



This system is used with a router either portably or in a router table. It is usually easier to use in a router table, unless the size of the work prohibits this.

### STOCK SIZE

The Big Biscuit requires a minimum stock thickness of 1/2". The narrowest stock that can be used and still conceal the biscuit on a 90° butt joint is 1-1/2" and on a 45° miter joint it's 1-3/16".

The Mini Biscuit requires a minimum stock thickness of 1/4". The narrowest stock that can be used and still conceal the biscuit on a 90° butt joint is 1" and on a 45° miter joint it's 3/4".

### USING IN A ROUTER TABLE

Use a miter gauge and/or router fence. Use a guard whenever possible and never attempt router table cuts freehand.

Mark your joint center line locations. *See fig. 1.* Cut biscuit joints by aligning the joint center line with center line of the bit and plunge the work into the bit, then back out. It is not necessary to move the work side-to-side. The depth of cut is controlled by the bearing on the bit.

End grain cuts can be made in several ways. One is to slide the work from right to left along the right side (as you face the front) of your fence. For extra safety, you can add a second fence parallel to the main fence. *See fig. 2 & 3.* The other option is to slide the work along a guide butted against the fence and clamped to the table. Set the guide, so that the work center will line up with the bit center. *See fig. 4.*

# Big & Mini Biscuits & Bits™

*Please Read Carefully!*

1



2



3



*Second fence added for safety*

4



*90° guide butted against fence and clamped to table.*

You can make edge grain cuts several ways. One is to use a miter gauge with a fence and stop. *See fig. 5.* Another method is to pivot the work against a stop attached to your fence. Set the stop so that the center of the joint will line up with the bit center. *See fig. 6.* Face cuts are also possible using a miter gauge with a miter fence and stop. *See fig. 7.*

For mitered joints, feed the work into the bit by sliding it in between your regular fence and a second fence set parallel to it. Adjust these two fences so that the work slides in between them without slop. Feed the work with the "pointed" end against your regular router fence. This means you will feed from the right side of the fence for one half of the joint and from the left side of the fence for the other half of the joint. Do not attempt this without the second fence and a push block to feed the part! Never feed the part with your hands! *See fig. 8.*

### USING WITH A ROUTER PORTABLY

Cut biscuit joints on the edge of the work by making a plunge type cut with the slot cutter, using a straight edge clamped to the work to as a guide.

For cutting joints in the face of work where it is impossible to use the slot cutter (10% or less of most joinery), use a straight bit. You'll need a 15/64" (or 6mm) bit for the Big Biscuits and a 1/8" bit for the Mini Biscuits. Clamp a straight edge to your work and make the cuts using a plunge router.

### GLUING

Before gluing, dry fit all joints. Apply glue to both halves of the biscuit joint and the edges of work. Assemble the joint and clamp. You can remove your clamps in as little as 20 minutes. Rough handling or machining should wait until the glue has cured according to the manufacturers directions.

Keep the biscuits dry by storing them in a sealed container.

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