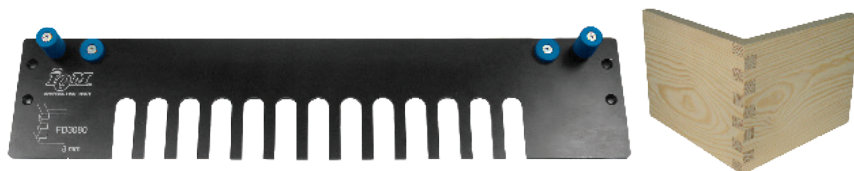




FD3080-3130 FD6080-6130



OPTIONAL TEMPLATE

for dovetail jig FD300-600

8 mm (5/16") BOX COMB FD3080&6080

12,7 mm (1/2") BOX COMB FD3130&6130

Operating instructions EN



PDF ONLINE
www.igmttools.info



Operating manual
OPTIONAL TEMPLATES
for DOVETAIL JIG FD300 & 600

8 mm (5/16") BOX COMB
FD3080 & 6080

12,7 mm (1/2") BOX COMB
FD3130 & 6130

TEXT PART - V5

8 mm (5/16") & 12,7 mm (1/2") BOX JOINT TEMPLATES

Illustration H

Both parts of joint are routed at the same time.

Joint Description	Edge Guide Information			Ø Guide Dimensions	Router Bit
	Diameter	Colour	Position		
8 mm (5/16") Box Joint FD3080	Ø 14 x 6 mm (9/16" x 6 mm)	Blue	F1	11,1 mm 7/16"	Ø 8 x 25 mm Ø 5/16" x 1"
	Ø 21 x 25 mm (13/16" x 25 mm)	Blue	F2		
8 mm (5/16") Box Joint FD6080		Blue	F1	11,1 mm 7/16"	Ø 8 x 25 mm Ø 5/16" x 1"
	Ø 10/26 x 31 mm	Blue	F2		
12,7 mm (1/2") Box Joint FD3130	Ø 19,7 x 6 mm (3/4" x 6 mm)	Red	F1	15,8 mm 5/8"	Ø 12,7 x 25 mm Ø 1/2" x 1"
	Ø 17,3 x 31 mm (11/16" x 31 mm)	Red	F2		
12,7 mm (1/2") Box Joint FD6130	Ø 11,3 x 6 mm	Red	F1	15,8 mm 5/8"	Ø 12,7 x 25 mm Ø 1/2" x 1"
	Ø 10 x 31 mm	Red	F2		

Stock preparation

- Cut all pieces for box to the exact dimensions. Make sure ends are perfectly square and exact width.
- For symmetrical joints use widths of stock according to the table. Smallest width is equal to 3 times the size of the joint. For example, a 8 mm (5/16") box joint has minimum width of 24 mm (15/16").
- Both workpieces will be clamped together under the front clamp. The face side of one workpiece should be toward you, the face of the other piece should be toward the jig.

Workpiece width

8 mm (5/16") Box Joint

This 8 mm (5/16") box joint template can be used with stock from 24 mm (1-1/4") to 305 mm (12") wide with FD300 jig or to 610 mm (24") wide with FD600 jig. For symmetrical pin placement, use this table as a guide:

#of Whole Tails:		1	2	3	4	5	6	7
Ideal stock tails	mm	24	40	56	72	88	104	120
	inch	15/16"						

12,7 mm (1/2") Box Joint

This 12,7 mm (1/2") box joint template can be used with stock from 38,1 mm (1-1/2") to 305 mm (12") wide with FD300 jig or to 610 mm (24") wide with FD600 jig. For symmetrical pin placement, use this table as a guide:

#of Whole Tails:		1	2	3	4	5	6	7
Ideal stock tails	mm	38,1	63,5	88,9	114,3	139,3	165,1	190,5
	inch	1-1/2						

- Prepare a piece of scrap stock at least 6 mm (1/4") thicker than your workpieces and long enough to be held securely by the top clamp. This scrap piece serves as a backer board to the workpieces and reduces the chance of tearout. See **illustration H5**

Set up

- Attach edge guides to the jig in the positions listed in the table above.
- Place X piece under front clamp with the inside surface towards you and push tight against edge guide .
- Tighten front clamp knobs.
- Place scrap piece into top clamp and butt against the X workpiece. Important: be sure this scrap stock is 1/4" thicker than your workpieces!
- Tighten top clamp knobs.
- Remove workpiece from front clamp.
- Turn template adjustment nuts until they are against the body.
- Tighten template assembly knobs, be sure the template is against the scrap stock.
- Place workpiece X under the front clamp with the face toward you, and piece Y under the clamp with the face toward the jig. Push tight against edge guides, and be sure the ends of workpieces are against against template.
- Tighten front clamp knobs.

Only for FD600

Set up sliding edge guide for symmetrical joints as follows:

- For box 8 and 12,7 mm (1/2") draw center line and offset lines 1,6 mm to left and right of the center line.
- Place workpieces into front clamp.
- Fit template comb assembly with brackets, slots to front.
- For left hand , place workpiece so that left offset line flush left edge of slot and vice versa for other end of jig.
- Tighten front clamp .
- Slide edge guides against edge of timber.
- Tighten edge guide locking knob.

- Install the template guide in the router.
- Install the router bit in the router.
- Adjust the cutting depth of the router bit to match the thickness of your stock.

Routing

- Place the router on the template ensuring that the router bit does not touch the workpiece.
- Switch on.
- Rout carefully from left to right following the fingers of the template with the template guide.
- Switch off the router and carefully remove from jig.
- Check that all slots are routed clean. If not, rout again.
- Remove the workpiece from the jig.
- Test joint.

ATTENTION !

Scrap stock must be 6 mm (¼") thicker than workpieces. Without this extra thickness severe damage may occur to your jig and router bit.

If joint is not perfect :

Joint too shallow= increase cutting depth of routerbit.

Joint too deep= decrease cutting depth of routerbit.

Adjust the template assembly according to this table and rout new joint again.

SAFETY

- Before changing router bit or making any kind of adjustment, always turn off and unplug your router.
- Use protective glasses during routing.
- Use hearing protectors.
- Always use a dust-protection mask or respirator.
- Use dust collection.
- Do not wear loose clothes. Make sure that your sleeves are either rolled up or fastened and that you are not wearing a tie.
- Before starting your router remove all tools, nuts and other loose object from the work area.
- Avoid an inadvertent start of your router. Before you plug it in, verify the switch is in "off" position.
- Before you make any adjustments, wait till your router cutter completely stops.

FD3130 & 6130 SPARE PARTS LIST			v.5
Pos. #	Description	quantity	code
10	Screw M4 x 16	2	FS200126
13	Template brackets FD300 – not included , from FD300	2	FD6001-22
	Template brackets FD600 – not included , from FD600	2	FD6001-21
14	Screw M4 x 8	4	FS200128
22	Screw M5 x 8	2	FS200143
23	Hex key 2,5	1	F9900620
29	Template comb 12,7 mm (½") Box Comb FD300	1	FD3130-04
	Template comb 12,7 mm (½") Box Comb FD600	1	FD6130-04
35	Guide bush D15,8 mm x 4 – not included, from FD300 & 600	1	FGB158-04
43	Edge guide D17,3 mm x 31 mm red FD3130	2	FD3130-03
	Edge guide D10 mm x 31 mm red FD6130	2	FD6130-03
44	Edge guide D19,7 mm x 6 mm red FD3130	2	FD3130-02
	Edge guide D11,3 mm x 8 mm red FD6130	2	FD6130-02
69	Screw M4 x 40	2	FS200141

FD3080 & 6080 SPARE PARTS LIST			v.5
Pos. #	Description	quantity	code
10	Screw M4 x 16	2	FS200126
13	Template brackets – not included , from FD300	2	FD6001-22
	Template brackets – not included , from FD600	2	FD6001-21
14	Screw M4 x 8	4	FS200128
22	Screw M5 x 8	2	FS200143
23	Hex key 2,5	1	F9900620
27	Template comb 8 mm (5/16") Box Comb FD300	1	FD3080-05
	Template comb 8 mm (5/16") Box Comb FD600	1	FD6080-04
34	Guide bush D11,1 mm x 4 mm	1	FGB111-03
39	Edge guide D14 mm x 6 mm blue FD3080	2	FD3080-03
	Edge guide D10/26 mm blue FD6080	2	FD6080-02
40	Edge guide D21 mm x 25mm blue FD3080	2	FD3080-04
69	Screw M4 x 40	2	FS200141



IGM nástroje a stroje s.r.o., Ke Kopanině 560,
Tuchoměřice, 252 67, Czech Republic, EU
+420 220 950 910, www.igmtools.com