

## Cut the groove first

1. The cutters and guide bearing need to be arranged as shown in **Fig. 1**. If they're not already in that order, fit a 9/16" wrench onto the collar at the top of the bit shank (to hold the bit) and use a 1/2" wrench to loosen and remove the nut at the top of the bit.
2. Starting from the shank end, stack the bit in this order: bearing, cutter, bearing. Install the washer and use the wrenches to tighten the nut at the top of the bit, taking care to maintain alignment of the cutting edges. **Fig. 1**.  
**Note:** Make sure the cutting edges are facing as shown.
3. Install the bit in a table-mounted router and set the cutting height so that the groove will be centered on the thickness of your stock. Use a straightedge to set the router table fence in line with the guide bearing on the bit.
4. Using a scrap piece that's the same thickness as your stock, make a test cut. Fine-tune the bit height until the groove is centered.  
**Note:** Use a featherboard and push stick for better results and increased safety. Always keep hands away from cutters.
5. Rout the grooves in your stock.

## Next, cut the tongue

1. Remove the bit from the router to reconfigure the cutters. Fit the 9/16" wrench onto the collar at the top of the bit shank and use a 1/2" wrench to loosen and remove the nut at the top of the bit.
2. Starting from the shank end, stack the bit in this order: cutter, bearing, cutter. Install the washer and use the wrenches to tighten the nut at the top of the bit, taking care to maintain alignment of the cutting edges. **Fig. 2**.  
**Note:** Make sure the cutting edges are facing as shown.
3. Reinstall the bit in your table-mounted router and use one of your grooved workpieces as a guide to set the approximate cutting height. Use a straightedge to set the router table fence in line with the guide bearings on the bit.
4. Using a scrap piece that's the same thickness as your stock, make a test cut.  
**Note:** Use a miter gauge or wide backer board to support the stock as you make this cross-grain cut.
5. Check the fit of the tongue in one of your grooved workpieces. If it's too loose, remove the bit from the table (or, if possible, raise it high enough for adequate access). Loosen and remove the nut and top cutter and add one of the included shims between the bearing and the top cutter. Reassemble the bit, reinstall it in the router and reset the bit height and


**Fig. 1**

**Fig. 2**

**Finished joint**

fence position. Make another test cut and check the fit. Add additional shims until the tongue fits the groove.

6. Verify the bit height by test fitting the tongue in the groove. The faces of your two pieces should be flush. Adjust as necessary.
7. Once you've achieved the desired fit, rout the tongues on your workpieces.

## Warnings

- Use only in a table-mounted router at reduced RPMs.
- Do not bottom out bit in your router collet. Allow at least 1/8" gap between bottom of bit shank and bottom of router collet.
- Keep hands clear of bit.
- Wear eye protection at all times.

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