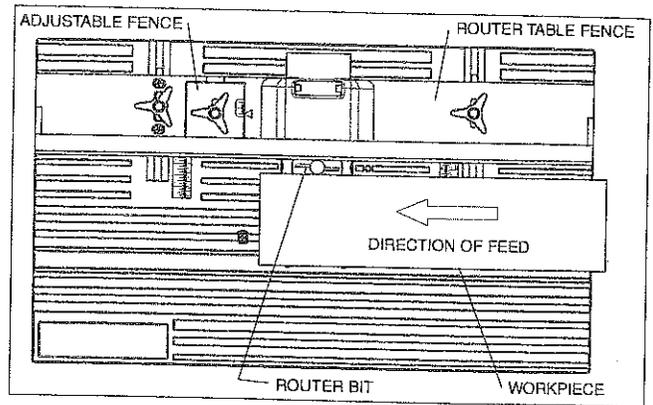
1. Position the fence in the same manner as with non-piloted bits.
2. Move the fence back only enough to permit the pilot to control the cutting depth. Positioning the fence as close to the pilot as possible will serve as a back-up and will help to prevent chances of an accident and possible personal injury. See Figure 48.
3. **LOWER THE OVERHEAD GUARD** to the **OPERATING POSITION**. Overhead guard shown raised for reasons of clarity.
4. Test cut a piece of scrap wood to make sure adjustments are satisfactory.

NOTE

Feed work against the rotation of the cutter (in the direction shown by the arrow in Figure 50).

5. The router table is now ready for use.

FIGURE 50



Guard not shown for reasons of clarity.

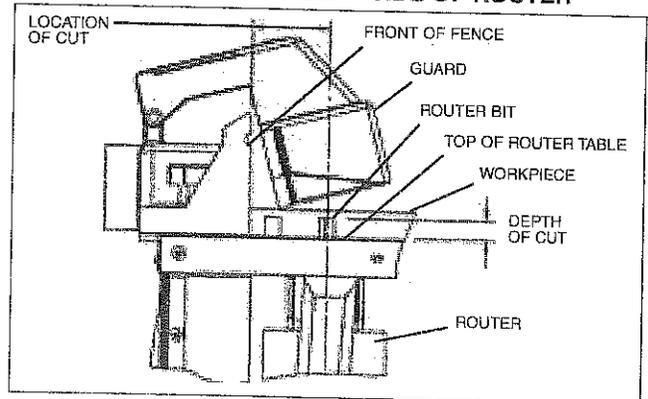
Grooving, fluting, and veining:

Always **UNPLUG** the router before making any settings, adjustments, or changing bits. When routing, always **FEED AGAINST** the rotation of the cutter. Feed workpiece in the direction of arrow, as in Figure 50.

For maximum accuracy, one edge of your workpiece (edge sliding against the fence) must be true and straight. Set up your fence as follows:

1. Position the fence behind the router bit for the desired cutting depth (the distance of the cut from the edge of the workpiece, as shown in Figure 51). Make sure that the overhead guard is in place as shown.

FIGURE 51, VIEW FROM LEFT SIDE OF ROUTER

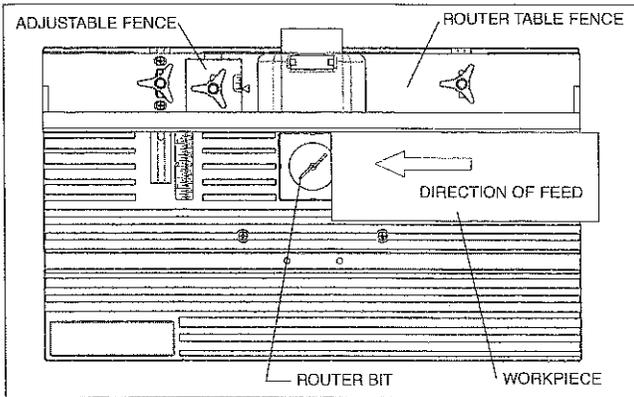


2. Securely **TIGHTEN** knobs.
3. Make the cut by sliding the straight edge of the workpiece against the fence, as shown in Figure 52. (For each successive cut, the fence would need to be readjusted.)

NOTE

Test cut a piece of scrap wood before making your finish cut. Feed workpiece in the direction of arrow. (Refer to Figure 52.)

FIGURE 52



Guard not shown for reasons of clarity.

NOTE

When routing deep cuts (controlled by the router bit height) in a workpiece, remove a small amount of wood at a time to prevent the router from overloading. Repeat the operation with several gradually deeper cuts until the desired depth is attained.

ROUTING USING THE MITRE GAUGE AND THE FENCE

End cutting:

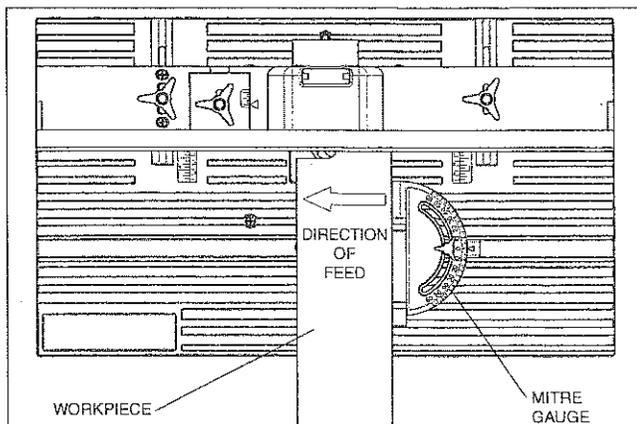
Your mitre gauge will serve as a handy aid when extra support is needed for routing small workpieces or the ends of long workpieces. See Figure 53. (Overhead guard not shown for reasons of clarity.)

NOTE

For ALL routing operations requiring use of mitre gauge along with the fence assembly, be sure to align fence assembly with mitre bar slot before making any cuts. Refer to the section, **FENCE**, on Pages 10 and 11.

Mitres can be cut by loosening the protractor head knob, turning the protractor head up to 60° in either direction and re-tightening the protractor head knob.

FIGURE 53



Guard not shown for reasons of clarity.

WARNING

- The OVERHEAD GUARD MUST BE DOWN in the OPERATING POSITION when using the mitre gauge.
- Always HOLD the workpiece FIRMLY AND SECURELY AGAINST the mitre gauge, the router table and the fence assembly when making this cut.
- Make sure that neither YOUR FINGERS, HANDS, NOR ANY OTHER PART OF YOUR BODY is in line with the router bit when using the mitre gauge, or serious bodily injury can occur.

END CUTTING USING THE FENCE WITH THE PUSH BLOCK

WARNING

End cutting is performed with the overhead guard rotated back so that it does not cover the router bit. Therefore, **EXTREME CARE** must be taken when end cutting so that fingers, hands, or any other parts of your body **DO NOT** contact the bit, which can result in serious bodily injury.

When routing on the ends of a workpiece for making tenons, sliding dovetails, and tongue and groove joints, the workpiece must be made smooth with both the edges and the ends made true to each other and its surfaces. All surfaces must be square, or at 90° with each other.

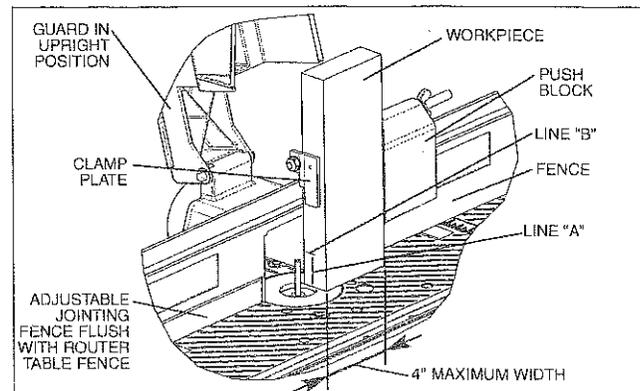
NOTE

The push block and clamp plate assembly will not accommodate workpieces wider than 4".

Cutting tenons:

1. Make certain that the adjustable fence is locked in position with its face flush with the front face of the fence.
2. Mount the push block assembly on the fence.
3. Install proper tabletop insert into the tabletop hole.
4. Mark line "A" and "B" on the edge of the workpiece closest to the end to be cut. Line "A" is the FULL DEPTH OF CUT (total amount of material you want to remove), and line "B" is the FULL DESIRED HEIGHT OF THE TENON (Figure 54).

FIGURE 54



5. Position the workpiece between the clamp plate and the push block so that its side is held flush against the face of the fence. The end to be cut is resting on the edge of the router table insert hole, and the surface marked with Lines "A" and "B" is facing the router bit. Clamp the workpiece in this position by snugly tightening the wing nut on the clamp rod, making sure that the clamp plate stays oriented on the workpiece (Figure 54 on page 27). Make sure the router is UNPLUGGED when positioning and clamping the workpiece and making adjustments.

NOTE Tighten the wing nut just enough to clamp the work piece in position. OVERTIGHTENING the wing nut could cause binding in the sliding motion of the push block, which in turn could result in variations and/or steps in the finished tenon surface when cut.

6. Slide workpiece up next to the router bit and adjust the fence and the router, as described in the section, **ADJUSTING DEPTH AND HEIGHT OF CUT**. The outer most cutting edge of the bit should be aligned with line "A", and the top cutting edge of the bit should be aligned with line "B". Tightly secure the fence and the router.

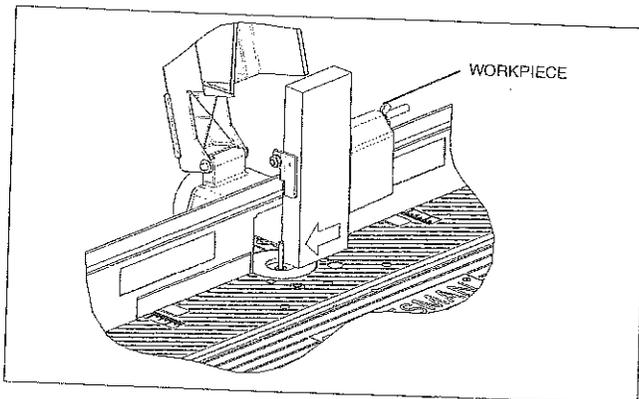
7. Slide the push block with the workpiece clamped, back away from the bit.

8. Turn router "ON" using the switch. Holding the push block and workpiece against the fence WITH BOTH HANDS AND FINGERS A SAFE DISTANCE AWAY FROM THE SPINNING BIT, feed the work piece across the bit, making a full depth of cut in one pass. (DO NOT STOP FEEDING THE WORK PIECE UNTIL IT HAS COMPLETELY PASSED ACROSS THE ROUTER BIT.) (Figure 55)

NOTE Clamp and test cut a scrap piece of wood to check your adjustments before making your finished cut.

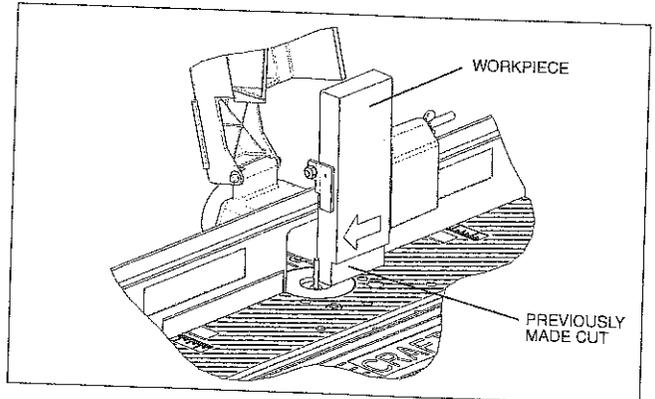
9. Turn router "OFF" using the switch. Unclamp the work piece and slide the push block back to the previous starting position.

FIGURE 55



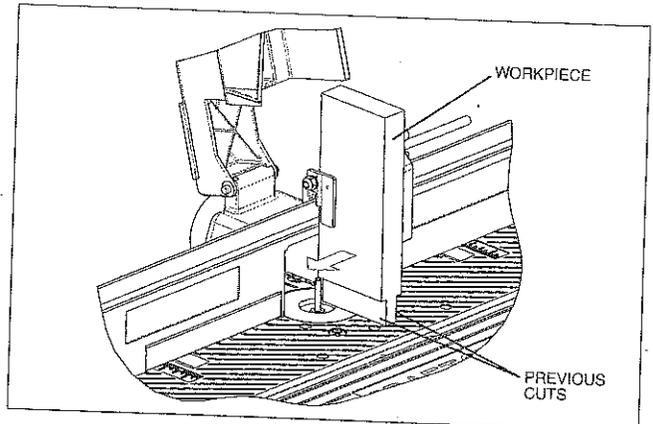
10. Position and clamp the workpiece in the same manner as described in step 5 (Figure 56). (Make sure the wing nut is tightened just enough to clamp the work piece in position, and the end to be cut is resting flat on the top of the router table.) Repeat steps 7, 8, and 9.

FIGURE 56



11. To cut ends of the tenon, position and clamp the workpiece in the same manner as described in step 5 with the workpiece oriented (Figure 57). Repeat steps 7, 8, and 9. Follow these same steps for cutting the opposite side.

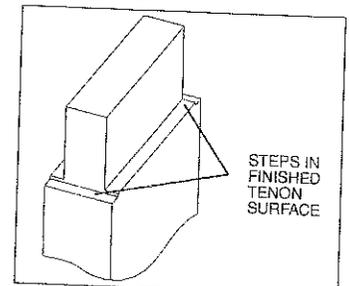
FIGURE 57



NOTE When cutting tenons, always clamp the workpiece with the end to be cut resting flat on the table top. This will minimize steps in the finished tenon surface due to variations in the table top flatness. (Figure 58)

NOTE Always cut full depth on all four sides of tenon in one pass across bit.

FIGURE 58



PARTS LIST

PARTS LIST FOR MASTERCRAFT® MAXIMUM™ ROUTER TABLE

MODEL NO. 54-6800-2

Key	Part No.	Description	Qty.	Key	Part No.	Description	Qty.
		Router table assembly consists of:				Miscellaneous parts consist of:	
1	29LCN-1116-3	Industrial router table	1	18	29LCN-1124-1	Tabletop insert (1 1/4" diameter)	1
2	29LCN-986	Router table leg	2	19	29LCN-1124-2	Tabletop insert (1 7/8" diameter)	1
3	29LCN-990	Side extension	2	20	29LCN-1124-3	Tabletop insert (2 1/8" diameter)	1
4	29LCN-988	Extension brace (right side)	2	21	29LCN-1161	Spacer	4
5	29LCN-989	Extension brace (left side)	2	22	29LCN-1163	Right side scale	
6	29LCN-1122	Router table adaptor plate	1	23	29LCN-1164	Left side scale	1
		Fence assembly consists of:				Fasteners consist of:	
7	29L-660	Clamping knob	3	24	29A-1113	#10-32 KEPS nut	36
8	29LCN-994-3	Router table fence	1	25	29GD-321	1/4" washer cap pushnut	1
9	29LCN-1165	Clevis pin	1	26	29A-306-37	13/64" I.D. x 9/16" O.D. x .040" thick washer	1
10	29LCN-760	Overhead guard	1	27	29A-306-41	9/32" I.D. x 3/4" O.D. x 1/16" thick washer	3
11	29LCN-758	Adjustable fence	1	28	29A-306-42	11/32" I.D. x 11/16" O.D. x 1/16" thick washer	2
12	29LCN-997-1	Fence guide	1	29	29L-469-22	#10-32 x 7/8" long panhead machine screw w/Phillips recess	2
		Mitre gauge consists of:		30	29LD-841-2	#10-32 x 5/8" long flat countersunk head machine screw w/Phillips recess	4
13	312-560	Mitre gauge knob	1	31	29A-970-5	#10-32 x 1/2" long truss head machine screw w/Phillips recess	34
14	29L-253	Protractor head	1	32	29A-246-20	1/4-20 x 1" long hex cap screw (finished hex bolt)	1
15	29LCN-1119	Mitre bar	1	33	29A-310-7	1/4-20 x 1 3/4" long round head square neck bolt	2
		Switch assembly consists of:		34	29A-310-26	#10-24 x 7/8" long round head square neck bolt	1
16	29LCN-1019	Switch assembly	1	35	29LCN-979-1	#10-16 x 1/2" long type "BT" tapping panhead screw w/Phillips recess	1
17	29LCN-1018	Switch safety key (repair part only)	1	--	49LCN-89	Owner's manual	1
		Push block assembly consists of:		D	29A-252-16	5/16-18 wing nut	1
A	29LCN-759	Push block	1	E	29A-242-16	1/4-28 hex machine screw nut	1
B	29L-651	Clamp rod	1	F	29A-327-5	1/4" I.D. x 1/2" O.D. x 3/64" thick spring lock washer	1
C	29L-652	Clamp plate	1				

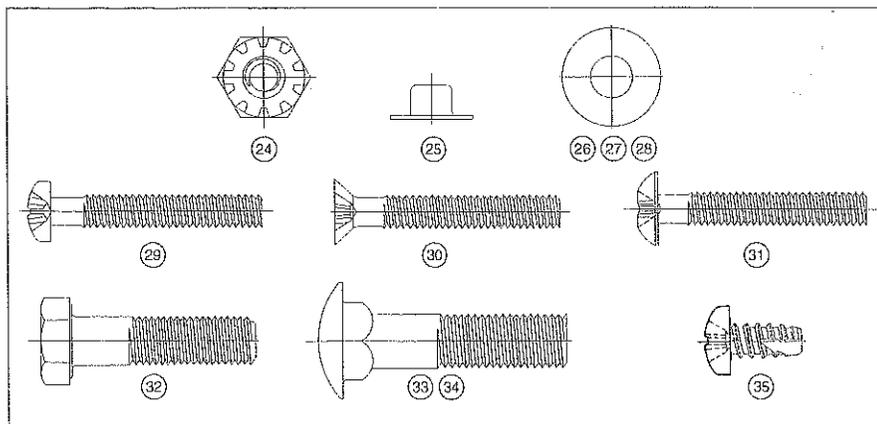
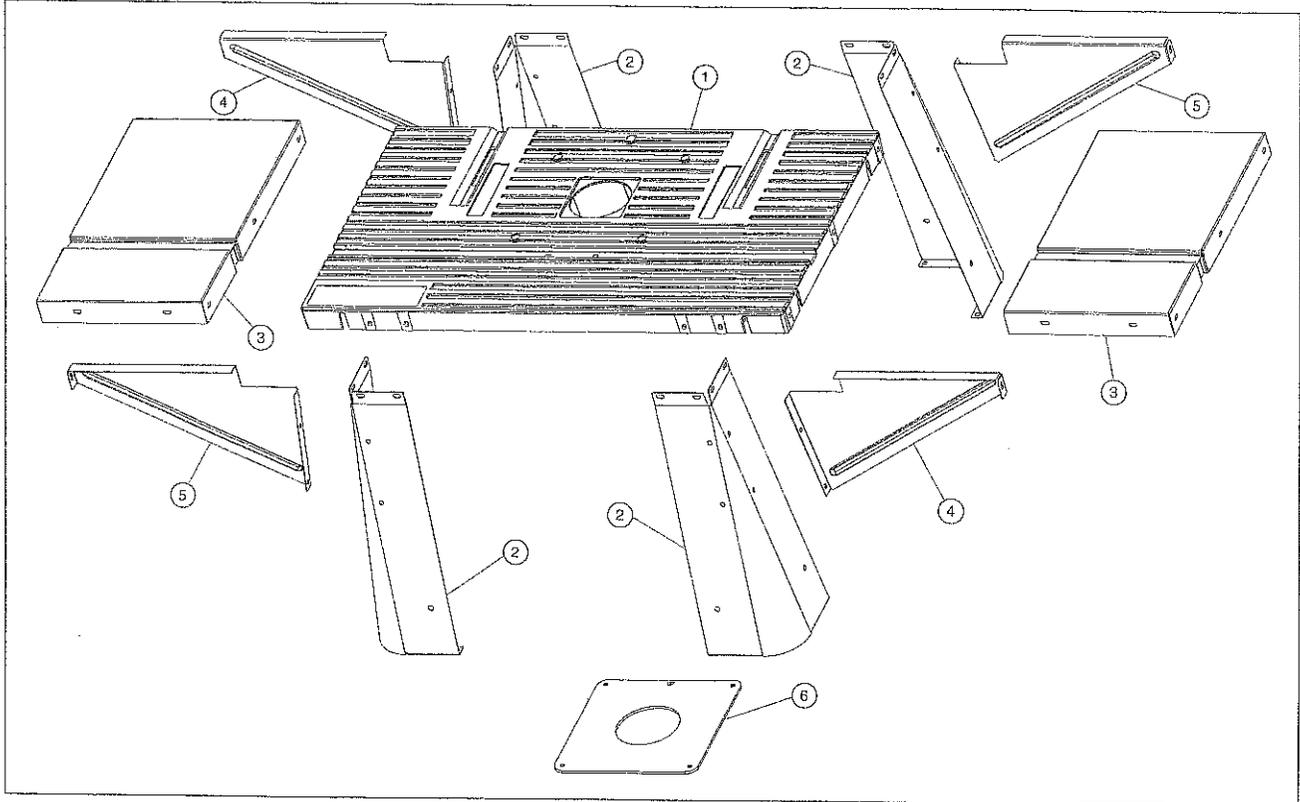
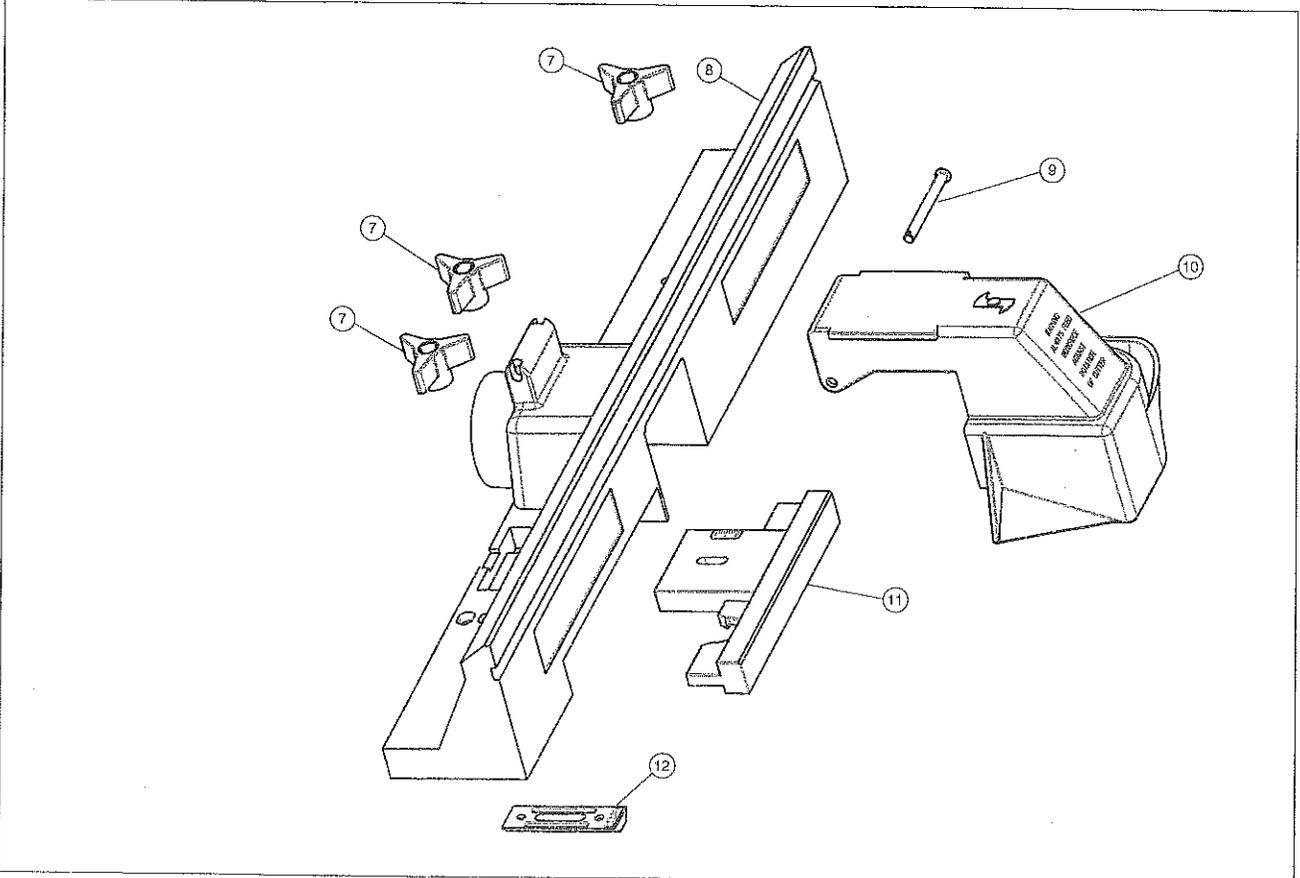


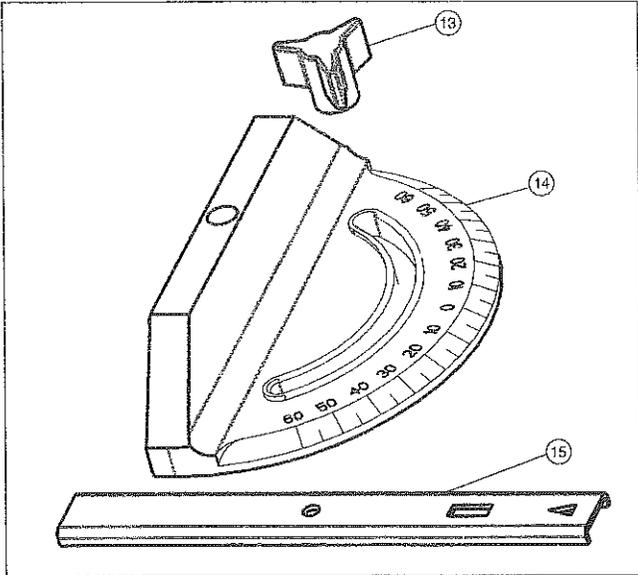
TABLE ASSEMBLY



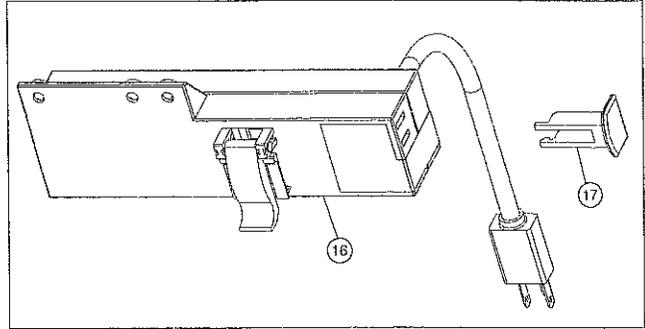
FENCE ASSEMBLY



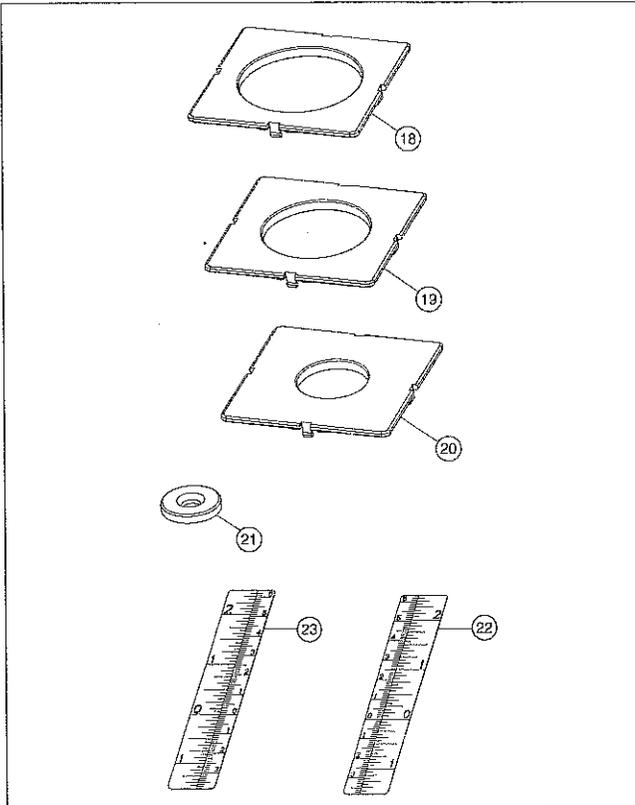
MITRE GAUGE



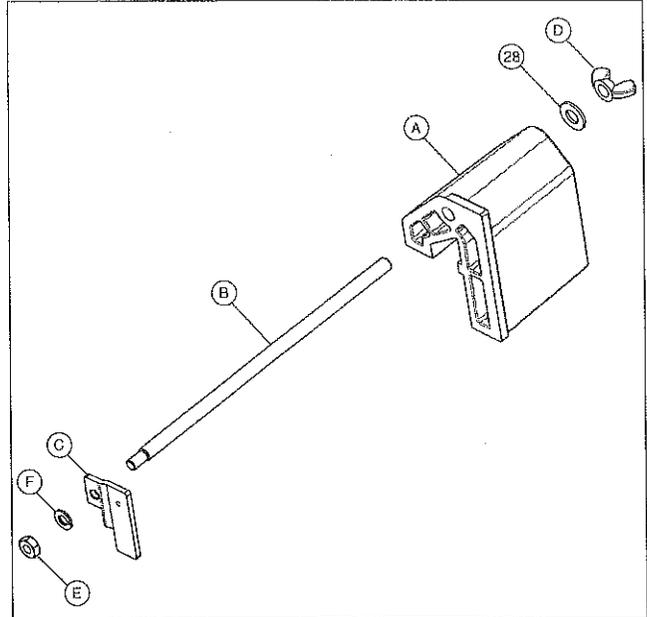
SWITCH ASSEMBLY

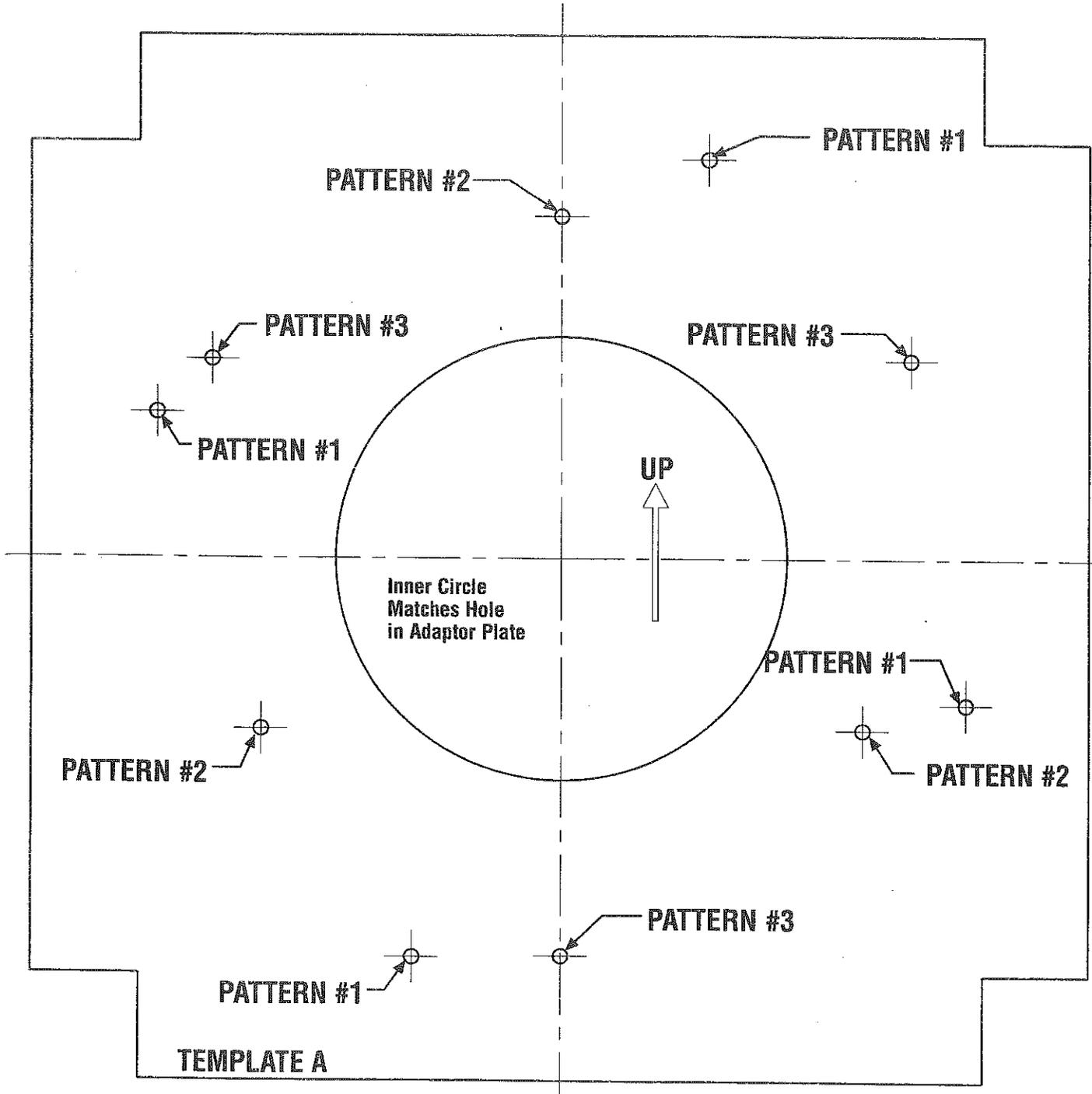


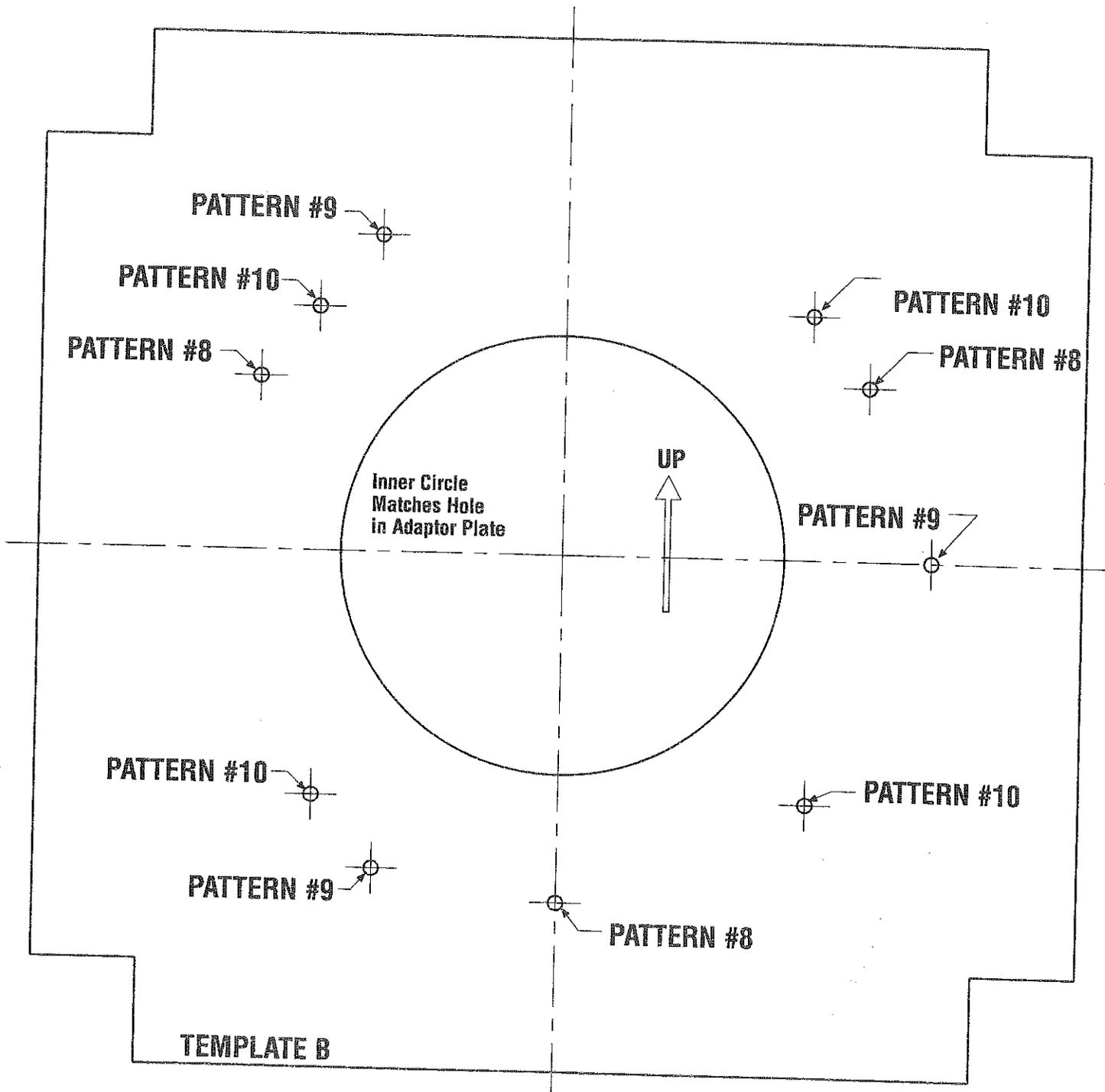
MISCELLANEOUS PARTS

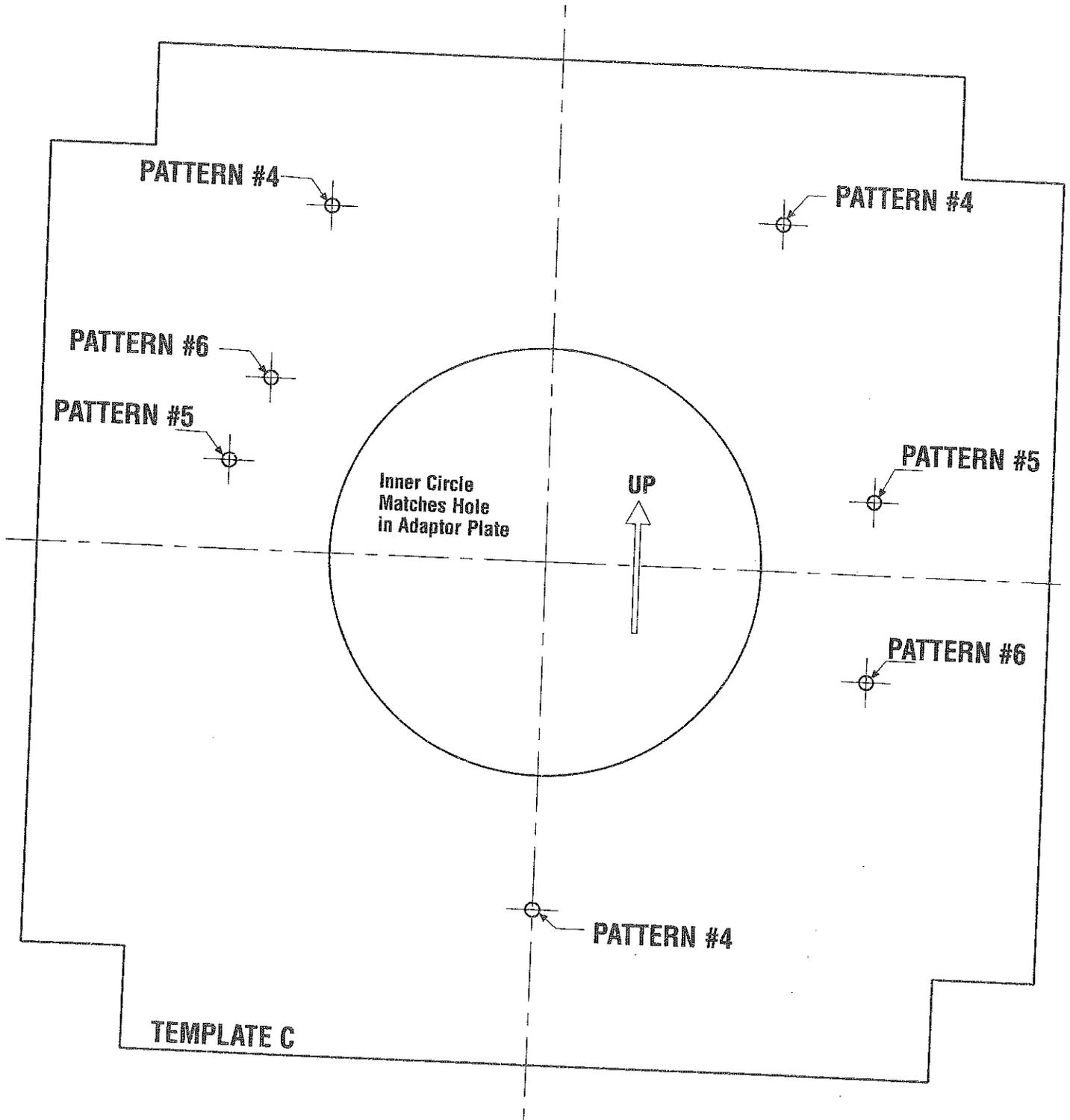


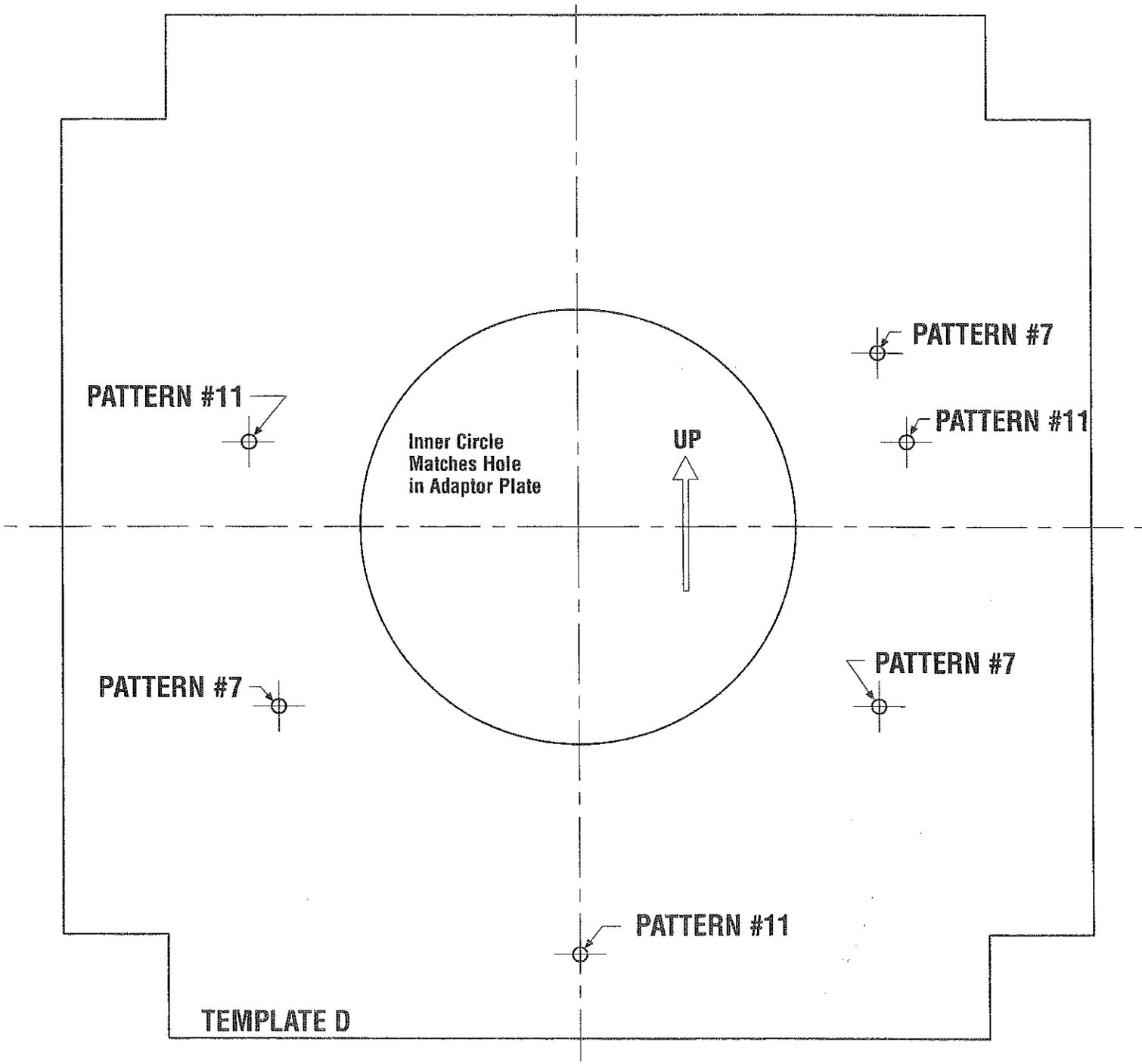
PUSH BLOCK

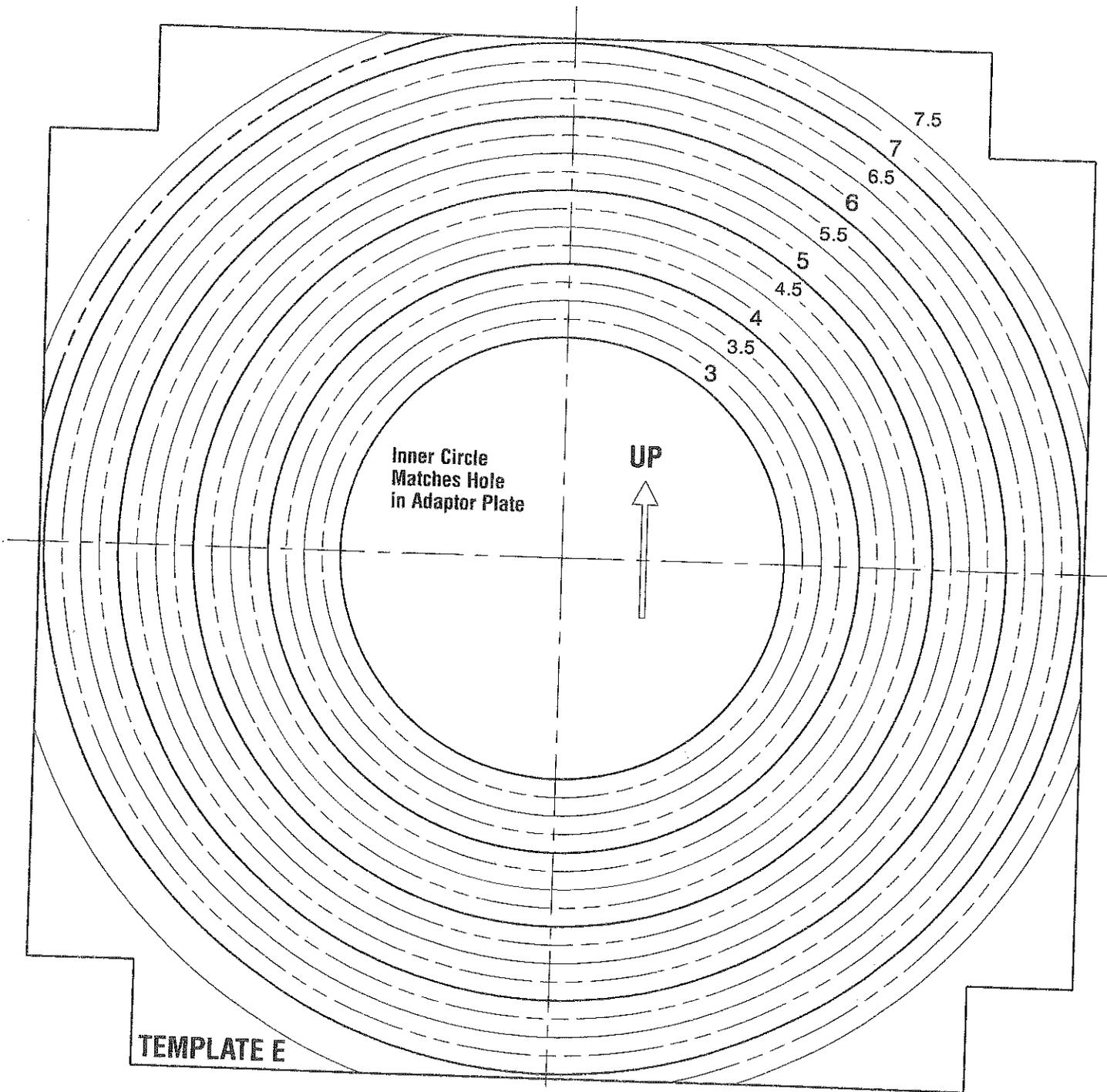


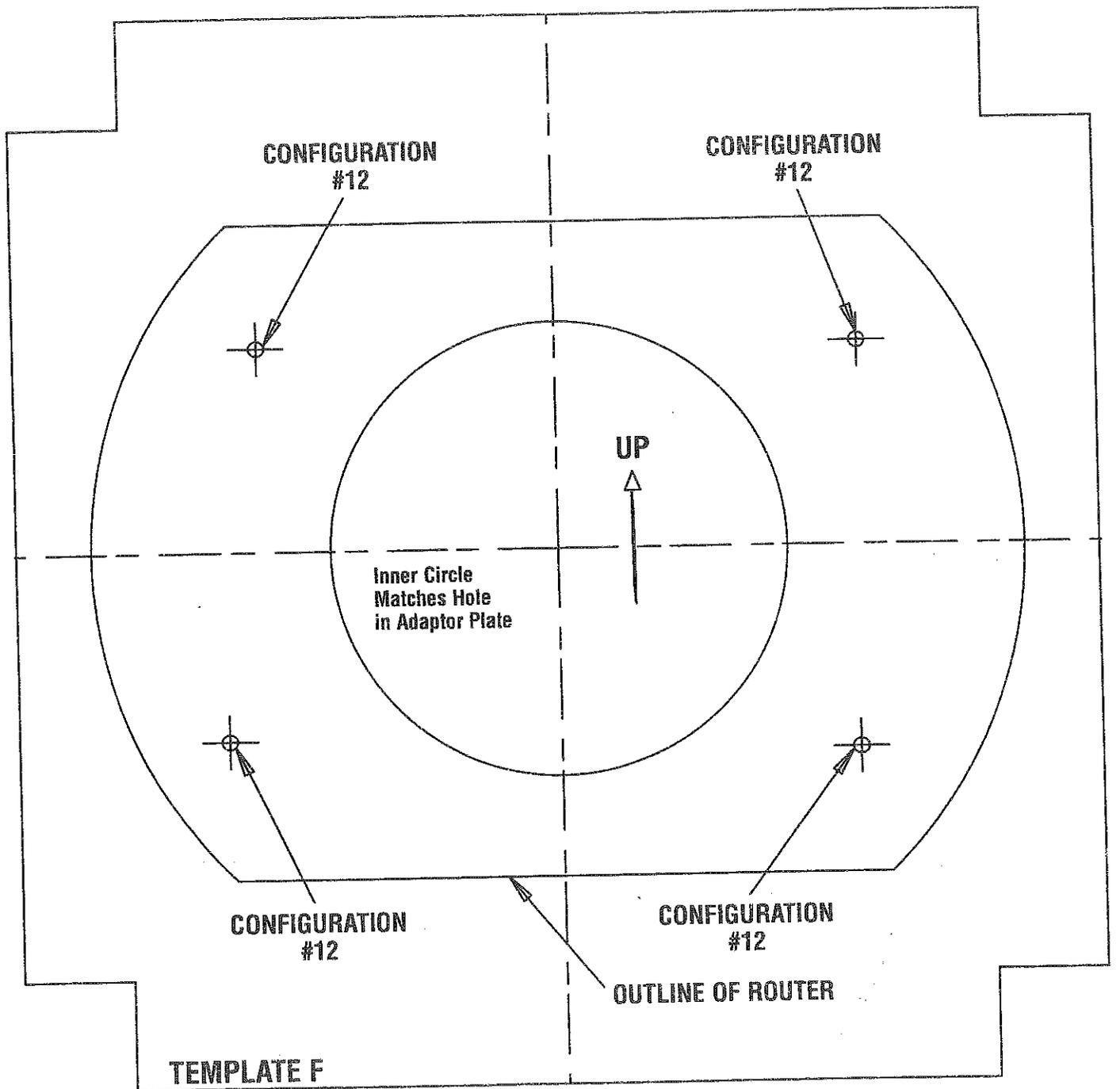




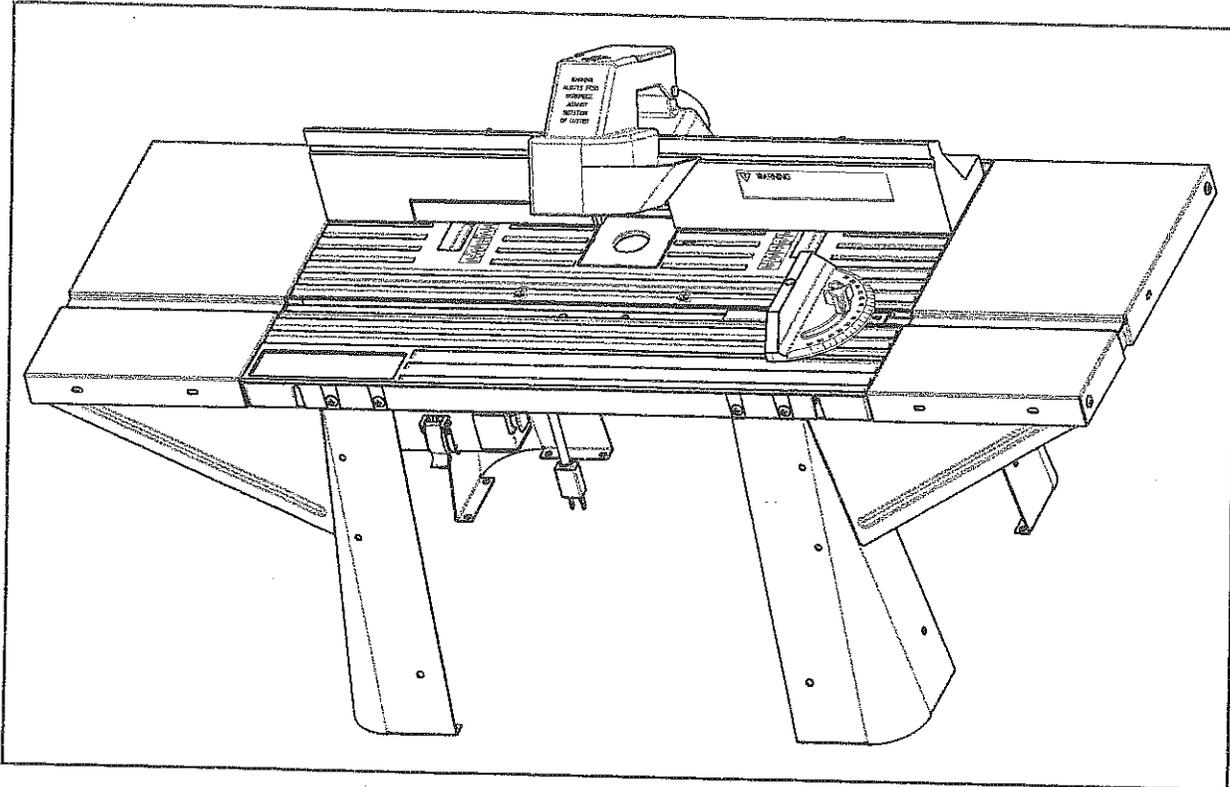








Mastercraft
MAXIMUM
ROUTER TABLE



MODEL #54-6800-2

WARNING

Before operating product,
read this manual and follow
all its safety and operating
instructions.

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