Congratulations on the purchase of your new Disc Sander Angle Jig! It allows you to sand precise angles on the end of your workpiece and to sand perfectly round circles. For safe and effective operation of the jig, please read the instructions fully before starting.
### GENERAL SAFETY WARNINGS

This tool is designed for specific applications as defined in the instructions and should not be modified and/or used for any other applications. Before using the Disc Sander Angle Jig read, understand and follow all instructions and safety information provided. **KEEP THESE INSTRUCTIONS.**

- For any tool that is used in conjunction with this product always read, understand and follow the instructions and safety warnings for that tool.
- Before using this product, review and verify that all tools used with it are in proper working order as defined by the tool's owner's manual.
- All safety equipment must be installed and working properly as defined by the tool's owner's manual.
- Do not use this product until you have read the provided instructions and warnings and are confident you understand them.
- Always wear safety glasses in compliance with ANSI safety standards and hearing protection and follow all standard shop safety practices including:
  - Keep your work area well lit and clean.
  - Use dust collection tools and dust face masks to reduce exposure to dust.
  - Use accessory safety equipment such as feather boards, push sticks, and push blocks whenever appropriate.
  - Do not use power tools in explosive environments, e.g. in the presence of flammable liquids, fumes or dust.
  - Keep children and bystanders away while operating your tools.
  - Maintain proper footing at all times and do not overreach.
  - Do not force the tool.
  - Unplug all power tools before making any adjustments or changing accessories.
- Remain alert and use good judgment when using this tool. Do not use this tool if you are in any way impaired by medications, alcohol, drugs or fatigue.
- Dress appropriately and remove all jewelry, secure loose clothing and tie up long hair before using this tool.
- It is the sole responsibility of the purchaser of this tool to ensure that any third party reads and agrees to all the safety precautions outlined in this manual prior to using the tool.
- Maintain these instructions and warnings as long as you own the tool. Keep in a place where they will be readily available for reference.
- The user assumes all risk for the proper use of this tool and for ensuring product suitability for intended application.
- These warnings and instructions do not represent the total of all information available regarding tool safety, use and technique. Always seek out opportunities to learn more and improve your skills and knowledge.

### SPECIFIC SAFETY WARNINGS

- The bolt of the expandable miter bar must be tightened to secure the jig before turning on the disc sander.
- Always keep your fingers away from the sanding disc.
- All sanding must be done on the downward-moving quadrant of the disc.
- When sanding with the jig fence as a support, the fence must be secured by tightening all knobs.
PARTS LIST

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<td>4</td>
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<tr>
<td>6</td>
<td>3/4&quot; x 5/16-18 T-Bolt</td>
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<td>16</td>
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Angle Jig Base (1). If the Angle Jig Base (1) does not extend past the edge of the disc, remove the Miter Bar (13) and Expandable Miter Bar (10) and reinstall them, using the rear set of mounting holes.

3. Mark the location of the disc’s edge on the side of the Angle Jig Base (1).

4. Move the jig to a work surface and remove the fence assembly, the Miter Bar (13) and the Expandable Miter Bar (10).

5. Measure 1/16” back from the mark you made in Step 3 and mark across the face of the Angle Jig Base (1). This will be your cut line. Fig. 2.

Note: No more then 3” should be removed from Angle Jig Base (1). If the Angle Jig Base (1) does not extend past the edge of the disc, remove the Miter Bar (13) and Expandable Miter Bar (10) and reinstall them, using the rear set of mounting holes.

Fig. 1

Jig Setup

1. Install the fence assembly on the Angle Jig Base (1). Do NOT install the T-track (8) in the Angle Jig Base (1) at this time.

2. Disc sanders come in different sizes, therefore, you will need to trim the front of the Angle Jig Base (1) to fit your disc sander. To do this, unplug your sander and position the jig next to the sander, square to the disc, so the miter bar on the underside of the Angle Jig Base (1) aligns with the miter slot in the sander’s table. The front of the Angle Jig Base (1) should extend beyond the edge of the disc. Make sure that the fence assembly will be able to pivot along the full range without contacting the disc. Fig. 1.

Note: The jig comes with the Miter Bar (13) and Expandable Miter Bar (10) already installed on the Angle Jig Base (1).
the Angle Jig Base (1) to allow the arm to have full range motion.

6. Using a table saw or circular saw with a straightedge guide, trim the front of the Angle Jig Base (1) to the cut line. Fig. 3.

7. Reinstall the Miter Bar (13), Expandable Miter Bar (10) and fence assembly on the jig.

8. Attach the T-track (8) in the slot in the Angle Jig Base (1). To do this, align one end of the T-track (8) with the back edge of the Angle Jig Base (1), mark and drill 1/16" diameter stopped pilot holes and secure with the included #6 x 3/8" screws (9).
Fence Calibration
1. Install the jig on the disc sander so the Miter Bar (13) and Expanding Miter Bar (10) are in the miter slot on the sander. Use a Phillips-head screwdriver to tighten the Expandable Miter Bar Bolt (11).

2. Loosen the fence assembly and use a combination or try square to position the fence 90° to the sanding disc. Tighten the knobs to lock the fence assembly in position. Fig. 4.

3. Use a Phillips-head screwdriver to loosen the screws securing the Hairline Indicator. Adjust the Hairline Indicator until its line is on the 0° line on the scale, then tighten the screws to secure. Fig. 5.

Jig Use
Sanding Angles
The Circle Sanding Point (16) should not be inserted in the T-track (8) during angle sanding operations.

1. Set the fence assembly to the desired angle and tighten the knobs to lock it in position.

2. Install the jig on the disc sander so the Miter Bar (13) and Expanding Miter Bar (13) are in the miter slot on the sander. Position the jig so that your workpiece will be roughly centered on the quadrant of the disc that is rotating downward. (If your disc sander spins
counterclockwise, this would be the left side of the disc.) Tighten the Expandable Miter Bar (10) to secure, and check to be sure the jig won’t shift.

**CAUTION** IT IS IMPORTANT TO POSITION THE WORKPIECE ON THE CORRECT SIDE OF THE DISC TO AVOID THE DANGER OF THE SPINNING DISC CATCHING AND LIFTING OR PROPELLING THE WORKPIECE.

3. Keeping your workpiece against the fence assembly and tight to the jig, turn the sander on and carefully advance the workpiece until it makes contact with the abrasive disc. Fig. 6.

**CAUTION** KEEP YOUR HANDS AWAY FROM THE DISC WHILE IT’S IN MOTION.

4. Sand the workpiece until the desired angle is achieved.

### Sanding Circles

1. If necessary, remove the fence assembly from the jig.

2. Install the jig on the disc sander so the Miter Bar (13) and Expanding Miter Bar (10) are in the miter slot on the sander. Position the jig so that the T-track (8) is roughly centered on the section of the disc that is rotating downward. Tighten the Expandable Miter Bar (10) to secure.

3. Slide the Circle Stop (15) into the T-track (8), followed by the Circle Sanding Point (16). The Circle Stop (15) must be between the sanding disc and the Circle Sanding Point (16).

4. Position the Circle Sanding Point (16) so the tip is set back from the sanding disc a distance equal to the desired finished radius of the circular workpiece to be sanded.

5. Holding the Circle Sanding Point (16) in position, slide the Circle Stop (15) up against it and use a 2mm hex wrench (not included) to tighten it in place. Double-check the setting to be sure the point is the correct distance from the disc. Fig. 7.

6. Drill a 1/8" diameter x 1/8" deep stopped hole centered on the underside of the workpiece. This will register the workpiece on the Circle Sanding Point (16). Note: It is best to cut off excess material to the desired circle diameter

7. Position the workpiece on the jig, with the center hole on the Circle Sanding Point (16). Turn on the sander and advance the workpiece into the sanding disc, holding it down and turning it slowly. Continue to advance and spin the workpiece until the Circle Sanding Point (16) contacts the Circle Stop (15). At this point, your workpiece should be at its final size. Fig. 8.

Check Rockler.com for updates. If you have further questions, please contact our Technical Support Department at 1-800-260-9663 or support@rockler.com