



ROCKLER®
WOODWORKING AND HARDWARE

Create with Confidence™

Cutting Board Juice Groove Routing Jig Instructions

Effective April 2023



Review full instructions prior to use for important safety information.
Always check [Rockler.com](https://www.rockler.com) to confirm that you are using the most recent version of instructions for your product.

GENERAL SAFETY WARNINGS

This product is designed only for specific applications as defined in the instructions and should not be modified or used for any manner not described in these instructions. Use only recommended accessories. Before using the Cutting Board Juice Groove Routing Jig: **READ, UNDERSTAND** and **FOLLOW ALL INSTRUCTIONS AND SAFETY WARNINGS. KEEP THESE INSTRUCTIONS READILY AVAILABLE FOR FUTURE REFERENCE.**

- > Always confirm that you are using the most recent version of the instructions and safety warnings for your product (see the instructions link on the product page at Rockler.com).
- > Before using another tool with this product, always read, understand and follow the instructions and safety warnings in the owner's manual for that tool. If you do not have the owner's manual, obtain one from the tool's manufacturer before using it with this product.
- > Before using any chemical with this product, always read, understand and follow all safety warnings and guidelines in the manufacturer's Safety Data Sheet (SDS; formerly called "MSDS"), especially regarding:
 - How to safely use the chemical, including potential hazards and recommended first aid measures;
 - Personal safety equipment required to safely use the chemical (e.g. gloves, eye protection, mask/respirator, etc.);
 - Proper and safe handling, storage and disposal of the chemical.
- > Before using this product, review and verify that all tools to be used with it have safety equipment installed and are in proper working order as defined by the tool's owner's manual.
- > Do not use this product until you have read and are confident you understand:
 - Product Specific Safety Warnings (p. 3);
 - Parts List (p. 4);
 - Connect the Rails (p.4);
 - Install the Corner Guides (pp. 4 - 5);
 - Attach the Clamping Brackets to the Rails (p. 5);
 - Fitting to Cutting Board Workpiece (p. 6);
 - Install the Guide Bushing and Bit on Your Router (p. 6);
 - Routing the Groove(pp. 7 - 8);
 - Routing Around Handle Openings (p. 8).
- > The user assumes all risk and responsibility for the proper and safe use of this product and for ensuring product suitability for the intended application.
- > It is the sole responsibility of the purchaser of this product to ensure that anyone you allow to use this product reads and complies with all instructions and safety precautions outlined in this manual prior to use.
- > Follow all standard shop safety practices, including:
 - Keep children and bystanders away from the tool operating area;
 - Do **NOT** use power tools in explosive environments, or in the presence of flammable liquids, fumes or dust;
 - **TURN OFF AND UNPLUG** all power tools **BEFORE** making any adjustments or changing accessories;
 - Remain alert and use good judgment. Do not use this product if you are in any way impaired by medications, alcohol, drugs or fatigue;
 - Keep your work area well lit and clean;
 - Dress appropriately. Secure loose clothing, remove all jewelry and tie up long hair before using this product;
 - **ALWAYS** wear safety glasses, hearing protection and respiratory protection that complies with NIOSH/OSHA/ANSI safety standards;
 - Use dust collection tools and dust face masks to reduce exposure to dust;
 - Use safety equipment such as featherboards, push sticks and push blocks, etc., when appropriate;
 - Maintain proper footing at all times and do not overreach;
 - Do **NOT** force woodworking tools.
- > These warnings and instructions do **NOT** represent the total of all information available regarding tool safety, use and technique. Always seek out opportunities to learn more and improve your skills and knowledge.

⚠ WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to www.P65Warnings.ca.gov/wood.

- | | |
|------------------|--|
| ⚠ DANGER | Danger indicates a hazardous situation that, if not avoided, will result in death or serious injury. |
| ⚠ WARNING | Warning indicates a hazardous situation that, if not avoided, could result in death or serious injury. |
| ⚠ CAUTION | Caution indicates a hazardous situation that, if not avoided, may result in minor or moderate injury or property damage. |
| NOTICE | Notice indicates important or helpful information and/or user tips. |

PRODUCT SPECIFIC SAFETY WARNINGS

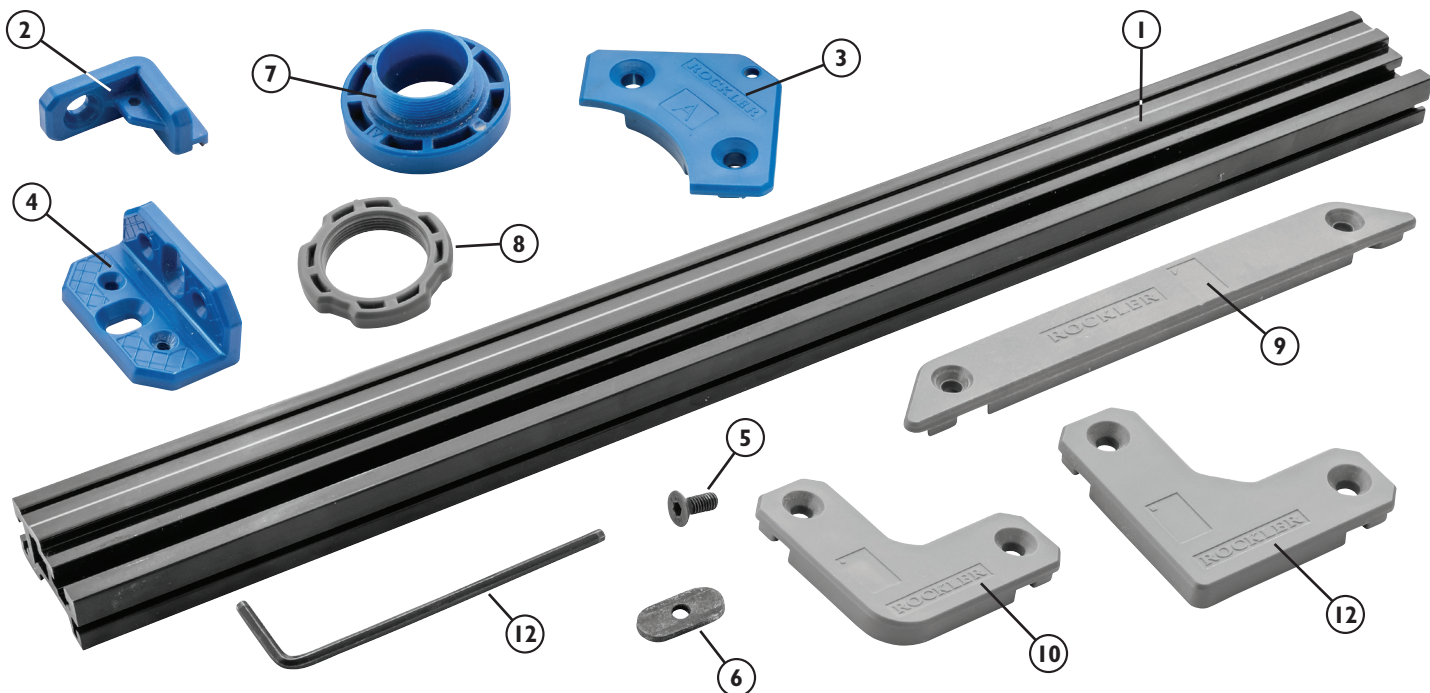


⚠ DANGER

- > To avoid serious injury, keep hands and fingers away from the spinning router bit. Always maintain awareness of the bit.

⚠ WARNING

- > **TURN OFF AND DISCONNECT POWER** to your router before installing the guide bushing or router bit or adjusting the cutter height.
- > Cutter edges are sharp. Exercise special care when installing or adjusting the cutter.
- > Use **ONLY** with a plunge router equipped with a baseplate that can accept standard guide bushings.
- > Do **NOT** try to rout the full depth of the groove in a single pass. Instead, make two shallower passes and then a final pass at full depth to remove scorch marks.
- > Always make sure that all four rails of the jig are tight against the four edges of your workpiece, that the Corner Guides are tight to the top face of the workpiece, and that all fasteners are fully tightened before using the jig.
- > Once the Cutting Board Juice Groove Routing Jig has been adjusted to capture the cutting board workpiece, the jig **MUST** be secured to the worktop by clamping or screwing **all four** Clamp Brackets in place.
- > During routing, the bottom of the Guide Bushing **MUST** remain flat to the workpiece **AND** tight against the inside edge of the Rails. Failure to maintain this positioning will result in an irregular groove and subpar results.
- > Maximum workpiece length x width: 18" x 18"
- > Workpiece thickness: Minimum 3/4"; maximum 1 1/4". If you want to use the jig on thicker boards, you will need to add spacers under the Clamping Brackets; thinner boards will require a spacer under the workpiece.



PARTS LIST

| | Quantity |
|--------------------------------|----------|
| 1 Rail | 4 |
| 2 Support Bracket | 4 |
| 3 Standard Corner Guide | 4 |
| 4 Clamping Bracket | 4 |
| 5 Flathead Screw | 16 |
| 6 Washer Nuts | 16 |
| 7 Guide Bushing | 1 |
| 8 Guide Bushing Lock Nut | 1 |
| 9 Triangle handle Corner Guide | 1 |
| 10 Round Handle Corner Guide | 1 |
| 11 Square Handle Corner Guide | 1 |
| 12 Hex Key | 1 |

Connect the Rails

1. Arrange the Rails (1) in the shape of a square on the work surface. Orient the Rails so that the faces with the wide channel are down against the surface and the narrower, S-shaped profile is toward the inside. The Rails must be oriented correctly, or you won't be able to assemble and use the jig.
2. At one corner, slide a Support Bracket (2) into the bottom slot of the S-shaped profile of the Rail (1) on your right. **Fig. 1.**
3. Slide a Washer Nut (6) into the T-slot in the outside edge of the left perpendicular Rail (1). Position that Rail tightly against the inside edge of the first Rail and attach the Support Bracket (2) to the second Rail with a Flat-Head Screw (5) secured in the Washer Nut. **Fig. 1.** Make sure that the end of the left rail is tight against the inside edge of the right rail before tightening the screw with the included Hex Key (12).

4. Repeat Steps 2 and 3 to install Support Brackets (2) in the remaining corners. Keep in mind that you'll need to work on the final two corners in tandem to bring the jig frame together. With the Support Brackets attached, you're still able to move the Rails (1) in and out because each Support Bracket slides along the groove in the inside edge of the Rail.

Install the Corner Guides

1. Install a Standard Corner Guide (3, also marked with an "A") in each corner of the jig. To do this you first need to slide two Washer Nuts (6) into the top T-slot of each Rail (1). Slide the first Washer Nut almost as far forward as it will go; slide the second so it's at the intersection of the Rails. **Fig. 2.**

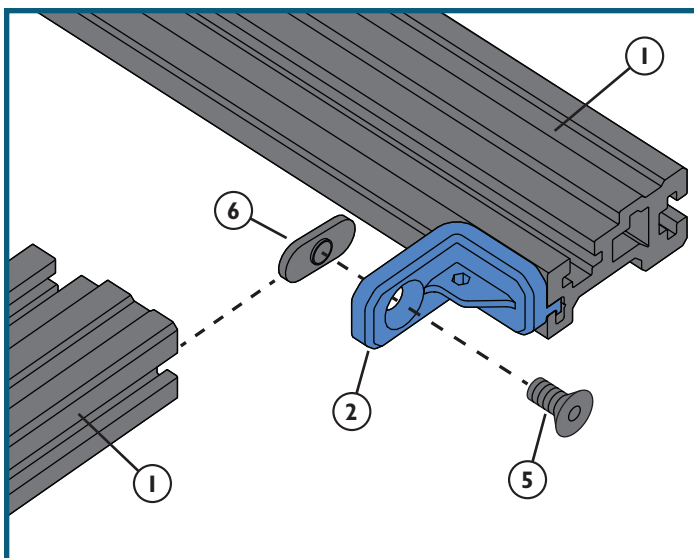


Fig. 1

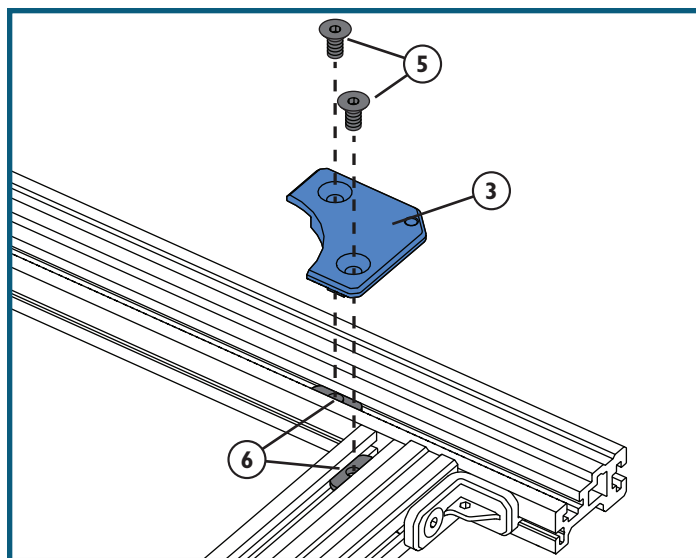


Fig. 2

2. Fit the keys on the underside of the Standard Corner Guide (3) into the slots in the intersecting Rails (1) and adjust the positions of the Washer Nuts (6) to align them with the mounting holes in the guide. Insert two Flat-Head Screws (5) in the countersunk holes in the Corner Guide and thread them into the Washer Nuts. Use the included Hex Key (12) to tighten the screw that's on the same side as the screw in the Support Bracket (4); don't tighten the other now, or you won't be able to adjust the rail positions. **Fig. 2.** Install a Corner Guide in all four corners of the jig.

Attach the Clamping Brackets to the Rails

⚠ WARNING

- > Workpiece thickness: minimum 3/4"; maximum 1 1/4". If you want to use the jig on thicker boards, you will need to add spacers under the Clamping Brackets; thinner boards will require a spacer under the workpiece.

1. Determine on which Rails (1) it will be best to mount the Clamping Brackets (4). This will depend, in part, on how you plan to secure them to the work surface. If you plan to use clamps to secure the jig in a corner of your work surface, you will need to position two Clamping Brackets along each of the two Rails that will be accessible. If you plan to use screws to attach the Clamping Bracket, which have holes for #8 flathead screws (not included), we recommend positioning the brackets on opposing Rails, two on each.
2. Orient the Clamping Brackets (4) correctly for the thickness of your workpiece. Orient the bracket with the shorter leg against the Rail (1) for workpieces between 3/4" and 1" thick. Orient the bracket with the shorter leg against the Rail (1) for workpieces between 1" and 1 1/4" thick. **Figs. 3 and 4.**
3. To install the Clamping Brackets (4), slide two Washer Nuts (6) into the outside T-slot of each of the two Rails (1), spacing them along the Rail. Position each Clamping Bracket so that its mounting hole is aligned with the Washer Nut and then attach with a Flathead Screw (5). Fully tighten the screw with the included Hex Key (12). **Fig. 3 and 4.**

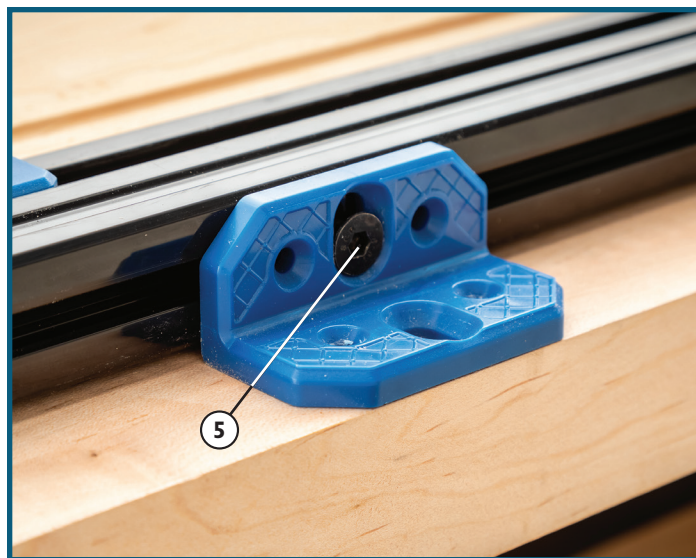


Fig. 3 - Orientation for 3/4" to 1" thick workpieces

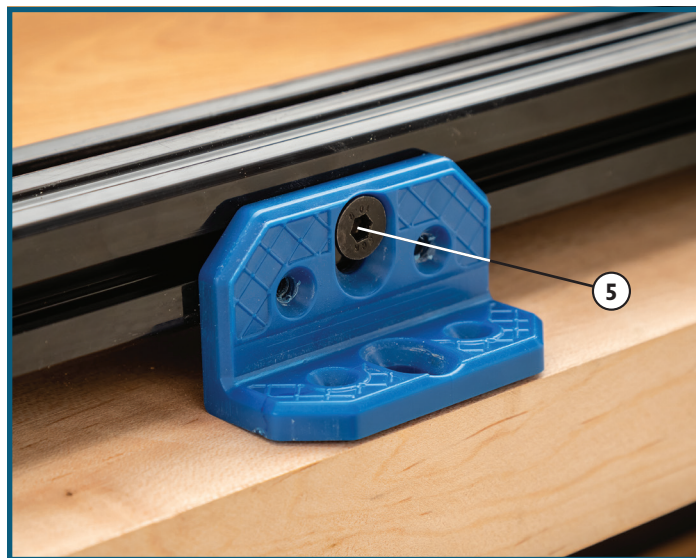


Fig. 4 - Orientation for 1" to 1 1/4" thick workpieces



Fig. 5

Fitting to Cutting Board Workpiece

1. If necessary, adjust the jig so that you're able to fit your cutting board workpiece between the rails, then place the workpiece in the center of the jig. **Fig. 5.**
2. Adjust the Rails (1) to bring them tightly against the sides of the workpiece. Make sure all four Corner Guides (3) are resting on top of the workpiece. With all four Rails tight to the workpiece, use the included Hex Key (12) to fully tighten the Flathead Screw (5) on each of the four Corner Guides that you left loose earlier.
3. **Secure all four Clamping Brackets (4)** to the work surface with clamps or screws. Make sure that the jig and workpiece are not able to shift.

Install the Guide Bushing and Bit on Your Router

⚠ WARNING

- > Always make sure that all four Rails of the jig are tight against the four edges of your workpiece, that the Corner Guides are tight to the top face of the workpiece, and that all fasteners are fully tightened before using the jig.
- > Once the Cutting Board Juice Groove Routing Jig has been adjusted to capture the cutting board workpiece, the jig **MUST** be secured to the worktop by clamping or screwing **all four** Clamp Brackets in place.
- > Maximum workpiece length x width: 18" x 18"

1. Make sure that the baseplate of your plunge router can accept a standard guide bushing. If it can't, obtain a baseplate or adapter that will enable it to accept a standard guide bushing.

NOTICE

Rockler offers a 1/4" Shank Router Baseplate Centering Guide (89238, sold separately) to help make the step easier.

2. Make sure that the baseplate of your plunge router is perfectly centered in relation to the collet. If you're uncertain about this, follow the manual that came with your router to center the baseplate.
3. Working from the underside of the router baseplate, fit the threaded end of the Guide Bushing (7) into the center hole.
4. Thread the Guide Bushing Lock Nut (8) onto the Guide Bushing (7) and finger tighten securely.

NOTICE

Rockler offers two exclusive Rounded-Shoulder Juice Groove Router Bits that will both rout the juice groove and slightly ease the shoulders of the groove so there's no need to soften them by sanding. One bit routs a 1/2" wide x 3/16" high groove (61817, sold separately); the other routs a 3/8" wide x 1/8" high groove (64169, sold separately).

5. Install the desired router bit securely in your router.



Fig. 6

Routing the Groove

THESE WARNINGS PERTAIN TO THIS SECTION:



⚠ DANGER

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⚠ WARNING

- > Always make sure that all four rails of the jig are tight against the four edges of your workpiece, that the Corner Guides are tight to the top face of the workpiece, and that all fasteners are fully tightened before using the jig.
- > Once the Cutting Board Juice Groove Routing Jig has been adjusted to capture the cutting board workpiece, the jig **MUST** be secured to the worktop by clamping or screwing **all four** Clamp Brackets in place.
- > Do **NOT** try to rout the full depth of the groove in a single pass. Instead, make two shallower passes and then a final pass at full depth to remove scorch marks.
- > During routing, the bottom of the Guide Bushing **MUST** remain flat to the workpiece **AND** tight against the inside edge of the Rails. Failure to maintain this positioning will result in an irregular groove and subpar results.

NOTICE

We **STRONGLY** recommend that you familiarize yourself with the routing motion involved in using the Cutting Board Juice Groove Routing Jig before cutting your final workpiece. On a piece of scrap wood that's the same thickness as your final workpiece, practice moving the router around the inside of the jig with the motor off and the bit fully retracted. Then try routing a practice groove in the scrap piece to get a feel for keeping the Guide Bushing tight to the inside edge of the Rails as you go.

1. Set the overall plunge depth to the desired final depth of your juice groove. If your router's plunge base allows, also set it to make two shallower passes – one about half the full depth and then another just shy of the full depth. This will allow you to make the final smoothing pass at full depth to remove a very small amount of material and most scorch marks.
2. Position the router, with Guide Bushing (7) installed, on the jig. The Guide Bushing should be flat to the workpiece and tight up against the inside edge of one of the Rails (1). The baseplate of the router should be flat to the Rail.
3. Maintaining this router position, turn on the router and carefully plunge the bit into the workpiece about halfway to the groove's final depth. Carefully move the router clockwise around the inside of the jig, keeping the Guide Bushing (7) flat to the workpiece and tight up against the inside edge of the Rails, until you've completed the first pass. Try to maintain a consistent pace, and try not to stop until your groove is complete. Turn off the router and allow the bit to come to a complete stop. **Fig. 6.**
4. Once the bit has come to a complete stop, adjust your plunge stop to make the pass just shy of full depth and repeat Steps 2 and 3 at this setting. Again, once this pass has been completed, turn off the router and allow the bit to come to a complete stop.



Fig. 7

5. Adjust the plunge stop to make the pass at full depth and then repeat Steps 2 and 3 again to finish routing your groove.
6. Sand away any remaining scorch marks or rough spots. Contour Sanding Grips (54412, sold separately) can help make the sanding process easier while also preserving the curve of the groove.

Routing Around Handle Openings

The Cutting Board Juice Groove Routing Jig includes three additional corner guides for offsetting a juice groove around handle openings made with a 1¼" diameter Forstner bit or the triangular or square section of the 4-in-1 Cutting Board Handle Routing Template (68393, sold separately).

To use these corners:

1. Install the jig on the cutting board as you normally would. Make sure that the side of the workpiece in which you want the groove is facing up.

2. Remove the Standard Corner Guide (3) from the corner where the handle cutout is or will be. Keep the Flathead Screws (5) accessible; you will need them.
3. Place the desired Handle Corner Guide on the jig, fitting the keys on the underside of the guide into the slots in the intersecting Rails (1). Adjust the positions of the Washer Nuts (6) to align them with the mounting holes in the guide and secure everything in place with the Flathead Screws (5). **Fig. 7.**
4. Rout the juice groove as described in these instructions.

Check Rockler.com for updates. If you have further questions, please contact our Technical Support Department at 1-800-260-9663 or support@rockler.com