

1-800-533-9298 ♦ mlcswoodworking.com



Router Bits and Professional Woodworking Products

# PRECISION SLIDING ROUTER TABLE (Item #9463)

## INSTRUCTION MANUAL



---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## **TABLE OF CONTENTS**

<b>SECTION 1: HEALTH WARNING AND SAFETY.....</b>	<b>3</b>
<b>SECTION 2: INTRODUCTION.....</b>	<b>7</b>
<b>SECTION 3: CIRCUIT REQUIREMENTS.....</b>	<b>8</b>
<b>SECTION 4: MACHINE FEATURES AND SPECIFICATIONS... </b>	<b>9</b>
<b>SECTION 5: SET-UP.....</b>	<b>11</b>
Small Parts Listing.....	11
Cleanup.....	12
Site Consideration.....	12
Assembly.....	13
Cross Supports.....	14
Stand.....	15
Table Lifting Struts.....	17
Fence.....	18
Fence Hold-Downs.....	19
Cross Feed Hold-Down.....	20
Switch.....	21
Mounting The Router.....	21
Dust Port Hook-Up.....	22
<b>SECTION 6: OPERATIONS.....</b>	<b>23</b>
<b>SECTION 7: REFERENCE INFORMATION.....</b>	<b>25</b>
<b>SECTION 8: WARRANTY AND RETURN PROCEDURES.....</b>	<b>26</b>
<b>SECTION 9: EXPLODED DIAGRAM AND PARTS LIST.....</b>	<b>27</b>

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## **SECTION 1: HEALTH WARNING AND SAFETY**

### **HEALTH WARNING**

Sanding, sawing, routing, drilling, and other activities may create airborne dust particles containing chemicals known to cause cancer, birth defects, and other health complications. For example: lead from paints, crystalline silica in masonry products like brick and cement, arsenic and chromium from treated lumber.

Level of risk varies depending on frequency of exposure. To help mitigate detrimental effects, always work in an area with adequate ventilation using approved safety equipment, such as dust masks specifically rated to filter out microscopic particles.

### **SAFETY PRECAUTIONS WHEN WORKING WITH POWER TOOLS**

- Make sure all guards are properly positioned and working correctly.
- Be sure that all adjusting wrenches and keys have been removed prior to turning on your machine.
- Maintain a clean work area. Clutter can lead to unsafe conditions and accidents.
- Only use power tools in a safe environment. Never operate in damp conditions or in unventilated areas where noxious or flammable fumes may collect. Always work in a well-lighted area.
- All visitors and children should be kept away from the work area.
- Childproof your work area using locks, master switches, remove starter keys, and other devices.
- Don't force a tool beyond its capabilities. Use a tool for the job in which it was designed and do not exceed the proper rate of use.
- Wear proper clothing. NEVER wear dangling or loose clothing, necklaces, bracelets, neckties, or other articles that could be caught in moving parts. Likewise, cover long hair. Non-slip footwear also increases safety.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



- Wear safety glasses and face or dust mask. Remember: eyeglasses do NOT provide the same protection as safety glasses.
- Extension Cord Safety: Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

WIRE GAUGE

- An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.
- Secure Your Work. When possible, use a clamp or a vise for added safety. This keeps both hands free to operate your tool more securely.
- Never Over-Reach. Proper footing and balance must be kept at all times to avoid a dangerous fall.
- Keep Your Tools Well-Cared For. Tools that are kept sharp and clean work best and safest. Lubricate tools and change out accessories as instructed by the tool manual.
- Use Approved Accessories Only. Using accessories other than those recommended in the Owner's Manual can cause damage and injury.
- Avoid Unintentional Starts. To reduce the risk of accidental starts, machinery should ALWAYS be unplugged prior to making adjustments or performing service. Verify that the switch is in the OFF position before reconnecting the power.
- Inspect Damaged Parts. Any damaged parts must be thoroughly inspected before continued use to ensure proper functioning. Pay close attention to alignment and binding of moving parts, breakage, mounting and other potentially problematic conditions. Promptly repair and replace any damaged parts.

-----  
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



- Shut Off Your Tool Before Leaving. A running tool should NEVER be left unattended. Wait for the machine to come to a COMPLETE stop before leaving.
- Stay Alert! Machinery should not be used without full mental alertness. For example, never use machinery while tired or under the influence of drugs or alcohol.
- If you have a problem, stop using the tool immediately and contact service for further instructions.

## **SAFETY INSTRUCTIONS FOR ROUTER TABLE USE**

- **Keep your hands safe.** Do not place hands in front of or over the cutter. As your hand moves toward the cutter, you should arc it away toward the out feed side and then place it back behind the cutter.
- **Use Long Enough Stock to Keep Hands from Blades.** Special jigs or fixtures, such as a Safety Small Parts Holder, should always be used when routing stock less than 12 inches. If you can, rout stock before cutting and then cut to size.
- Keep the cutters below the workpiece whenever practical for added safety.
- **Check Rotation First.** Whenever you adjust your set-up, remove the machine from the power supply and rotate the collet by hand to ensure that the cutters can spin freely before starting the machine.
- If not using the full depth of the cutter be sure to keep any excess cutting height below the table surface.
- **Watch your depth of cut.** Removing too much material is dangerous and makes a rougher cut. Using multiple light passes enhances safety and improves the quality of the finished cut.
- **Stop when You Encounter Difficulty.** Any time you have a problem; you should stop work immediately and contact service or check with a qualified expert for additional instruction.
- **Choose the Right Safety Tools.** Often, push sticks are helpful safety devices. However, they can also be dangerous. If a push stick touches a cutter on the end grain, it can be forcefully ejected from your hand, causing possible serious injury. Fixtures, jigs, and hold-downs are often better options. Always use a guard or protective device of some sort.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



- **Feed AGAINST** the rotation of the cutter at all times.
- **NEVER** remove the fence guard.
- **ALLERGY WARNING:** Certain types of wood can cause allergic reactions. Be aware of possible reactions and use a respirator to minimize exposure to dust particles.
- You **MUST** read and fully understand the manual and operating guide for the router to be used prior to working with it.
- **NEVER reach below the table while the router is running or plugged in.**

**!!WARNING!!**

To avoid serious personal injury, please read this manual thoroughly and become very familiar with its contents, including all safety precautions.

**!!WARNING!!**

In addition to these guidelines, additional precautions should be taken specific to your own shop environment. Always use caution and common sense when operating machinery to avoid the risk of serious injury.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## **SECTION 2: INTRODUCTION**

MLCS is pleased to provide you with our *Item #9463 Precision Sliding Router Table*, one of our ever-expanding lines of quality woodworking products and machines. The Table will provide a long-life of trouble-free, easy operation when the guidelines in this manual are followed. We're confident that this table will serve as proof of MLCS's dedication to customer satisfaction and product quality.

This comprehensive manual was included to clearly cover the process of assembly, general safety precautions, and general operating procedures. Please let us know if you have any questions or comments regarding this documentation via the following methods:

- 1) Mail to:  
MLCS Ltd.  
PO Box 165  
Huntingdon Valley, PA 19006
- 2) Phone 1-215-938-5060
- 3) E-mail [sawdust@mlcswoodworking.com](mailto:sawdust@mlcswoodworking.com)

MLCS products are always guaranteed. For any service needs, warranty issues, or parts requests, please contact us via one of the following methods:

- 1) Mail to:  
MLCS Ltd.  
PO Box 165  
Huntingdon Valley, PA 19006
- 2) Phone 1-215-938-5060
- 3) E-mail [sawdust@mlcswoodworking.com](mailto:sawdust@mlcswoodworking.com)

Every effort is made to ensure that this manual and all its specifications, drawings, and product diagrams are complete and correct at the time of publication. However, as we continually modify and improve our products to better serve our customers, changes may be made from time to time with no obligation from MLCS.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## SECTION 3: CIRCUIT REQUIREMENTS

### **!!WARNING!!**

Improper wiring can cause a fire. Check that all system components (wiring, receptacle, plug, and circuit breaker) are adequate for the power demands of your machinery. If you cannot be certain, contact a qualified electrician for a review of your system and any necessary upgrades. You should never replace a circuit breaker with one rated for a higher amperage than other components of the circuit are designed for.

This machine's Power Switch can be used with 2-prong double-insulated plugs or 3 prong grounding plugs. The handy switch allows convenient and safe router control as you can switch the power on and off from the front of the table without reaching under the table. You can also power additional devices with the router turned on.

The power switch should be plugged into a properly grounded wall outlet.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*





## **SECTION 4: MACHINE FEATURES AND SPECIFICATIONS**

### **FEATURES**

- Accepts any brand of portable router from 3/4HP to 3-1/2HP.
- Table top can be tilted 45 degrees to make router bit adjustments.
- Precision ground cast iron table.
- The extruded aluminum sliding table is fitted with a toggle clamp for fast workpiece clamping.
- Precision split aluminum fence.
- 2.5” diameter dust hood.
- Key switch prevents unauthorized operation.
- Aluminum sliding table makes cutting easier.
- Hold-down is supplied as a standard accessory.

### **SPECIFICATIONS**

Suitable Portable Routers	3/4HP to 3-1/2HP
Main Table Surface	30-7/8” x 9-7/8”
Sliding Table Surface	30-15/16” x 12-1/4”
Table Tilts	45 degrees
Table Inserts	2 pcs accept 1-3/8” guide template
Table Height	33-7/8”
Fence Sizes (each side)	12” x 2-15/16”
Dust Hood Outlet	2”ID x 2-3/8”OD
Net Weight	134 lbs
Gross Weight	139 lbs
Packing Dimensions	35-1/2” x 25-3/4” x 8”

-----  
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



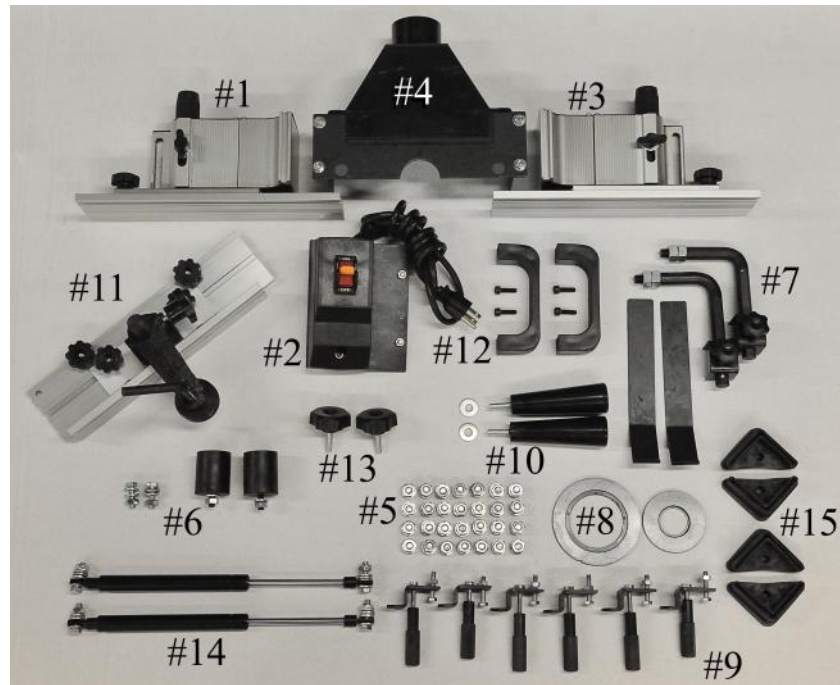
See pages 27 to 30 for the exploded diagram and parts list.



---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*

## SECTION 5: SET-UP



### SMALL PARTS LISTING

#1, Left Fence Assembly (1)	#7, Fence Hold Downs Assembly
#2, Power Switch and Cord (1)	#8, Table Inserts (2 piece set)
#3, Right Fence Assembly (1)	#9, Router Clamping Assemblies (6)
#4, Dust Hood Assembly (1)	#10, Fence Handles (2)
#5, Screw Package For Stand	#11, Pusher Set (1)
8mm carriage bolts (28)	#12, Table Handles (2) & Screws (4)
8mm flat washers (28)	#13, Table Locking Knobs (2)
8mm hex nuts (28)	#14, Hydraulic Lifting Struts (2)
#6, Screw Package For Table	8mm x 25mm hex bolts (4)
8mm x 25mm hex bolts (2)	8mm flat washers (16)
8mm flat washers (6)	8mm hex nut w/nylon insert (4)
8mm hex nuts (4)	#15, Rubber Feet (4)
Rubber Table Bumpers (2)	

-----  
 This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.



## CLEAN UP

A wax or oil coating may be used on some metal components to prevent rust during shipping. Any such coating should be cleaned and removed with solvent cleaner or a citrus degreasing agent. You may need to disassemble/remove some parts for thorough cleaning. To ensure the best performance of your machine, all moving parts and sliding contact surfaces must be thoroughly cleaned.

### **!!WARNING!!**

Gas and petroleum-based products are prone to explosion due to their low flash point. NEVER use these products for cleaning your machinery.

### **!!WARNING!!**

Solvents are flammable. To avoid the risk of explosion, fire, and/or injury, NEVER smoke while using these products.

### **!!WARNING!!**

Working in an area with inadequate ventilation can cause dangerous fumes to build up, increasing the risk of explosion, fire, and risks to personal health. ALWAYS work in a well-ventilated area.

## SITE CONSIDERATIONS

**Weight Support:** MLCS item #9463 weighs a sturdy 134 lbs. Most shop floors should handle this weight. However, if you have doubts, you should test and reinforce the floor prior to installation.

**Safe Clearance:** Always arrange your shop to allow adequate distance between machine and obstacles for safe operation. Carefully consider your machinery needs, the potential size of your work pieces, and additional space needed for other stands and worktables. The arrangement of each machine relative to other equipment should be carefully planned to allow most efficient handling of materials.

**Proper Lighting/Electrical Coverage:** Proper lighting should be bright enough to avoid eyestrain and eliminate shadows. Position electrical outlets or arrange machinery so that power cords and extension cords are not placed in high-traffic areas. Always follow local codes when installing new electrical components.

-----  
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## ASSEMBLY

Please follow these steps **IN ORDER** to assemble your machine. Then please read the remainder of the manual completely **BEFORE** you begin operation of your new machine.

**SAFETY IS THE HIGHEST PRIORITY!** Please observe these warnings during the assembly process:

### **!!WARNING!!**

Serious injury may occur if long hair or loose clothing is caught in moving parts of machinery. Always roll up loose clothing and tie up long hair to keep it safely away from your machinery.

### **!!WARNING!!**

Machinery should **ALWAYS** be unplugged during all assembly operations or serious personal injury could result.

### **!!WARNING!!**

Items expelled from the machine can cause eye injury. Wear appropriate safety glasses during assembly.

### **!!WARNING!!**

Metal parts may have sharp edges that can cause injury. Please inspect all metal edges and handle carefully.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*

## CROSS SUPPORTS

### Components:

Table Assembly (Quantity 1)  
Upper Front Brace (Quantity 1)  
Upper Side Brace (Quantity 2)  
Rubber Bumpers (Quantity 2)  
Hex Bolts 8mm x 25mm (Quantity 2)  
Flat Washers 8mm (Quantity 8)  
Hex Nuts 8mm (Quantity 4)

**Tools needed:** 12mm & 14mm Wrenches or one 12mm Wrench and one 14mm Socket

### Assembly:

1. Put the table assembly face down on the floor, on top of a piece of cardboard or blanket to protect the top from getting damaged.
2. Align the upper side braces and the upper front brace on the table assembly matching the boltholes as shown in Figure A. The upper side braces have offset holes and will only match up with the table supports, fitting only one direction.



Figure A

3. Use 2 hex bolts, 4 flat washers, and 2 hex bolts to connect the upper side braces and upper front brace to the table frame through "hex bolt hole" position. Place 1 flat washer on each side of the assembly, with the braces and table frame sandwiched between the two flat washers.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



4. Use the threaded rubber bumpers, 4 flat washers, and 2 hex nuts to attach the upper side braces to the table frame through the "bumper hole location" position. Remove 1 hex nut and 1 flat washer from the threaded rubber bumper. With the rubber head of the bumper facing the bottom of the table, insert the threaded part through the holes in the table frame and the upper side braces. Replace the flat washer that was removed earlier and secure with the hex nut that was also removed earlier. The height of the rubber bumper can be adjusted by moving the hex nuts up or down the threaded part of the rubber bumper, thereby leveling the table top.

## STAND

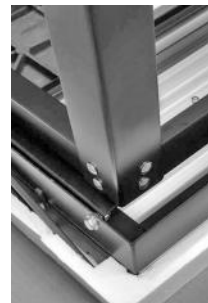
### Components:

Stand Legs (Quantity 4)  
45-degree Diagonal Support Brace (Quantity 2)  
Lower Tray (Quantity 1)  
Intermediate Strut Side Brace (Quantity 2)  
Carriage Bolts 8mm (Quantity 28)  
Flat Washers 8mm (Quantity 28)  
Lock Washers 8mm (Quantity 28)  
Hex Nuts 8mm (Quantity 28)

**Tools needed:** 14mm Wrench or Socket

### Assembly:

1. Use 12 carriage bolts, 12 flat washers, 12 lock washers, and 12 hex nuts to attach the stand legs to the upper front and upper side braces. At this time only finger tighten the hex nuts as you may need to maneuver the parts during assembly.
2. Use 4 carriage bolts, 4 flat washers and 4 hex nuts to attach the intermediate strut side brace to the legs. This brace should be mounted with the strut mounting hole facing the front of the stand for proper strut operation.

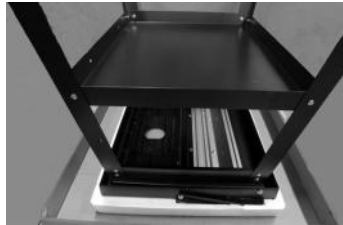


---

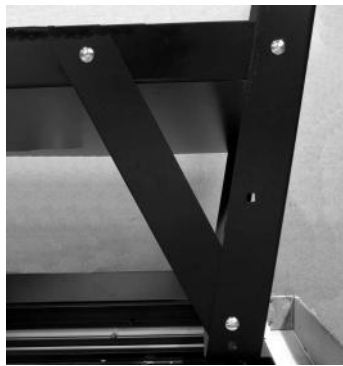
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



3. Use 8 carriage bolts, 8 flat washers, 8 lock washers, and 8 hex nuts to attach the lower tray to the legs of the stand. The two slots in the tray edge are to be placed on the back side of the table stand. At this time only finger tighten the hex nuts, as you may need to maneuver the parts during assembly.



4. Use 4 carriage bolts, 4 flat washers, 4 lock washers, and 4 hex nuts to connect the 45-degree support braces to the back side of the tray and stand legs.



5. Use the proper tools to tighten all hex nuts to secure the stand together.
6. Place the rubber feet on the bottom of the legs.
7. With the help of a second person, carefully turn the table right side up so it sits firmly on the rubber feet.
8. Remove the protective paper from the cast iron table surface. Use a solvent cleaner or degreaser to remove the coating from the cast iron table surface. Follow the directions on the label of the cleaner and allow for proper ventilation when using any solvents. Use caution to avoid getting any of the cleaner on the painted parts of the table and stand as this may cause the paint to be removed. Properly dispose of any soiled rags as some solvents may pose a flammable risk.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*





## TABLE LIFTING STRUTS

### Components:

- Hydraulic Struts (Quantity 2)
- 8mm Hex Bolts (Quantity 4)
- 8mm Flat Washers (Quantity 16)
- 8mm Hex Nuts with Nylon Insert (Quantity 4)

**Tools needed:** 12mm wrench, 14mm wrench

### **!!WARNING!!**

NEVER place hands or fingers near the stand edge while the table is raised. Serious injury can occur if fingers or hands are caught between the stand edge and table.

### Assembly:

1. Slide a flat washer on the hex bolt. Insert the hex bolt through the eye on the chromed end of the hydraulic strut.
2. Place three more flat washers on the bolt and pass the bolt threads through the hole in the table frame.

Top of Strut attached to Table



Bottom of Strut attached to Stand



From the inside of the frame, secure the strut to the table frame using the nylock nut. Do not completely tighten the nylock nut as the strut will need to be able to pivot whenever the top is raised or lowered.

3. Repeat this same operation for the other end of the hydraulic strut (barrel end), This time passing the bolt through the intermediate side strut brace.
4. Repeat for the other side of the table.
5. The struts will allow the table to stay up at a 45-degree angle. Use the (2) table locking knobs to secure the table down in a working position. The (2)

---

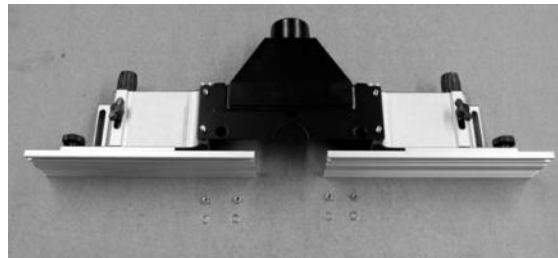
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*

handles used to aid in raising and lowering the table top can now be attached to the back edge of the table, to aid in holding the table down while the table locking knobs are tightened.

## FENCE

### Components:

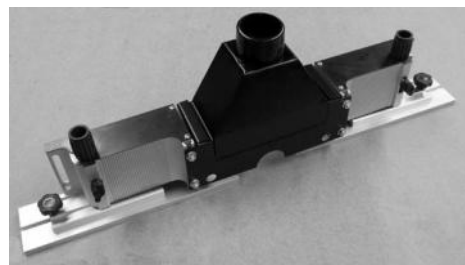
- Left Fence (Quantity 1)
- Right Fence (Quantity 1)
- Dust Hood (Quantity 1)
- Vertical Fence Lock Handles (Quantity 2)
- Flat Washers 8mm (Quantity 2)



**Tools Needed:** 10mm Wrench or Socket

### Assembly:

1. Remove the four 10mm hex nuts and washers from the dust port assembly. Slide two of the hex nut heads into the t-slots in the top of each right and left fence assembly.
2. Place the dust hood over the hex bolts to attach the dust port to the two fence halves. Use the washers and hex nuts to hold the three pieces together, but only tighten the hex nuts finger tight at this time.
3. Make sure the fence faces are fully retracted into the fence assemblies. Do this by loosening the butterfly knobs on the top of each fence assembly, then turn the knurled knob on the back of each fence assembly counter clockwise. Retighten the butterfly knobs before continuing.
4. The fence faces may need to be aligned. To do this, place the fence and fence faces down on a perfectly flat surface. Allow the fence faces to sit perfectly flat and this will insure that they are properly aligned.



---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



5. With the fence now in perfect alignment, tighten the 10mm hex nuts using a 10mm wrench.
6. Place the aligned fence assembly onto the router tabletop. Use the two vertical fence lock handles and flat washers to secure the fence to the router table.

## FENCE HOLD-DOWNS

### Components:

Hold-Down Assemblies (Quantity 2)

**Tools Needed:** 19mm Wrench

### Assembly:

1. Take one hex bolt off each L-bar.
2. Attach the L-bar to the fence assembly by inserting the threads on the L-bar through the dust hood's mounting holes. Then use the previously removed hex nut to secure the L-bar in place from underneath the dust hood.



3. Tighten the hex nuts until the brackets are secured perpendicular to the fence faces.
4. Place the hold down holder onto the L-bar. Orient the hold down holder so the threaded star knob so it will contact the L-bar on the flattened surface.
5. Slide the hold down through the hold down holder. The bend in the hold down should be oriented toward the table surface and to the left.



---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*

6. Tighten the threaded star knob to lock the hold-down in position. Exact placement is not essential at this point in the process.

## CROSS FEED HOLD-DOWN

### Components Needed:

Cross Feed Hold Down Assembly (Quantity 1)

### Assembly:

1. Insert the T-bolts into the T-track in the sliding aluminum table to attach the cross feed hold-down to the sliding table. Align the cross feed hold downs in position and tighten the star knobs. Use a machinist square to align the cross feed hold down to the front edge of the sliding aluminum table. Exact placement along the aluminum-sliding table is not essential at this time.



2. The cross feed hold down is now ready for use for making 90-degree cuts.



For making 45-degree miter cuts, use the hole that is near the corner in the cross feed hold down base (see image above for proper set-up).

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## SWITCH

### Components Needed:

Switch Box (Quantity 1)

**Tools needed:** Phillips Head Screwdriver, Adjustable Wrench

### Assembly:

1. Use the Phillips head screws, flat washers, and hex nuts to attach the power box to the front right leg using the appropriate through holes in the stand leg.



## MOUNTING THE ROUTER

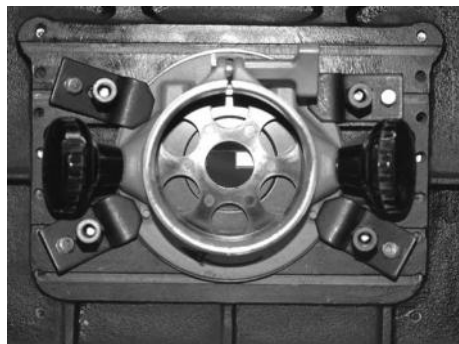
### Components Needed:

Router Clamps (Quantity 4)

**Tools Needed:** 10mm Wrench, 14mm Wrench

### Assembly:

1. Remove the table locking knobs. The table top will lift to a 45 degree position for allowing access to the bottom of the table.
2. Insert the 4 router clamps into the T-slots underneath the table.
3. Loosen the clamps so that the base of your router can press flat against the table bottom. Be certain that the router collet is centered in the table opening.



---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



4. Firmly attach the router base to the table by tightening the thickness bolts and jam nuts on each of the 4-router clamps.



5. Tighten the clamps to firmly hold the router in position.

## **DUST PORT HOOK-UP**

Never use this table without appropriate dust collection. Be sure to connect the dust port to a vacuum or dust collector system.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## **SECTION 6: OPERATIONS**

### **BEFORE ROUTING**

**STAY SAFE:** Please observe all the following warnings during operation of your table.

### **ROUTING ON YOUR TABLE**

**!!WARNING!!**

ALWAYS wear safety glasses, respirator, and hearing protection when using this machine. Otherwise, damage to lungs, ears, and eyes could result.

**!!WARNING!!**

Serious injury may occur if long hair or loose clothing is caught in moving parts of machinery. Always roll up loose clothing and tie up long hair to keep it safely away from your machinery.

**!!WARNING!!**

Avoid serious injury by familiarizing yourself with this entire manual prior to using your item #9463 Precision Sliding Router Table.

There are 3 basic routing operations that can be performed on your table:  
Edge Jointing, Groove Cutting, and Profile Routing.

In **Edge Jointing**, one uses a straight cutting bit to remove material from the edge face of a board to create a flat, square edge.

1. Insert a straight cutting router bit into your router per the instructions for your router and bit.
2. Insert the round table insert into the recessed hole in the table. Choose the smallest insert opening that does not interfere with the bit movement.
3. Move the out feed fence (left fence) to a position that is forward of the in feed fence (right fence). The distance between the two should be your desired cutting depth. Shallow cuts are more desirable than a single heavy cut for producing a smoother finish.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



4. Align the out feed fence with the cutting edge of the router bit.
5. Adjust the fence opening width to allow proper router bit clearance, but provide the proper support to safely make your cut.
6. Raise the router bit up slightly above the thickness of the stock you will be jointing.
7. After your stock passes the router bit and is cut, make sure to keep the board tight to the out feed fence to avoid making “bowed” cuts.

**Groove Cutting**, makes a groove or dado in the face of a board.

1. Insert a router bit into your router per the instructions for your router and bit.
2. Insert the round table insert into the recessed hole in the table. Choose the smallest insert opening that does not interfere with the bit movement. Raise the router bit to the desired height.
3. Reposition the fence so that the router bit is the desired distance away from the router fence.

**Profile Cutting** typically uses a bit with a ball bearing. The bearing follows along the uncut edge, controlling the depth of cut, while the cutter removes wood from the edge face of a board.

1. Insert a router bit into your router per the instructions for your router and bit.
2. Insert the round table insert into the recessed hole in the table. Choose the smallest insert opening that does not interfere with the bit movement.
3. Raise the router bit to the desired height.
4. Adjust the fence opening width to allow proper router bit clearance, but provide the proper support to safely make your cut.
5. Move the fence back just enough so the ball bearing can control the cut depth.
6. Move the fence back toward the bearing as close as possible to provide added support and safety.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*





## **SECTION 7: REFERENCE INFORMATION**

For parts or assembly assistance, please contact our technical support department. They will be happy to assist. For comments and questions regarding this manual, our **MLCS** warranty and return policy, and any general assistance, please contact us via one of the following methods:

**Phone:** 1-215-938-5060

**E-mail:** sawdust@mlcswoodworking.com

**Postal Mail:** MLCS Ltd., PO Box 165, Huntingdon Valley, PA 19006

We have made every effort to detail all necessary safety guidelines for operating this equipment throughout this manual. Nonetheless, please keep in mind that every shop and situation is different and all these rules should be considered and applied with common sense given the specifics of your own situation.

This manual contains only basic guidelines and instructions for general, safe operation of this machine. To become a skilled and accomplished woodworker and fully realize the potential of this machine, you will need to avail yourself of additional resources. Trade journals, woodworking magazines, the local library, and community colleges can all be indispensable sources of guidance and knowledge.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## **SECTION 8: MLCS WARRANTY AND RETURN PROCEDURES**

Every **MLCS** product has a 3-year Guarantee from the original date of purchase indicated on the invoice or packing list. Defects due (directly or indirectly) to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance are expressly excluded from this warranty. This is **MLCS's** sole written warranty for this product. Any and all other warranties that may be implied by law are hereby limited to the duration of this written warranty. In no event shall **MLCS's** liability exceed the purchase price paid for this product and any resulting legal actions will be tried in the courts of Huntingdon Valley, PA, County of Montgomery.

**MLCS** shall in no way be held liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damage arising from the use of our products.

For warranty related service, please contact us by mail or by phone at 1-215-938-5060. Please be prepared to provide all purchase details, including name and address of purchaser, date of purchase, invoice number, and issues with the product so that we may properly assist you. Additional instructions will be provided at the time of contact for the most expedient resolution to your particular issues. Any items returned for refund or replacement should include proper proof of purchase, such as an invoice or packing list.

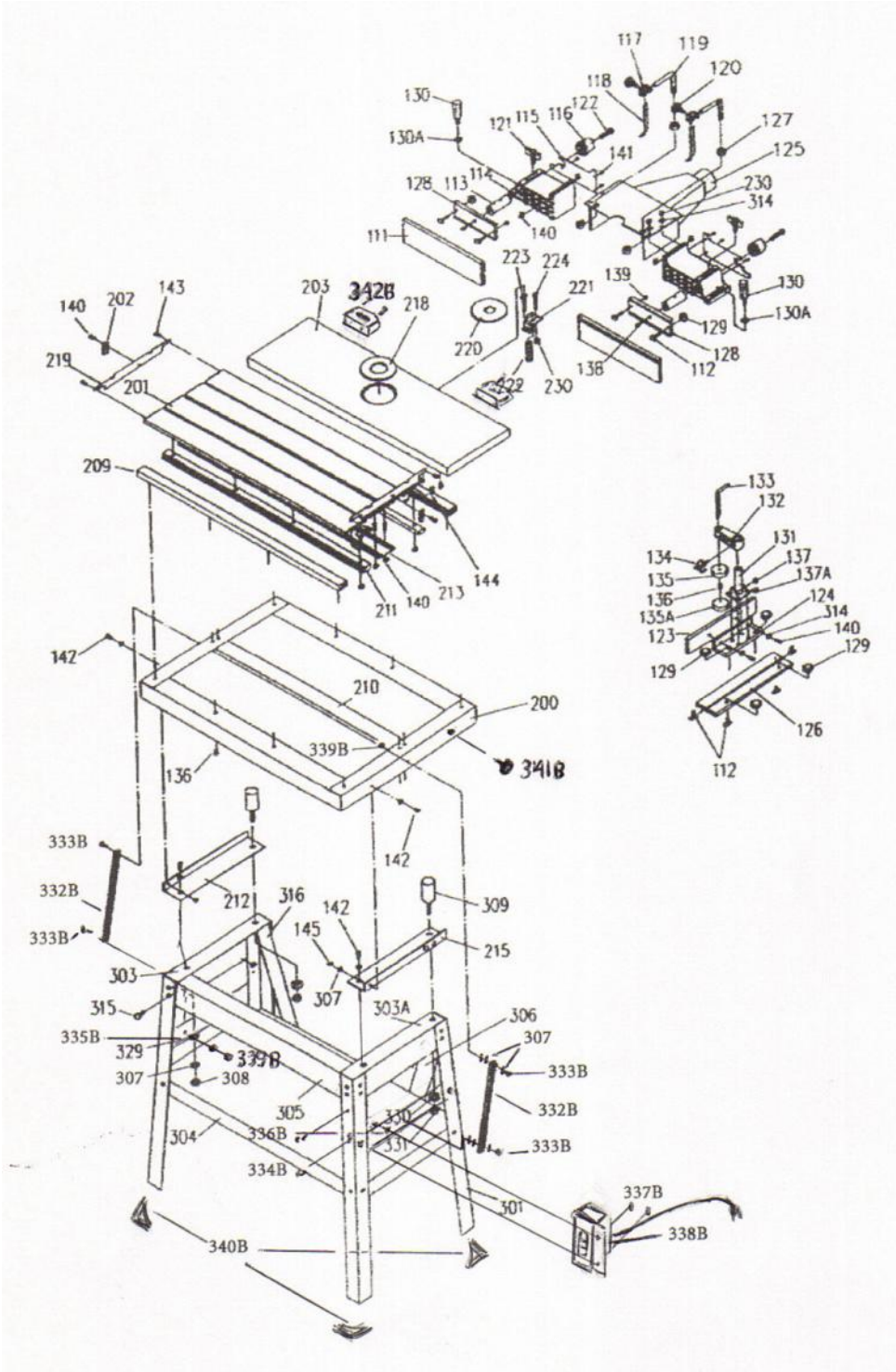
**MLCS** reserves the right to change the specifications of this product at any time as we strive to always improve the quality of our products based on continued research and development and customer feedback. It is our primary goal to ensure that our products are safe, high quality and durable. We sincerely hope you will never need to take advantage of this warranty.

Thank you again for your purchase and your support of **MLCS Woodworking** with your continued business. We look forward to serving you again in the near future and, for now; wish you happy and safe woodworking.

---

*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*

### EXPLODED DIAGRAM



*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



## PARTS LIST

PART No.	REFERENCE No.	DESCRIPTION	QTY
111	50000111	Fence half	2
112	50000112	Sliding screw 6mm x25mm	8
113	50000113	Micrometric adjustment rod	2
114	50000114	Fence body	1 left /1 right
115	50000115	Fence body guard	1 left /1 right
116	50000116	Micrometric adjustment nut	2
117	50000117	Hold-down holder	2
118	50000118	Hold-down	2
119	50000119	L bar	2
120	50000120	8mm Studded knob	2
121	50000121	10mm Butterfly knob	2
122	S0020624	10mm Hexagonal bolt	2
123	50000122	Fence plate	1
124	50000123	Clamp holder	1
125	50000124	Dust hood	1
126	50000125	Short fence	1
127	S0110812	13mm nut	4
128	50000126	Clamp plate	2
129	10505015	6mm Through knob	6
130	0104045	Heavy handle	2
130A	S0210501	Washer	2
131	50000127	Clamp bracket	1
132	50000128	Bracket	1
133	50000129	Clamp rod	1
134	50000130	6mm Star knob	1
135	50000131	Clamp plate	1
136	S0030300	8mm Round head screw	13
137	S0010410	5mm Hex head bolt	4
137A	S0230400	Spring washer	4

-----  
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



PART No.	REFERENCE No.	DESCRIPTION	QTY
138	S0020610	10mm Hex head bolt	2
139	S0120200	6mm Hex nut with nylon insert	2
140	S0020408	6mm Hex head bolt	16
142	S0020501	8mm Hex head bolt	4
143	S0030304	5mm Round head screw	12
144	S0020412	6mm Hex head bolt	8
145	S01 20201	8mm Hex nut with nylon insert	2
200	50400200	Table frame	1
201	50400201	Sliding table	2
202	30203004	Upper plate	2
203	50400203	Fixed Table	1
209	50400209	Sliding table guide	2
210	50400210	Middle bracket	1
211	50400211	Slide rail	2
212	50000212L	Table left support	1
213	50400212	Fix piece	1
215	50000214R	Table right support	1
218	50000217	4" Table insert	1
219	50400218	Guard	2
220	50000219	2-3/4" Table insert	1
221	50400220	Motor clamp piece	6
222	50400221	Hexagonal damp piece	6
223	50000222a	6mm x 50mm Sliding Screw	6
224	S0020425	6mm Hex head bolt	6
230	S01 10400	6mm Hex nut	30
301	50000301	Stand leg	4
303	50000303L	Upper left angle plate	1
303A	50000303R	Upper right angle plate	1
304	50300304	Lower plate	1
305	50300305	Front upper brace	1

-----  
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*



PART No.	REFERENCE No.	DESCRIPTION	QTY
306	50300306	Right bracket	1
307	S0210500c	8mm Flat Washer	52
308	S0110500	8mm Hex Nut	28
309	11800038	Bumper	2
314	S02 10401	Plain Washer	12
315	S0060509	8mm Carriage Bolt	28
316	50000306	Left bracket	1
330		8mm washer	2
331		8mm nut	2
332B		Lifting Strut	2
333B		8mm Hex Bolt	4
334B		Right cross support	1
335B		Left cross support	1
336B		Cross head screw	2
337B		Hex Nut	2
338B		Switch assembly	1
339B		8mm Hex nut with nylon insert	4
340B		Rubber feet	4
341B		8mm Star Knob	2
342B		Table lifting handle	2

-----  
*This manual may not be copied or reproduced in any way without the express written consent of MLCS Woodworking.*