

Precision Router-Table Insert Plate INSTALLATION INSTRUCTIONS



INSTRUCTIONS POUR L'INSTALLATION INSTRUCCIONES DE INSTALACIÓN

Item # PRS4034

[Fits Triton TRA001 and MOF001]

Item # PRS4036

[Fits Bosch 1617, Porter-Cable 690 and 890 series]

Item # PRS4038

[Not drilled].

Article #PRS4034

(Convient aux modèles Triton TRA001 et MOF001)

Article #PRS4036

(Convient à la série 1617 de Bosch et aux séries 690 et 890 de Porter-Cable)

Article #PRS4038

(Non percé).

Artículo # PRS4034

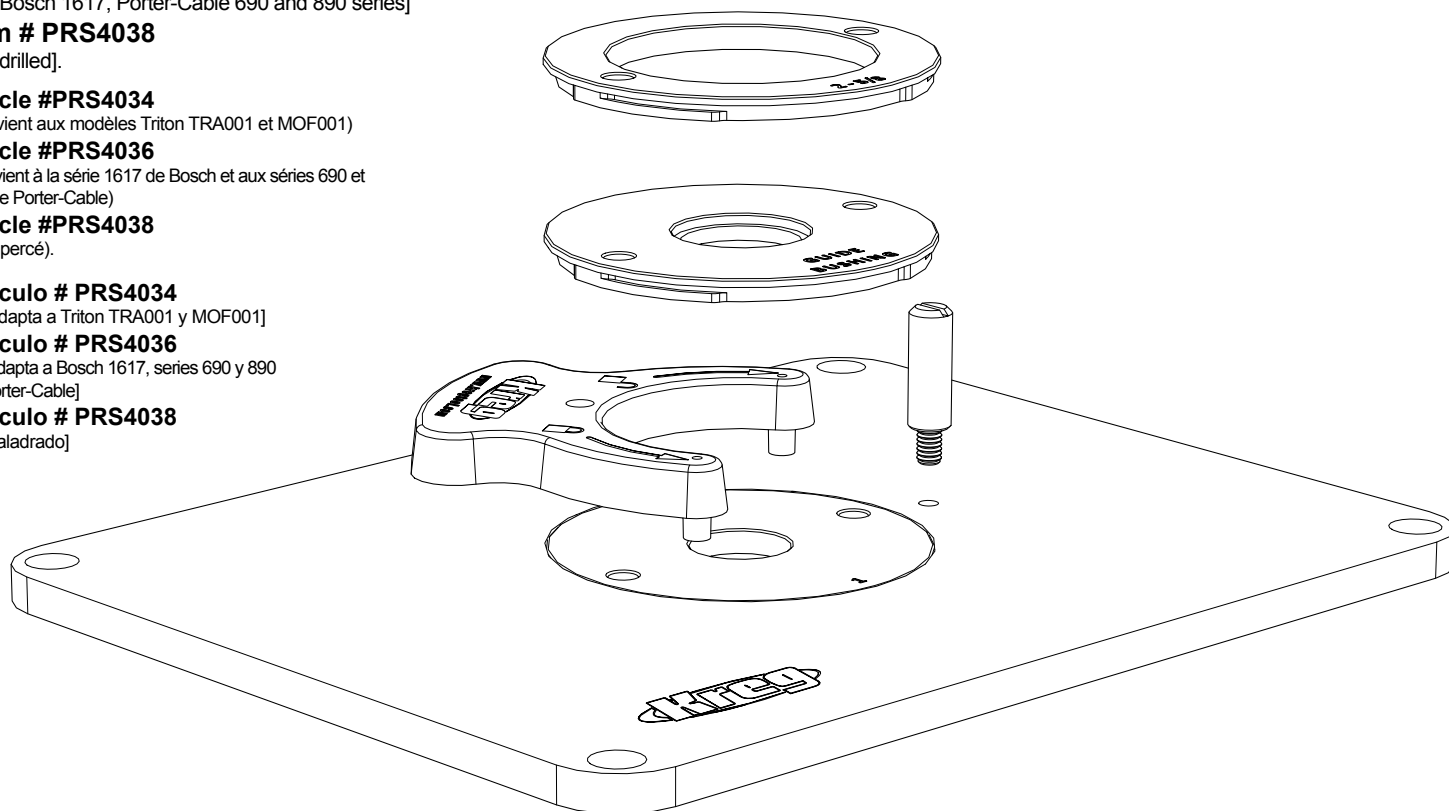
[Se adapta a Triton TRA001 y MOF001]

Artículo # PRS4036

[Se adapta a Bosch 1617, series 690 y 890 de Porter-Cable]

Artículo # PRS4038

[Sin taladrado]



Tools Required:

- Phillips Screwdriver
- Masking Tape
- Double-faced Tape
- Drill press
- Drill Bits, Countersink Bit
- Router, top-bearing pattern bit

Parts:

- Insert Plate
- (3) Reducing Rings: 1", 1 3/16" (guide bushing), 2 5/8"
- Ring Wrench
- (4) 1/4-20 x 1 3/4" flathead machine screws (lock-down screws)
- 1/4-20 x 3/4" set screw
- Brass starting pin
- 1/8" hex wrench
- Router-base mounting screws (pre-drilled insert plates only)

Outils nécessaires :

- Tournevis cruciforme
- Ruban-cache
- Ruban adhésif à double face
- Perceuse à colonne
- Forets, fraise
- Toupie, fraise à roulement à billes supérieur

Pièces :

- Plaque d'insertion
- 3 anneaux de réduction : 1 po, 1 3/16 po (douille de guidage), 2 5/8 po
- Clé pour anneau
- 4 vis à métaux à tête plate de 1/4-20 x 1 3/4 po (vis de verrouillage)
- Vis de calage de 1/4-20 x 3/4 po
- Cheville de départ en laiton
- Clé hexagonale de 1/8 po
- Vis de montage pour la base de la toupie (plaques d'insertion prépercées uniquement)

Herramientas necesarias:

- Destornillador Phillips
- Cinta adhesiva
- Cinta de doble faz
- Prensa de taladrar
- Brocas para taladro, broca para avellanar
- Rebajadora, broca para diseño de rodamiento superior

Piezas:

- Placa de accesorio
- (3) anillos reductores: 1", 1 3/16" (conector de la guía), 2 5/8"
- Llave de tuerca de anillo
- (4) tornillos de cabeza plana (tornillos para fijación) de 1/4-20 x 1 3/4"
- Tornillo de ajuste de 1/4-20 x 3/4"
- Pasador de inicio de latón
- Llave de tuercas hexagonal de 1/8"
- Tornillos de montaje para base de rebajadora (solo placas de accesorio pretaladrados)



WARNING Read, understand, and follow your router manufacturer's instructions in addition to the safety precautions below to reduce risk of fire, electric shock, and personal injury. Read all these instructions before attempting to operate this product. **SAVE THESE INSTRUCTIONS.**

1) Work area safety

- a) **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- b) **Don't use power tools in a dangerous environment.** Don't use power tools in damp or wet locations, or expose them to rain.
- c) **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks that can ignite the fumes or dust.
- d) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.
- e) **Make your workshop child proof.** Use padlocks, master switches, or remove starter keys.

2) Electrical safety

- a) **Ground electric tools.** If the tool is equipped with a three-prong plug, it must be plugged into a grounded three-hole electrical outlet. If the proper outlet is not available, have one installed by a qualified electrician. Never remove the third prong or modify the provided plug in any way.
- b) **Do not expose power tools to rain or wet conditions.** Water entering a power tool increases the risk of electric shock.
- c) **Do not abuse the cord.** Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.
- d) **Use a proper extension cord and make sure it is in good condition.** When using an extension cord, be sure to use one heavy enough to carry the current your power tool draws. An undersized cord causes a drop in line voltage resulting in loss of power and overheating. Table 1 shows the correct cord gauge to use depending on cord length and tool nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- e) **When operating electric tools, avoid body contact with grounded or earthed surfaces such as pipes, radiators, kitchen ranges, and refrigerators.** Contact with a grounded surface increases the risk of electric shock.

3) Personal safety

- a) **Stay alert, watch what you are doing and use common sense when operating a power tool.** Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools can result in serious personal injury.
- b) **Always wear safety glasses.** Everyday eyeglasses are not safety glasses. Safety glasses have specially constructed lenses, frames, and side shields.
- c) **Use safety equipment.** Use a face or dust mask when the cutting operation is dusty. Safety equipment such as a dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions reduces personal injuries.
- d) **Avoid accidental starting.** Make sure the switch is in the off-position before plugging in. Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.
- e) **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool can result in personal injury.
- f) **Do not overreach.** Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- g) **Secure workpieces.** Use clamps or a vise to hold work when practical. This is safer than using your hand and it frees both hands to operate the tool.
- h) **Never stand on the machine.** Serious injury can occur if the tool tips or if the cutting tool is unintentionally contacted.
- i) **Dress properly.** Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts. Roll up long sleeves to the elbow. Wear protective hair covering to contain long hair.
- j) **If devices are provided for the connection of dust extraction and collection equipment, ensure these are connected and properly used.** Use of these devices reduces dust-related hazards.

4) Power tool use and care

- a) **Keep guards in place and in working order.**

b) **Do not force the power tool.** Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.

c) **Use the right tool.** Don't force a tool or attachment to do a job for which it was not designed.

d) **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.

e) **Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.

f) **Never leave a tool running unattended.** Turn power off. Don't leave the tool until it comes to a complete stop.

g) **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool and these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.

h) **Maintain power tools.** Check for misalignment or binding of moving parts, broken parts, and any other condition that can affect power tool operation. If damaged, have the power tool repaired before use. Many accidents are caused by poorly maintained power tools.

i) **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.

j) **Use the recommended speed for the cutting tool or accessory and workpiece material.**

k) **Only use parts and accessories recommended by the manufacturer.**

Consult the owner's manual for recommended accessories.

Using improper accessories can cause personal injury.

l) **Use the power tool, accessories, and tool bits in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed.**

Use of the power tool for operations different from those intended can result in a hazardous situation.

5) Service

a) **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This ensures that the safety of the power tool is maintained.

6) SAFETY INSTRUCTIONS SPECIFIC TO USING A ROUTER TABLE FITTED WITH A PRECISION ROUTER TABLE-INSERT PLATE

a) **Read, understand, and follow your router manufacturer's safety warnings and instructions.**

b) **Disconnect the router from power before making adjustments.** Never adjust the fence, plate, reducing rings, or any part of the router or router table while the router is running.

c) **Place the router table on a flat surface to prevent tipping or sliding.** Never stand on the router table.

d) **Do not attempt to rout warped, twisted, or bowed workpieces.**

All workpieces must have flat faces and square edges.

e) **Do not attempt to rout very large workpieces on a router table.** Very large workpieces can be difficult to control and can cause the router table to tip over.

f) **Only use router bits in your router.** Never use tools such as carving burrs, mounted abrasives, wire wheels, or drill pits, even if the shanks match the diameter of the router collet.

g) **Wear gloves when handling router bits.** Cutting edges are sharp.

h) **Never use dirty, dull, or damaged router bits.** Remove wood-resin build-up with a cleaner specifically formulated for cutting tools. Have dull bits sharpened by a qualified person. Discard damaged bits.

i) **Make sure at least 75% of the router-bit shank length is securely held in the router collet.** To ensure a secure hold, leave 1/16" to 1/8" (2mm-3mm) between the end of the bit shanks and the bottom of the collet.

j) **Use the insert-plate reducing ring with the smallest opening that allows the bit to pass through it.** A large gap around the bit can allow the workpiece to tip into the bit and kick back.

k) Position the fence faces as close as possible to the bit.

Turn the bit by hand to check for interference. Firmly tighten the fence-face T-knobs before routing.

l) Adjust router speed to match the diameter of the bit. Reduce router speed when using large-diameter bits. See **Table 2** for recommended router speeds.

m) Make sure the router motor is securely clamped in the base before starting the router.

n) Always support the workpiece with the fence or start pin.

Only use the starter in with router bits that have a guide bearing.

o) When using the fence, always position the bit guard over the router bit and as close to the workpiece surface as possible.

p) Never remove a large quantity of stock in one cut. Make several progressively deeper cuts, adjusting the router bit or fence position between cuts.

q) Keep hands away from the rotating bit and your body out of the path of the cut. Always use the bit guard, use push sticks, push blocks, and feather boards whenever possible, especially when routing narrow workpieces.

Turn off the router before clearing parts of scrap.

r) Avoid awkward hand positions, where a sudden slip could cause contact with the rotating bit. Never overreach.

s) Avoid routing small parts. Rout the profile on a large workpiece and then cut the part to final size from the large workpiece. If you must rout a small part, build an appropriate jig or hold the part with a wood handscrew clamp.

t) Make sure the workpiece is clear of the bit and the bit comes to a complete stop before adjusting the workpiece position. Never start the router with the workpiece in contact with the bit.

u) Avoid kickbacks. Kickbacks occur when the workpiece binds or lifts off the table while being routed, causing it to be thrown back toward the operator. To avoid kickbacks and potential injury, use sharp bits, keep the machine aligned and maintained properly, and adequately support the workpiece. Do not attempt to rout workpieces that are twisted, warped, or bowed, or that have loose knots.

v) Feed the workpiece against (not with) the bit rotation. The bit can grab a workpiece fed with the rotation of the bit, violently eject it from the router table, and can cause your hand to contact the bit.

w) Never trap a workpiece between the bit and the fence. When forming a profile on the straight edge of a workpiece, always rout with the bit housed in the fence and the edge of the workpiece against the fence.

x) Whenever routing a profile in which material is not being removed below a protruding portion of the bit, or a part of the profile is trapped between cutters above and below, take extra precautions to prevent the workpiece from lifting off the table surface during routing. A workpiece lifting off the table can kick back and cause serious personal injury. When routing these profiles, it is especially important to use straight, flat stock and avoid warped, bowed, or twisted stock.

y) Periodically check the tightness of fasteners and adjustment and locking knobs and the alignment of the fence. Loose fasteners and knobs and a misaligned fence can cause personal injury.

z) This router table insert is designed for a specific application.

Do not modify and or use it for any other application. If you have questions relative to the application of the insert, DO NOT use it until you have contacted Kreg Tool Company and have been advised accordingly.

Guidelines for extension cord use

Extension cords are only to be used for temporary purposes. They do not replace the need for installation of outlets and proper wiring where necessary.

In the shop and on construction sites:

1. Extension cords with an equipment grounding conductor must be used at all times.
2. Extension cords must be protected from damage, and not run through doorways or windows where the doors or windows can close, causing damage to the cord.
3. Extension cords must be a minimum of 16 AWG and be rated for the equipment in use.
4. Extension cords must be periodically inspected to ensure that the insulation and conductivity of the wires are not compromised.
5. Extension cords should not be run through water or allowed to have connections that may be exposed to accumulated water.

TABLE 1

Nameplate Amperes @120 V	Extension Cord Length					
	25'	50'	75'	100'	150'	200'
	Recommended Wire Gauge					
0 - 5	16	16	16	14	12	12
5.1 - 8	16	16	14	12	10	NR
8.1 - 12	14	14	12	10	NR	NR
12.1 - 16	12	12	NR	NR	NR	NR

NR – Not Recommended

TABLE 2

Recommended Router Bit Speeds	
Bit Diameter	Maximum Speed (RPM)
Up to 1" (25mm)	24,000
1¼" to 2" (32mm-51mm)	18,000
2¼" to 2½" (57mm-64mm)	16,000
3" to 3½" (76mm-89mm)	12,000

Always follow bit manufacturer's speed recommendations. Some bit designs require specific speeds for safety or performance.

⚠ WARNING: This product can expose you to chemicals including Acrylonitrile and other chemicals, which are known to the State of California to cause cancer and reproductive harm. For more information go to www.P65Warnings.ca.gov.

⚠ 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.

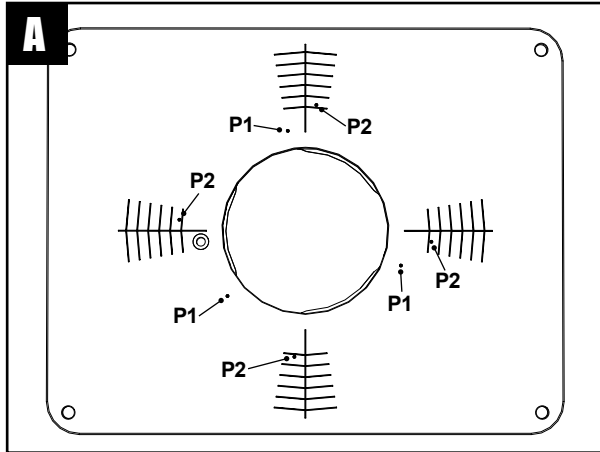
Before you start...

These instructions show you how to mount your router on the Kreg Precision Router-Table Insert Plate and install the insert plate in a shop-built router table. There are two installation methods:

- Create an opening with a rabbeted edge that accepts the insert plate.
- Create a straight-sided opening and install Kreg Precision Router Table Insert Plate Levelers (sold separately).

PRS4034 and PRS4036 insert plates are pre-drilled to accept most Triton, Bosch, and Porter-Cable routers. For these plates, simply fasten your router base to the insert plate using the screws provided with the plate.

Drill the Insert Plate.



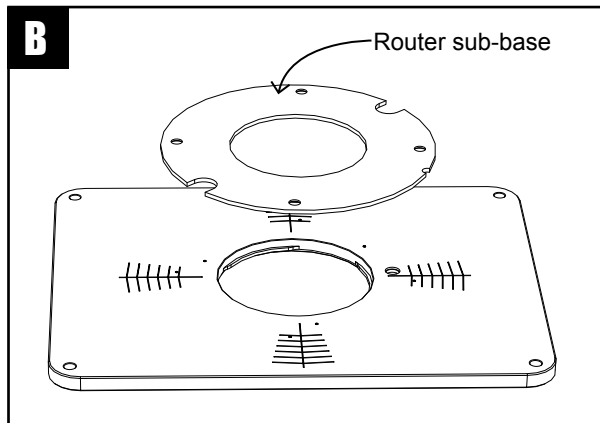
1. PRS4038 has center points molded into the bottom face for drilling mounting holes for the following routers [**Drawing A**]:

Pattern 1 (three holes): Bosch 1617 and 1618; DeWalt 616 and 618; Hitachi M12VC; Makita 1100; Milwaukee 5616 and 5624; Porter-Cable 690, 890, 7529, 97529, and 8529; and Ridgid 2930 Combo Kit.

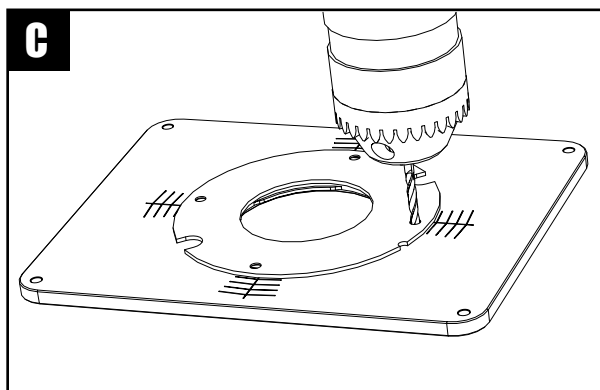
Pattern 2 (four holes): Milwaukee 5625-20; Porter-Cable 7518, 7519, 7538, and 7539; and Triton TRA001 and MOF001.

Drill holes and counterbores or countersinks to accommodate the mounting screws supplied with the router. For routers equipped with a built-in lift system, use the router sub-base as a guide for the location and size of the access hole and as a drilling guide.

For routers not covered by **Pattern 1** or **Pattern 2**, follow **Steps 2** and **3** below.



2. Place the insert plate on your workbench with the target pattern facing up. Remove the sub-base from your router and select a drill bit that fits the mounting holes. If your router is equipped with a built-in lift system, also select a bit that fits the lift-access hole. Apply several small pieces of double-faced tape to the sub-base. Center the sub-base on the insert plate, using the target pattern as a guide [**Drawing B**]. Keep in mind where you want the router controls positioned. Make sure that none of the holes you are about to drill align with the threaded hole for the starting pin. Press the sub-base firmly onto the insert plate.

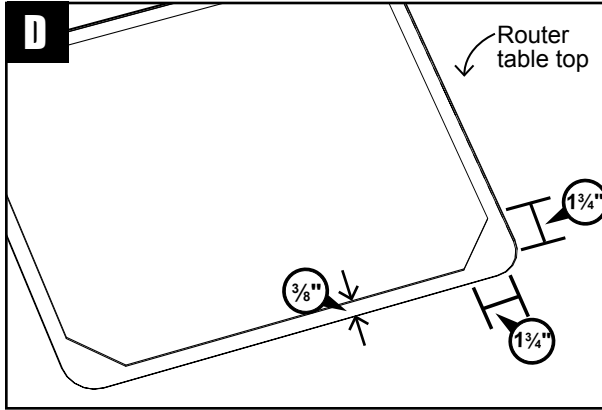


3. Place a scrapwood backer board under the insert plate and securely clamp the insert plate and backer to your drill-press table. Using the holes in the sub-base as guides, drill holes in the insert plate [**Drawing C**]. With the holes drilled, remove the sub-base from the insert plate. Flip the insert plate over and countersink the mounting holes so the mounting-screw heads sit slightly below the plate surface when tightened. Store the router sub-base in a convenient place. You will need it when you remove your router from the router table for hand-held routing.

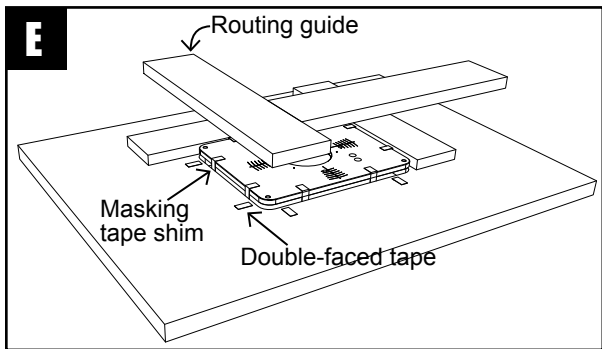
Form the insert-plate opening in your router table top

Rabbeted opening method

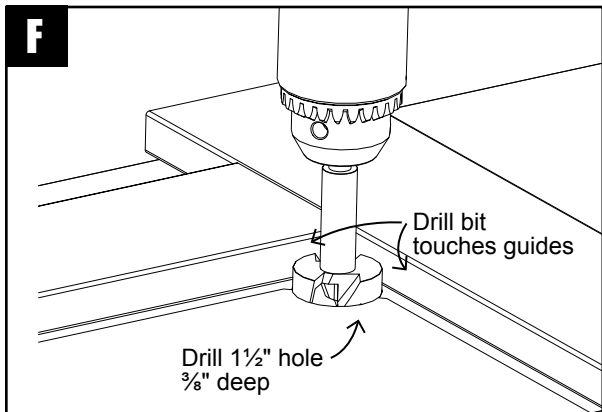
1. Position the insert plate on your router table top, squaring the plate with the table. Trace around the plate with a pencil. Remove the plate. To form areas to anchor the four $\frac{1}{4}$ -20 x $1\frac{3}{4}$ " flathead machine screws (lock-down screws) that secure the insert plate to the router table top, draw 45° lines across each corner of the outline to form triangles with $1\frac{3}{4}$ "-long legs [Drawing D]. Draw lines $\frac{3}{8}$ " inside and parallel to the traced insert-plate outline.



2. To provide clearance for installing and removing the insert plate, adhere strips of masking tape to all four edges of the plate. Then apply small pieces of double-faced tape to one face. (Use just enough tape to keep the plate in place. Too much tape will make the plate hard to remove later.) Reposition the insert plate on your router table top and firmly press it into place.

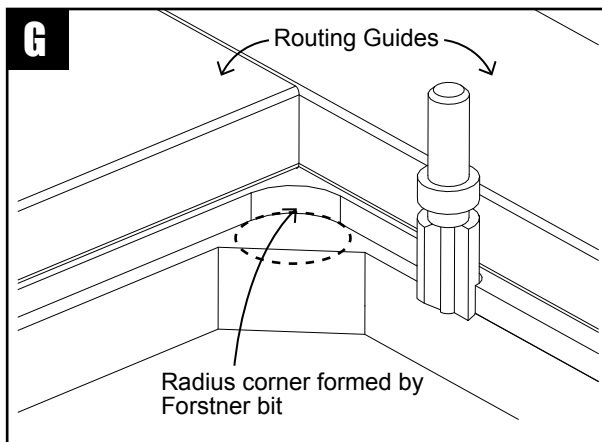


3. Cut four $\frac{3}{4}$ x $3\frac{1}{2}$ x $15\frac{1}{2}$ " scrapwood routing guides. Apply double-faced tape and adhere the routing guides to the router table top with the edges against the masking tape strips on the insert plate edges [Drawing E]. Remove the plate. Chuck a $1\frac{1}{2}$ " Forstner bit into your drill press. Drilling test holes in the area of the router-table top you'll remove for the insert plate, set the drilling depth to $\frac{3}{8}$ ". With the edge of the bit just touching the inside faces of the routing guides, drill a $\frac{3}{8}$ "-deep hole into the router-table top at each corner [Drawing F].



4. Drill a blade-start hole inside the pencil lines. With the outside edge of your jigsaw base riding on the routing guides and the inside edge supported by a $\frac{3}{4}$ "-thick scrapwood block, cut just inside the lines, leaving the $\frac{3}{8}$ "-wide area inside the insert-plate outline as well as the triangular areas at each corner.

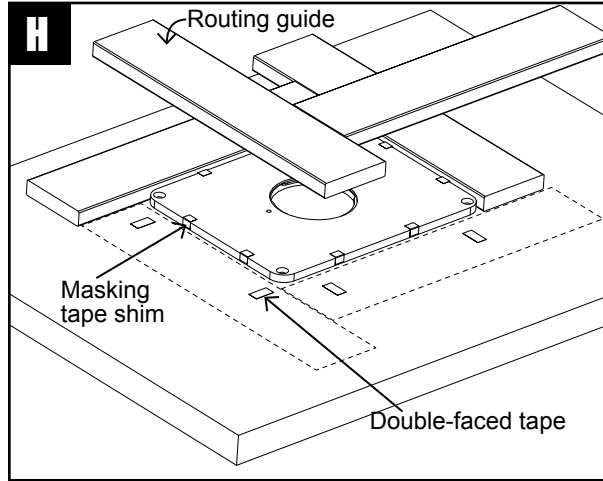
5. Chuck a top-bearing pattern bit with a $\frac{3}{4}$ " cutting length into your router. Adjust the cutting depth to the thickness of the insert plate plus the routing guide. Make test cuts in scrap stock to ensure that the cut depth exactly matches the thickness of the insert plate. Rout the perimeter rabbet and the corner triangles in several passes until the pattern-bit guide bearing runs smoothly against the edges of the routing guides [Drawing G]. Be sure to stop routing along each side where the $\frac{3}{4}$ "-radius corners formed by the drilled holes meet the routing guides. Carefully remove one routing guide and test-fit the insert plate in the opening. If the rabbet is too shallow, replace the guide, adjust the routing depth, and re-rout the rabbet. A too-deep rabbet can be shimmed with tape. When satisfied with the fit, remove the routing guides.



6. With the insert plate in place, use the countersunk corner holes as guides to drill $\frac{1}{4}$ " holes through the triangular corner areas in the table top. Secure the plate with the lock-down screws and your own washers and hex nuts or wing nuts. For greater convenience, remove the insert plate, enlarge the holes in the table top, and install T-nuts.

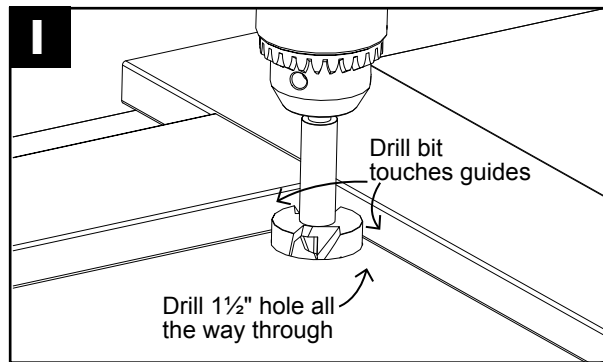
Kreg Precision Router Table Insert Plate Levelers method

! ATTENTION! This method requires the purchase of Kreg Precision Router Table Plate Levelers from your Kreg dealer. These levelers feature eight leveling screws that work with four lock-down screws to keep the insert plate flush with the router-table surface.

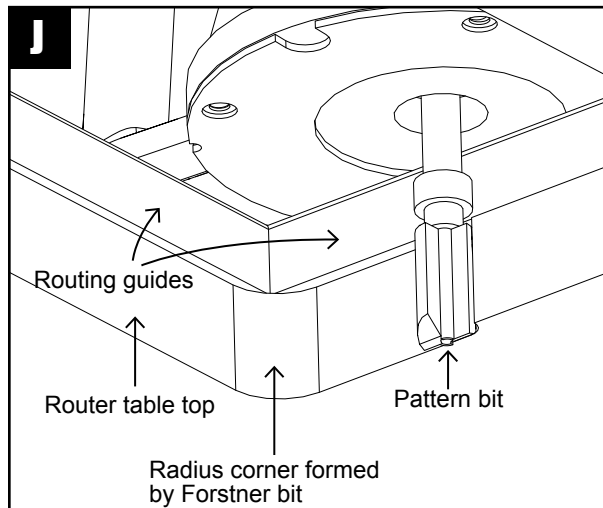


1. To provide clearance for installing and removing the insert plate, adhere strips of masking tape to all four edges of the plate. Then apply small pieces of double-faced tape to one face. (Use just enough tape to keep the plate in place. Too much tape will make the plate hard to remove later.) Position the insert plate on your router table top, squaring the plate with the table, and firmly press it into place.

2. Cut four $\frac{3}{4} \times 3\frac{1}{2} \times 15\frac{1}{2}$ " scrapwood routing guides. Apply double-faced tape and adhere the routing guides to the router table top with the edges against the masking tape strips on the insert plate edges **[Drawing H]**. Remove the plate. Chuck a $1\frac{1}{2}$ " Forstner bit into your drill press. With the edge of the bit just touching the inside faces of the routing guides, drill a hole all the way through the router-table top at each corner **[Drawing I]**.



3. Rough-cut the opening with a jigsaw, staying $\frac{1}{8}$ " inside the routing guides and cutting from corner hole to corner hole. For best results, support the inside edge of the jigsaw base with a $\frac{3}{4}$ "-thick scrapwood block.



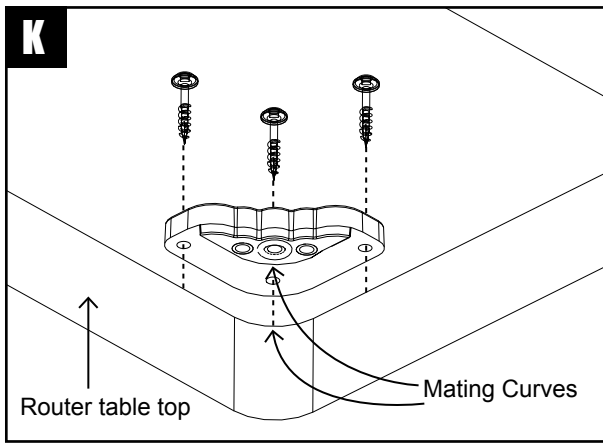
4. Chuck a top-bearing pattern bit into your router. With the guide bearing running against the routing guides, rout the edges of the opening **[Drawing J]**. Stop routing where the $\frac{3}{4}$ "-radius corners formed by the drilled holes meet the routing guides. If the thickness of your router-table top is greater than the reach of your pattern bit, switch to a bottom-bearing flush-trim bit, flip over the router-table top, and finish the cut with the flush-trim bit guide bearing running against the surface routed with the pattern bit. Remove the routing guides.

Install the Insert Plate

Rabbeted opening method

1. Attach the router base to the insert plate, using the screws that were used to attach the sub-base to the router base. Depending on the thickness of your router sub-base, it may be necessary to purchase longer screws. Make certain that the screws are long enough to fully thread into the router base. For fixed-base routers, install the motor unit in the router base and install the insert plate, with router attached, in the table.

2. Drop the four lock-down screws through the countersunk holes in the insert plate and thread them into the hex nut, wing nut or T-nut. Tighten the screws.



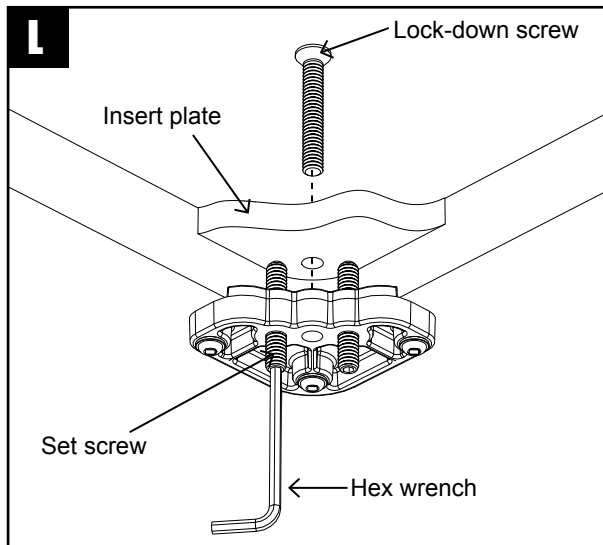
Kreg Precision Router Table Insert Plate Levelers method

1. With the table top upside down, position an insert-plate leveler in one corner of the table-top opening, mating the curve on the raised portion of the leveler with the radius corner of the opening. Firmly holding the leveler in place and using the three mounting holes in the leveler flange as guides, drill pilot holes into the table top. Fasten the leveler to the tabletop with three 1 $\frac{1}{4}$ " coarse-thread screws provided [Drawing K]. Repeat with the remaining levelers.

! ATTENTION! The 1 $\frac{1}{4}$ " coarse-thread screws provided with the levelers are for use on router table tops with a minimum thickness of 1". For thinner tops, use your own shorter screws.

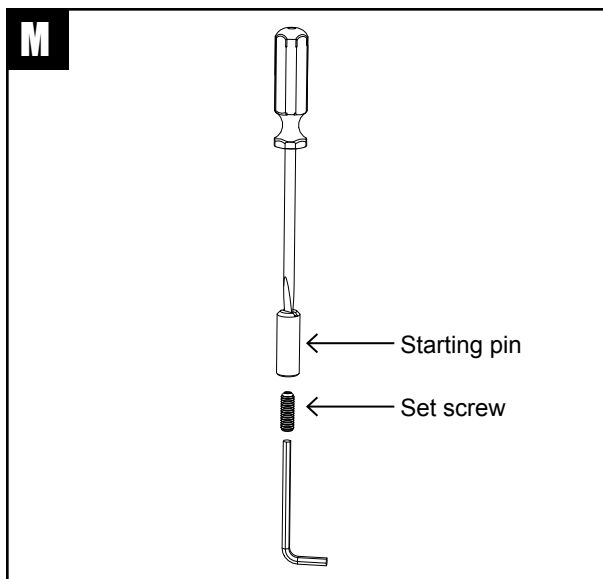
2. Using the $\frac{1}{8}$ " hex wrench, drive a $\frac{1}{4}$ -20 x 1 $\frac{1}{2}$ " socket-head set screw into each outside hole in each leveler, threading them in from the bottom until the tips are $\frac{3}{8}$ " below the table surface.

3. For Kreg PRS4034 and PRS4036 Precision Insert Plates, fasten the router base to the insert plate using the screws supplied with the plate. For the Kreg PRS4038 Precision Insert Plate, use the screws that were used to attach the sub-base to the router base to attach the router base to the insert plate. Make certain that the screws are long enough to fully thread into the router base. It may be necessary to purchase longer screws. For fixed-base routers, install the motor unit in the router base.



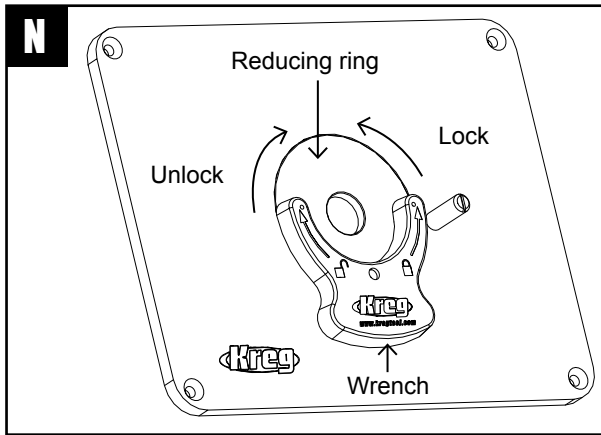
4. Place the insert plate with the router attached in the table-top opening, resting it on the eight set screws. Using the hex wrench, adjust the set screws from under the table to align the surfaces of the plate and the table. Check the alignment with a straight edge. Make sure all eight set screws are in equal contact with the insert plate

5. Thread the four $\frac{1}{4}$ -20 x 1 $\frac{3}{4}$ " machine screws (lock-down screws) through the countersunk holes in the insert plate and into the center hole on each leveler and snug them down [Drawing L]. Some adjustment of the lock-down screws and set screws may be necessary to fine-tune the alignment.



Finishing Up

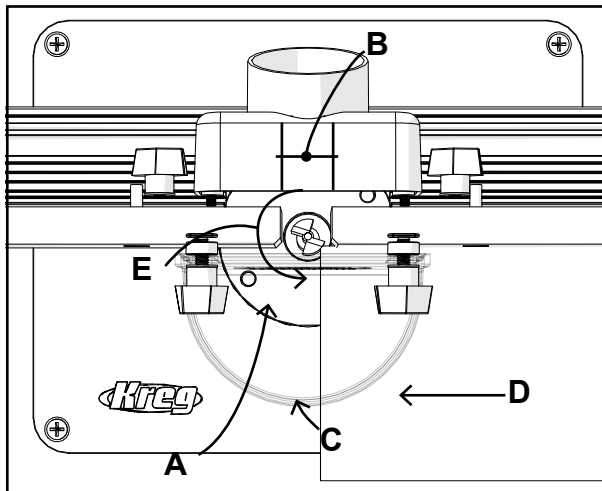
1. Thread the $\frac{1}{4}$ -20 x $\frac{3}{4}$ " set screw into the bottom of the brass starting pin using a flat-blade screw driver and $\frac{1}{8}$ " hex wrench, until the two are tightly secured together [Drawing M]. When ready for use, thread the starting pin assembly into the threaded hole in the insert-plate and tighten it.



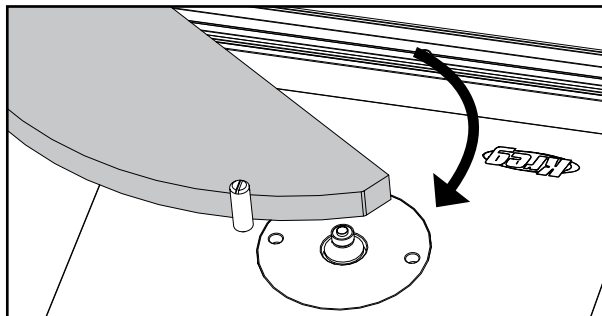
2. To install a reducing ring, simply drop it into the insert-plate opening and turn it by hand until it drops flush with the plate surface. Insert the pegs at the ends of the arms of the ring wrench into the mating holes in the reducing ring and rotate the ring counterclockwise **[Drawing N]**. Rotation of about $\frac{3}{8}$ " is sufficient to lock the ring in place. To remove the ring, turn the wrench clockwise and lift the ring out of the opening.

! ATTENTION! The Kreg Precision Insert Plate includes three Level-Lock reducing rings for flexibility in matching the size of the insert-plate opening to the diameter of the router bit in use. The ring with the rabbeted opening accepts standard universal-style guide bushings, allowing you to use your router table for pattern routing. A set of four additional reducing rings plus a blank disk for making a zero-clearance ring is available from your Kreg dealer.

General Routing

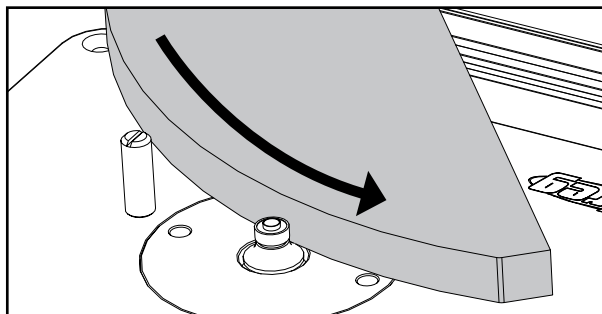


(A) Use the insert-plate reducing ring with the smallest opening that allows the bit to pass through it. **(B)** Position the fence faces as close as possible to the bit. Turn the bit by hand to check for interference. Firmly tighten the fence-face T-knobs before routing. **(C)** Position the bit guard over the router bit and as close to the workpiece surface as possible. **(D)** Feed the workpiece against (not with) the **(E)** bit rotation.



Starting Pin

To use the starting pin, begin with your workpiece touching the pin, but not in contact with the router bit. Slowly pivot the workpiece into the bit until the workpiece makes contact with the bit guide bearing. Always feed the workpiece so the router bit rotates against (not with) the feed direction. With the workpiece in solid contact with the guide bearing, ease the workpiece off of the starting pin and feed the workpiece along the guide bearing.



! WARNING! Use the starting pin when routing along curved edges and only with router bits that have a guide bearing. When routing against straight edges, always use the fence.