

WOODHAVEN

BEFORE BEGINNING

Read the instructions at least once, familiarizing yourself with the parts and instructions before beginning.

Your stock should be flat, square and between 1/4 and 3/4" thick. The boards do not all have to be the same thickness. Cut the finished length of the boards between 1/32" and 1/16" longer than the finished length. This gets removed after assembly. Use scraps for the initial test cuts.

ASSEMBLY

Remove the existing template from your 7600-7603 Woodhaven Dovetail Jig and replace it with the Keller Dovetail Template (**7640T1**). The dovetail half of the joints need to be cut first as this is the non-adjustable part of the joint.

Install the dovetail bit (**7533**) in your router and set the depth of cut to 1/64" more than the thickness of your stock (maximum 3/4" thick stock capacity), taking into account the 1/2" thickness of the template.

Swap the locations of the existing stops and position them even with the first opening at each end of the template for now. *See fig. 1.*

CUT DOVETAILS

Loosen the two ratchet handles on the two template nuts and raise or lower the template until a scrap board just fits between the underside of the template and the top edge of the Ultra Track, then retighten the handles. Position the edge of the scrap flush with the face of the Ultra Track and clamp it in place using the dovetail jigs clamps. The scrap board should be at least 1/16" thicker and about 1" wider than the work. The scrap board prevents tear out when the bit exits the back of the work and provides an extra margin of safety to help insure the bit won't hit the Ultra Track.

Install the work in the front of the jig with the **OUTSIDE FACE** of the work against the Ultra Track. Place the end of the work against the underside of the template and the edge of the work against the edge of the stop. Adjust the stop position to align the work where desired in relation to the fingers on the template (center or offset pattern as desired). Tighten the front clamps to hold the work in place. *See fig. 2.*

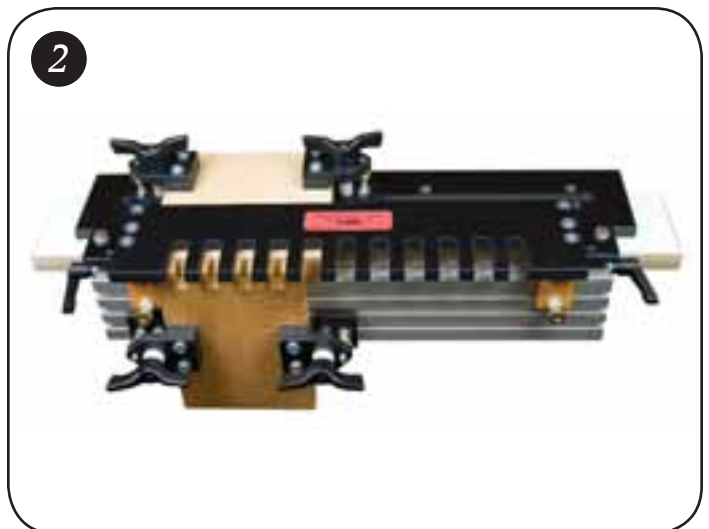
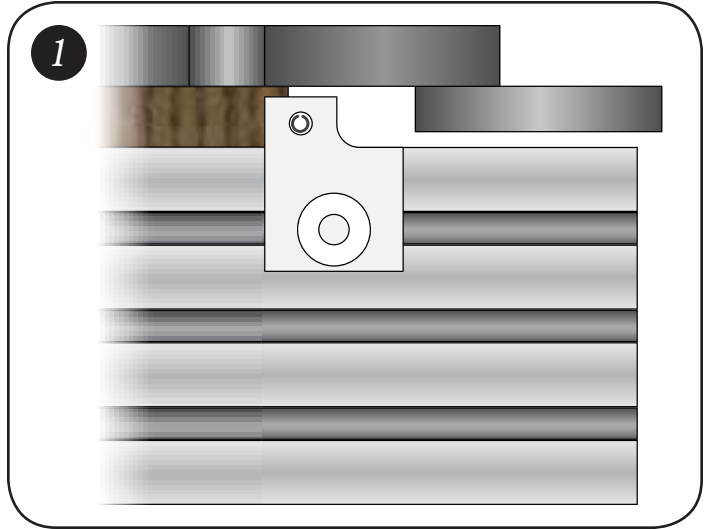
Make a test cut in some scrap. Cut from left to right, following the fingers of the template. If you get chipping on the exposed face of your work you may need to clamp a scrap of 1/4" plywood or hardboard to the face of the work. When satisfied, make all the dovetail cuts in all of your parts.

7640 Keller Dovetail Kit

Please Read Carefully!

Parts List:

Part	Description	Quantity
7640T1	Keller Dovetail Template.....	1
7640T2	Keller Pin Template.....	1
7533	Dovetail Bit.....	1
7543	Straight Bit.....	1



CUTTING PINS

Install the Keller Pin Template (*7640T2*) in place of the Keller Dovetail Template. Install the straight bit (*7543*) in your router. Set the depth of cut to 1/64" to 1/32" more than the thickness of your stock, taking into account the 1/2" thickness of the Pin Template.

Install a new piece of scrap in place of the scarp used for the dovetails, following the same process.

Install the work in the front of the jig with the *INSIDE FACE* of the part against the Ultra Track. Place the end of the work against the underside of the template and the edge of the work against the edge of the stop. The stops must not be moved from the location they were at when you cut the dovetails or the parts will not line up when assembled!! Tighten the front clamps to hold the work in place. *See fig. 3.*

Make a test cut in some scrap. Cut from left to right, following the fingers of the template. If you get chipping on the face of your work you may need to clamp a scrap of 1/4" plywood or hardboard to the face of the work.

Test the fit of the pins in the dovetailed part. The parts should go together with light tapping at most. If the pins are too loose, move the Pin Template forward. If the pins are too tight, move the Pin Template back. A 1/16" (.0625) adjustment (forward or back) of the Pin Template makes a 1/64" (.015) difference in pin width. The template brackets/pin template are adjusted in or out by loosening the two 3/4" bolts holding the template brackets to the template nuts. Make equal adjustments to both template brackets. When satisfied, make all the pin cuts on all of your parts. *See fig. 4.*

Any excess overhang of pins and dovetails can be removed by sanding or routing after assembly.

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