



Biscuit Joinery

**Kits # 6065, 8365, 6064, 8364, 6063, 8363
Katana Kits #16065, 18365**

Biscuit joinery has become a standard woodworking operation, replacing many traditional techniques such as doweling and mortise and tenon. Originally, an expensive (\$300 - \$500) machine was needed to make this easy and convenient joint. Now MLCS has a system for less than \$35.

The heart of our system is a bearing guided slot cutter, sized to the standard biscuit thickness of 5/32" or 1/8" thickness for the H-9 biscuit. The biscuits are industry- standard, made of a compressed beech that swells and locks the joint upon contact with common water-based woodworker's glue. (Elmer's, Titebond, etc.) You can use the biscuit cutter either freehand or in a table-mounted router.

The basic edge-to-edge joint is easy to setup and do. Install the bit in your router and set bit height to approximately the center of the wood thickness. It doesn't have to be exact; the beauty of this joint is that both pieces to be joined register against the router base and cut the slot the same distance from the face of the wood. This makes the joint perfect every time. Also, you do not need to make the slots any particular length or location. Just run several 5" to 6" slots and put biscuits all along the joint. This eliminates tedious marking for centerlines. Spread glue in the slots, place the biscuits, and clamp tight.

Biscuits can also be used on miter joints. These can be done with caution on the router table. Set up your bit as before. Then clamp a guide to the table for the workpiece to ride against as you feed it into the bit. The round (#11) style of biscuits works best for this application, as they are deeper and shorter than the #20 size. For particularly tiny frames, the #H-9 size biscuit is only 1-1/2" long and thinner (1/8") than standard. With thicker wood, you can use a double biscuit for a super strong joint.

