



# WHITESIDE MACHINE & REPAIR CO., INC.

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## 1.) MAKING THE PATTERN

MAKE THE PATTERN OUT OF 1/4" MATERIAL, PREFERABLY MASONITE, PLEXI-GLASS, OR A SIMILAR MATERIAL. LEAVE AT LEAST 3" TO 5" OF MATERIAL ON THE OUTSIDE OF PATTERN TO SUPPORT THE ROUTER BASE. REMEMBER TO LEAVE ALL OPENINGS IN THE PATTERN LARGE ENOUGH FOR THE 9/16" BUSHING.

## 2.) PREPARING THE ROUTER

PLACE THE THREADED BRASS BUSHING INTO THE ROUTER'S BASE PLATE. INSTALL THE NUT FROM THE TOP SIDE OF THE BASE PLATE AND FINGER TIGHTEN. INSTALL THE CENTERING PIN INTO THE ROUTER COLLET. LOWER OR PLUNGE ROUTER DOWN, MAKING SURE ROUTER IS OFF AND UNPLUGGED. ALIGN PIN WITH BUSHING CENTER HOLE. AFTER PIN IS ALL THE WAY INTO BUSHING, FINISH TIGHTENING NUT. RAISE ROUTER AND REPLACE WITH 1/8" SOLID CARBIDE SPIRAL. THIS PROCEDURE CENTERS BUSHING IN RELATION TO ROUTER COLLET. USE EXTRA CAUTION WHEN HANDLING, INSTALLING, AND USING BIT. DUE TO THE NATURE OF SOLID CARBIDE, THE BIT IS VERY FRAGILE. SET CUTTING DEPTH OF BIT EQUAL TO THE THICKNESS OF THE INLAY MATERIAL.

## 3.) ROUTING THE WORKPIECE

CLAMP THE PATTERN TO THE WORK PIECE SO THAT IT WILL NOT SLIP. PLACE THE SMALL BRASS BUSHING RING ONTO THE BUSHING ALREADY INSTALLED ON THE ROUTER. OBEYING ALL SAFETY PRECAUTIONS, NOTE: THE SMALL BRASS BUSHING IS NOT THREADED, IT IS HELD ON BY AN O-RING INSIDE THE BUSHING. IT WILL BE TIGHT THE FIRST COUPLE OF TIMES IT IS TAKEN OFF AND ON.

TURN THE ROUTER ON AND ROUTE AROUND THE INSIDE OF THE PATTERN, MOVING IN A CLOCKWISE DIRECTION. THIS WILL GIVE YOU AN OUTLINE OF YOUR PATTERN. THEN THE REMAINING MATERIAL MUST BE REMOVED VIA ROUTING FOR BEST RESULTS.

## 4.) ROUTING THE INLAY

IT WOULD BE BEST TO APPLY DOUBLE SIDED TAPE TO THE AREA FROM WHICH THE INLAY WILL BE CUT. THIS WILL PREVENT THE INLAY FROM MOVING OR FLYING OUT BEFORE YOU ARE FINISHED. NEXT, CLAMP THE PATTERN OVER THE INLAY MATERIAL. REMOVE THE SMALL BRASS BUSHING RING AND ROUTE CLOCKWISE AROUND THE PATTERN.

## 5.) INSERTING THE INLAY

INSERT THE INLAY INTO THE WORKPIECE THAT HAS BEEN CUT OUT. IT MAY BE NECESSARY TO SAND EDGES AND CORNERS OF INLAY TO GET A PERFECT FIT. BE CAREFUL NOT TO OVER SAND.

NOTE: THE INLAY KIT IS DESIGNED TO FIT MOST PORTER-CABLE & BLACK & DECKER ROUTERS. IT IS ALSO RECOMMENDED THAT A PLUNGE ROUTER BE USED WHENEVER POSSIBLE.

REPLACEMENT BIT: PART NUMBER RD1600 1/8" SOLID CARBIDE DOWNCUT SPIRAL BIT WITH 1/4" SHANK.