

Routing Raised Panel for Raised Panel Doors Using Horizontal Panel Raisers

- If you would like the panel flush with the stile and rail, make your panel 5/8" thick. If you are using an undercutter the panel can be the same thickness as the stile and rail.
- Max RPM for the Horizontal Raised Panel Cutters is 12000 RPM.
- It is always better to take 3 or 4 passes to achieve the desired cut.
- Try to use dust collection when possible.
- Panels should be planed and cut to size before using the raised panel cutter.
- To make the panels the correct size use this formula.
For the panel width: Take the door width and subtract the stile width twice and then add 3/4" to the result width for stile and rail groove.
For panel height: Take the height of the door and subtract the rail height twice and add 3/4" to the result for the stile and rail groove.
(Remember that the panel should be 1/16" to 1/8" smaller than measurement for expansion. Example: If the panel for your door needs to be 12-1/4" wide by 16-1/4" high cut the panel 12-1/8" by 16-1/8")
- Mount the Raised Panel bit into the router and raise the bit 25 to 35 percent of the final height of the cut.
(If you are using a bit with an under-cutter installed you will need to adjust the bit to proper height and rout the wood in 3 or 4 steps by moving the fence to achieve the desired cut.)
- Make 3 or 4 passes raising the bit each pass. When finished the tongue thickness should be just shy of the groove opening.
(Whiteside bits produce a 1/4" groove opening that is 3/8" deep on our standard stile and rail or 5/32" by 1/4" deep for the miniature.)
- Always cut end grain first.
- Always use scrap material to test each cut and make sure the cut feels good before proceeding.
- When panel is finished, the panel should fit into groove without pressure. If the panel is too tight for the groove the wood may split on the stile and rail.
- Do not use glue on the panel (where it inserts into the stile and rail) when gluing up the door.
Glue on the raised panel may cause the door to warp or the stile and rail may come apart from pressure.