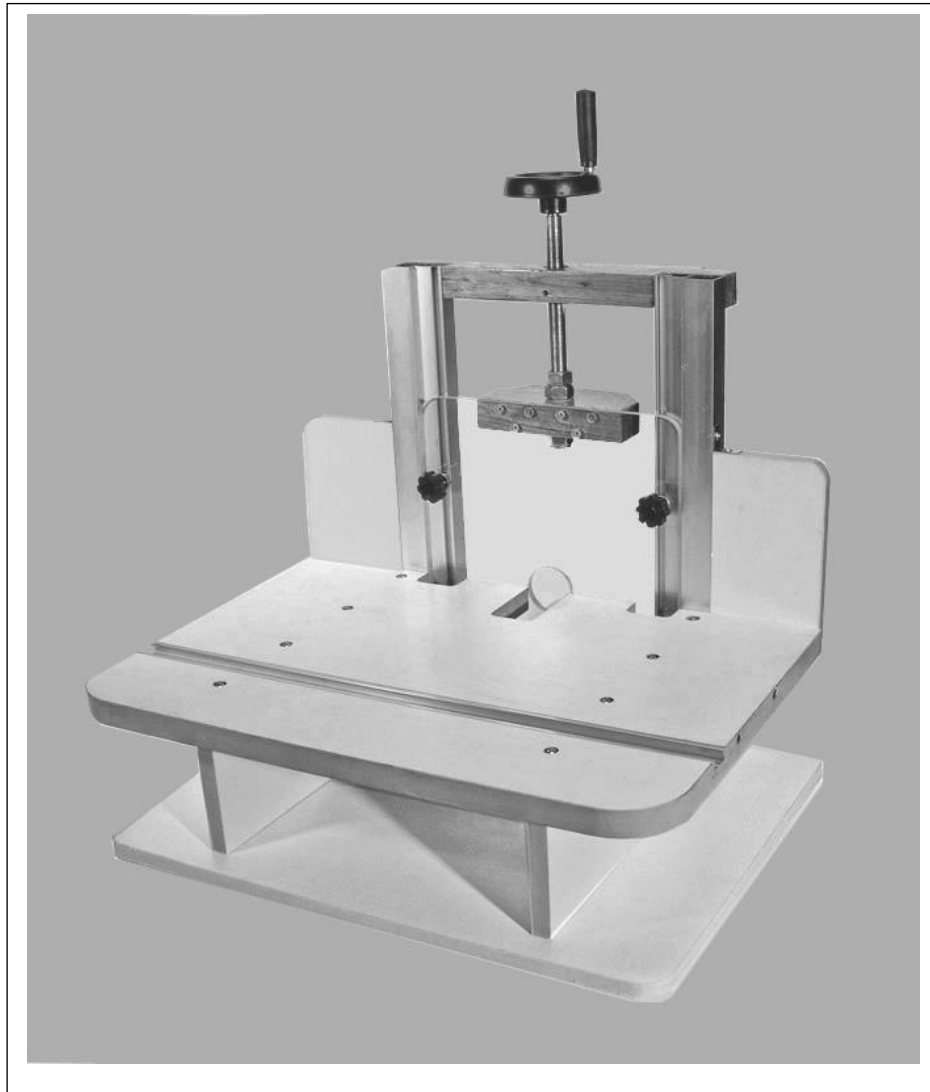




MLCS Manual for #9767 Horizontal “Flatbed” Router Table





General Guidelines, Tips, and Safety:

- Always wear your safety glasses, hearing and dust protection.
- Read and understand the instructions for both the machinery and cutters before starting to work.
- Use safety devices such as pushblocks, featherboards or bit guards/blade guards where appropriate.
- As a general rule of safety, keep your fingers and hands **at least** one hand-length from any cutting blade.
- When using the router, pay particular attention to the condition of the collet. Frequently, bit breakage and poor performance can be directly attributed to a worn or damaged router collet.
- Always inspect a router bit before use. Make sure the wax is removed from the cutting blades and bearing. Check for chips in the carbide, frozen bearings, worn shaft, and be sure set screws and nuts are tight in bit assemblies.
- Always change bits or make adjustments with the router unplugged.
- Make sure the router bit shaft is set at least 3/4" into the collet, but not bottomed out. The end of the shank should be about 1/16" up from the bottom of the collet.
- Two light passes cut more smoothly and easily than one heavy pass. Proper bit RPM is important, especially with larger, heavier bits. In general, burning of the wood or excessive vibration can be corrected with a slower rpm and a lighter cutting pass.
- Use a variable speed router or speed control to reduce the speeds when cutting large diameter bits, as follows: 1/4" to 2" Dia. --- 18,000 RPM; 2-1/8" to 2-1/2" Dia.--- 16,000 RPM; 2-5/8" to 3-1/2" Dia. --- 12,000 RPM. Bits with a carbide height greater than 1-1/2" should also be run at 16,000 RPM or less and it is **EXTREMELY IMPORTANT** to make multiple passes with these router bits.
- Be aware that some cleaning solvents can dissolve the lubricating oil in bit bearings. Either remove the bearing or re-oil it after cleaning a bit.
- Failure to follow all safety instructions and warnings can result in serious bodily injury.
- In no event shall we be liable for death, injuries to persons or property arising from use of our products.
- Defects from misuse, abuse, negligence, or alterations are not covered by the warranty. Our liability is limited to replacement or refund of the product.



Safety First: After assembly of the table. Secure the table to your work surface before using as the table with the router mounted will be weighted toward the back and could tip over backwards. We recommend either screwing it to your work surface or using clamps. To ensure the safest operation, always make sure the router bit is not positioned above your stock and feed your stock from left to right into the rotation of the cutter.

Assembly of the Table Base Unit

1.) Start the assembly by installing the two vertical table supports (part#23) to the router table base (part #24) using (8) screws (part #22). The table base should have the countersunk holes on the bottom. The vertical table supports should have the threaded inserts facing the rear of the table.

Preparing the Router Mounting Plate

There are (4) countersunk/counterbored holes above the router bit opening on the router mounting plate. Those holes are there to allow you to mount the MLCS PowerLift to the Horizontal Router Table for increasing the versatility of the Horizontal Router Table.

2.) Remove the protective paper backing from both sides of the Router Mounting Plate (part #25). Center your router over the hole in the Router Mounting Plate and mark the mounting holes for your router. (Note: After marking these positions, it may be helpful to remove the sub-base from the router and use it as a drilling guide. Line up the sub-base with the marked mounting holes and attach with double sided tape.) Drill and countersink the holes for the router. The countersinks for router mounting holes must be drilled on the same face of the Router Plate as the countersunk holes for the drive block.

Installing the Router Plate to the Drive Block

The router plate is left uninstalled to ease preparing the router plate for router installation.

3.) First, follow the instructions for marking and drilling the Router Plate (#25) to accept your router.

4.) Thread the drive rod (#3) through the hex nut in the top support (#5), with the smooth turned down section facing the top of the top support (the nylon bushing is on the top of the top support). Thread two 3/4" hex nuts (#7) onto the drive rod. Place the drive block (#8) on the drive rod with the four plate mounting screw holes facing upward. Finally, place the 3/4" hex nylock locking nut on the bottom of the drive rod. Tighten the two hex

nuts that are above the drive block against each other as close to the drive block as possible while still allowing the drive block to spin freely around the drive rod.

Attack the two aluminum columns (#10 & 18) to the top support using two hex bolts (#6) and flat washers per side.

5.) Slide two 5/16" Hex Bolt (#17) into the t-slot on each aluminum column. Place the Router Plate (#25) onto the Horizontal Router Table with the four 5/16" Hex Bolts (#17) protruding through the holes near the edge of the Router Plate (#25). Secure the Router Plate (#25) loosely using the four 5/16" Locking Knobs (#20). Slide the Router Plate (#25) to position where the mounting holes in the Router Plate (#25) are aligned with the predrilled holes (from step 5.) in the Drive Block (#8). Secure the Router Plate (#25) to the Drive Block (#8) using six 3/16" Wood Screws (#16). *Tighten securely but do not over tighten as you may either strip the wooden Drive Block or crack the acrylic Router Plate. If your router plate is not flush with the aluminum extrusion, a few pieces of masking tape or slick tape may be applied to the back of the plate where the plate contacts the extrusions to shim the plate flush.*

Attaching the Router Mechanism

6.) Attach the router mechanism (part numbers 3, 4, 5, 6, 7, 8, 9, 10, 15, 16 +18) to the base assembly with (6) hex bolts & washers (part #26). Do not over-tighten as you may bend the aluminum columns (part #10 + #18)

7.) Continue by installing the router table top (part #21) to the vertical table supports (part #23) using the (8) remaining screws (part #22). The countersunk holes will be facing up on the router tabletop.

Attaching the Extension Fences

8.) Attach extension fences (part #13 + #19) to the table top using (4) screws (parts #22). Complete this step by attaching the top of the extension fences (part #13 + #19) to the aluminum columns (part #10 + #18) using screws (part #12) and screwing through the angle support brackets (part #11)

Assembly of the Handle and Height Wheel

9.) The handle (part #2) has two flattened sides on the stud that is protruding from the bottom of the handle. These will allow you to tighten the handle to the height wheel. See figure 1.



(figure 1)

10.) Use a 10mm open end wrench to secure the handle to the height wheel. The handle will be able to rotate freely even when the stud is secured to the height wheel. See figure 2.



(figure 2)

11.) Use an open ended wrench to secure the handle to the height wheel.

12.) The handle (part #2) should now be able to turn freely.

Attaching the Handle to the Drive Rod

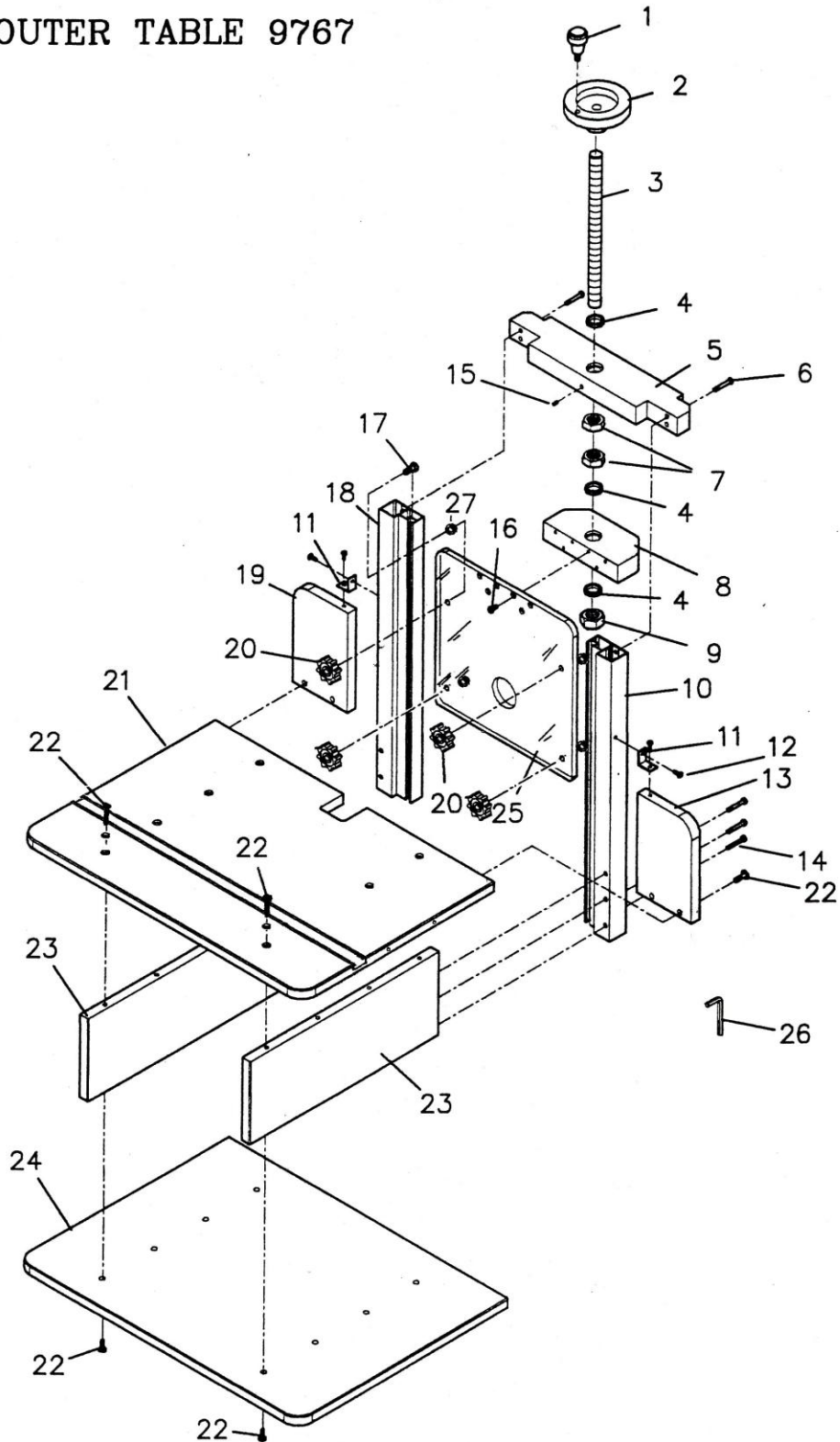
13.) Place Handle (part #1) and Height Wheel (part # 2) assembly onto the drive rod (part #3) so that the allen set screw is oriented towards the flat spot on the drive rod. Secure by tightening the setscrew.

You may now install your router on the Horizontal Table after completing the full assembly instructions.



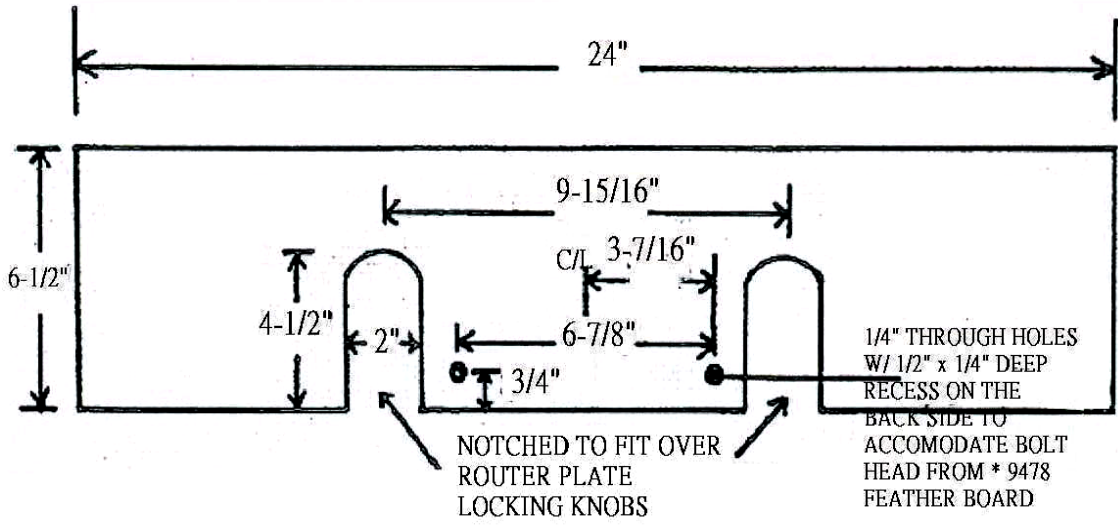
Router Table 9767 Part List			
REF NO.	PART NAME	QTY	NOTE
1	Handle	1	
2	Height wheel	1	
3	Drive rod (3/4" x 16tpi)	1	
4	Nylon bushing	3	
5	Top support	1	
6	Hex head bolt (M6 x 1 x 50mm)	4	
7	Hex nut (3/4" x 16tpi)	2	
8	Drive block	1	
9	Lock nut (M18 x 1.5mm)	1	
10	Aluminum column (Right)	1	
11	Angle support bracket	2	
12	Screws (M4 x 12mm)	4	
13	Extension fence (right)	1	
14	Hex head bolt (M6 x 1 x 50mm) plus flat washer	6	
15	Screws (M6 x 10mm)	1	
16	Plate mounting screw (M4 x 18mm)	6	
17	Hex head bolt (M8 x 1.25 x 25mm)	4	
18	Aluminum column (left)	1	
19	Extension fence (left)	1	
20	Lock knob (M8 x 1.25mm)	4	
21	Router table top, Miter Track & Threaded Inserts	1	
22	Screws (M6 x 1 x 30mm) & 6mm Flat Washers	20	
23	Vertical table support	2	
24	Router table base	1	
25	Plate	1	
26	Hex wrench (Accessory)	1	

ROUTER TABLE 9767





FEATHER BOARD HOLDER DESIGNED TO BE CLAMPED ON TO #9767 HORIZONTAL "FLATBED" ROUTER TABLE



MATERIAL NEEDED:
 24" x 6-1/2" x 3/4" MATERIAL
 FOR FEATHER BOARD MOUNT

TOOLS NEEDED:
 1/4" x 1/2" DRILL OR FORSTNER
 BITS AND DRILL JIG SAW

ACCESSORIES NEEDED:
 (1) MLCS #9478 FEATHER
 BOARD
 (2) MINIMUM 1-1/2"
 CAPACITY CLAMPS TO
 HOLD THIS ASSEMBLY TO
 THE HORIZONTAL
 "FLATBED " ROUTER
 TABLE



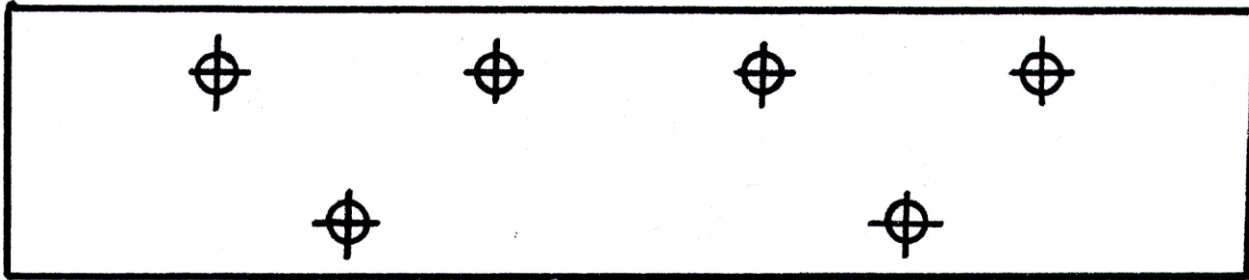
Making Raised Panels on the HORIZONTAL ROUTER TABLE #9767

Note: The Horizontal Router Table cannot be used to make cathedral doors.

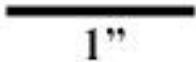
- 1) Start by cutting your panel to its finished size. You may choose to allow a small 1/16" to 1/8" gap inside the rail & stile for seasonal wood movement.
- 2) After you have cut your panel to its finished dimension, install a vertical raised panel bit in your router.
- 3) Adjust the router bit depth so the router bit will cut a 3/8" depth flat cut before the profile cut starts. Position the router plate height so that the router bit's edge is just above the surface of the tabletop. Turn the locking knobs to secure the router and plate in place.
- 4) Turn on the router and working from left to right, make the first pass on the end grain of the panel. Cut the end grain first so that any tear out can be cleaned up when you cut with the grain.
- 5) After cutting the end grain on the panel, cut the two remaining edges (with grain cuts).
- 6) **Turn off the router and wait for the router bit to come to a complete stop.**
- 7) Loosen the two locking knobs on the router plate and adjust the bit up a small amount. Lock the knobs to secure the plate and make your second pass on the panel.
- 8) Repeat until you have a 1/4" tongue to fit into the slot on the rails and stiles. **TIP:** Taking many shallow passes will yield a better cut than trying to cut too aggressively which may lead to a poor cut quality or excessive tear-out.

Remember Safety Rules: Wear proper eye protection, keep hands away from router bit and never rout with the router bit above your workpiece – always keep your workpiece above the router bit.

Use this template to mark the router plate mounting holes



Onto the face (longer edge) of the Drive Block (#8).



This line should be exactly 1" long.

Please use this measurement to make sure this template was printed at the proper size.

If it was printed too small, please follow these instructions to get this template to print at the proper size:

If you are NOT already on the website:

Go to www.MLCSwoodworking.com

On the LEFT menu click on HOW TO INSTRUCTION

In the expanded menu click PRODUCT MANUALS

Then select ROUTER TABLE - HORIZONTAL MANUAL

If you are already on the Website:

Make sure this file is open

Select FILE in the top menu bar

Drag down and select PRINT

Go to PRINT SCALING and select NONE in the drop down menu. (The default setting is Shrink to Printable area - this needs to be changed.)

Now select OK to print