



**Crown / Architectural Molding,
Chair Rail, Casing/Base Molding**

**Bits #7864-70, 7886, 7891-99, 7900-03
KATANA #17868, 18065, 18075, 18079**

The Crown and Architectural Molding bits will make custom trim for projects and home at a fraction of the cost of store-bought molding and allow you to use any species of wood. The following tips will help you run these larger bits safely and produce great results.

These bits should always be run in a router table with a fence. Bits should be run at a reduced speed to control burning and tearout. Be sure to support your work well both on the infeed and outfeed side of the table, especially with longer moldings.

Because you are cutting into the face grain of the wood with these bits, create a zero-clearance opening in your fence to reduce tearout. This can be an extra piece of plywood fastened to the original fence that you cut through with the bit to create the zero-clearance opening.

Attach featherboards to the table and fence of the router table to hold the work firmly against the bit. This will minimize chatter marks that are difficult to sand out. Most of the time the cut can be made in one pass with a good quality 1 1/2hp or larger router. With hardwoods a two-pass operation is easy to do. Set the fence for the full cut. Then temporarily fasten a piece of 1/4" plywood on to the fence, cut out to clear the bit. This effectively spaces the work away from the bit for a light first pass. Run all the molding, remove the 1/4" plywood "mask" and run the molding again at the full bit depth.

Since the bits cut across almost the entire face of the molding, you can experience difficulty on the outfeed side because there is little wood left to ride against the fence. The solution is to start with a board wide enough for the molding profile and some flat section. Set your featherboard to push against this flat. Then rip the board to final width after the profile is run. If the board is wide enough, you can run the profile on both edges, leave the flat in the middle, and get two runs of molding from one board.

