

## **SAFETY**

The Reverse Glue Joint Bit must be used in a table-mounted router, at a maximum of 18,000 rpm.

Always unplug the router before changing or working around the router bit.

Always use push sticks, feather boards and other appropriate safety devices to keep your hands a safe distance from the bit.

## **MATERIAL PREPARATION**

The boards being joined should be the same thickness and have straight square edges.

Lay out the pieces being joined in the order they will be in the finished panel.

Mark one side of each joint with an "A" and the other side with a "B," writing on the top of the boards next to each joint. If several boards are being joined, number their ends, left to right, so they can be returned to their proper position for gluing.

## **BIT SETUP**

Use test pieces the same thickness as the material to be joined. When the setup is perfected, save one of the final test pieces as a setup gauge when joining the same thickness wood in the future.

Draw a line along the center of the edges being joined and adjust the height of the Reverse Glue Joint Bit so the center of the upper bevel on the tooth-like projection aligns with the centerline of the stock. Adjust the fence so inner vertical edges of the Reverse Glue Joint Bit cutter are flush with the face of the fence.

See photos at left.

Cut the test "A" piece face up and the "B" piece face down. Turn the "B" piece right side up and fit them together to see how even the pieces are at the joint. If the "B" piece is low, raise the bit one-half of the difference between the boards. If the "B" piece is highest, lower the bit one-half of the difference. Repeat the test cuts and adjust as necessary until the faces of the two boards are flush when fit together.

**Note:** You cannot re-cut the test boards. After each cut, use a new set of test boards or cut a fresh, square edge on the pieces.

When the test joints come out flush, your Reverse Glue Joint Bit is ready to machine the joints on the project wood.

**Tip:** Using feather boards to keep the wood flat against the table as it passes over the bit will help produce straight, even joints.