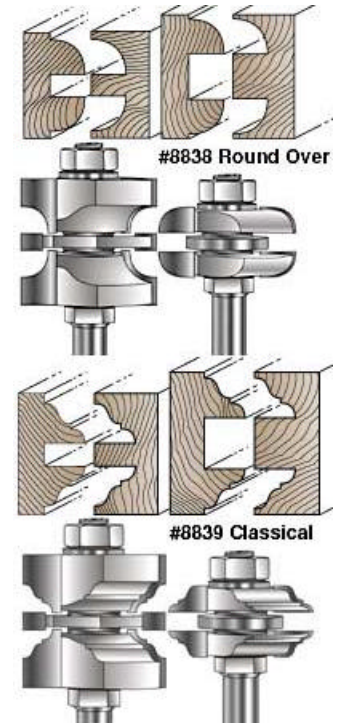


IMPORTANT POINTS

- ◆ Always use a router table and fence. These cutters should **NOT** be used freehand.
- ◆ Cutters should **ALWAYS** be run at a **REDUCED SPEED**. Use the **MLCS #9000 or #9400 Speed Control** or a variable speed router.
- ◆ This bit set comes assembled for making a 1/4" tongue and slot. If you are going to make a 1/2" tongue and slot, make sure to replace both the slot cutter and spacer/rub collar or your rails and stiles will not properly match up.
- ◆ Check the top nut when you first receive your cutters and periodically with use. The nut should be very snug, but not over-tightened. This will destroy the adjustment shims.
- ◆ Use Push Blocks (**MLCS #9138, 9139, 9140**) and a miter gauge or sled to feed your rails and stiles. **NEVER** use fingers to feed narrow stock!
- ◆ A 1-1/2 HP **PROFESSIONAL QUALITY** router will cut the profile in one pass. You can make the cut in 2 passes in difficult wood by adjusting the fence.



DESIGN AND CONSTRUCTION

- ◆ The cope and stick corner created by the bits is not strong enough by itself for a full-sized door. Our favorite method for reinforcing the corners is to assemble the door, then drill through the outside stiles and add screws or dowels into the rails.
- ◆ Glass panels can be made by assembling the door then routing out the profile on one side with a 3/8" Rabbeting Bit. Clean up the corners with a chisel, then make a small piece of molding to hold the glass in place.
- ◆ Panels for the door can be made using any of the MLCS Raised Panel bits. They can be "raised" on one or both sides. Depending on the profile you select, you may have to adjust the thickness of the panel stock so you end up with a 1/4" or 1/2" tongue to fit the frame groove. You can also use 1/4" or 1/2" thick veneer plywood for flat panels.
- ◆ **NOTE:** Veneer plywood will be a true 1/4" or 1/2" while cabinet grade plywood may be up to 1/32" undersized on the thickness, possibly leaving a loose, rattling panel.