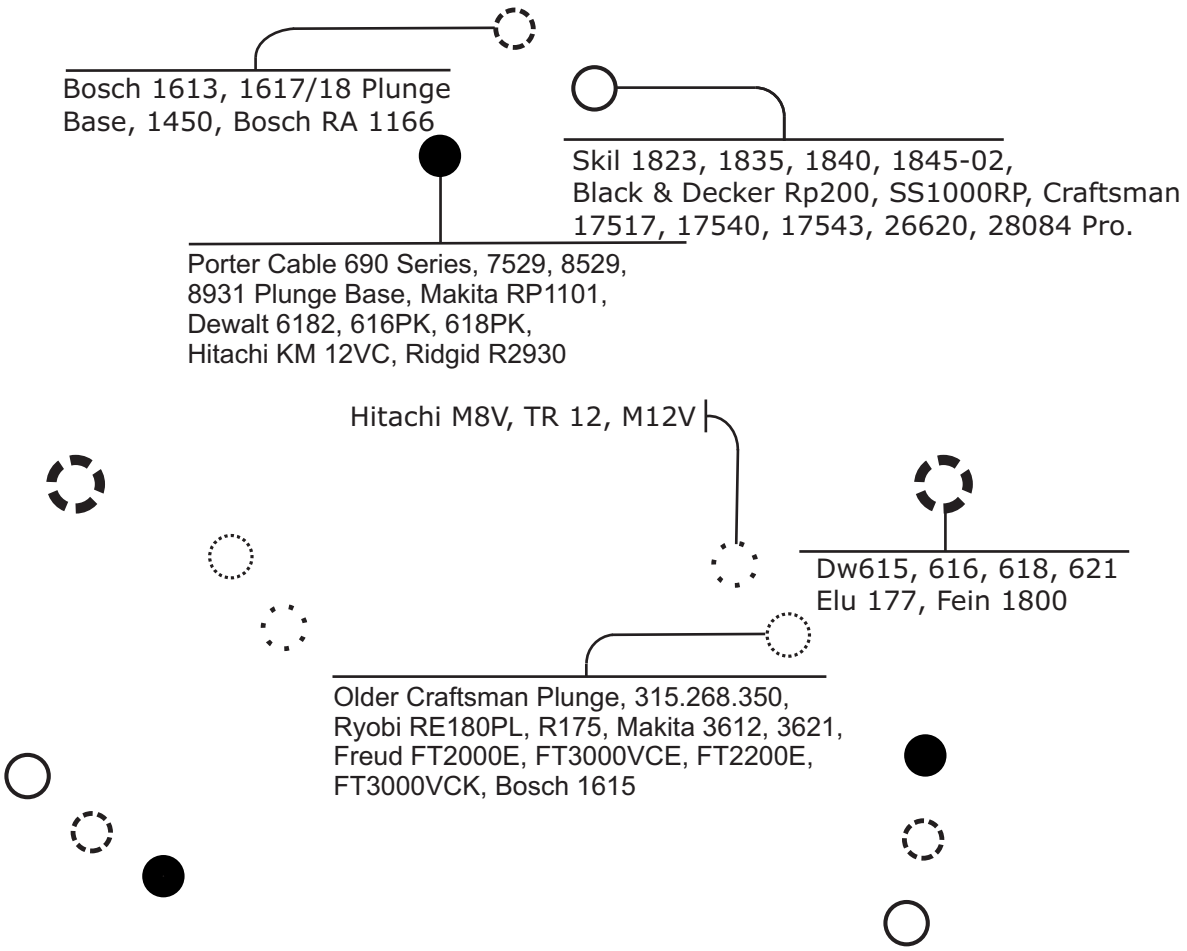
M240 Instructions



USING OTHER BIT DIAMETERS: To make a cutout with a bit other than ¼ inch diameter, select the pivot hole by using the following equation:

Pivot Hole Value = Cutout Diameter - Bit Diameter + 0.25

To make a disk with a bit diameter other than ¼ inch, use the following equation:

Pivot Hole Value = Disk Diameter + Bit Diameter + 0.25

CONVERSIONS: To convert MM to inches: Inches = MM ÷ 25.4. Use the following example to convert decimal fractional parts to fractional parts: If your cutout is 6.729 inches, you convert the fractional part (0.729) to 16ths of an inch by multiplying 0.729 X 16 which is equal to 11.664. Round this number up to 12. So your cutout would be 6 12/16 or 6 ¾ inches in diameter.

USE THE GUIDE FOR METRIC DIMENSIONS

(Note: These equations calculate the Pivot hole on the Guide in Inches)

To Make a Metric Cutout in MM:

$$\text{Pivot Hole on Guide (Inches)} = \frac{\text{Cutout Diameter(MM)} - \text{Bit Diameter(MM)} + 6.35}{25.4}$$

To Make a Metric Disk in MM:

$$\text{Pivot Hole on Guide (Inches)} = \frac{\text{Cutout Diameter(MM)} + \text{Bit Diameter(MM)} + 6.35}{25.4}$$

M240 Instructions (Cont)

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The Model 240 Pro Circle Guide is made from polycarbonate and is virtually unbreakable. It makes circles from 1 inch to 18 3/16 inches in diameter in 1/16 inch increments . The scale is calibrated to read direct cutout diameter when a 1/4 inch router bit is used. A calibration disk is included that is used to calibrate the guide to your router.

6 73046 01240 7

SAFETY: Read all precautions that came with your router. Make sure your router is unplugged while changing the bit and leave router unplugged until you complete your setup and you are ready to route your circle. Always use eye protection while routing. Always use proper ventalation when routing MDF or other carcinogenic materials.

MOUNTING THE GUIDE TO THE ROUTER: Your circle guide has a calibration disk installed with two dowel pins. Leave this disk in place. Remove the plastic base plate from your router. A 1/4 inch dowel pin has been provided in the hardware tube. Install the 1/4 inch dowel pin in the collet of your router, so that 7/8 of an inch of the pin is protruding from the collet. Plunge the router down and lock it so that the 1/4 inch pin protrudes 1/2 an inch below the base of the router. Note that you may need to use your 1/4 inch reducer to properly install the dowel pin. There is a 1/4 inch hole in the calibration disk. Hold the guide and calibration disk assembly by the calibration disk and install it on the 1/4 inch dowel pin. Rotate the guide around the router base until the mounting holes line up and mount the guide with the supplied screws. Release the lock on the router and **remove** the calibration disk from the guide by pressing on the top side with a screwdriver. Replace the 1/4 inch dowel pin with a 1/4 inch router bit. Your circle guide is now calibrated for your router.

REINSTALLING THE CALIBRATION DISK ON THE GUIDE: Save the calibration disk and 1/4 inch dowel pin for future installation. To reinstall the centering disk on the circle guide, place the pin closest to the 1/4 inch hole in the 1 1/16 pivot hole. The other pin goes in the 3/4 inch pivot hole. The disk should be reinstalled in the guide by tapping it into position with a small hammer. The disk should remain in the guide when the guide is not in use.

HOW TO USE THE SCALE: The guide has inches listed along the horizontal scale on the bottom edge of the pivot hole pattern, and the fractions listed vertically along the left end. To find the 12 ½ inch pivot hole, find the 12 inch column of holes from the horizontal scale and the ½ inch row of holes from the vertical scale. Follow these lines to the 12 ½ inch pivot hole. **The scale will face the work piece while routing the circle.** When you have located the pivot hole for the diameter circle you wish to make, insert the pivot pin in that hole. The pivot holes are precision drilled so that the guide holds the pin in the selected hole without falling out. When you turn your router over the pin will not fall out of the guide.

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Visit our web-site,www.jaspertools.com, for the latest information on our products. To check if your router fits our circle guides or adapter plates, click on the router compatibility tab and select circle guides. If your router is not listed in the router compatibility table, go to the bottom of the page and click on CLICK HERE if your router is not listed. All of the mounting layouts on our circle guides are listed here with the distance between mounting holes.. You can measure the distance between mounting holes on your router and compare with the layouts. If you find a match your router will fit. You may have to remove the base plate from your router to see all the mounting holes.

SETTING UP: Figure 1 shows a typical setup for cutting circular holes, mortises, or disks. The work-piece should be taped to the backup with double sided tape on both the inside and the outside of the cutout. Using a 1/8 inch diameter drill bit, drill a vertical hole through the work-piece and into the backup. This hole should be located at the center of the circle to be cut. Clear the hole by moving the drill bit up and down while running so that the pivot pin slips in easily. Tap the pivot pin in the desired pivot hole for the diameter you desire to cut with a small hammer. If you are cutting a recess, adjust the plunge depth on your router to the desired depth for the recess. Cut the recess first. After cutting the recess, set the plunge depth to cut the first pass on the cutout. Multiple cuts may be necessary to prevent overload of the router and over heating of the bit. If necessary, use a pair of pliers to remove the pivot pin from the circle guide.

SETUP FOR CIRCLE ROUTING

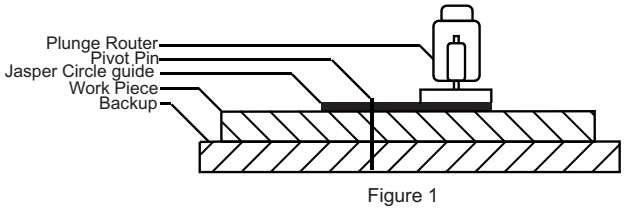

Figure 1