

WOODHAVEN

# 528 Small Coping Sled

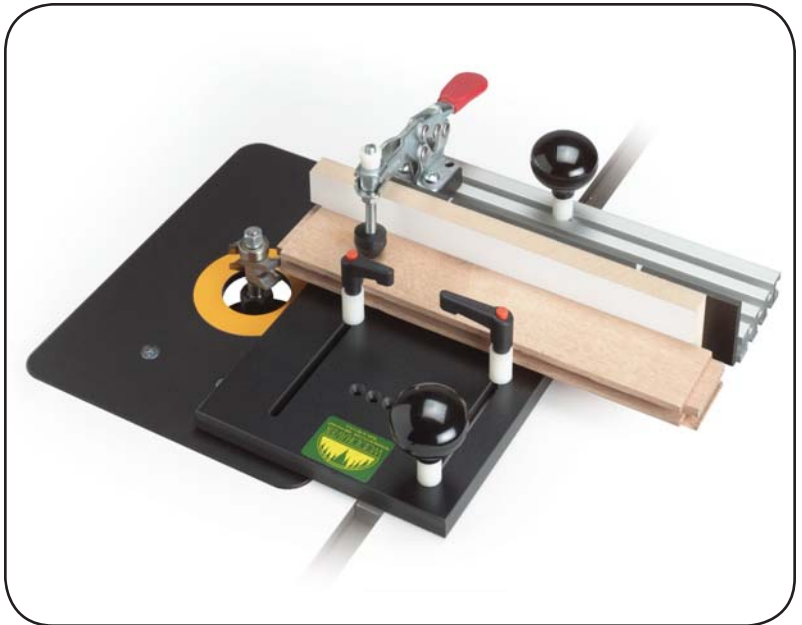
*Please Read Carefully!*

## 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
528B	Sled Base . . . . .	1
526A	1/4" Phenolic Fence . . . . .	1
4412	12" Ultra Track Fence . . . . .	1
6305IC	Inboard Clamp . . . . .	1
4912B	11-3/4" Jig Bar . . . . .	1



Part#	Description	Qty.
BUSH004	5/8" Spacer	4

Part#	Description	Qty.
5760B	Oval Nut	4

Part#	Description	Qty.
STP001	3/4" Screw	4

Part#	Description	Qty.
HB040	1-1/4" Bolt	3

Part#	Description	Qty.
BUSH001	1/8" Spacer	2

Part#	Description	Qty.
MF005	1/2" Screw	2

Part#	Description	Qty.
MF010	3/4" Screw	2

Part#	Description	Qty.
MF040	3/4" Screw	2

Part#	Description	Qty.
5590	Knob	2

Part#	Description	Qty.
5860	Ratchet Handle	2

Part#	Description	Qty.
HB030	1" Bolt	1

## 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 assembly. We recommend a #3 Phillips screwdriver for the 1/4-20 Phillips drive screws and a #2 Phillips screwdriver for the smaller Phillips drive screws.

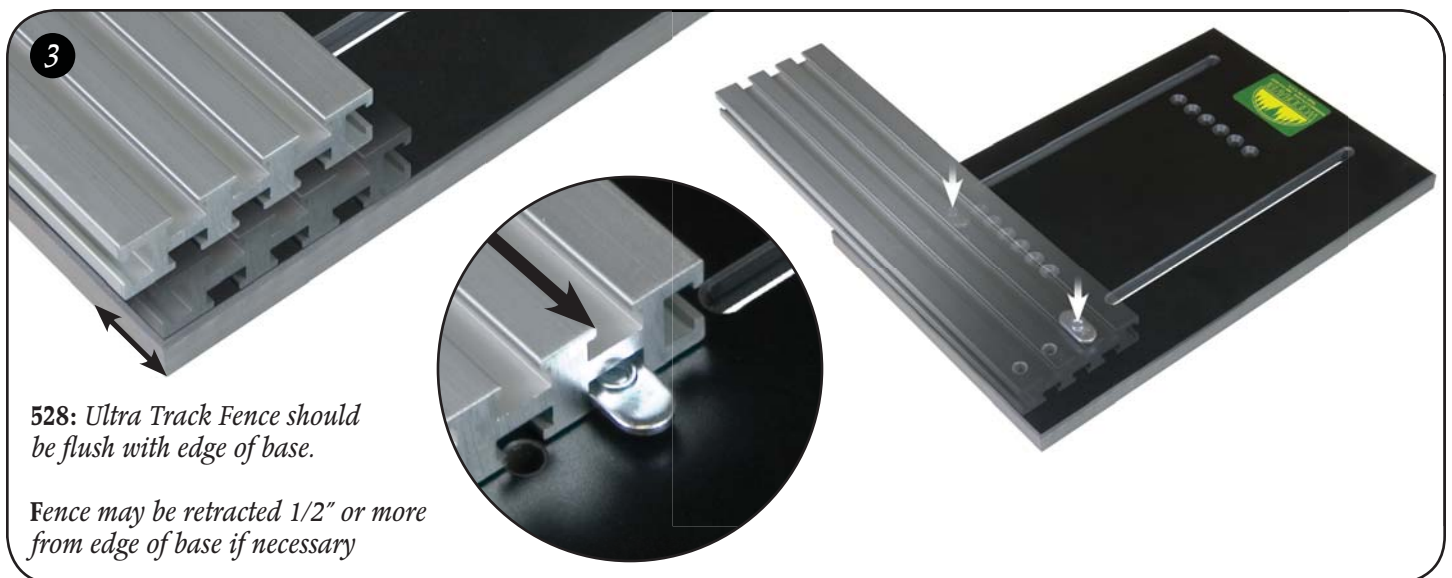
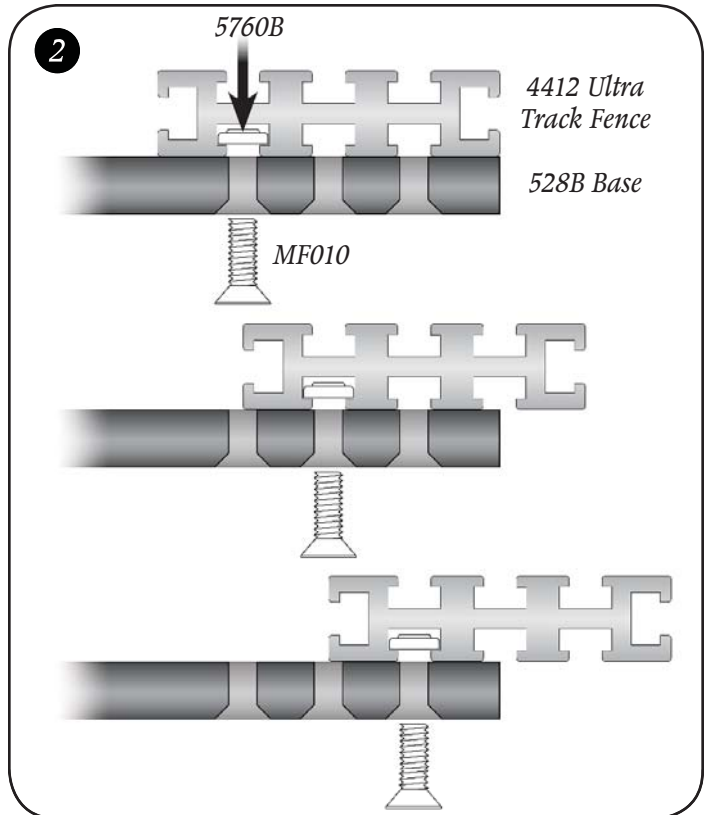
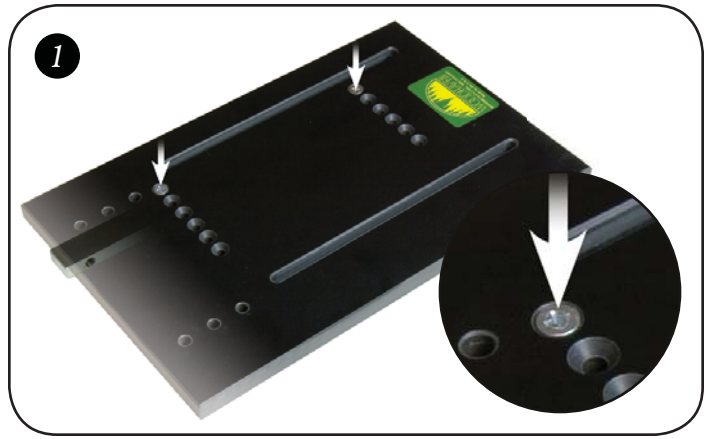
## ASSEMBLY

Open the Jig Bar (**4912B**) and follow the assembly instructions that come with it. After adjusting the bar to fit your miter slot, attach the bar to the phenolic Base (**528B**) using two of the predrilled mounting holes in the base. Select mounting holes that position the base as close as possible to the cutter you'll be using with out striking it. Follow the instruction that come with the bar, *except* use the two 3/4" screws (**MF040**) to attach the bar to the base instead of the 1" screws that come with the bar. *See fig. 1.*

Determine where on the base you wish to attach the 12" Ultra Track Fence (**4412**). *See fig. 2.* The position of the Ultra Track Fence on the base will affect the maximum width of stock that can be used. Referring to *fig. 2*, the upper most drawing depicts the Ultra Track Fence located as far forward on the base as possible, this will limit the maximum stock width you can use to 6-3/8". By using one of the other two mounting positions you can increase this width by 3/4" (7-1/8" capacity) or 1-1/2" (7-7/8" capacity), but you'll also increase the minimum stock width.

Insert a 3/4" screw (**MF010**) through the two selected countersunk holes in the base. Start an oval nut (**5760B - smooth side first**) on the ends of the screws and slide the Ultra Track Fence on the oval nuts. Check the Ultra Track Fence against the base for square and, if you have the **528**, position the end of the fence flush with the inboard edge of the base. *See fig. 3.*

If necessary, you may position the end of the fence 1/2" (or enough so the bit won't strike the fence assembly) back from the inboard edge of the base. *See fig. 3.*



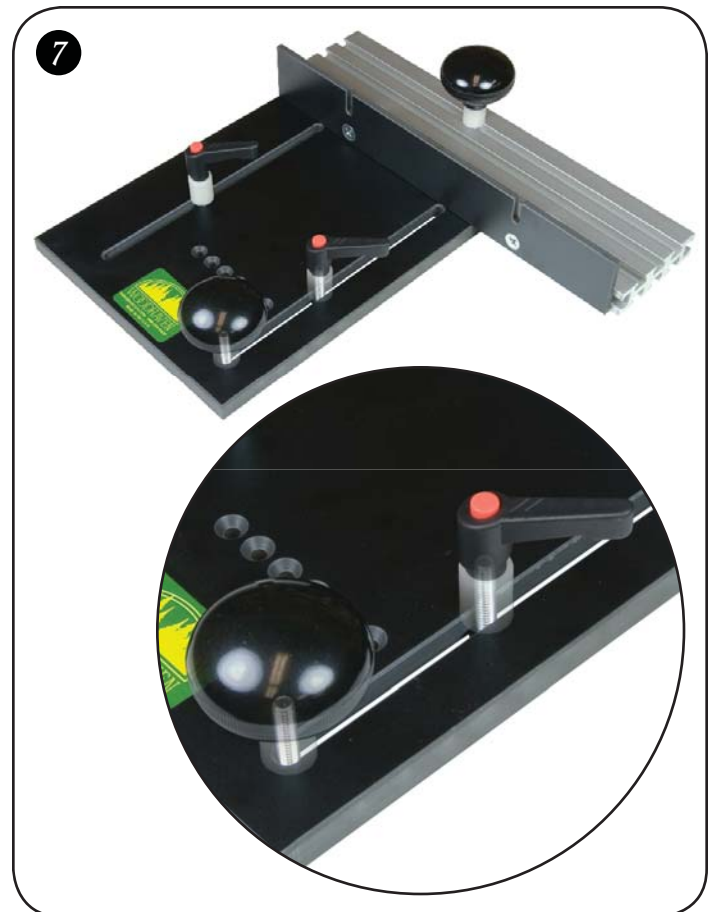
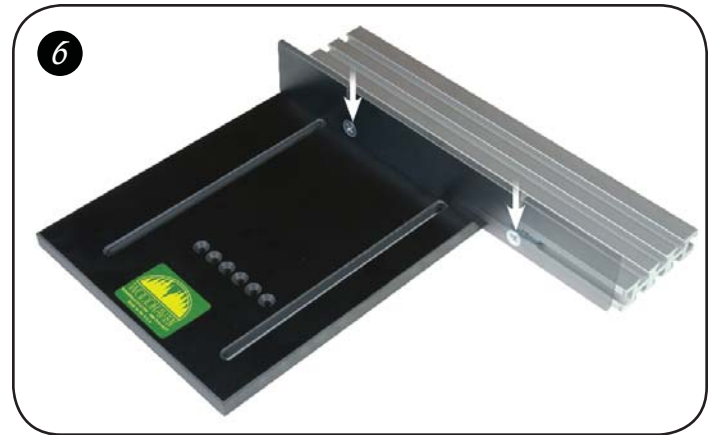
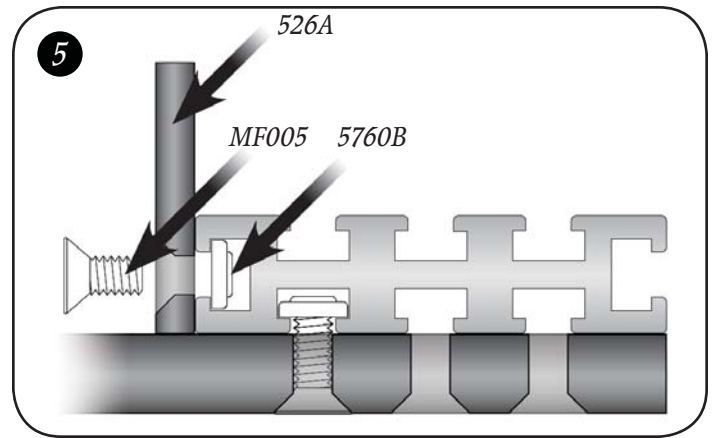
Attach the 1/4" Phenolic Sub-Fence (526A) to the Ultra Track Fence using two 1/2" screws (MF005) and oval nuts (5760B). Insert the screws thru the countersunk holes in the sub-fence and start the oval nuts, smooth side first, on the ends of the screws. Slide the sub-fence on to the front T-slot of the Ultra Track Fence, center it side-to-side on the track and tighten the screws. *See fig. 5-6.*

Attach a knob on the base where shown. Insert a 1-1/4" bolt (HB040) thru the slot in the base, then a 5/8" spacer (BUSH004) and a knob (5590) on the end of the bolt. For now, position the knob at the far corner of the base and tighten. *See fig. 7.*

Attach the two hold-ins on the base. Insert a 1-1/4" bolt (HB040) thru each slot in the base, then a 5/8" spacer (BUSH004), a 1/8" spacer (BUSH001) and a ratchet handle (5860) on the end of each bolt. The hold-ins are positioned against the work to help hold it against the fence when cutting, but can be removed if desired. *See fig. 7.*

Attach a knob on the fence. Insert a 1" bolt (HB030) in the T-slot shown in the fence, then a 5/8" spacer (BUSH004) and a knob (5590) on the end of the bolt. For now, position the knob 5" from the bit end of the fence and tighten. *See fig. 7.*

Assemble the Inboard Clamp (63051C) according to the directions included with it. For now, attach the Inboard Clamp to the fence where indicated. *See fig. 8.*



## USING THE COPING SLED

Make and install a 3/4" thick wood fence. It should be 1-3/4" to 2" tall by whatever length (12 to 24" depending on fence and part length) you desire. Attach the wood fence to the slotted openings in the sub-fence using the 3/4" screws (*STP001*) provided. Wood fences can be quickly changed, so make extras to cover all the zero-clearance bit profiles you need. *See fig. 9.*

Install a cope bit/cutter in your router or shaper. Adjust the bit height, taking into account the 1/2" thickness of the base. We use an extra thick base to insure that there's no distortion to the base when you use the toggle clamp. Most cope bits and routers will work with this sled, but make sure you have at least 3/4" of the bit shank in the router before making any cuts. If extra bit height is needed, you may need to use a router lift or collet extension.

*Make sure the bit or cutter will not strike the base or Ultra Track fence assembly during operation!*

We recommend using the infeed side of your fence and a spacer to help position the work on the sled. The fence must be parallel to the miter slot for this to work. Adjust the fence so the spacer is in line with the bearing on the cope bit. Slide the hold-ins against the work and tighten the ratchet handles. Turn the router on and, holding both knobs, slide the Coping Sled forward past the bit. In the unlikely event the work moves during cutting, glue a strip of 120 grit sandpaper on the base. *See fig. 10 - 11.*

Get the optional *6305R 1" Riser Kit* (one per clamp) to increase the clamp capacity by 1". The *6305OC Outboard Clamp* attaches to the sled base and helps clamp wide boards. The *525F 24" Fence Kit* provides more support for long boards.

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