

## Router Table



### Manual and other Paperwork (See QR Codes above)

- IncraRouter1: [https://incra.com/manuals/MastRLiftII\\_Manual.pdf](https://incra.com/manuals/MastRLiftII_Manual.pdf)
- IncraRTInfo: [https://incra.com/router\\_system\\_accessories-mast-r-lift-ii.html](https://incra.com/router_system_accessories-mast-r-lift-ii.html)
- BoraRouter: <https://boratool.com/mwdownloads/download/link/id/188/>

### Instructional Websites and Video Links (See QR Codes above)

- RTSafety1: <https://www.wwgoa.com/article/12-tips-for-using-a-router-safely/>
- RTSafety2: <https://www.youtube.com/watch?v=23lqfubRtTg>

### Tool Specific Rules

- Unplug the machine when changing bits.
- Unlock the router table cam lock before adjusting height (rotate counter clockwise ¼ turn), lock the cam lock before turning on the router (rotate clockwise ¼ turn). Note the arrows do not always line up correctly.
- Ensure that the bit is not cracked or chipped before using it.
- Ensure that the collet is securely tightened using the wrenches provided with the router.
- The workpiece must always be in firm contact with the fence, OR a rub bearing mounted on the bit. Do not try to make free-hand cuts (ie while using a bit without a bearing and not contacting the fence).
- Never start the router with the bit in contact with the stock.

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- Make sure that the workpiece is fed from Right to Left. Never climb cut (feeding stock in the same direction as the bit is spinning).
- Match the router speed to the diameter of the cutter. The speed dial on the router is at the lowest point on the router (as installed on the router table). Router manufacturer recommended speeds:

#### Variable Speed Dial

The variable speed dial allows you to adjust the rotating speed (RPM) of the tool.

Use the following chart to determine the best speed for the bit diameter.

Speed Setting	RPM	Max. Bit Diameter
Slow	10,000	3" to 3-1/2"
Slow	12,000	3" to 3-1/2"
Medium	14,000	2-1/4" to 2-1/2"
Medium	16,000	2-1/4" to 2-1/2"
Medium	18,000	1-1/4" to 2"
Fast	20,000	1"
Fast	22,000	1"

- Use the smallest diameter magnetic table insert that will allow the bit to pass through it.
- Never adjust the router depth, fence position or fence gap with the router running.
- When the router bit overlaps the fence, minimize the gap in the fence. Adjust the fence halves so that they come to within 1/16" to 1/8" from the bit.
- Never shape stock less than 12" in length unless it is secured in an appropriate jig or fixture or push blocks.
- To control the stock, use push sticks, push blocks, feather boards, or any other safety device whenever possible.
- When pattern shaping, ensure that the workpiece is adequately secured to the pattern with screws or sufficient double-sided tape.
- Never cut narrow stock that is less than three times the width of the profile to be cut.
- Cut at a moderate feed rate. Feeding too fast may cause the workpiece to have tearout or excessive machine marks. Feeding too slow may cause the cutter to heat up and burn the workpiece.
- Ensure that the base cabinet door is closed when the shaper is running. This door prevents access to moving parts and ensures that the dust collection system is operating efficiently.
- Ensure that the dust collector is running and that the blast gate to the router table is open before starting the router. Close the blast gate when you are finished using the router table and turn off the dust collector if no one else is using it.