Review full manual instructions prior to use for important safety information. Always check Rockler.com to confirm that you are using the most recent manual version for your product.
This product 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 Router Table Box Joint Jig, read, understand and follow all instructions and safety information provided. KEEP THESE INSTRUCTIONS FOR FUTURE REFERENCE.

> Always confirm that you are using the most recent version of the Instructions and safety warnings for your product. To find the most recent version, find the product page on Rockler.com and click on the link to the Instructions.

> For any tool used in conjunction with this product, always read, understand and follow the instructions and safety warnings in the owner’s manual for that tool. If you do not have the owner’s manual, obtain one from the tool’s manufacturer before using it with this product.

> Before using this product, review and verify that all tools to be used with it have safety equipment installed and are in proper working order as defined by the tools’ owner’s manuals.

> Do not use this product until you have read and are confident you understand:
  • Product Specific Safety Warnings (p. 3);
  • Parts List (p. 4);
  • Setup (pp. 5-7);
  • Use (pp. 7-8).

> Do not use this product in any manner other than what is described in these instructions. Use only recommended 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 product to ensure that any third party whom you allow to use this product reads and complies with all the instructions and safety precautions outlined in this manual prior to use.

> Maintain these instructions and warnings as long as you own the product. Keep this booklet in a place where it will be readily available for reference.

> The user assumes all risk and responsibility for the proper use of this product and for ensuring product suitability for intended application.

> 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;
  • Unplug all power tools before making any adjustments or changing accessories;
  • Use dust collection tools and dust face masks to reduce exposure to dust;
  • Use accessory safety equipment such as featherboards, 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 from the tool operating area;
  • Maintain proper footing at all times and do not overreach;
  • Do not force the tool.

> These warnings and instructions do not represent the total of all information available regarding tool safety, use and technique. Please read the full manual before using this product and always seek out opportunities to learn more and improve your skills and knowledge.

⚠️WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to www.P65Warnings.ca.gov/wood.

⚠️ DANGER: Danger indicates a hazardous situation that, if not avoided, will result in death or serious injury.

⚠️ WARNING: Warning indicates a hazardous situation that, if not avoided, could result in death or serious injury.

⚠️ CAUTION: Caution indicates a hazardous situation that, if not avoided, may result in minor or moderate injury or property damage.

⚠️ NOTICE: Notice indicates important or helpful information and/or user tips.
PRODUCT SPECIFIC SAFETY WARNINGS

⚠️ DANGER

> To avoid serious injury, keep hands and fingers away from rotating cutter.

⚠️ WARNING

> Use only with wood and MDF no more than 1" thick.

> Platform (1) **MUST** be secured in the router table miter slot by fully tightening the five-star knobs of the Miter Slot Hardware (2).

> Indexing Key (4, 5 or 6) and MDF Sacrificial Fence (7) **MUST** be securely attached to Sled (3).

> Sled (3) must be able to slide smoothly in Platform (1) slots.

> To avoid risk of serious injury, unplug the router before installing, removing or adjusting the router bit.

> To avoid the chance of serious injury, keep fingers away from spinning router bit.

> Maintain control of the Sled and workpiece at all times by holding workpiece securely or clamping the workpiece to the Sled’s flat clamping areas.

> To avoid risk of serious injury and damage to the jig, never set the bit cutting height more than 1" above the surface of the jig Platform (1).

> If you encounter excessive resistance when routing, turn off the router immediately and determine the cause (for example, a dull bit).

> Do **NOT** attempt to machine more than one workpiece at a time (for example, by stacking).
<table>
<thead>
<tr>
<th>PARTS LIST</th>
<th>Quantity</th>
<th>PARTS LIST</th>
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<tbody>
<tr>
<td>1 Platform</td>
<td>1</td>
<td>7 1/4&quot; Indexing Key</td>
<td>1</td>
</tr>
<tr>
<td>2 Five-star Knob</td>
<td>2</td>
<td>8 3/8&quot; Indexing Key</td>
<td>1</td>
</tr>
<tr>
<td>3 Washer</td>
<td>2</td>
<td>9 1/2&quot; Indexing Key</td>
<td>1</td>
</tr>
<tr>
<td>4 Expandable Miter Bar</td>
<td>2</td>
<td>10 MDF Sacrificial Fence</td>
<td>1</td>
</tr>
<tr>
<td>5 Miter Bar Bolt</td>
<td>2</td>
<td>11 1/4&quot;-20 Machine Screws</td>
<td>2</td>
</tr>
<tr>
<td>6 Sled</td>
<td>1</td>
<td>12 1&quot; Panhead Screws</td>
<td>2</td>
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Setup

1. Assemble the jig, but leave off the MDF Sacrificial Fence (7) for now.

2. Select the appropriate Indexing Key (4, 5 or 6) for the width of box joint fingers you want to cut and securely install the key in the Sled (3), using the provided 1/4"-20 machine screws (8). The Router Table Box Joint Jig includes Indexing Keys for 1/4", 3/8" and 1/2" box joints. Make sure that the Indexing Key extends out the front side of the Sled and that the flat face of the Key is down.

3. Chuck a straight router bit with a diameter matching the width of the Indexing Key in your table-mounted router. For example, 1/4" wide box joint fingers would require a 1/4" diameter bit. For best results, use an up-cut spiral bit.

4. Position the Platform (1) on your router table so that the Miter Slot Hardware (2) fits in your table’s miter slot and the bit extends up through the oblong hole in the Platform. Do not tighten then Miter Slot Hardware (2) yet. Fig. 2.

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**THESE WARNINGS PERTAIN TO ALL REMAINING STEPS:**

![DANGER]

- To avoid serious injury, keep hands and fingers away from rotating cutter.

![WARNING]

- Use only with wood and MDF no more than 1" thick.
- Platform (1) **MUST** be secured in the router table miter slot by fully tightening the five-star knobs of the Miter Slot Hardware (2).
- Indexing Key (4, 5 or 6) and MDF Sacrificial Fence (7) **MUST** be securely attached to Sled (3).
- Sled (3) must be able to slide smoothly in Platform (1) slots.
- Maintain control of the Sled and workpiece at all times by holding workpiece securely or clamping the workpiece to the Sacrificial Fence/Sled’s flat clamping areas.
- If you encounter excessive resistance when routing, turn off the router immediately and determine the cause (for example, a dull bit).

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**NOTICE**

Store the Indexing Keys that aren’t being used in the onboard compartments incorporated in the Sled.

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**WARNING**

To avoid risk of serious injury, unplug the router before installing, removing or adjusting the router bit.

**NOTICE**

For the jig to work, the width of the Indexing Key must match the diameter of the router bit.

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To avoid serious injury, keep hands and fingers away from rotating cutter.
5. Set the cutting height of your router bit so that the top extends above the Platform surface just a hair more than the thickness of your material. (This will make the fingers of the joint stand a little proud when assembled so that you can sand them flush for a perfect joint.) **Fig. 3.**

6. Place the Sled (3), with Indexing Key attached, on the Platform (1) so that its runners slide in the slots in the Platform (1).

7. With the Sled (3) slid back away from the bit, install the MDF Sacrificial Fence (7). Fit the notch in the MDF Sacrificial Fence (7) over the Indexing Key and align the Fence with the sides of the Sled (3). Before attaching, place a few thicknesses of paper or another thin spacer under the MDF Sacrificial Fence (7) to raise it off the surface of the Platform (1) slightly to ensure that the Sled (3) will slide freely. Attach the MDF Sacrificial Fence (7) with the included 1" Panhead Screws (9) through the mounting holes in the Sled (3). Test to be sure the Sled (3) will slide smoothly. **Fig. 4.**

8. Slide the Sled (3) forward in its slots until the Indexing Key is even with the bit.

9. Adjust the Platform (1) side to side until the space between the bit and Indexing Key is equal to the diameter of the bit (and width of Indexing Key). For example, box joints with 1/4" fingers require a 1/4" gap between the two. We recommend Precision Brass Setup Bars (36918 or 51936, sold separately) for easy, accurate setup. **Fig. 5.**

**WARNING** The Five-star Knobs (2) **MUST** be securely tightened to avoid the chance of the Platform shifting, potentially causing serious injury.

10. Once the precise spacing has been achieved, lock the Platform (1) in position by securely tightening the five-star knobs of the Miter Slot Hardware. Test to be sure the Platform cannot shift.

11. Plug in the router and, using test pieces that are the same thickness as your final workpieces, make test cuts to verify that the spacing is correct and the joints will fit snugly together. After each pass, fit the area just cut over the Indexing Key for the next cut.
12. If needed, adjust the spacing between the bit and Indexing Key. Unplug the router and loosen one of the five-star knobs on the Platform (1). If the fit of your box joints is too tight, nudge the Platform slightly so that the Indexing Key is closer to the bit. If the fit is too loose, nudge the Platform to move the Indexing Key a hair farther from the bit.

Use

**THESE WARNINGS PERTAIN TO ALL REMAINING STEPS:**

![DANGER]

> To avoid serious injury, keep hands and fingers away from rotating cutter.

![WARNING]

> Use only with wood and MDF no more than 1" thick.
> Platform (1) MUST be secured in the router table miter slot by fully tightening the five-star knobs of the Miter Slot Hardware (2).
> Indexing Key (4, 5 or 6) and MDF Sacrificial Fence (7) MUST be securely attached to Sled (3).
> Sled (3) must be able to slide smoothly in Platform (1) slots.
> Maintain control of the Sled and workpiece at all times by holding workpiece securely or clamping the workpiece to the Sacrificial Fence/Sled’s flat clamping areas.
> If you encounter excessive resistance when routing, turn off the router immediately and determine the cause (for example, a dull bit).
> Do NOT attempt to machine more than one workpiece at a time (for example, by stacking).

**NOTICE**

The Router Table Box Joint Jig is intended for use in cutting end-grain joints like those shown. Joints cut across the grain could result in significant tear-out unless an additional sacrificial backer is used.

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1. After setting up the jig for your application, lay out all four sides of your box with the inside faces up. Label each piece on the inside face (A, B, C and D) and mark the top and bottom edges (T and B). Fig. 6.

2. To make the first cut, position the top edge of Workpiece A flush against the Indexing Key’s left edge and hold or clamp it there. Make the cut by sliding the Sled forward across the bit and then back to the starting point. Fig. 7.
3. For successive cuts, reposition Workpiece A with
   the previous cut over the Indexing Key and hold or
   clamp in place. Slide the Sled forward across the bit
   and then back to the starting point to make the cut.
   Repeat until all cuts have been made on that edge.
   Fig. 8.

4. To make the first cut in the adjacent side
   piece (Workpiece B), use the original
   piece (Workpiece A) as a spacer. Position
   Workpiece A with the top edge positioned as
   shown in Fig. 9. Butt Workpiece B against
   Workpiece A, hold or clamp the workpieces
   and make the cut.

5. Remove Workpiece A, reposition Workpiece B so
   the area just cut is on the Indexing Key, hold or clamp
   it in place and make the second cut. Fig. 10. For
   successive cuts, reposition Workpiece B with the
   previous cut over the indexing key. Repeat until all
   cuts have been made on that edge.

6. To make the cuts in workpieces C and D, follow
   the process outlined in Steps 2-5.

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