

Whiteside USA Stile and Rail Setup

Recommended RPM for Whiteside Stile and Rail Router Bits is
18000 RPM

All stock should run “face down” when making stile and rail doors.

- Stiles are as long as the door is tall plus 1/16” (1/16” trim or sanding allowance)
- Rails are = to door width minus stile width *2 plus 3/4”(1/2” for miniature)
Example: If the door is 12” wide and the stiles are 2” wide then
 $12 - (2 * 2) + 3/4(1/2 \text{ for miniature}) = 8 - 3/4$ ” wide rails (8-1/2” wide for miniature)
- Rails generally look better a little wider than the stiles
- Material for stiles and rails should be the same thickness
- Insert the bit into the router and align the fence even with the bearing. Without turning the router on, make sure a straight edge can pass by and touches the bearing.
- Rout the entire inside edge with the stile bit. The large diameter of the bit should cut about a 1/16” step when running the stile bit. This will ensure there is enough wood on the back side to hold the panel in place without any problems. (Whiteside #'s its bits with an “A” for the stile and “B” for the rail ends)
- Now you are ready to rout the rail ends. To align the rail cutter correctly after it is inserted into the router, take a stile, which has already been routed and with the face down align the bottom side of the groover with the bottom of the tab above the slot. This will get the cut very close and fine adjustment may be necessary to make sure the boards line up flush.
- For safety, always use a push block that can support the entire rail when routing the ends. If you do not use a good push block, the material can turn in the cut or grab the wood and give an unsatisfactory cut.
- Always use an extra piece of wood to get the correct setup and prevent extra waste.
- **Use a door edge bit to complete the door with a nice detail provided with the bits to the right.**

Do not rout the edge until the doors have been assembled and the glue has dried.

Door Edge Bits

Improve any stile and rail door with any of these edge profiles.

Insert door profiles here

Page 29, 8 pictures with tool #'s below

