



4555

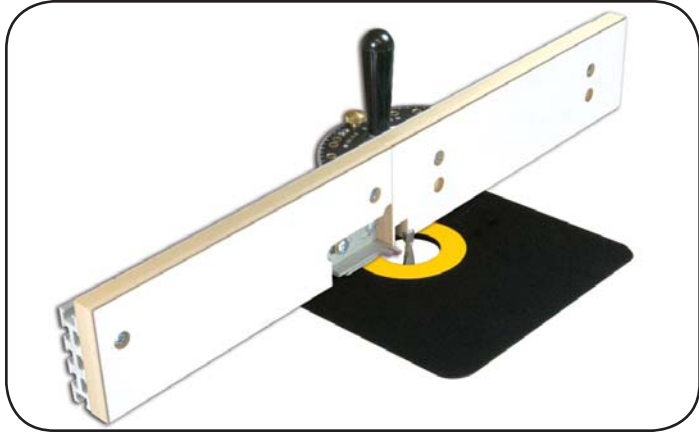
Box Joint Jig

Owners Manual

Please Read Carefully!

4555 Parts List:
 Please identify and verify that you have all of the hardware shown below prior to assembly.
 Parts listed below are not shown in the hardware drawings. Refer to photos in the instructions:

Part	Description	Quantity
4555A	24" Ultra Track.....	1
4555F	MDF Sub-Fence, 2 pc. set.....	1
4555S	Aluminum Stops, 2 pc. set.....	1



Part#	Description	Qty.
HB040	1-1/4" Bolt	2

Part#	Description	Qty.
5771B	3/4" Screw	4

Part#	Description	Qty.
MP375	3/8" Screw	1

Part#	Description	Qty.
5770B	1/2" Screw	1

Part#	Description	Qty.
WB002	Washer	3

Part#	Description	Qty.
5765B	Offset Oval Nut	2

Part#	Description	Qty.
5760B	Oval Nut	4

Part#	Description	Qty.
5540	Knob	2



BEFORE BEGINNING

Identify and verify that you have all the parts listed. Read the instructions at least once, familiarizing yourself with the parts before beginning. You'll need a #2 & #3 Phillips screwdriver for assembly.

ASSEMBLY

To attach the Ultra Track to a Woodhaven miter gauge, use the hardware that came with the miter gauge. To attach the Ultra Track to another brand of miter gauge, mount a 3/4" thick wood sub-fence to your miter gauge with wood screws and drill two 9/32" mounting holes in the wood sub-fence. The mounting holes should be located 1-1/2" to 2-1/4" up off the table and be located in an area that will not interfere with the operation of the miter gauge or the use of the knobs. Use the 1-1/4" bolts (*HB040*), washers (*WB002*) and knobs (*5540*) to attach the Ultra Track to the wood sub-fence. *See Fig. 1.*

Install the 3/4" screws (*5771B*) into the counterbored holes in the two MDF Sub-Fences (*4555S*) and install oval nuts (*5760B*) on the ends of the screws. The Sub-Fence is a two piece set. One piece is rectangular in shape and the other is rectangular with a cutout. With the bottom edge of the 24" Ultra Track (*4555A*) resting on a flat surface, install the rectangular Sub-Fence on the Track. The oval nuts will slide in the upper T-slot of the track. Position the end of the Sub-Fence even with the end of the track and tighten the screws. This Sub-Fence has an extra set of holes so it can be rotated 180° and the opposite end can be used. *See fig. 2.*

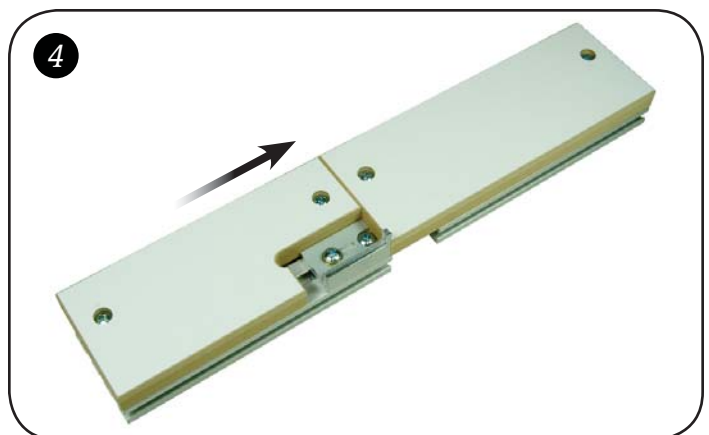
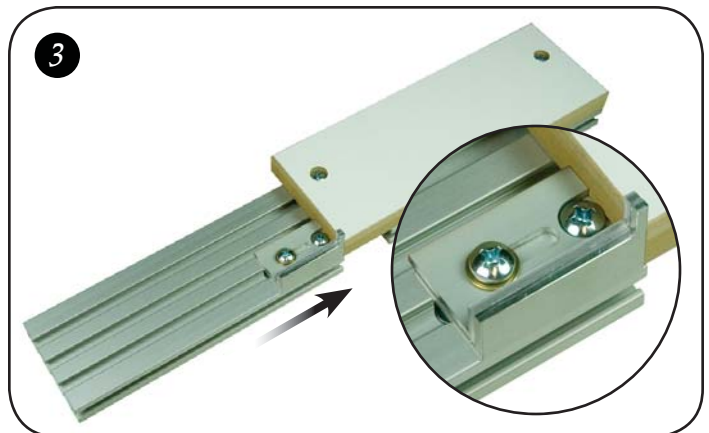
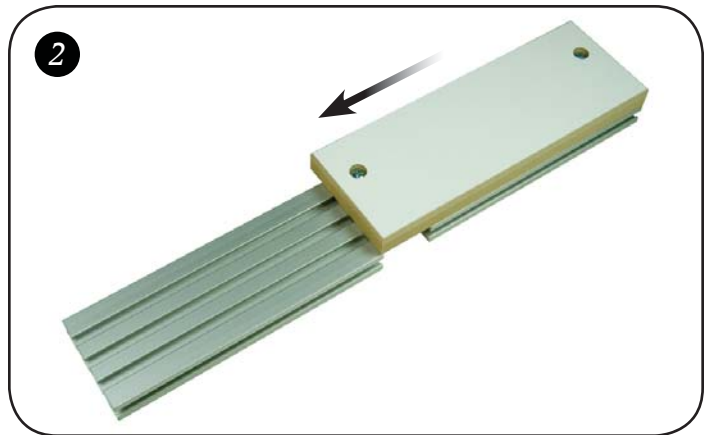
Attach both Stops (*4554S*) to the Ultra Track (*4555A*). Holding the two Stops together, insert a 3/8" screw (*MP375*) thru the right hole in the rear Stationary Stop and start an offset oval nut (*5765B*) on the end of the screw. Install a washer (*WB002*) on the 1/2" screw (*5770B*) and insert it thru the slot/hole to the left of the 3/8" screw just installed and start an offset oval nut (*5765B*) on the end of the screw.

Install the Stop assembly on the Track. Insert the offset oval nuts in the lower T-slot of the Track, keeping the offset portion of the oval nuts facing to the left. With the bottom edge of the Track resting on a flat surface, slide the Stops to the right, against the rectangular Sub-Fence, and tighten the screws. *See fig. 3.*

Install the remaining MDF Sub-Fence (*with the cut out*) on the left side of the Track and tighten the screws. *See fig. 4.*

CUTTERS

The most common router bits for box joints are 1/4", 3/8" and 1/2". The minimum required depth of cut with this jig is 1/4". Set the cutting height of the tool (dado blade or router bit) to the thickness of work plus 1/32", or the minimum depth required above, whichever is greater. Any overhang will be removed later after assembly by sanding, sawing or routing with a flush trim bit. Make sure you allow for this overhang when figuring the overall length of the workpiece. 1/2" shank spiral bits are excellent when cutting solid woods. Dado blades work best for cuts over 1/2" wide or more than 3/4" deep.



USING THE BOX JOINT JIG

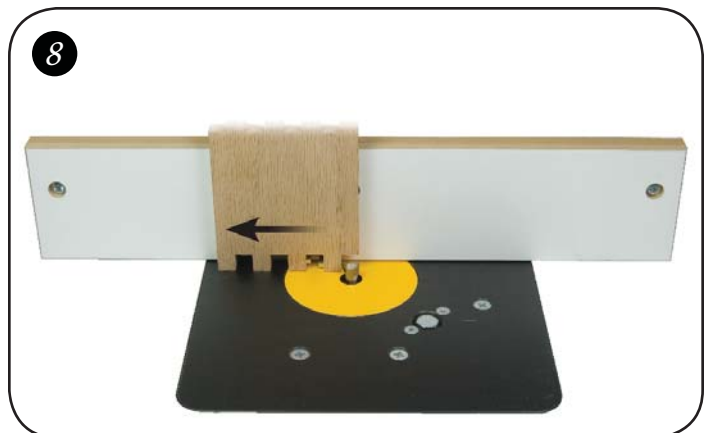
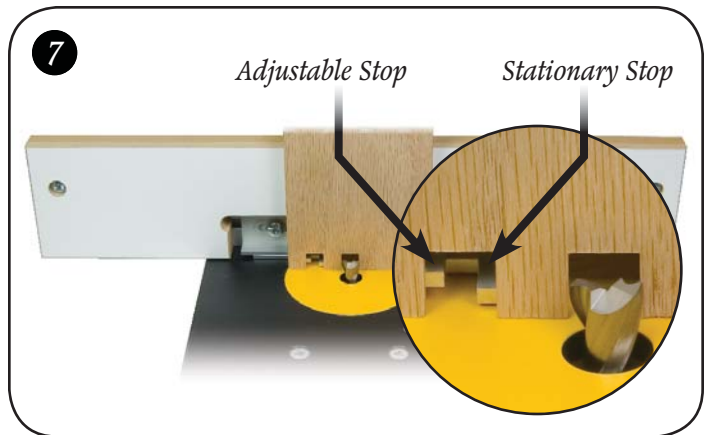
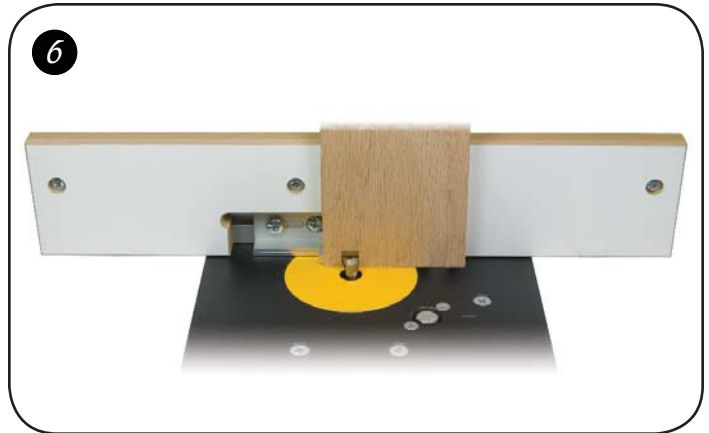
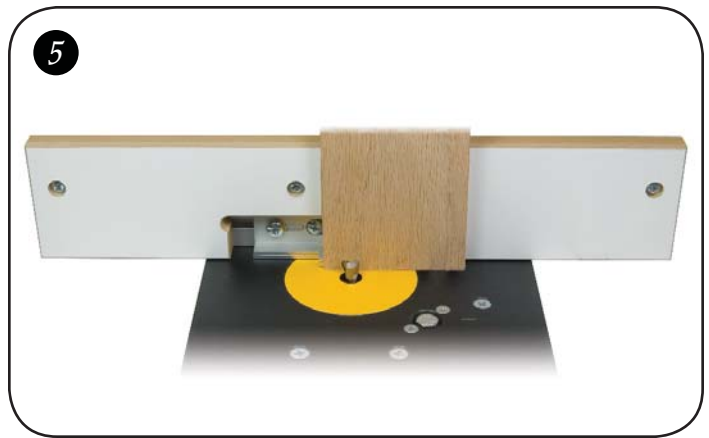
The capacity of this jig is 13/16" wide by 1-5/8" deep. Attach the Track/Jig to your miter gauge. Adjust the track left or right in relation to the blade so that the distance between the edge of the Stationary Stop and the edge of the router bit (or dado blade) **EQUALS** the cutting width of the router bit or dado blade. This will require test cuts.

Stand the first workpiece on end with its edge butted up against the Stationary Stop. Hold or clamp the workpiece and slide the jig forward far enough to cut completely through the workpiece and **NO FURTHER**, then turn the power off. This helps prevent injury when the cutter exits the rear of the jig. If desired, a homemade guard can be added to the back of the track. *See fig. 5 & 6.*

Hop-sotch the workpiece over the Stationary Stop. Index the edge of the cut-out against the Stationary Stop. Slide the Adjustable Stop away from the Stationary Stop until it touches the opposite side of the box joint, then tighten. The work should be captured firmly between both Stops. *See fig. 7.*

Continue cutting along the entire width of the workpiece, hop-scutching each cut-out over the Stops to index the workpiece for the next cut. *See fig. 8.*

Continued on back page....



To make the mating cuts on the second workpiece, you need to offset the first cut on the second workpiece by the width of the joint (which is the same as the width of the router bit or dado blade). Take your first workpiece and flip it edge for edge so that the first box joint is indexed on both Stops. Butt the second workpiece against the edge of the first workpiece. *See fig. 9.*

Hold both pieces and make the first cut on the second workpiece. Remove the first workpiece and continue cutting the second workpiece as you did the first. *See fig. 10.*

You can cut multiple parts at one time by clamping like parts together (fronts & backs, left & rights, etc.) with their edges aligned.

Joints that are glued should have a “slip” fit (.004 to .008" of gap) to allow room for the glue. Adjust the fit of your joints by slightly increasing or decreasing the distance between the Stationary Stop and the cutter by moving the entire jig left or right on your miter gauge. To aid in making small adjustments, clamp a board to the back of the jig, on the side you want to move it to, and butted against the head of the miter gauge. Now when you move the jig, a small gap will open up between the board and the miter gauge. By using a feeler gauge, or piece(s) of paper (a piece of paper is about .002" thick), you can move the jig in small increments to adjust the joint fit.

Replacement fences (*4555F*) are available from Woodhaven, or you can make your own out of 3/4" material.

©Copyright WOODHAVEN INC. 11/10/08
(800) 344-6657 or WWW.WOODHAVEN.COM

