



FREUD® EASY-SET INSTRUCTIONS

Using the Freud® Easy-Set Jig

FIRST - Determine the thickness of your stock. Don't assume that hardwood or softwood stock you buy in a lumberyard or home center is of a consistent thickness...or that it is as stated. For example, most 3/4" plywood is actually 23/32" thick. Dial calipers are best for these measurements. The decimal conversion tables below will help. A fractional calipers works best.

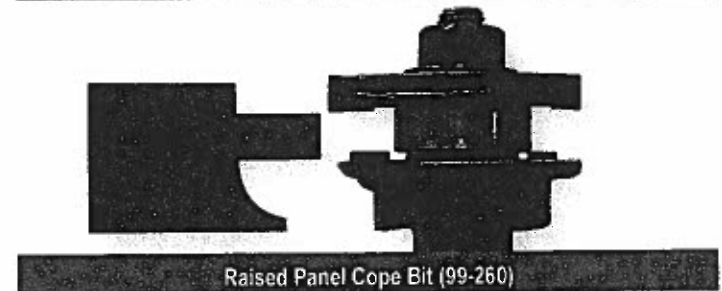
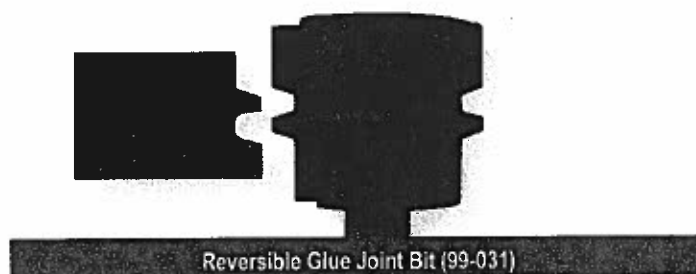
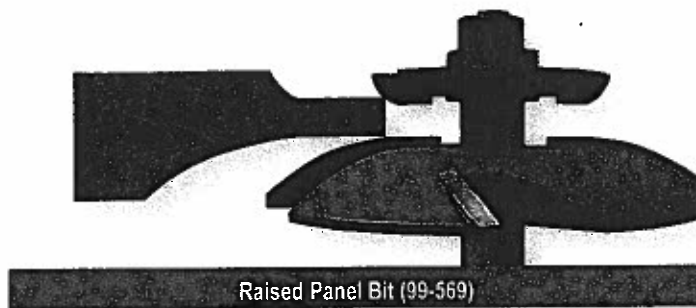
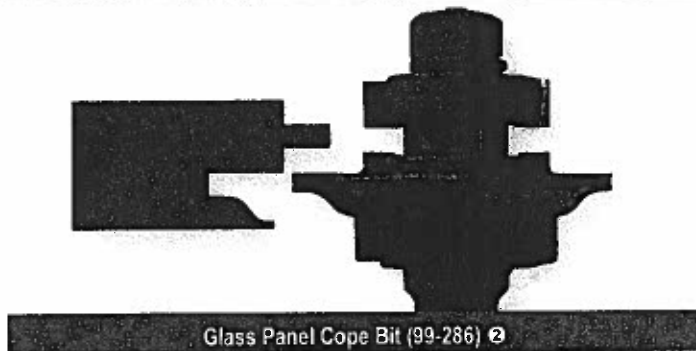
NEXT - Set the Easy-Set dial - Each mark on the outer jig dial = 1/128" (.0078"). Each medium-length line = 1/64" (.0156"). Each full-length line = 1/32" (.0312"). Start by turning the center grip all the way counter-clockwise until the arrow on the grip stops at the *star*.

At this position, the jig is set for 23/32" (the standard thickness of most 3/4" plywood). Turn the dial clockwise to the next full-length line and it will be set for 3/4" thick stock. Each audible click clockwise raises the jig 1/128" for thicker stock. During your first 360° rotation, read the numbers on the right of

the full-length lines. During the second rotation, read the numbers on the left of the full-length lines.

Baby Lock Miter Settings: When using Freud's Baby Lock Miter Bit, the jig functions a little differently...and can be set to handle stock from 15/32" to 3/4" thick. When using 1/2" thick stock, turn the center grip all the way counter-clockwise until it stops. Then turn the grip four clicks clockwise until the 1/2" indicator is aligned with the smaller arrow on the outer ring. Each audible click clockwise raises the jig 1/128" for thicker stock. For 3/4" stock turn the center grip clockwise one revolution until the 1/2" indicator aligns with the outer ring arrow again. This is the correct setting for 3/4" thick stock.

FINALLY - Line-up your Bit's cutting edge with the Easy-Set profile - With the bottom of the Easy-Set Jig resting flatly on your router table surface, align the indicated edge of your bit with the edge of the Easy-Set jig profile (see arrows with drawings).



IMPORTANT NOTES: ① / ② Any Freud raised panel cope cutter or raised panel bits can be set with the Easy Set Jig since only the tongue portion of the Jig's profile is used during the height-setting process (shown w/ 99-569 Cove Raised Panel Bit w/ Back Cutter).

③ Material thickness makes no difference with Drawer Lock Bits. Set the Jig to 23/32" and align the angle on the Jig and Bit as in the 99-240 photo above.