



WOODHAVEN

BEFORE BEGINNING

Read the instructions at least once, familiarizing yourself with the parts and instructions before beginning.

ASSEMBLY

Remove the existing template from your 7600-7603 Woodhaven Dovetail Jig and replace it with the 3/4" box joint template (7630T).

Install the 1/2" bit (25203 or 13416) in your routers collet. Set the depth of cut to 1/64" more than the thickness of your stock (maximum 3/4" thick stock capacity with 25203 bit), taking into account the 1/2" thickness of the template. If applicable, install the bushing (5030) and lock nut (5040) on your routers base plate.

Swap the locations of the existing stops and position them even with the first opening at each end of the template for now. *See fig. 1.*

CUTTING A BOX JOINT

Loosen the two ratchet handles on the two template nuts and raise or lower the template until a scrap board just fits between the underside of the template and the top edge of the Ultra Track, then retighten the handles. Position the edge of the scrap flush with the face of the Ultra Track and clamp it in place using the dovetail jigs clamps. The scrap board should be at least 1/16" thicker and about 1" wider than the work. The scrap board prevents tear out when the bit exits the back of the work and provides an extra margin of safety to help insure the bit won't hit the Ultra Track.

Install the work in the front of the jig where the dovetailed drawer sides normally are placed. Place the end of the work against the underside of the template and the edge of the work against the edge of the stop. Adjust the stop position to align the work where desired in relation to the fingers on the template. Tighten the front clamps to hold the work in place.

Make a test cut in some scrap. Cut from left to right, following the fingers of the template. If you get chipping on the face of your work you may need to clamp a scrap of 1/4" plywood or hardboard to the face of the work.

The cuts on the mating workpiece will need to be offset by 3/4" to line up to the first workpiece when assembled. Rip a 3/4" spacer on your table saw (the same width as one of the box joint fingers from a successful test cut) and place it between the stop and the work to offset it 3/4".

7630 & 7631 3/4" Box Joint Kit *Please Read Carefully!*

Parts List:

Part	Description	Quantity
7630T	3/4" Box Joint Template	1
	<i>7630 Includes:</i>	
25203	1/2" dia. x 1/4" Shank Bearing Bit	1
	<i>7631 Includes:</i>	
13416	1/2" dia. x 1/2" Shank Bit	1
5030	5/8" Bushing	1
5040	Lock Nut	1

