



# 966

## Biscuit Master

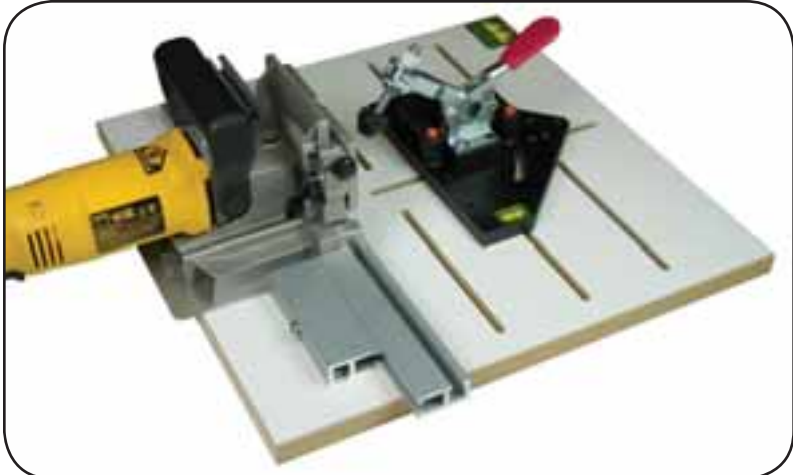
### Owners Manual

*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
966A	Clamp Fence	1
966B	15-3/4" sq. MDF Base	1
966C	Fence Bracket	2
4006	6" Double Track Fence	3
6305	500 lb. Toggle Clamp	1



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

Part#	Description	Qty.
5772B	1" Screw	2

Part#	Description	Qty.
MF015	1" Screw	2

Part#	Description	Qty.
WB002	Washer	4

Part#	Description	Qty.
BUSH1250	1/4" Spacer	4

Part#	Description	Qty.
MF020	1-1/4" Screw	4

Part#	Description	Qty.
5760B	Oval Nut	8

Part#	Description	Qty.
5863	Ratchet Handle	4

Part#	Description	Qty.
MP200	2" Screw	2

Part#	Description	Qty.
NUT025	3/4" Sq. Nut	4

Part#	Description	Qty.
5525	Nylon Knob	1

Part#	Description	Qty.
6305B	Clamp Pad	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. You'll need a #3 Phillips screwdriver for assembly.

### 1-2. BASE ASSEMBLY

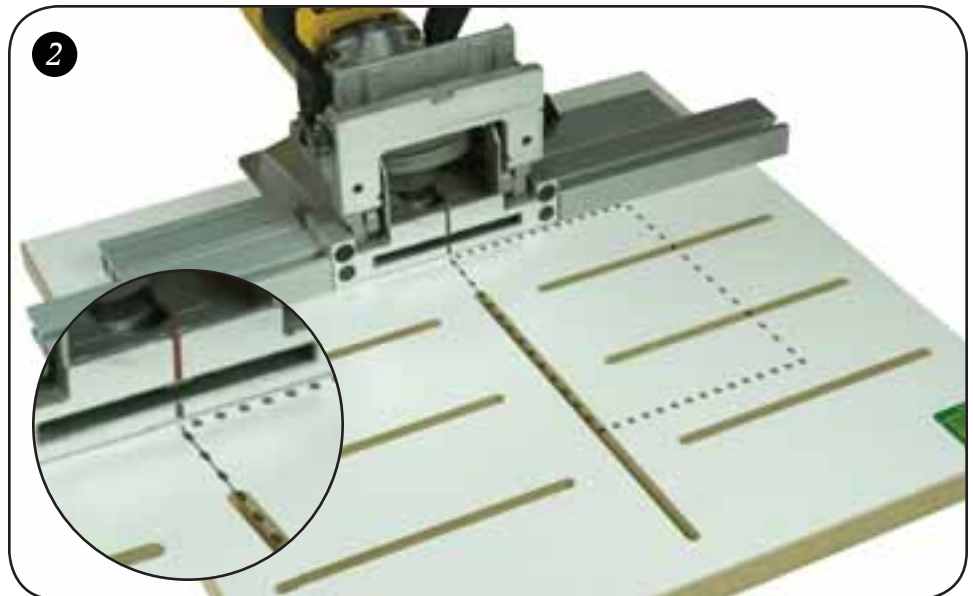
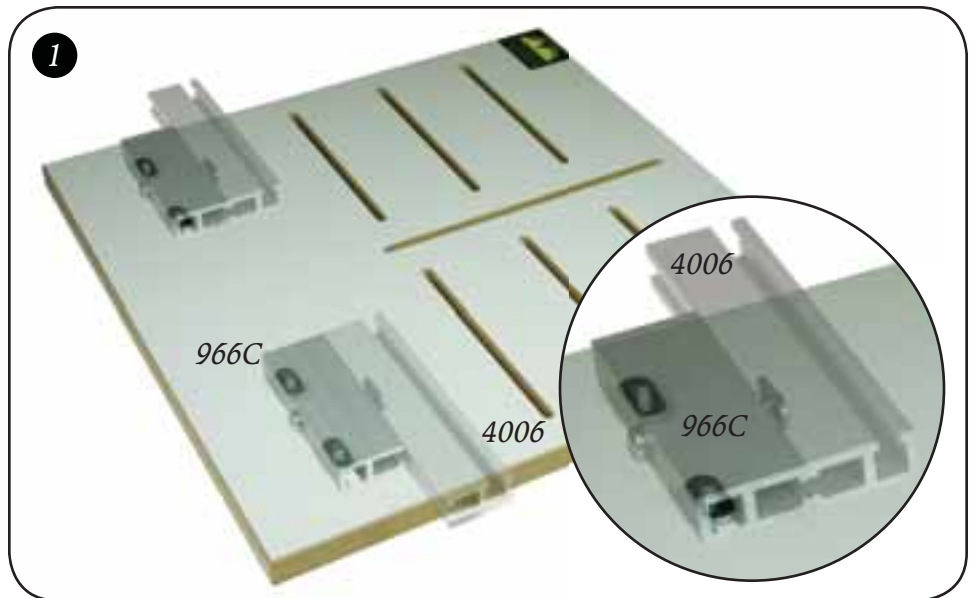
Insert the 1-1/4" screws (**MF020**) through the countersunk holes in the MDF Base (**966B**) and start an oval nut (**5760B**) on the end of each screw. *See fig. 1.*

Slide the Fence Brackets (**966C**) on to the oval nuts so they're approximately centered them. Install a washer (**WB002**) on both 2" screws (**MP200**). Starting from the smooth edge of the Fence Bracket, insert a 2" screw through the hole in each bracket and start an oval nut (**5760B**) on the end of each screw. Slide a 6" Double Track Fence (**4006**) on the oval nut. Position the Fence even with the inside ends of each Fence Bracket and tighten the screw. *See fig. 1.*

Clamp the MDF Base to a bench so the 1-1/4" screws overhang the edge of the bench and you can tighten them from the underside. Mark a center line on the MDF Base in line with its center slot. *See fig. 2 inset.*

Place your biscuit machine between the Fence/Fence Brackets, centered on the line you just made. Slide the Fence/Fence Brackets against each side of the biscuit machine. Don't force the Fence/Fence Brackets too tight against the sides of the biscuit machine as their only purpose is to prevent major side-to-side play. In fact a little play (1/32" or less) is preferable for easier removal of the biscuit machine. It's not necessary that the Fence/Fence Brackets conform to the shape of your biscuit machines sides. Use a straight edge to align the Fences with each other and tighten the four 1-1/4" screws from the underside of the MDF Base.

Some biscuit machines have mounting holes in their base and, if desired, you can fasten your biscuit machine directly to the MDF Base.



### 3. The Clamp Fence

There are many different ways that the Clamp Fence (966A) can be attached to the Base. If possible, it's always best to position the Clamp Fence so the work is forced against it, rather than pulled away from it, by the cutting action of the biscuit machine. Determine how you'll be using the biscuit machine, and where to attach the Clamp Fence to the Base after reviewing the instructions covering specific applications.

The Clamp Fence attaches to the Base in one or more of the machined slots. Make sure the two countersunk holes in the face of the Clamp Fence are against the MDF Base. Install a washer (WB002) on two of the Ratchet Handles (5863). Insert the Ratchet Handles thru the selected hole/slot in the Clamp Fence (see *specific applications*), thru the selected slot in the MDF Base and screw it into a Square Nut (NUT025) inserted in the recess in the underside of the slot in the MDF Base.

You should always have one Ratchet Handle located directly in front of the Toggle Clamp (or where the Toggle Clamp will eventually be attached) to prevent the Clamp Fence from lifting off the Base. The second Ratchet Handle is used to the side or rear of the Toggle Clamp to prevent the Clamp Fence from rotating out of position on the MDF Base. You should use two Ratchet Handles on the Clamp Fence whenever possible.

After attaching the Clamp Fence to the MDF Base, attach the Toggle Clamp (6305) to the Clamp Pad (6305B) with the 3/8" screw (MP375) at one of the back corners near the handle of the Toggle Clamp. Insert two 1" screws (5772B) at the two front corners of the Toggle Clamp, thru the Clamp Pad and screw them into the Clamp Fence. The Nylon Knob (5525) replaces the hex nut on the top of the Toggle Clamp spindle for faster adjustments. When changing the location of the Clamp Fence on the MDF Base, it's usually easier if you remove the Toggle Clamp from the Clamp Fence first. See fig. 3.

Two Positioners are provided to assist in holding parts against the Clamp Fence and they can be attached in any of the slots in the base. Each Positioner consists of a Ratchet Handle, two 1/4" Spacers (BUSH1250) and a square nut. See fig. 4 inset.

#### USING THE BISCUIT MASTER

Clamp the Biscuit Master on a bench. When making cuts, the front of the biscuit machine should be in line with the front of the Fences. Most biscuit machines can set directly on the MDF Base and, in that position, the biscuit slot will more or less be in the center of a 3/4" thick board. If necessary, the biscuit machine can be raised (make a shim) above the Base up to 1/2" (or more) if necessary - see the section on Bevels.

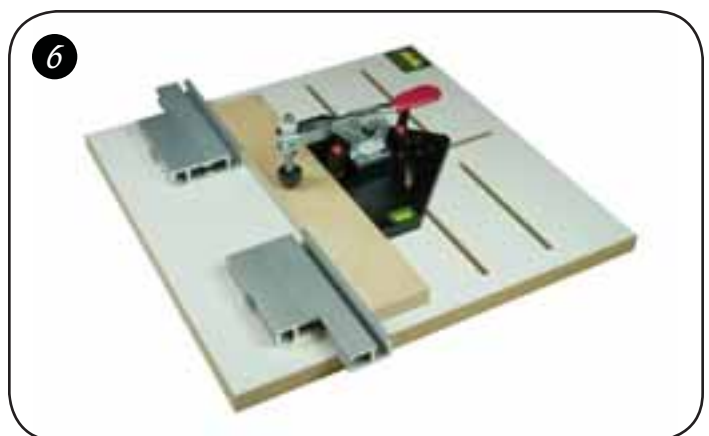
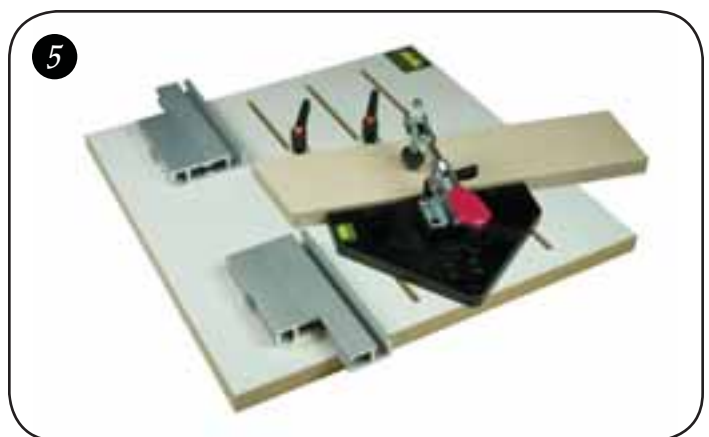
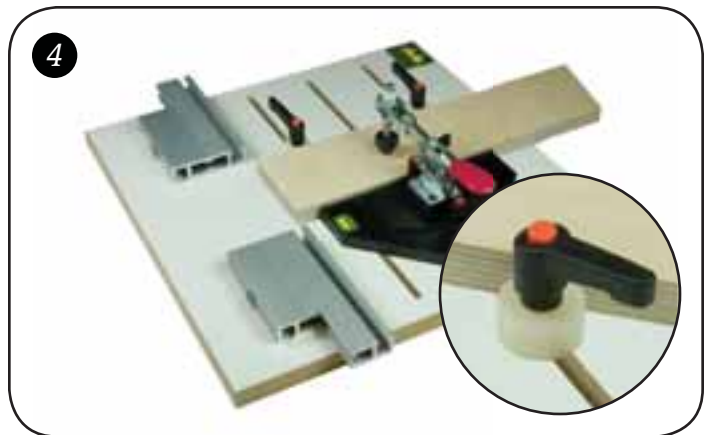
## Specific Applications:

#### 4-5. END CUTS AND MITERS LESS THEN 45°

Fasten the Clamp Fence to the right of the biscuit machine as shown. See fig. 4 & 5.

#### 6. EDGE & FACE CUTS

Fasten the Clamp Fence to the center slot as shown. If the Clamp Fence can't be adjusted far enough forward to hold the stock against the Fences, place a spacer between the Clamp Fence and the back of the stock. See fig. 6.

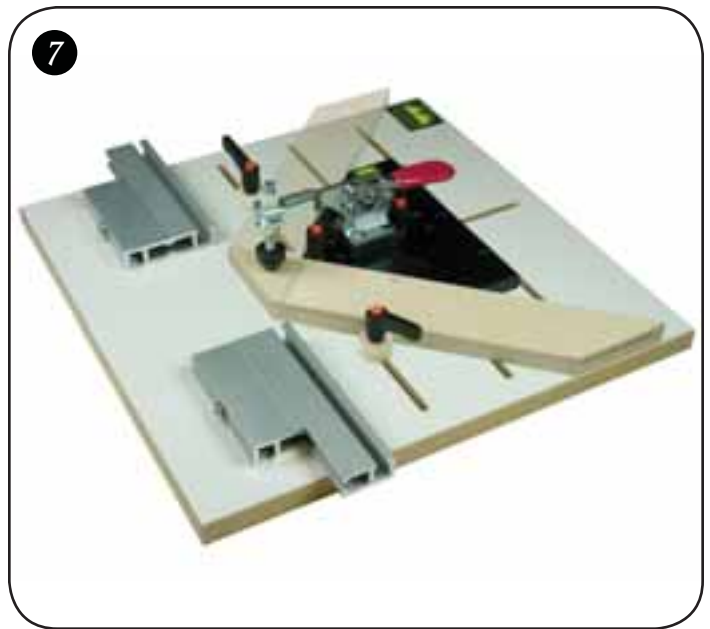


## 7. 45° MITERS

Fasten the Clamp Fence to the center slot as shown. This setup allows you to do both miters without repositioning the Clamp Fence for each side. *See fig. 7.*

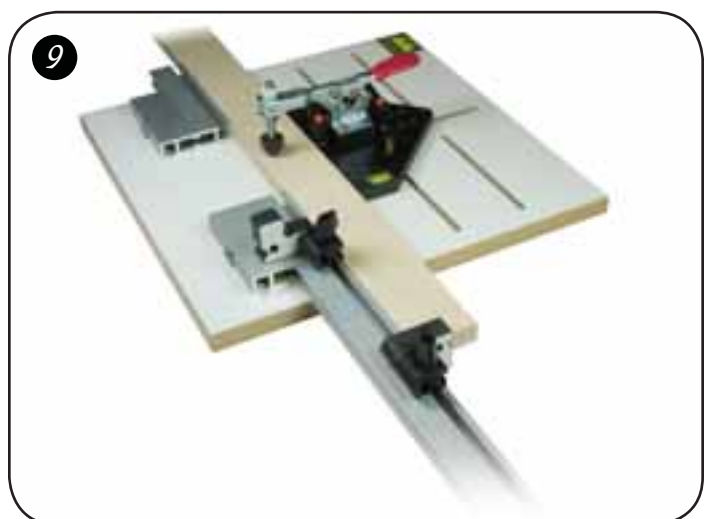
## 8. BEVELS

Remove the Toggle Clamp from the Clamp Fence. Attach the 6" Fence (4006) to the Clamp Fence using two 1" screws (MF015) and oval nuts (5760B). The back of the part will rest against the top edge of this fence. Adjust the Clamp Fence forward or back until the beveled edge is square to the Base and flush against the Fences. Hold the part in this position as you make the cut. The biscuit machine must be raised above the Base to position the biscuit in the wider part of the bevel. A typical bevel on 3/4" thick stock will require roughly a 1/2" thick spacer under the biscuit machine. Because the Fences are 3/4" tall, the biscuit machine will still be adequately held between them. Thicker stock would require raising the biscuit machine even higher. In those cases you can use the T-slot in the top of the Fences to add spacers. *See fig. 8.*



## 9. OPTIONAL ACCESSORIES

We offer longer lengths of Double Track Fence (24" - PN 4024, or 48" - PN 4048) that replace the stock 6" Fence on one or both sides of the Biscuit Master. We also offer Flip Stops which attach to the top of the fence and allow you to use multiple stops for multiple parts with the same biscuit slots. For long stock that extends past the MDF Base, you may need to provide a 3/4" thick spacer for the stock to rest on. *See fig. 9.*



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